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RUBBER FABRIC PLATES SPECIFICATIONS

TY 105 1044-76



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The present specifications pertains to rubber fabric plates which has got working capacity in all climatic areas, at an ambient air temperature from minus 55°C to plus 50°C, resistance to the influence of oils, fuels and solvents in case of their falling on plates.

Example of designation of rubber fabric plates as per present specification:

PTn TY 1051044-76.

1. TECHNICAL REQUIREMENTS

Plates should comply with the requirements of the present specifications and be manufactured as per technological schedule, approved in the established order.

1.1.0. Basic dimensions.

1.1.1. Plates should be manufactured final cut with a length at least 20 m and width $500 \div 1400$ mm. Limit deviation on width should be ± 20 mm.

Concrete width of plates is specified during order.

1.1.2. Thickness of plates should be (10.0 ± 1.5) mm.

1.1.3. Non parallel edges of plates should be within the limits of tolerance on width of plates.

1.2.0. Characteristics.

1.2.1. Plates should consist of fabric core of layer cut design and a double side rubber facing.

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Table 1 contd.

(1)	(2)
Shore hardness A	60-70
Temperature limit of brittleness, °C, not more than	minus 55

1.2.6. Plates should have working efficiency at a temperature down to minus 55°C in case of falling of oil and fuel.

1.2.7. The surface of plate should be smooth without folds, cracks, spills. Other inclusions of dimensions more than 5 mm and cavities (drops) having dimension upto 5 mm in a quantity not more than 4 pieces per 10 m² surface are not allowed.

The traces of face, imprints from the ends of press plate, traces of repairing the defective places and waviness of plate frame having a total area 0.5 m² per 10 m² surface, spots, differing in colour from general surface, similarly, traces from ~~fields~~^{foldes} of external layings, without influencing total thickness of plate, are allowed on the plate surface.

1.2.8. One of the layings may be shifted on one side along the edge of plate at sections having length not more than 1.5 m and a total length, not excee-

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ding 10% from the length of plate.

1.3.0. Marking.

1.3.1. The plates should have sharp marking in the form of the engraving impression. Marking should be at the ends and in the centre of plate.

1.3.2. The marking should contain: Nomenclature on trade mark of manufacturing plant, date of manufacture (year) and designation of the plate.

1.3.3. Fabric tag should be glued at the end of each plate indicating:

a. Nomenclature or trademark of manufacturing plant;

b. Date of manufacture (year, month)

c. Designation of plate;

d. Q.I.D. Stamp.

1.4.0. Packing.

Rubber fabric plates should be folded up in roll and tied up at a few plates with a fabric tape.

2. ACCEPTANCE RULES

2.1.0. Plates are supplied in batches. Plates in a quantity not exceeding 20 pcs., accompanied by one document on quality (certificate drawn up as per appendix 1) are considered to be in a batch.

2.2.0. For checking the compliance of plates with the requirements of the present specifications, QID

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of manufacturing plant carries out their tests, specified in Table 2.

Table 2.

Description of the parameter.	Para no. & section		Number of plates, checked from a batch.
	TR	Test procedure.	
Dimensions:			
Thickness	1.1.2	3.2	100%
Width	1.1.1	3.2	100%
Length	1.1.1	3.2	100%
External view	1.2.7	3.3	100%
Rupture strength	1.2.3	3.4	Two plates.

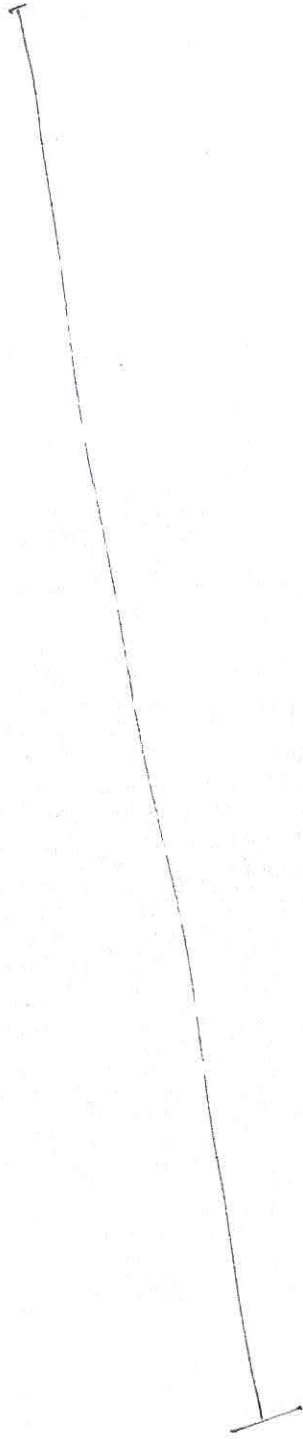
2.3. Plates, having passed tests as per para 2.2; are subjected to tests as per parameters in a quantity specified in Table 3.

Table 3.

Description of parameters	Para no. & section		Number of plates being checked, periodicity of tests.
	Tech. reqmts.	Test procedure.	
Bending strength	1.2.4	3.5	2 plates from each batch.
Physical mechanical parameters of rubber			2 once in a month.

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Development of cracks on rubber facing of plates is not considered to be a defect, affecting the serviceability of plates.



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Name of the Manufacturing Plant.

C E R T I F I C A T E

Specifications.

1. General information about plates.

- Rubber fabric plates
- Designation of plates
- Quantity
- Batch no.
- Date of manufacture.

2. Basic Technical data

Length, m.

Thickness, mm.

width, mm.

Plates are serviceable at an ambient temperature $+55^{\circ}\text{C}$ to $+50^{\circ}\text{C}$.

Rupture strength of plates, N/mm (kgf/cm).....

Bonding strength between layings, N/mm (kgf/cm)

.....

Bonding strength between core and facing, N/mm

(kgf/cm).....

3. Acceptance Certificate.

Rubber fabric plates batch no.....complies with specificationsand fit for use.

QID Representative

Date of manufacture.

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LIST OF STANDARD TECHNICAL DOCUMENTS, REFERRED TO IN
TY 1051044-76.

1. "Technical rubber articles for regions with tropical climate. General technical requirements EC3KC" GOST 15152-69.
2. "Indicator Thickness measuring gauges with division value 0.01 and 0.1 mm. Specifications" GOST 11358-74.
3. "Metal measuring ^{rules} reels. Specifications". GOST 7502-80.
4. "Metal measuring rules. "Specifications" GOST 427-75.
5. "Rubber and rubberized fabric. Method of determining the bonding strength between layers during lamination "GOST 6768-75.
6. "Rubber Method of determining the elastic strength properties during extension" GOST 270-75.
7. "Rubber Method of determining the rupture strength" GOST 262-79.
8. "Rubber. Test procedure for resistance to thermic age EC3KC GOST 9.024-74.
9. "Rubber method of determining the hardness with WOP-A GOST 263-75.
10. "Rubber Method of determining the temperature limit of fragility" GOST 7912-74.

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