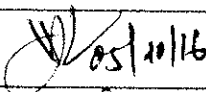
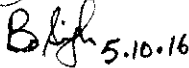
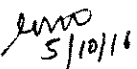
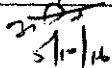


Schedule of Infrastructure Requirements For manufacturing and Testing of Spring Dome for FIAT Bogie		
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Schedule of Infrastructure Requirements for manufacturing and Testing of Spring Dome for FIAT Bogie

Name	Designation	Signature	Date	Level
Naib Singh Mehta	SSE/BD	 05/10/16	05.10.16	Prepared
Balwant Singh	SME/BD	 5.10.16	05.10.16	Agreed
Lalit Kishore	Dy CME/D-1	 5/10/16	05.10.16	Reviewed
A. K. Kathpal	CDE	 5/10/16	05.10.16	Approved


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Schedule of Infrastructure Requirements		
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1. General:

This specification defines the schedule of requirement of infrastructure for manufacturing and testing of Spring Dome for FIAT bogie.

2. Eligibility Criteria:

2.1. The tenderer must submit clause-wise comments on the specification. In absence of above, offers shall be deemed as incomplete and may not be considered.

2.2. The manufacturer should have following in-house infrastructure facilities for manufacture and inspection of spring dome for FIAT bogies:

- 2.2.1. High definition CNC plasma or Laser profile cutting machine.
- 2.2.2. Oxy-acetylene profile cutting machine with capacity of 35mm.
- 2.2.3. Machining centre.
- 2.2.4. Roll bending machine of suitable capacity for accurate bending of Spring Dome Web.
- 2.2.5. Shot/Sand blasting facilities.
- 2.2.6. Primer / Painting facility.
- 2.2.7. Minimum two MAG welding sets (400A or more).
- 2.2.8. Levelled surface plate of size 700mmX700mm (Minimum).
- 2.2.9. Certified welder for precision & heavy fabrication from accredited labs/ RDSO.
- 2.2.10. Vernier caliper of size 700mm.
- 2.2.11. Micrometer of size 150mm.
- 2.2.12. Vernier Depth Gauge of size 350mm.
- 2.2.13. Vernier Height Gauge of size 400mm.

2.3. The manufacturer shall have in-house or tie-up arrangement for following tests with NABL certified labs:

- 2.3.1. The firm shall be ready for carrying out chemical and mechanical test of spring dome, from NABL certified Lab at their own expense as and when required.

2.4. The manufacturer shall be an ISO-9001-2000 certified company.


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3. Raw material:

- 3.1. Chemical and Mechanical properties of steel plates, to be used, shall conform to specification mentioned in the drawings.
- 3.2. All records of physical, chemical and impact tests shall be kept and made available to Inspecting Agency, if required. All plates to be taken up for manufacture shall be visually checked for surface defects such as cracks, dents, pitting, bend, rust, scales etc. and they shall be free from all these defects.

4. Edge preparation:

- 4.1. Edge preparation of Spring Dome Web shall conform to drawings.
- 4.2. Weld joint dimensions shall be as per the relevant drawing/IS specification.

5. Fixtures and Manipulators:

The manufacturer shall prepare fixtures for assembly of Spring Dome web and Spring Dome plate before start of manufacture of Spring Dome.


6. Welding requirements:

- 6.1. **Shielding gas:** MAG welding process using mixture of 82% Argon & 18%CO2 gas shielding media shall be used for fabrication of Spring Dome.
- 6.2. **Filler metal:** Filler material should be used as per spec: EN440-G3Si1.
- 6.3. **Welder qualifications:** Qualified welder as per EN-287-1 shall be employed for fabrication work as per FIAT's welding procedure specification 22.026 part document 100 03.
- 6.4. The edge preparation shall be in accordance with their drawing.

7. Shot Blasting:

Spring Dome should be shot blasted for cleaning of rust, scales, spatters etc. before painting of Spring Dome.


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8. Primer / Painting:

Immediately after shot blasting, the Spring Dome should be coated with primer as per RCF specification no. MDTS-166 Rev 02 or latest.

9. Identification Marking:

Each Spring Dome shall be punched with manufacturer's identification mark, serial number and date of manufacture to facilitate identification/correlation with the inspection/ test results.

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