

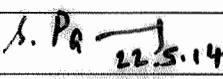



**GOVERNMENT OF INDIA  
(Ministry of Railways)**

**SPECIFICATION FOR  
CUTTING-OFF WHEEL  
FOR STOPPER-PIPE CUTTING  
(PL No.72983760)**

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

**Issued by  
SSE/D**

|   |  |   |   |
|---|--|---|---|
| <br>22/5 | <br>22/5/14 | <br>22.5.14 | <br>2015 |
| CME<br>APPROVED BY  | CWE/W<br>REVIEWED BY   | Dy. CME/Mfg.<br>VERIFIED BY   | WM/Wheel<br>PREPARED BY   |

**JOB No. 6317**

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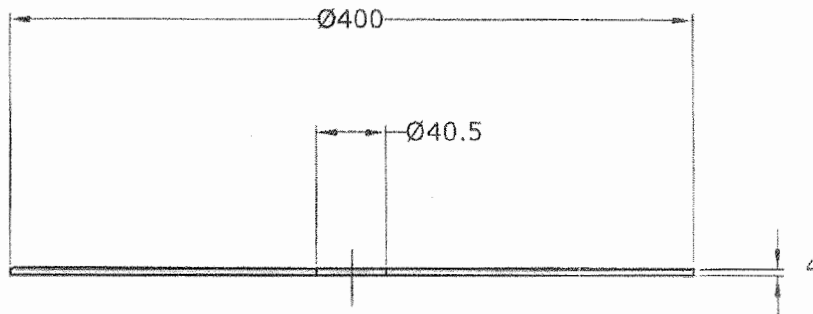
## SPECIFICATION FOR CUTTING-OFF WHEEL FOR STOPPER-PIPE CUTTING

### 1.0 SCOPE

The Specification covers the manufacture, supply and putting into beneficial use of Cutting-Off wheels to be used for stopper pipe cutting in Rail Wheel Factory, Yelahanka, Bangalore – 560064, Karnataka State, India as per Instructions and Conditions of contract and Tender Papers.



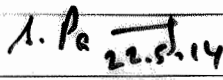
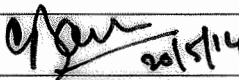
### 2.0 DESCRIPTION

Cutting-Off wheel as defined in Cl.3.7 of IS1249: 1937 and illustrated in the following figure , suitable for running at 3900 RPM max.



### 3.0 JOB REQUIREMENTS

- 3.1 The Cutting-off wheels are to be used in Stopper Cutting Machine for cutting-off the mild steel stopper-pipe having an OD of 25 mm and 2.5mm thick, which is assembled during the manufacture of the cast steel rail wheels. The cast wheel is subsequently processed at hot sprue grinding machine for grinding the sprues. During cutting the stopper pipe, the temperature of the stopper pipe is 300°C approximately.
- 3.2 The stopper pipe is cut on a stopper pipe cutter manufactured with motor of 3.7 kW, 5 hp having an RPM of 3000. The load applied while cutting is automatic and no cooling medium is applied during cutting.
- 3.3 The average number of stopper pipes cut per hour is 24 in normal working condition.

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|--|--|---|--|
| <br>22/5/14 | <br>22/5/14 | <br>22.5.14 | <br>20/5/14 |
| CME  | CWE/W  | Dy. CME/Mfg.  | WM/Wheel   |
| APPROVED BY  | REVIEWED BY  | VERIFIED BY   | PREPARED BY  |

**4.0 TECHNICAL DATA OF CUTTING-OFF WHEEL**

|             |   |          |
|-------------|---|----------|
| Outside dia | : | 400 mm   |
| Bore        | : | 40.5 mm. |
| Thickness   | : | 4 mm.    |
| R.P.M.      | : | 3900 max |

**5.0** The manufacturer/supplier should indicate the expiry date for usage on every Cutting-Off Wheel at prominent location.

**6.0** The supply shall accompany the Manufacturer's Test Certificate.

**7.0 INSPECTION**

**7.1** Sampling Plan : As per IS 2500(Part1) to its latest revision, GIL-II

**7.2** Acceptance Level : AQL 10

**7.3** Sampling Norms for Performance Test.





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

**8.0 PRACTICAL TEST**

Samples, drawn as per the above table are fitted to the Stopper-pipe cutter, shall cut-off a minimum of 200 numbers of stopper-pipes in the normal operation occurring before sprue grinding operation.

**9.0 ACCEPTANCE CRITERIA**

Based on the Manufacturer's Test Certificate as given in Cl. 6.0 and guaranteed consumption rate as given in Cl. 8.0.

|  |  |  |  |
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