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0109/K

Rail Coach Factory, Kapurthala

HD3513:

Dated. 9-6-98

Sub: Specification for Welding Wire conduit assembly.  
M.D.T.S. 054 Rev. "nil"

Ref: .....

Please find enclosed herewith a copy of the specs. no. M.D.T.S. 054 Revn./Amendment no. nil

You are requested to:

- (a) Confirm the applicability of this Specs./Revn.
- (b) Cut in-point for revised/updated specs.
- (c) Carry corrections in the Master List with effect from dated:

CQM, CPLE, CWE (Shell), CWE (FW)  
 Dy CME (Dev), Dy CME/D, SME (FW), SME (Shell)  
 SME/BD, ADE (Dev.)  
 ✓ SSE/REC.  
 SSE/LIB  
 Encl: As above.

*(Signature)*  
 (Gantosh Sinha)  
 Dy. CME/TOT

Copy for kind information.

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 CDE  
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SSE/Specs. *(Signature)*



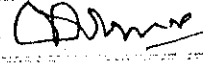
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MDTS 054 REV "NIL"

DATED 03-6-98

SCHEDULE OF TECHNICAL REQUIREMENTS FOR SPECIFICATION FOR  
WELDING WIRE CONDUIT ASSLY

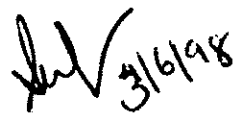
NAME	DESIGNATION	SIGNATURE	DATE	LEVEL
Mr. G.S. KAPLI	SSE / SPECN		03-6-98	PREPARED
Mr. SANTOSH SINHA	Dy. CME / TOT		3/6/98	AGREED
Mr. A. KHARE	CDE		9-6-98	APPROVED


ISSUE/REV	DETAILS OF CHANGES	DATE

  
PREPARED BY

  
3/6/98  
AGREED BY

Prepared this MDTS specification  
Based on the documents received from COM. originals  
Placed at sl.No. 963 file no. MD35131.

Dy. CME / TOT   
3/6/98

  
03-6-98

SPECIFICATION FOR WELDING WIRE  
CONDUIT ASSEMBLY

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DATE 03-6-98

Metallurgical and chemical properties of wire conduit assembly shall meet the following requirements.

S No	Item	Specified Property
1.	Bush	Chemical composition Copper = 56.5 to 60.0% Lead = 0.6 to 2.0%
2.	Spiral	Chemical composition as per IS4454 (Pt. I) 1981, Grade I Helix test as per test method given below.
3.	Sleeve	a) Material - PVC b) It shall be fire-retardant. Test method - Sleeve is to be taken out from spiral. It is to be put on luminous flame for 20 seconds and then removed; fire should extinguish itself in 20 seconds.

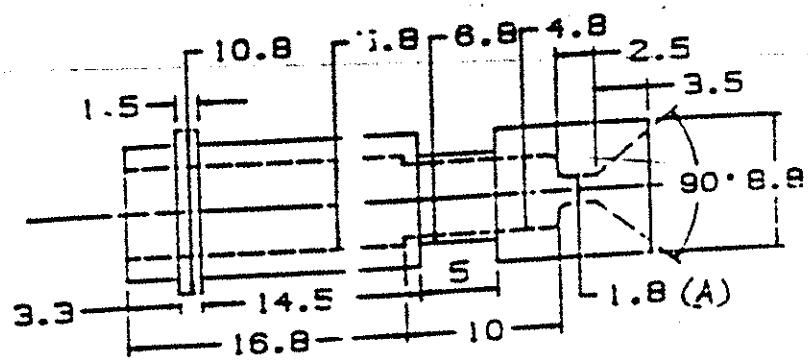
Test method for helix test for wire conduit

The sample of spiral alongwith sleeve shall be wound around a cylindrical steel mandrel of dia 100mm( $\pm$ 2mm) and shall be kept for 24 hours at 27 deg. C and 65% relative humidity. The spring shall be removed and is to be visually examined for any defect on PVC like crack etc. and on spring like permanent set, bending, cracking etc.

*MP*  
PREPARED BY

*Ant* 3/6/98  
AGREED BY

SPECIFICATION FOR WELDING WIRE  
CONDUIT ASSEMBLY



NOTE - ① FOR 1.2 M.M. WIRE CONDUIT; A =  $\phi$  1.8 MM  
 ② FOR 08 MM WIRE CONDUIT; A =  $\phi$  1.4 MM

NOTE :-

1. ALL DIMENSIONS IN mm.
2. SAMPLE TO BE APPROVED FROM DY.CEE/MTC BEFORE BULK MANUFACTURE
3. MATERIAL LEADED BRASS AS PER ISI: IS 6812/95

①

*[Signature]*

SCALE 2:1

WIRE CONDUIT		
(1.2 mm, LENGTH 4.5 M FOR WELDING TORCH)		
RAIL COACH FACTORY KAPURTHALA		
ELECTRICAL MTC.	DRN	PAGE-1
	DATE	PAGE-2
	DRG NO.	WS/MTC/02.1

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