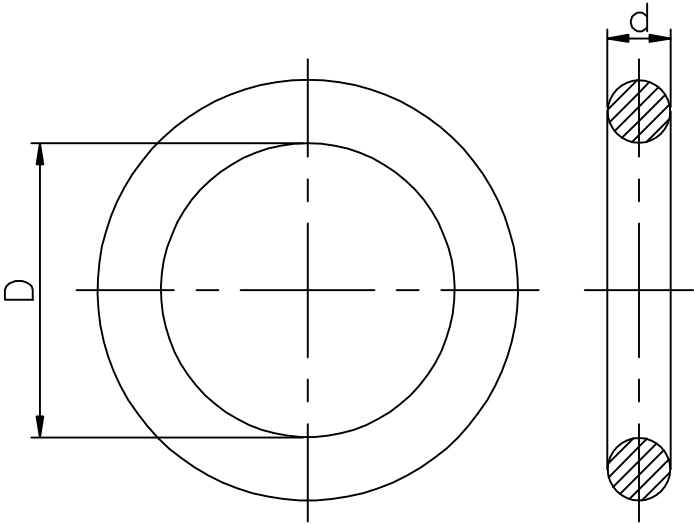


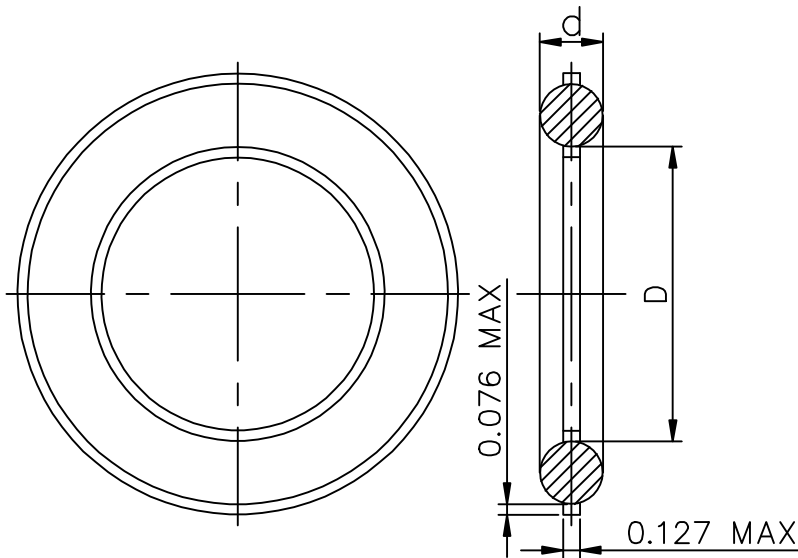
3-20-001-01855
DRAWING NO.

NOTE: FOR DIMENSIONS REFER TABLE BELOW

TYPE	φ D (mm)		d (mm)		Material	Temp °C		Wt / 1000 in kg	Material code	Shore Hardness
	Basic	Tol.	Basic	Tol.		Normal during Appln.	Short period of 48 Hours.			
A	20.6	±0.15	2.30	±0.1	Nitrile	121	149	4.5	96 353 090 0000	75 ± 5
A	94.0	±0.4	5.30	±0.15	Viton	204	315	12.88	96 353 060 0000	75 ± 5
A	97.0	±0.4	5.30	±0.15	Viton	204	315	13.27	96 353 061 0000	75 ± 5
B	21.8	±0.15	3.50	±0.1	Nitrile	121	149	6.5	96 353 307 0000	75 ± 5



TYPE – ‘A’



TYPE – ‘B’


NOTES:

- 01. O-RINGS ARE TO BE STORED UNDER COVERED AREA.
- 02. EXPOSING TO ATMOSPHERE WILL DAMAGE THE MATERIAL.
- 03. TO BE PACKED AND DESPATCHED IN CARD BOARD / WOODEN BOXES.
- 04. FOR QUALITY REQUIREMENTS REFER LATEST APPLICABLE QUALITY PROCEDURES.

THIS DRAWING REPLACES SPECIFICATION TSB:022

REV	DATE	ALTERED
		CHD & APPD

CAUTION: 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.

NO OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	REMARKS	ITEM No	
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT										
 BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI-620014.						DRN	NAME J.SANKAR	SIGN J.S	DATE 24.09.10	NO.OF VAR.
						CHD	K.SRIDHARAN	K.S	24.09.10	
						APPD	K.SRIDHARAN	K.S	24.09.10	
DEPT SB			SCALE NTS	WEIGHT (KG).	REFERENCE INFORMATION				NO. OF ITEMS	
CODE 330										
TITLE ' O ' RINGS						CARD CODE U 01	DRAWING NO. 3-20-001-01855		REV 00	

1.0 MATERIAL SPECIFICATION - Elastomer materials of grade specified in P.O.or drg. The property requirements are as given in Table-1.

2.0 GENERAL

These Elastomeric compounds are for use as O-rings/ packing in water and oil based drilling fluids, seawater, petroleum based lubricants and ethylene glycol anti-freeze mixtures.

Shall be manufactured to the relevant size in the drawing.

The grade nos. specified correspond to the Standards of M/s National; USA.

3.0 ENGINEERING REQUIREMENTS

MATERIAL PROPERTIES: The property requirements for the elastomers are given in table-1.

The hardness tests shall be carried out as per D2240/ D1415 and tensile tests as per D412/D1414(as per D1457 for PTFE materials).Additional property requirements for grades MS-447 & MS 452 (tested as per D621) are as follows.

MS 447 MS 452

Coefficient of thermal expansion (in/in/ Fx10-5) at 75 to 300°F 6.0+ 0.5 7.6+0.5

% deformation under load (max.)(24 Hours at 2000 psi at 70°F Min). 5.0 3.5

% permanent deformation (max.) after load release 2.0 2.2

4.0 INSPECTION & TESTING

The dimensions on the finished product shall conform to the relevant drawing.

Sampling inspection shall be carried out for visual, dimensions & hardness as per Cl.8.0.

The following type tests shall be carried out for conformance to this specification:

TYPE TESTS

AIR AGING TEST : This test shall be carried out in an Air oven (ASTM D573) or by heating in air in a test tube enclosure (ASTM D865).The purpose of this test is to determine the influence of elevated temperatures on the physical properties of vulcanized rubber.

The test shall be carried out at Minimum test temperature shown in table-2 for each grade for 70 hrs. in accordance with ASTM D412 and properties after air aging test shall conform to table-2.

COMPRESSION SET TEST :This test shall be carried out in accordance with ASTM D395 B i.e. Compression set under constant deflection in air with exceptions listed out in ASTM D1414 Cl.10.0

The test shall be performed at a minimum test temperature indicated in table-2 for 70 hours, except for Grade MS 225. For grade MS:225, the test duration shall be 22 hours.

The maximum permanent compression set shall comply to table-2.

LOW TEMPERATURE BRITTLENESS TEST : This test ensures that rubber will not exhibit fracture when subjected to specified impact conditions. The Test shall be carried out in accordance with ASTM D2137/D746 and shall PASS at the test temperature indicated in table-2.

IMMERSION TEST : This test ensures the ability to withstand the effect of liquids and shall be carried out in accordance with ASTM D471/D1414.

The liquids used for the test shall be ASTM Oil 1&3 at a minimum temperature indicated in Table-3 for various grades and Distilled water at a minimum temperature of 212oF for a period of 70 hrs.

Permissible variation in properties after immersion in liquids are given in Table- 3.

Immersion test is not applicable for grades MS 447 & MS 452.

VALIDITY : The validity of these Type test results is for two years from the date of test,in the case of PSL 1,2 & 3. However, in case of PSL 4,this test shall be carried out for each batch of purchase order. The type test shall be conducted at approved laboratory or witnessed by BHEL.

5.0 SPECIAL REQUIREMENTS

Insert ring shall be positioned as shown in BHEL drawing or the drawing approved by BHEL.

After Moulding, all parts must be inspected by the vendor/manufacturer to ensure proper positioning of the insert ring. The NDE to be followed can be RT/MT and meet the requirement indicated in the drawing. The ring must be generally located in the web of the seal, but in no case,in flexible lip of the seal.

No part of the ring shall be visible to the naked eye unless it is specified in the drawings.

6.0 DOCUMENTATION

For PSL 1,2 & 3: Certificate of compliance which indicates P.O.No, Drg No,Material grade & type tested compound no, Batchwise Cure/mould date & Shelf life(expiry date) shall be submitted.

For PSL 4 : Test certificates for the physical properties ,in addition to certificates mentioned above shall be submitted for each P.O.

7.0 MARKING AND PACKING

Each item shall be packed in polythene cover individually with suitable preservatives like French chalk powder with label having following details.

- (a) Drg. Number & size (b) Purchase Order No. (c) Batch Number
(d) Compound No. (e) Date of Cure/Mould (f) Shelf life (expiry date)
(g) Any other relevant details specified in the Purchase Order/drawing.

Each item shall be supplied in sturdy carton boxes to protect against permanent distortion during shipment and storage and from sunlight, dust etc. during shipment and storage. Each box shall contain only one size and lot of the product as given below.

(1) Size more than 6" -- each separate box (2) Size 2" to 6" -- 5 nos.in one box

(3) Size below 2" -- 10 nos.in one box.

Each box shall also be labeled with details specified above viz (a) to (g) above.

8.0 SAMPLING PLAN:for elastomeric compounds based on MIL-STD-105(latest) single sampling normal inspection.

Lot size	Sample size	Acceptance/Rejection criteria
26 to 50	8	No defect permitted
51 to 90	13	-do-
91 to 150	20	Accept when no. of defect < 1; Otherwise reject
151 to 280	32	-do-
281 to 500	50	Accept when no. of defect < 2; Otherwise reject

For lot size 25 Nos. & below, 100% inspection shall be done.

TABLE-1 PROPERTY REQUIREMENT OF ELASTOMERS

Elastomer Grade		MS-219	MS-220	MS-221	MS-225	MS-231	MS-233	MS-426	MS-427	MS-428	MS-430	MS-431	MS-447	MS-452	
Material		NBR	NBR	NBR	NBR	FKM	FKM	TFEP	TFEP	FVMQ	HSN	XNBR	PTFE	PTFE	
Hardness	Value	60+5	70+5	90+5	70+5 -5	90+5	70+5	90+10	80+5	85+10	80+5	70+5	65+5	63+5	
	Type	(A)	(A)	(A)	(A)	(A)	(A)	(A)	(A)	(A)	(A)	(A)	(D)	(D)	
Applicable	Min.	0	-20	-20	32	0	-20	-20	-20	-50	-20	-20	-50	-50	
Temp. Range(oF)	Max.	180	180	180	200	250	250	250	250	250	250	180	250	250	
Tensile strength in Psi (min)		2000	2000	2500	2000	1600	1500	2200	2000	1000	2500	2000	1500	1000	
Ultimate elongation % (min)		500	300	200	350	100	100	100	100	150	150	300	75	75	
Tensile modulus (psi)at 100% elongation (min)		200	400	800	600	500	500	-	1000	500	500	400	-	-	
Tensile modulus (psi)at 50% elongation (min)		-	-	-	-	-	-	1500	-	-	-	-	-	-	
Shelf life in years		2	2	2	2	4	4	4	4	4	2	2	10	10	
NBR	- Nitrile	FVMQ - Fluoro Silicone (Silastic LS)							FKM - Fluoro carbon(VITON,FLUOREL)						
HSN	- Hydrogenated Nitrile	TFEP - Tetra fluoro ethylene & Propylene(AFLAS)							XNBR - Carboxylated Nitrile						
PTFE	- Teflon (W/25% carbon/graphite filler)-MS447 ;								PTFE - Teflon (W/RYTON/MoS2/Carbon filler)-MS452						

TABLE-2 : AIR AGING, COMPRESSION AND LOW TEMPERATURE BRITTLNESS TEST REQUIREMENTS

Grade	Temp °F	AIR AGING TEST				COMPRESSION TEST RESULT (Compression set) in (%) max	TEST TEMP. FOR LOW TEMPERATURE BRITTLNESS TEST.
		Hardness points	Tensile Strength(%)	Ultimate Elongation(%)	Volume (%)		
MS 219	180	+ 05	+ 10	+ 20	+ 10	40	0°F
MS 220	180	+ 10	+ 15	+ 20	+ 05	30	0°F&-20°F
MS 221	180	+ 05	+ 10	+ 30	+ 10	25	0°F&-20°F
MS 225	212	+ 10	+ 10	+ 20	+ 10	40	32°F
MS 231	250	+ 10	- 40max	- 20max	+ 10	40	0°F
MS 233	250	+ 10	- 40max	- 20max	+ 10	40	0°F&-20°F
MS 426	250	+ 10	+ 10	+ 15	+ 10	30	0°F&-20°F
MS 427	250	+ 10	- 25	- 25	-	40	0°F&-20°F

MS 428	250	+ 05	+ 10	+ 10	+ 10	30	0°F, -20°F, -50°F & -75°F
MS 430	250	+ 10	+ 10	+ 20	+ 10	30	0°F & -20°F
MS 431	180	+ 05	+ 15	+ 20	+ 10	35	0°F & -20°F
MS 447	-	-	-	-	-	-	0°F, -20°F & -50°F
MS 452	-	-	-	-	-	-	0°F, -20°F & -50°F

(*) Min. test temperature is same for both air aging test & compression test

TABLE-3 : IMMERSION TEST REQUIREMENT

Grade	Min Test	Permissible variation in properties (+) with										Distilled water	
		ASTM Oil # 1					ASTM Oil # 3						
---	temp. °F (*)	Hard- ness	Ten- sile stren- gth	Ulti- mate Elon- gation	Volume	Hard- ness	Ten- sile stren- gth	Ulti- mate Elon- gation	Volume	Hard- ness	Ten- sile stren- gth	Ulti- mate Elon- gation	Volume

MS219	180	05	10	20	10	10	20	15	20	05	15	20	10
MS220	180	10	20	20	10	10	20	20	10	10	20	20	10
MS221	180	05	15	30	10	05	15	30	10	05	15	10	05
MS225	212	05	05	10	05	05	05	10	10	-	-	-	-
MS231	250	05	15	10	05	05	10	10	05	05	20	10	10
MS233	250	05	15	10	05	05	10	10	05	05	20	10	10
MS426	250	10	15	20	10	10	15	20	20	10	15	20	10
MS427	250	05	15	25	10	10	20	25	10	05	15	20	10
MS428	250	05	15	10	10	10	20	10	30	05	10	10	10
MS430	250	10	10	20	10	10	10	20	10	05	10	10	10
MS431	180	10	20	20	10	10	20	20	10	-	-	-	-

*Min. test temp. specified is only for immersion test with ASTM Oil #1 & 3. For distilled water, the test temp. is 212°F.

NOTE: Values indicated in Table are % values, except for Hardness. For hardness, it is variation in absolute value.

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