

NO. M/EL/20 /TS -1

PARTICULARS FOR FIBRE GLASS-(SL-42) MOULDING
(To Drg. Nos. 05/1/50/440 ALT-7 PL 23929017 and
05/1/50/441 ALT-6/PL NO. 23928505 and
ELW.BSL/WAM4/3/74.004 ALT-1/PL NO. 23928517).

Filler & Pigments: The resins used shall not contain fillers (except as required for viscosity control or fine retardance)

Inner Surface: The inner surface shall be free of cracks and crazing with a smooth finish and with an average of not over 2 pits per 929cm^2 providing the pits are less than 3 mm in diameter and not over 0.8 mm deep and are covered with sufficient resin to avoid exposure of inner surface fabric between 0.25 mm and 0.50 mm of reinforced resin-rich surface shall be provided. This surface is to be reinforced with glass surfacing mat.

Interior Layer: A minimum of 2.54 mm of the laminate next to the inner surface shall be reinforced with not less than 20 percent nor more than 30 percent by weight of noncontinuous glass strands having fibre length from 10.7 mm to 50.8 mm.

Exterior Layer: The exterior layer or body of the laminate shall be suitable for the service and providing the additional strength necessary to meet the tensile and flexural requirements where separate layers such as mat, cloth or woven roving are used, all layers shall be lapped a minimum of 25.4 mm. Laps shall be staggered as much as possible. If woven roving or cloth is used a layer of chapped strand glass shall be placed as alternative layers. The exterior surface shall be relatively smooth with no exposed fibres or sharp projections. Hand work finish is acceptable but enough resin shall be present to prevent fibre show.

Cut Edges: All cut edges shall be coated with resin so that no glass fibres are exposed.

Wall Thickness: The minimum wall thickness shall of 3mm (1/8 inches).

Tensile Strength: The ultimate tensile strength of 3mm thick reinforced polyester laminate at 73.4°F (23°C) should be minimum 633 kg/cm^2 and flexural strength should be minimum 1125 kg/cm^2 .

Sd/-
S/ELDO(M)
12.6.87

<p>PARTICULAR SPECIFICATION FOR FIBRE GLASS MOULDING FOR SL HOOD</p>	<p>Sd/- (12/06/1981) Dy. CEE (D)</p>	<p>CHITTARANJAN LOCOMOTIVE WORKS, WEST BENGAL, INDIA</p> <p>No. M/EL/20/TS-1 Date :- 12/06/1981.</p>
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