

## VENDOR QUALIFICATION CRITERIA

Sl. No.	Nomenclature & drawing No.	Manufacturing Technology & Testing / Inspection facilities required to produce the item		Essential (To be possessed by the vendor in his premises) (P & M list and Testing / Inspection Equipment list to be submitted)	Desirable (May be possessed by the vendor in his premises or out sourced) ( Self declaration to be submitted)	Firm Compliance (Y/N)
	<b>7066118260</b> <b>ROLLER</b> <b>TY: 37 006.075-</b> <b>75</b> <b>(DIV18X26AP)</b>	TECHNOLOGY-1	Forging Process		Suitable Cold/ heading heading machines	
		TECHNOLOGY-2	Flash removal		Suitable Deflashing machine	
		TECHNOLOGY-3	Heat treatment		Heat treatment plant.	
		TECHNOLOGY-4	Roller grinding		Suitable Double Disc roller grinding machine Accuracy 0.005mm	
		TECHNOLOGY-5	Roller lapping		Suitable Double Disc roller lapping machine	
		TECHNOLOGY-6	Demagnetisation		Demagnetising Machine	
		INSPECTION-1	Test-1	1.Roundness Tester 2.Crack Detection Machine	1.Hardness Tester.	
		INSPECTION-2	Testing		NABL 1.Spectroscopy 2. Hardness Test 3. Macro & micro structure analysis.	
		INSPECTION-3	Surface finish		1. Surface Finish Tester	



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295

TY

MASTER COPY

ROLLING ELEMENT BEARINGS SHORT CYLINDRICAL ROLLERS

SPECIFICATIONS

TY 37.006.075-76

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TRD 85-122

Batch no. 12

Extract from TY 37.006.075-76

ROLLING-CONTACT BEARINGS, SHORT CYLINDRICAL ROLLERS

Specifications

The given specifications concern short cylindrical rollers having a straight line and <sup>a</sup>convex (*barrel-shaped*) generatrix, the length ( $l_p$ ) of <sup>roller</sup> which does not exceed 2.5 times the diameter ( $d_p$ ); they are used in rolling-contact <sup>element</sup> bearings and also as individual components of machines and devices.

Example of the designation of rollers supplied as individual components is given in section 5.

1. TECHNICAL REQUIREMENTS

1.1 The rollers must conform to the requirements of given specifications and those of the approved drawings.

1.4 The extreme <sup>deviation</sup> departure of the dimensions of rollers supplied as individual components from nominal dimensions (diameter and length) must correspond to the data indicated below:

for group E.

- <sup>between min and max</sup> range of roller diameters .. upto 50 mm,
- <sup>deviations</sup> extreme departure in diameter .. + 0.16 mm  
- 0.04 mm
- <sup>deviation</sup> extreme departure in length .. - 0.050 mm

1.5 Extreme <sup>deviations</sup> departure in the shape of rollers must not exceed: <sup>non-</sup> constancy of diameter and taper ... 1  $\mu$ m <sup>as per lobing</sup> of the face (while measuring in a prism of an angle of 60°).. 3  $\mu$ m

1.6 Difference in the dimensions of rollers (diameter and length) in one sorted group must not exceed the values given below:

<sup>for</sup>  
 - diameter .. 3  $\mu\text{m}$   
<sup>face</sup>  
 - length .. 8  $\mu\text{m}$

1.15 Numerical values of roughness <sup>of</sup> the generatrix of cylindrical surface and faces of rollers must correspond to the values:

for II and III degrees of accuracy

- <sup>for</sup> rolling surfaces of rollers ... 0.32  $\mu\text{m}$ , maximum
- <sup>for</sup> faces ... 0.63  $\mu\text{m}$ , maximum

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