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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	~

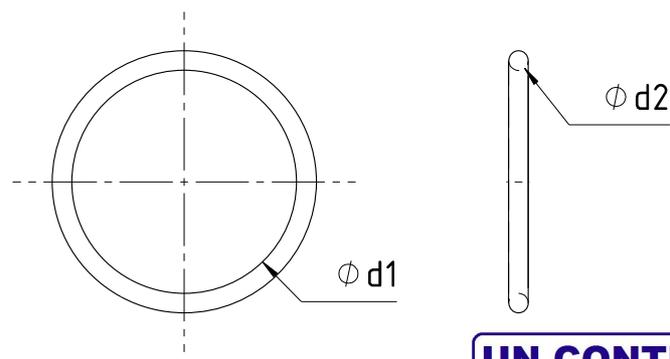
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

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.

WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96

STATUS: **MOCKUP/PROTO/PRODUCTION**



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 24₋₂⁰ HOUR : 35 % MAX.
- SWELLING BY VOLUME IN REFERENCE TO LIQUID 'B' AT 27 ±1°C FOR 24₋₂⁰ HOUR : 35 % MAX.

AFTER AGEING FOR 72₋₂⁰ 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: $\phi d1 = 234.62\text{mm}$, $\phi d2 = 2.62\text{mm}$ (AS PER ISO 3601-2, SC176)

GRADE No.	VALUE	SYMBOL	SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE (mm)	COMPANY STD./I.S	Wt. (Kg)	
N1	0.025	▽	N7	16		PRODUCT				
N2	0.05	▽	N8	3.2		REF DRG				
N3	0.1	▽	N9	6.3		MATERIAL	JIS CLASS 1-A(A70)			
N4	0.2	▽	N10	12.5		HEAT TREAT.	APPD MS		31.10.19	
N5	0.4	▽	N11	25		SURFACE TREAT.	REVD DB		30.10.19	
N6	0.8	▽	N12	50		TITLE	CHKD DB		30.10.19	
		▽					DRWN JC			
		▽					SCALE	1:2	SHEET 1 OF 1	Wt. 0.1Kg
		▽					DRG No.	926-81142		ALT 1

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE (mm)	COMPANY STD./I.S	Wt. (Kg)
			O-RING			
			REVISD & REDRAWN			
			ECN 92610261			
			DATE 02.06.2020			
			BY ILYAS			
			CHKD <i>[Signature]</i>			
			APPD <i>[Signature]</i>			
			BEML LIMITED			
			NEW FRONTIERS. NEW DREAMS			