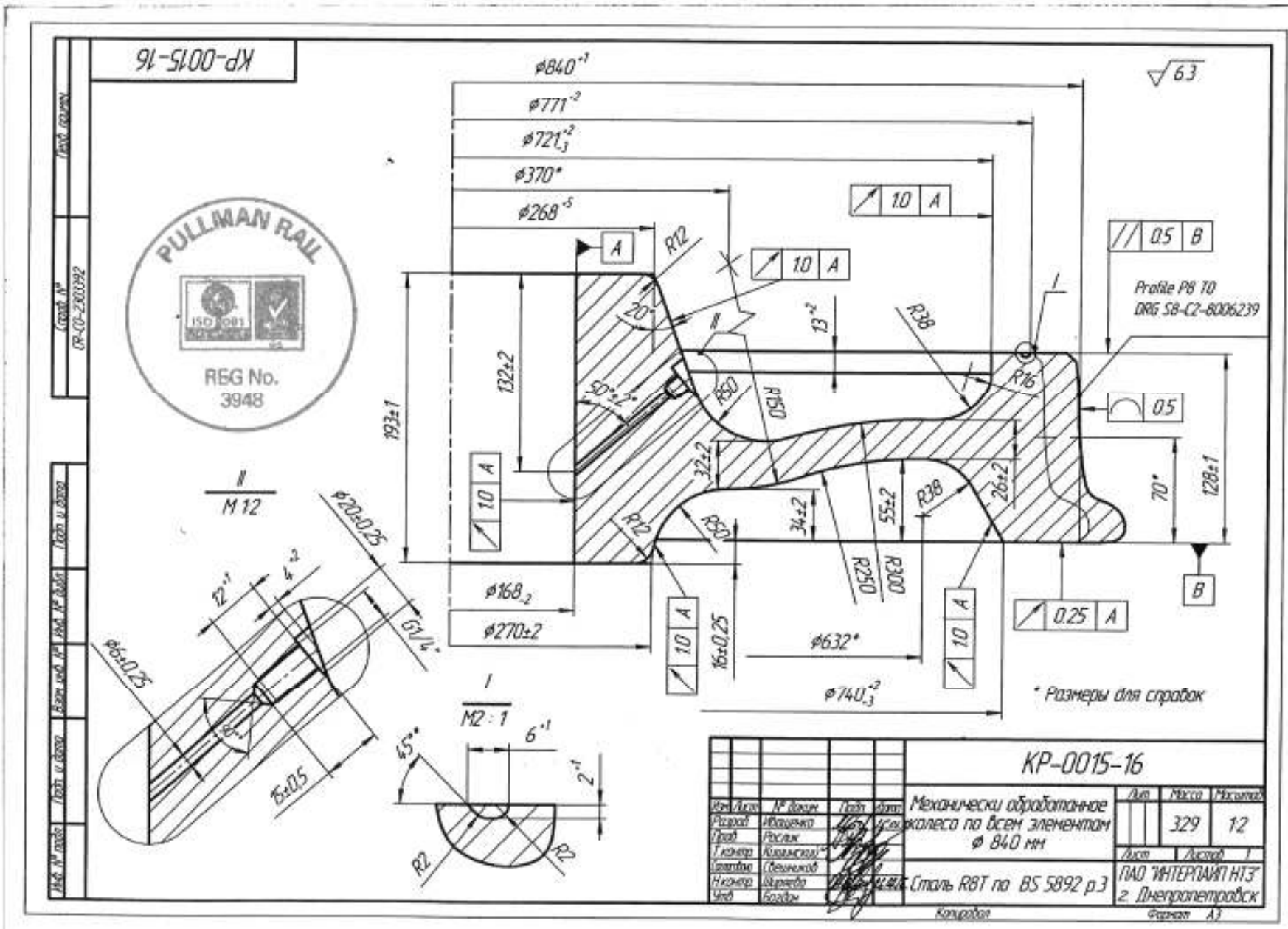
КР-0015-16
√63
ø840 -1
ø771 -3
ø721 -2 -3
ø370*
ø268 -5
A
R12
10 A
// 0.5 B
Profile P8 T0
DRG S8-C2-8006239
I
20°
13 -2
R38
132±2
193±1
40°±2°
R50
R16
0.5
32±2
R38
26±2
70°
128±1
34±2
55±2
R12
R30
R250
R300
B
ø168 -2
ø270±2
16±0.25
ø632*
ø740 -3
0.25 A
* Размеры для справок
II
M12
ø20±0.25
12 -1
4 -2
G1 1/4"
ø6±0.25
15±0.5
I
M2 : 1
45°
6 -1
2 -1
R2
R2
КР-0015-16
Механически обработанное колесо по всем элементам ø 840 мм
Сталь R8T по BS 5892 p.3
Лит
Масса
329
Масштаб
12
Лист
Листов 1
ПАО "ИНТЕРПАЙП НТЗ" г. Днепропетровск
Копировал
Формат А3
PULLMAN RAIL
ISO 9001
REG No. 3948

Technical Specification No. 97-24-2016, copy No.___
for Delivery of Machined Wheels for Great Britain

Description		Machined wheels **ø 840 mm.**
Standard		**BS 5892: Part 3** (actual revision). **GM/RT 2466, Edition 3 dated 2010**
Method of steelmaking		Electric-furnace melting with vacuum degassing and continuous steel casting
Hydrogen content		2 ppm at the most
Steel grade		**R8T**
Drawing		**No. KP-0015-16** (*last revision)* (*ref. No. CR-CC-2303392, revision A*)
Mechanical properties		As per standard **BS 5892: Part 3.**
1	**Tensile strength**	**860 – 980 N/mm²** (rim), **820 N/mm² max** (web)
2.	**Elongation**	**13 % min** (rim) **16 % min** (web)
3.	**Fracture energy (U-shaped notch)**	The average value of the three test pieces is **15 J min**, the individual value for each of the three test pieces should be as per **BS 5892: Part 3**
4	**Surface hardness distribution on the wheels**	Hundred-per-cent of the wheel rims in each batch. Range of the hardness values should be **255-285 HB.**
5	**Rim section hardness**	Control of the rim section hardness is carried out as per p. **8.3.6.2 BS 5892: Part 3** in the points specified at **fig.8** in particular at the depth of 5 mm and 35 mm from the wheel tread surface. The acceptable range of the hardness values should be **255-285 HB.**
Residual stresses		**as per BS 5892: Part 3.**
Ultrasonic inspection		**Hundred-per-cent** of the wheel rims axially and radially, the artificial flaw **Ø 2 mm.**
Macrostructure		The deep etching method according to **ISO 4969**: the availability of any flakes, delaminations, folded and countersunk sinterskins, nonmetallic inclusions, residual shrink holes and other failures of metal integrity is unpermitted.
Microstructure		The coarseness of grain should not exceed the 6-th number as per **ISO 643.** The inspection should be carried out on the samples subjected to a tensile test.
Surface quality		The superficial defects at visual control are forbidden.
Repeated tests		As per **p.10.10 BS 5892: Part 3**
Repeated heat treatment		A single supplementary heat treatment and two supplementary tempers at the most.
Residual unbalance		**Not more than 75 gm.**
Appearance and dimensions		As per **BS 5892: Part 3** and drawing No. **KP-0015-16.**
Marking		The marking is branded on a rim end face from the inside of a wheel in cold state with the marking signs being **between 6 and 10 mm** high and **at the least 0.2 mm** deep. The distance from an outside hub diameter up to the base of marking signs should make up **10 ± 2 mm.** It is unpermitted to use sharp-edged stamps. The marking should be legible and easy-to-read relative to the wheel center.
Marking order		As per **fig. B.6. GM/RT 2466** 1. Steel grade: 8**T** 2. Brand of manufacturing plant: **KLW** 3. The last two figures of the year of manufacturing 4. Heat number (*5 signs*) and serial number of a wheel in the heat (*3 signs*) 5. Place for the Inspector's stamp or QC department's stamp of the manufacturing plant 6. Simbol UT (*ultrasonic inspection*)
Supplementary marking		The position of a residual imbalance is marked from the inside of a wheel rim with radial strip paint (approximately 15 mm width). The designation of imbalance E2 should be indicated below the end of a strip. Outer diameter with accuracy to two decimal places (point) is stenciled with paint on wheel-rolling circle.

Coating and packing	As per **GM/GN 2498** (*actual revision*) The wheels are delivered in metal cassettes by 4 in each. The cassette has to have the underframe with 1100×1100 mm size. The wheels are delivered with temporary conservation coating **E-Tek 510** characterized by a film-forming inhibited composition. The coating is applied on all of the wheel components except for a hub hole. The wheels are conveyed by covered motor trucks being stored in places protected from weathering. The duration of wheel conservation period shall correspond to the time of delivery.
Warranty	The Manufacturer warrants that the wheels will comply with the requirements of this Technical Specification subject to keeping to the conditions of operation, storage, conveyance and assembly. The Quality Warranty Period is **60 months** since the day of bringing into service of the transport vehicles on which the Goods are being operated but **72 months** since the date of delivery **at the most**. The guarantee does not cover to a temporary conservation coating.