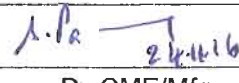


**GOVERNMENT OF INDIA
(Ministry of Railways)**

**SPECIFICATION FOR
GRINDING WHEEL WITH INSERTED NUT
(PL No.72110077)**

Issued by

**MECHANICAL DRAWING OFFICE
RAIL WHEEL FACTORY
YELAHANKA, BANGALORE-560 064
INDIA**

			
CWE/W	AED/M&C	Dy CME/Mfg	SSE/D
APPROVED	REVIEWED	VERIFIED	PREPARED

SPECIFICATION FOR GRINDING WHEEL WITH INSERTED NUT**1.0 SCOPE**

- 1.1 The Specification covers the manufacture and supply of Grinding Wheels with inserted nut to Rail Wheel Factory, Yelahanka, Karnataka State, India as per Instructions and Conditions of contract and Tender Papers.

2.0 DESCRIPTION

- 2.1 The Grinding Wheels with inserted nut, hexagonal in shape externally, should be as per Drawing No. RWF/GW-13 alt 'b'. Threads of the nut to be free of rust and to be coated with grease at the time of supply.

3.0 SAMPLING NORM

- 3.1 I.S.2500 – Part 1 to its latest revision, GIL-II
- 3.2 AQL Level 10
- 3.3 Sampling Norms for Performance Test.

Lot Size	Samples
≤ 100	2
> 100 ≤ 500	4
> 500 < 1000	8

4.0 PRACTICAL TEST AND ACCEPTANCE CRITERIA

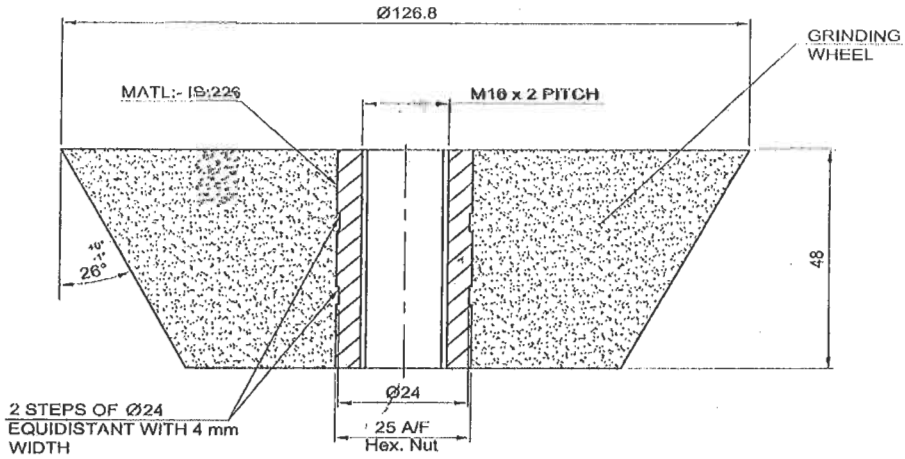
- 4.1 One Wheel shall grind 200 drag seats in manual operation.

5.0 SHELF LIFE:

- 5.1 The manufacturer shall specify the shelf life of the grinding wheels and it shall be a minimum of 24 months from the date of supply.

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ALT	DESCRIPTION	JOB No.	APPROVED
①	REVISED & REDRAWN	1461	-sd-
②	26° WAS 26°±30"	1796	-sd-
③	HEXAGONAL NUT WAS FERRULE INSERTED NUT	6854	<i>A.P.</i> 20.9.16



GRINDING WHEEL
 MATL: & SPECN. :- 37C 16R 4B-L5
 TO IS: 551 (GRINDWELL NORTON
 OR SIMILAR)

NOTE: THREADS OF THE NUT TO BE FREE OF RUST AND TO BE COATED WITH GREASE AT THE TIME OF SUPPLY.

ALL DIMENSIONS ARE IN mm UNLESS SPECIFIED OTHERWISE.

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
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APPROVED <i>A.P.</i> 20.9.16 DY.CME/MFG	INDIAN RAILWAYS		REF DRG.	
	GRINDING WHEEL		SCALE	AME/D
REVIEWED WM SARAN	FOR PORTABLE INGATE GRINDER -		—	SSE/D
	WAP/SK/MW-55		CHD	CHANDA
VERIFIED SARAN	RAIL WHEEL FACTORY		PROJECTION	DRN
	BANGALORE		ALT. ① ② ③	SARAN
		DRG.No. RWF/GW-13		20.09.16
		JOB No. 6854		SHEET 1 OF 1

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 SSE/D
 PREPARED

AMENDMENT SHEET

Sl. No	Alt 'a'		Alt 'b'		Job No	Sign
	Clause No.	Description	Clause No.	Description		
1	2.1	The Grinding Wheels with inserted nut should be as per Drawing No. WAP/GW-13. Threads of the nut to be free of rust and to be coated with grease at the time of supply.	2.1	The Grinding Wheels with inserted nut, hexagonal in shape externally, should be as per Drawing No. WAP/GW-13 alt 'b'. Threads of the nut to be free of rust and to be coated with grease at the time of supply.	6855	<i>Chande</i>
2	5.1	The manufacturer shall specify the shelf life of the grinding wheels.	5.1	The manufacturer shall specify the shelf life of the grinding wheels and it shall be a minimum of 24 months from the date of supply.		
3	Drg	(Drg No WAP/GW-13 alt 'a')	Drg	(Drg No RWF/GW-13 alt 'b')		

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