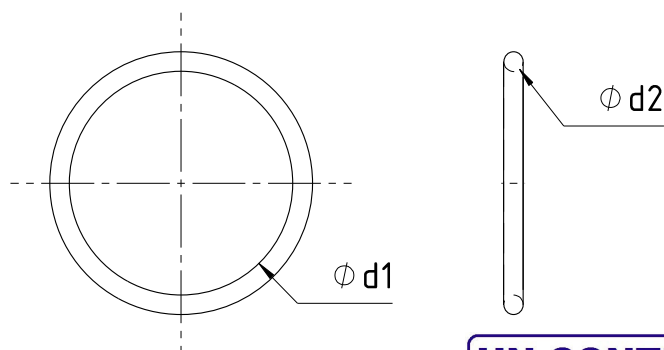


MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 – 6	6 – 30	30 – 120	120 – 315	315-1000	1000-2000	2000-4000	ABOVE 4000	RA
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	~
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227										
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM)							QUALITY OF WELD JOINTS REF, RD 230 MEDIUM			
VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS. 1012.C.							STATUS:	MOCKUP/PROTO/PRODUCTION		
WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96										



UN CONTROLLED COPY

SPECIFICATION FOR RUBBER RING

BASE RUBBER SHALL BE NITRILE SUITABLY COMPOUNDED TO MEET FOLLOWING:

TENSILE STRENGTH : 105 Kgf/Cm2

ELONGATION AT BREAK : 250% (MIN.)

SHORE HARDNESS : 60 ± 5

TEMPERATURE SUITABILITY : -10°C TO 120°C

COMPRESSION SET AT 100 ±1°C FOR 24⁰₋₂ HOUR : 35 % MAX.

SWELLING BY VOLUME IN REFERENCE

TO LIQUID 'B' AT $27 \pm 1^\circ\text{C}$ FOR 24^0_2 HOUR : 35 % MAX.

AFTER AGEING FOR 72⁰ HOUR AT 100 ± 1° C, CHANGE IN HARDNESS.

TENSILE STRENGTH & ELONGATION AT BREAK SHALL NOT EXCEED:-

HARDNESS : ± 15

TENSILE STRENGTH : $\pm 25\%$

ELONGATION AT BREAK : + 10 % , - 45 %

COLOUR : BLACK

ALL TEST PROCEDURE SHALL BE AS PER IS: 3400-87

DIMENSIONS: $\phi d1 = 234.62\text{mm}$, $\phi d2 = 2.62\text{mm}$ (AS PER ISO 3601-2, SC176)

N1

N2

N3

N4

N5

N6

N7

N8

N9

N10

N11

N12

GRADE No.

VALUE

SURFACE

ROUGHNESS

0.025

0.05

0.1

0.2

0.4

0.8

1.6

3.2

6.3

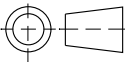
12.5

25

50

1

AFTER AGEING FOR 72⁰₂ HOUR AT 100 ± 1° C, CHANGE IN HARDNESS.
TENSILE STRENGTH & ELONGATION AT BREAK SHALL NOT EXCEED:-
HARDNESS : ± 15
TENSILE STRENGTH : ± 25 %
ELONGATION AT BREAK : + 10 % , - 45 %
COLOUR : BLACK
ALL TEST PROCEDURE SHALL BE AS PER IS: 3400-87
DIMENSIONS: Ød1 = 234.62mm, Ød2 = 2.62mm (AS PER ISO 3601-2, SC176)

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE (mm)	COMPANY STD./I.S	Wt. (Kg)	
					MATERIAL		
			PRODUCT	BMRCL METRO CARS			
			REF DRG				
			MATERIAL	JIS CLASS 1-A(A70)			
			HEAT TREAT.	APPD	MS	31.10.19	
			SURFACE TREAT.	REVD	DB	30.10.19	
			TITLE	CHKD	DB	30.10.19	
			O-RING	DRWN	JC		
				SCALE		SHEET	Wt.
				1:2		1 OF 1	0.1Kg
				DRG No.		ALT	
			BEM LIMITED		926-81142		
					