

ISO 9001:2008	Document No: TM/HM/6/400	Version No:0.0	Date effective: 24/11/17
Specification of Terminal Strip of Cutting Belt of FRM-80 (Part no.RE20.338 left & right)			



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**SPECIFICATION NO.TM/HM/6/400
SPECIFICATION OF TERMINAL STRIP OF CUTTING BELT OF FRM-80
(Part no.RE20.338 LEFT & RIGHT)**

DTM-III	EDTM	Page 1 of 3
Prepared By:	Issued By:	

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SPECIFICATION OF TERMINAL STRIP OF CUTTING BELT OF FRM-80 (Part no.RE20.338 LEFT & RIGHT)

- 1.0 Scope:** This specification covers the dimensional, functional and material requirements with testing criteria of Terminal Strip of Cutting Belt of FRM-80 Machine. This specification may be treated as provisional subject to modifications based on service performance.
- 2.0 Reference documents:** Following documents have been referred to in this specification. Full sets of relevant drawings and the referred codes/specifications, duly incorporating the up-dated corrections/amendments, shall be available for reference at manufacturer's works.
- i) IS:5517 - 1993 - Steel for Hardening and tempering - specification.
 - ii) IS:77-1976 - Linseed oil for paints - specification.
 - iii) RDSO Drg. No. RDSO/TM/23/17 & RDSO/TM/24/17 Terminal Strip of Cutting Belt of FRM-80
- 3.0 Functional requirement:** Terminal strip is a part of excavating chain of FRM-80. All surfaces meant for machining shall be finished as mentioned in the drawing no. RDSO/TM/23/17& RDSO/TM24/17.
- 4.0 Dimension & Tolerance:** Dimensions and tolerances of Terminal Strip of Cutting Belt of FRM-80 Machine shall be as mentioned in RDSO drawing no. RDSO/TM/23/17 & RDSO/TM/24/17.
- 5.0 Material:** Terminal Strip of Cutting Belt of FRM-80 Machine shall be made from Steel Grade 31Ni10Cr3Mo6 conforming to IS: 5517-1993 specification of Steel for Hardening and Tempering.
- 6.0 Manufacturing Process:** Terminal Strip of Cutting Belt of FRM-80 Machine shall be made by machining and fabrication from plate/sheet of specified material.
- 7.0 Heat Treatment:** Each component shall be heat treated by any suitable method to achieve hardness of 341 to 430 BHN.
- 8.0 Marking:** Month and year of manufacture and manufacturer's code / identification shall be engraved / embossed on the non-functioning surface of Terminal Strip.
- 9.0 Inspection and Acceptance Criteria:**
- i. Each component offered by manufacturer shall be checked visually for their surface finish, freedom from defect like porosity, cracks, improper edges etc.

DTM-III	EDTM	Page 2 of 3
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Machined surface shall be checked by any suitable pneumatic or electronic equipment.

- ii. The component found suitable after visual inspection shall be checked for their dimensional characteristics as per relevant drawing.
- iii. Supplier shall produce the certificate that the raw material used for manufacturing of the component conforms to material specified as mentioned in Para 5.0.
- iv. Minimum one no or 2 % sample of the Terminal Strip randomly picked up out of each lot of consignment and shall be subjected to chemical composition test. The consignee shall test the material for chemical composition at his laboratory or get the material tested in a reputed laboratory having proper facilities for testing. Before sending the samples for testing, the same shall be duly sealed and secret coding shall be done.
- v. Any deviation in the test result shall be the cause of rejection.

10.0 Packing and Protection: Each component shall be protected with one coat of boil linseed oil conforming to IS: -77-1976 (linseed oil for paint) and shall be packed in card board case.

DTM-III	EDTM	Page 3 of 3
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