

TECHNICAL DELIVERY CONDITIONS FOR PUSH BENCH ROLL CAGE (RING) BED

BHEL : SSTD : MPG : TDC : ROLL CAGE BED, DT 11-03-2002

01. PRODUCT :

Roll cage beds for push bench as per the following diagram

- a) Roll cage bed East-1 as per drg no 2-7-1127-05-00958 rev 05-1 NO
- b) Roll cage bed West-1 as per drg no 2-7-1127-05-00959 rev 04-1 NO
- c) Roll cage bed East-1 as per drg no 2-7-1127-05-00960 rev 03-2 NO
- d) Roll cage bed West-1 as per drg no 2-7-1127-05-00961 rev 03-2 NO
- e) Roll cage bed East-1 as per drg no 2-7-1127-05-00962 rev 03-1 NO
- f) Roll cage bed West-1 as per drg no 2-7-1127-05-00963 rev 03-1 NO
- g) Guide plate East-1 as per the drg no 3-7-1127-05-03125 rev 03-1 NO
- h) Guide plate West-1 as per the drg no 3-7-1127-05-03126 rev 03-1 NO
- i) Guide plate East-11,111as per the drg no 3-7-1127-05-03125 rev 03-2NO
- j) Guide plate West-11,111as per the drgno 3-7-1127-05-03126 rev 03-2NO
- k) Guide plate East-IV as per the drg no 3-7-1127-05-03125 rev 03-1 NO
- l) Guide plate West-IV as per the drg no 3-7-1127-05-03126 rev 02-1 NO

02. APPLICATION:

These roll cage beds are assembled in push bench where the roller die cages are fixed in various location in the groove- slots. These die cages slots has to withstand the starting pushing load of 180 metric tons and they reduced to 80 metric tons of load during pushing. The cages are inserted in the grooved with sliding fit for easy replacement and the machining shall be done as per the instruction given in the drawings.

03. material:

All the above parts shall be manufactured from rolled plates or from forged plates as per IS: 8500 grade Fe 570 B. Raw material defects like lamination in case of rolled plates and defects like internal cracks or internal fissures in case of forgings should be avoided. Steel used shall be killed as per IS: 961.