







		TM20592 REV.00 PAGE 01 OF 02																																					
	TME/2011																																							
COPYRIGHT AND CONFIDENTIAL The information on this document is the property of BHARAT HEAVY ELECTRICALS LTD. It must not be used directly or indirectly in any way detrimental to the interest of the company	<u>SPECIFICATION FOR SEALING RING FOR THREE PHASE TRACTION MOTOR TYPE 6FRA-6068 & 6FXA-7059</u>																																							
	<p>1. FOREWORD:- This specification covers the requirements of "SEALING RING" for manufacturing of Three phase Traction Motor type 6FRA-6068 & 6FXA-7059.</p> <p>2. Requirement: Requirement per no. form are indicated here under: -</p>																																							
	<table border="1"> <thead> <tr> <th colspan="6">DETAILS OF SEALING RING</th> </tr> <tr> <th rowspan="2">REFERENCE NO</th> <th rowspan="2">Machine type</th> <th rowspan="2">C & D NO</th> <th colspan="2">DESCRIPTION</th> <th>QTY/TM</th> </tr> <tr> <th>D1</th> <th>D2</th> </tr> </thead> <tbody> <tr> <td>1</td> <td rowspan="2">6FRA6068</td> <td>5780/004</td> <td>3 ± 0.2</td> <td>317 (+0/-3)</td> <td>01 NO</td> </tr> <tr> <td>2</td> <td>5780/007</td> <td>3 ± 0.2</td> <td>212 (+0/-3)</td> <td>01 NO</td> </tr> <tr> <td>3</td> <td rowspan="2">6FXA7059</td> <td>5890/003</td> <td>3 ± 0.2</td> <td>212 (+0/-3)</td> <td>01 NO</td> </tr> <tr> <td>4</td> <td>5890/006</td> <td>3 ± 0.2</td> <td>167(+0/-3)</td> <td>01 NO</td> </tr> </tbody> </table>				DETAILS OF SEALING RING						REFERENCE NO	Machine type	C & D NO	DESCRIPTION		QTY/TM	D1	D2	1	6FRA6068	5780/004	3 ± 0.2	317 (+0/-3)	01 NO	2	5780/007	3 ± 0.2	212 (+0/-3)	01 NO	3	6FXA7059	5890/003	3 ± 0.2	212 (+0/-3)	01 NO	4	5890/006	3 ± 0.2	167(+0/-3)	01 NO
DETAILS OF SEALING RING																																								
REFERENCE NO	Machine type	C & D NO	DESCRIPTION		QTY/TM																																			
			D1	D2																																				
1	6FRA6068	5780/004	3 ± 0.2	317 (+0/-3)	01 NO																																			
2		5780/007	3 ± 0.2	212 (+0/-3)	01 NO																																			
3	6FXA7059	5890/003	3 ± 0.2	212 (+0/-3)	01 NO																																			
4		5890/006	3 ± 0.2	167(+0/-3)	01 NO																																			
	Revision : 00 Date: 19.11.2020	Distribution QTM TXM TAM TME	Qty. 1 1 1 1	Approved by:  (Manish Verma) <table border="0"> <tr> <td>Prepared by:</td> <td>Checked by:</td> <td>Date:</td> </tr> <tr> <td>  (Abhishek Shukla) </td> <td>  (Abhijit Jain) </td> <td>19.11.2020</td> </tr> </table>		Prepared by:	Checked by:	Date:	 (Abhishek Shukla)	 (Abhijit Jain)	19.11.2020																													
Prepared by:	Checked by:	Date:																																						
 (Abhishek Shukla)	 (Abhijit Jain)	19.11.2020																																						

	 PRODUCT STANDARD TME DIVISION, BHOPAL		TM20592 REV.00 PAGE 02 OF 02
	TME/2011		
COPYRIGHT AND CONFIDENTIAL The information on this document is the property of BHARAT HEAVY ELECTRICALS LIMITED It must not be used directly or indirectly in any way detrimental to the interest of the company	TEST PARAMETERS FOR SEALING RINGS AS PER SPECIFICATION.ASTM D 2000-03a		
	TESTING PARAMETERS	SPECIFIED VALUE	REFERENCE
	Polymer	Neoprene Rubber	As per drg. no. 44454464053
	Hardness (Shore A)	70 ± 5	ASTM D 2000 - 3a, Table -6, BA material, Grade -3
	Tensile Strength (MPa), min	17	ASTM D 2000 - 3a, Table -6, BA material, Grade -3
	Ultimate elongation (%) min	300 min	ASTM D 2000 - 3a, Table -6, BA material, Grade -3
	Heat Resistance test (70 Hrs @ 100°C)		
	(A) Change in hardness (max), points	+10	ASTM D 2000 - 3a, Table -6, BA material, Grade -3
	(B) Change in tensile strength (max), (%)	-25	ASTM D 2000 - 3a, Table -6, BA material, Grade -3
	(C) Change in ultimate elongation (max). (%)	-25	ASTM D 2000 - 3a, Table -6, BA material, Grade -3
Compression set (max), (%) (22 hours at 70°C)	25	ASTM D 2000 - 3a, Table -6, BA material, Grade -3	
3. Special Condition:- Supplier to provide manufacturer's Guarantee certificate along with supplies.			
4. Marking & Packing:- Manufacturer's identification mark shall be provided on each item as per drawing/specification. Items shall be properly packed in box of suitable material to avoid damage during handling and transportation. All the items should be first kept in separate polythene packet and then in durable polythene packet and then finally kept in box. Two card indicating description of the material under stocking C&D No. The C&D No. with description of individual item including quantity duly signed by inspecting agency of BHEL (BHEL authorized inspecting agency/BHEL QC as per P.O.) shall be tagged, one inside and the other outside the box.			
5. Inspection:- a) Few nos. of each item shall be selected at random for inspection. b) SEALING RING shall be tested at NABL certified lab/ Govt. Lab /BHEL lab to conform the material as per above drawing/ specification.			
6. This specification is equivalent to CLW's specification no. 4TMS.096.086.			