

295

TY

MASTER COPY

ROLLING ELEMENT BEARINGS SHORT CYLINDRICAL ROLLERS

SPECIFICATIONS

TY 37.006.075-76

18

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295 T4

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 ^aconvex (*barrel-shaped*) generatrix, the length (l_p) of ^{roller} which does not exceed 2.5 times the diameter (d_p); they are used in rolling-contact ^{element} 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 ^{deviation} 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.

- ^{between min and max} range of roller diameters .. upto 50 mm,
- ^{deviations} extreme departure in diameter .. + 0.16 mm
- 0.04 mm
- ^{deviation} extreme departure in length .. - 0.050 mm

1.5 Extreme ^{deviations} departure in the shape of rollers must not exceed: ^{non-}constancy of diameter and taper ... 1 μ m
^{in as per} of the face (while measuring in a prism of an angle of 60°).. 3 μ m

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

^{for}
 - diameter .. 3 μm
^{face}
 - length .. 8 μm

1.15 Numerical values of roughness ^{of} the generatrix of cylindrical surface and faces of rollers must correspond to the values:

for II and III degrees of accuracy

- ^{for} rolling surfaces of rollers ... 0.32 μm , maximum
- ^{for} faces ... 0.63 μm , maximum

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FORMAT FOR THE METHOD OF MANUFACTURE/ INFRASTRUCTURE AVAILABLE

Nomenclature & Drawing No: _____

1	2	3	4	5	6	Remarks
<p>MANUFACTURING TECHNOLOGY&TESTING/ INSPECTION FACILITIES REQUIRED TO PRODUCE THE ITEM</p>	<p>POSSESSED BY THE VENDOR IN HIS OWN PREMISES –(P&M LIST &TESTING/INSPECTION EQUIPMENT LIST TO BE SUBMITTED)</p>	<p>PROVIDE DETAILS OF THE FACILITIES ASKED IN COLUMN (3)THAT ARE AVAILABLE IN-HOUSE (SELE-DECLARED P&M LIST (Nomenclature of machine, make/model, capacity/size & accuracy, date of installation, vintage of machine /year of manufacturing of machine)AND TESTING/INSPECTION EQUIPMENT,LIST (Nomenclature of the testing/inspection equipment make/model, size & range, Date of calibration)also to be submitted)</p>	<p>IF NOT POSSESSED BY THE VENDOR IN HIS OWN PREMISES IT MAY BE OUT SOURCED.(MOU/TIE-UP WITH THE OUTSOURCING VENDOR/SUB-VENDOR AND THEIR P&M LIST &TESTING/INSPECTIN EQUIPMENT LIST TO BE SUBMITTED)</p>	<p>PROVIDE DETAILS OF THE FACILITIES ASKED IN COLUMN (5)OUT-SOURCED FIRMS(NAME &ADDRESS OF THE OUTSOURCING VENDOR TO BE DECLARED BY THE FIRM IN FIRM'S LETTERHEAD, SELF-DECLARED P&M LIST (Nomenclature of machine, make/model, capacity/size& accuracy, date of installation, vintage of machine /year of manufacturing of machine)AND TESTING/INSPECTION EQUIPMENT,LIST (Nomenclature of the testing/inspection equipment make/model, size& range, date of calibration)AND MOU/TIE-UP ALSO TO BE SUBMITTED)</p>		
Technology 1						
Technology 2						
Technology 3						

Test/ inspection1						
Test/ Inspection2						
Test/ Inspection3						

*The above details furnished by the vendor is to be self-certified for technical evaluation

*Inspection of item will be carried out at par with QAP, which is attached along with TE

SIGNATURE OF AUTHORIZED PERSON WITH SEAL

