

Scope of Work:

Cover Emergency Access Device (52514014) is an assembly and it requires Manufacturing of SS components, Sub assembly and Furnishing of other bought out items.

Sl. No	Part No	Desc	UOM	Qty / DM	Qty / M&T	Qty / T.set	Qty for 138 Cars (23 T.sets)
1	52514014	Cover Emergency Access Device	No	2	2	12	276

Scope of work includes:

1. Laser cut , Form emergency covers, Brackets, Stopper bracket, Mounting Bracket & Ball catcher pad as per details in drawing 52514014. Sharp edges should be deburred.
2. Spot weld the Stopper bracket, Tack weld the Ball catcher at 3 points on Emergency cover.
3. All the weld joints should be pickled and passivated and weld Joints shall be sealed with Transparent Sealant LOCTITE SI 595.
4. Furnish the Emergency cover along with Other bought out items viz., EPDM Rubbers (Rubber Stopper, Seal Rubber), Snap Joiner, Silicon Rubber, Hinge Assy, SS Spring, Ball catcher, Hardwares as per Drawing 52514014.
5. Rubber items (item -9, -14 & -15) should be bonded as per Drawing 52514014.
6. Packing of finished "Cover Emergency Access Device" 52514014 properly so that Outside 2J finish surface should not get damaged.

SS Raw materials Specn & Thickness involved:

1) SUS301L-DLT (2J Finish) / SUS304 (2J Finish) : 2mm thick

2) SUS304: 1.0mm , 1.2mm, 2.0mm, 4.0mm thicknesses.

Material Details for Bought out items:

1. EPDM & Silicon Rubbers (item -4, -6, -9, -14 & -15 in Drawing 52514014) should be of thicknesses & Dimensions as per Drawing 52514014 and in Colour Black. Rubbers should be of Fire retardant and confirm to Fire standard UL94 V0. Rubber items (item -9, -14 & -15) should be bonded as per Drawing 52514014.
2. Snap Joiner (item-7 in Drawing 52514014) should be of size 1-041.01SL & Material Specn: ZnDC, DIRAK PART NO - 294-9104.00-02830.
3. Hinge Assy (item-10 in drawing 52514014) should be of 1.5mm thick & Material Specn: SUS304 Buff Finish.

4. Spring (item -11 in Drawing 52514014) should be of Size 1.2 Dia & Material Specn :Austenitic SS Spring wire to GR-1 of IS:4454 (Part-4). Stiffness of Spring shall be ensured such that the cover assembly is held tight in position, but can be hand operated.
5. Ball catcher (item-12 in drawing 52514014) should be of size 6-130 & Material Specn: DIRAK Part NO 263-9008.
6. Hardware is M3x6 cross recessed CSK Head screw of Specn IS:7485-1985 / MATL: ISO:3506-79, Gr-A2-70.
7. Silicone Sealant: Loctite SI 595

Notes:

1. The Outside visible surface of the Emergency Cover & Bracket (of SUS301L-DLY 2J Finish) (item -1 & -2 in Drawing 52514014) should not get scratched or damaged as it should match to Side wall skin.
2. DLT (2J finish) Material supplied by BEML will be ensured for scratch free Dull finish surface before Disptach from BEML. However, if any scratches found on the material after receipt shall be reported & rejected immediately before starting up of manufacturing.
3. Care should be taken during fabrication of covers or at any stage of Fabrication to avoid damages such as Forming Tool Marks / Scratches especially on 2J surface, since the 2J surface of covers should match and in line with surface of side wall of Car.

Delivery requirements:

1. Cover Emergency Access Device (52514014) Should confirm to TDC Doc NO: GR/TD/5110.
2. Sample Approval should be obtained from R&D, Production & Quality Department before Mass production.

I. BEML SCOPE OF SUPPLY:

BEML to supply only 2.0 mm thick stainless steel sheets to grade SUS 301L-DLT(2J Finish) raw material of size 907mm x 1800mm or 907mm x 1000 mm or 510 x 907mm length.

II. VENDOR SCOPE OF SUPPLY:

Vendor to procure "1.0mm, 1.2mm, 2mm & 4mm thick SUS304 material for SS brackets, EPDM Rubbers (Rubber Stopper, Seal Rubber), Snap Joiner, Silicon Rubber, Hinge Assy, SS Spring, Ball catcher, Hardware & Silicone sealant Loctite SI 595" as per BEML Drawing & Procurement Technical Specification (PTS). Test reports as specified in PTS/drawing shall be submitted to BEML.