

WAP / M / SPECN-1 / 033 / 1994			
ALT	DATE	JOB No	SIGN
ⓐ	06 10 94	2424	<i>G. S. G. 94</i>

GOVERNMENT OF INDIA
MINISTRY OF RAILWAYS

SPECIFICATION FOR
· DOME DISC
(PL.NO: 8498 0229)

ISSUED BY
MECHANICAL DRAWING OFFICE
WHEEL AND AXLE PLANT, YELAHANKA
BAN GALORE

<i>A. S. G. 94</i>	<i>H. S. G. 94</i>	<i>G. S. G. 94</i>
Dy. CME/WI	AWM/MR	SUPDT/DES
APPD. BY	CHD. BY	PREPD BY

SPECIFICATION FOR DOME DISC1) Scope

The Specification covers supply of Dome Disc for the usage during Mould preparation in the Stopper Setting Unit at Wheel and Axle Plant, Yelahanka, Bangalore - 560_064.

2) General Description:

Circular Annular Disc of non-asbestos Alumina Silicate.

3) Job requirement:

In the Stopper Setting Unit at WAP, the Stopper with Pipe is set along with Dome Disc.

- i) to maintain required height of blind Riser above the Wheel Hub.
- ii) to maintain alignment of Stopper Pipe.

The Dome Disc shall come in contact with Molten Metal at 1600°C.

4) Technical Data:

- i) Recovery : 25% min. (recovery after compressions at 2,000 Kgs after half-an-hour).
- ii) Density(Kg/M³) : 280 ± 10%
- iii) Breaking load(N) : 90 (Min.)
- iv) Dimensions : As per Drg.NO: C/MO-16/26 - alt-'b'

5) Test Certificate:

5.1 Recovery and breaking load tests should be done at the manufacturer's Works. A clear Certificate should be given indicating the values obtained. The method of testing should be explained in the Certificate.

5.2 Supplier to provide the evidence for having successfully supplied the material for similar process applications.

6) Packing:

It should be such that no damage/deterioration takes place in transit/handling etc.

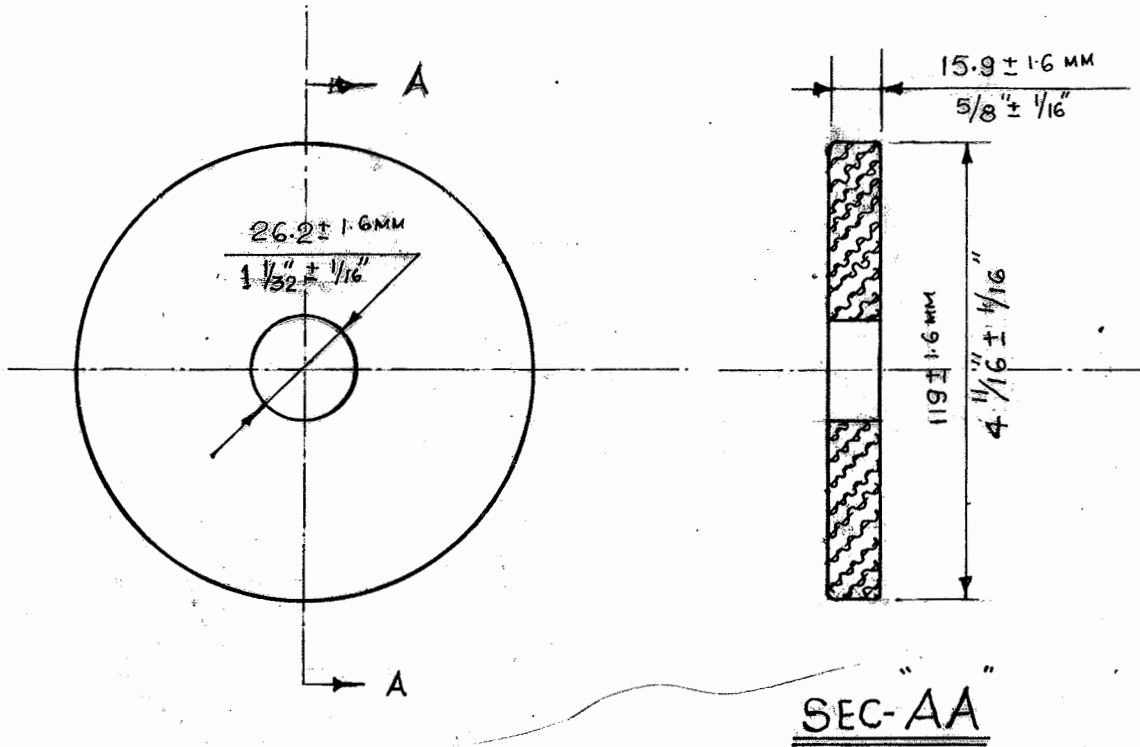
7) Inspection for Dimensions:

Sampling Norm: Single sampling normal Inspection, General Inspection level II of IS-2500 Part-I for inspection by attributes, to its latest revision.

AQL Level : 0.65 for single sampling and Normal inspection as per IS-2500 Part-I, to its latest revision.

DV.CHE/ W-I.	A.W.M./M.R.	SUPDT/DES.
APPROVED BY.	CHECKED BY	PREPARED BY

ALT.	DESCRIPTION	JOB No.	INITIAL & DATE
(a)	1) SPECIFICATION ADDED. 11) DELETED.	2088	CA 23/10/11
b	NOTES 2 & 3 ADDED. SPECIFICATIONS DELETED	2230	



NOTE

1. ALL DIMENSIONS ARE IN $\frac{\text{MM}}{\text{INCH}}$

2. MATL: ALUMINA SILICATE.

3. FOR MATL. SPEC. REFER SPCN. WAP/M/SPECN-11033.

PL No. 84980229

MACHINING SYMBOLS	HARDENED AND GROUND			ANGULAR DIMENSIONS		TOLERANCE FOR MACHINED AND UNMACHINED SURFACES UNLESS SPECIFIED OTHERWISE										
	FINISH	N1 N2 N3	N4 N5 N6	LENGTH OF SHORTER SIDE OF ANGLE	DEVIATION	OVER	>	6	30	120	315	1000	2000	4000		
XXX	FINE FINISH	N1 N2 N3	N4 N5 N6	ABOVE	UPTO	mm	DEGREE OR MINUTES	UPTO	6	30	120	315	1000	2000	4000	>
---	SMOOTH	N7 N8 N9	N10 N11	10	50	± 0.1	± 1°	MACHINED	± 0.05	± 0.1	± 0.2	± 0.3	± 0.5	± 0.8	± 1.2	± 2.0
---	ROUGH	N10 N11		50	120	± 0.6	± 20'	UNMACHINED	± 0.2	± 0.5	± 0.8	± 1.2	± 2.0	± 3.0	± 4.0	± 5.0
MACHINING SYMBOLS				120	---	± 0.8	± 10'									

ASSEMBLY SDE APPROVED AWM/D	INDIAN RAILWAYS		REF.
	DOME DISC		SUPERSEDED BY
	FOR MOULD BOX ASSEMBLY		SUPERSEDES
		SCAF	SD.
		CHD.	18-2-85
		DRN.	13-2-85
	ALT.	(a)(b)	
			DRG. No. C/MO-16/26

JOB NO: 1043