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Indian Standard

SPECIFICATION FOR TAMPERS AND RAMMERS FOR USE IN FOUNDRIES

- 1. Scope Covers requirements for tampers, rammers and shoes for pneumatic rammers for use in foundries.
- 2. Application Tampers and rammers are used for preparing mould and cones.
- 3. Dimensions Dimensions and weights of the tools shall be as specified in Tables 1 to 5.
- 4. Material
- 4.1 Handle
 - a) All tools except in Table 5 Mild steel or cast iron with threaded ends.
 - b) For tools in Table 5 Any seasoned hard wood.
- 4.2 Tamper and Rammer Heads Mild steel.
- 4.3 Combined Tamper and Rammer Mild steel.
- 4.4 Shoe for Rubber Tipped Pneumatic Rammer Mild steel.
- 4.5 V-Shoe and Disc Shoe Grey cast iron Grade 15, IS:210-1962 'Specification for grey iron castings (revised)'.
- 4.6 Rubber Tip of Pneumatic Rammer As required by the purchaser.
- 5. Tolerances Coarse class in IS:2102-1969 'Allowable deviations for dimensions without specified tolerances (first revision)'.
- 6. Coating Steel and iron components shall be coated with protective paint. Wooden components shall be coated with suitable varnish.
- 7. Marking Mark with the following:
 - a) Designation, and
 - b) Name or trade-mark of the manufacturer.
- 7.1 ISI Certification Marking Details available with the Indian Standards Institution, New Delhi 1.
- 8. Packing The tools shall be packed in wooden boxes weighing not more than 50 kg overall.
- 9. Supply As specified in IS: 1387-1967 'General requirements for the supply of metallurgical materials (first revision)'.
- 10. Fitting
- 10.1 The handles of tools in Tables 1, 2 and 3 shall be welded to the heads. Alternatively handles in Tables 1, 2 and 3 may be fixed by screwing in the rammer heads.
- 10.2 For tools in Table 5, the handle shall be secured to the head by countersunk screws conforming to M 4 of IS: 1365-1968 'Slotted countersunk head and slotted raised countersunk head screws (dia range 1.6 to 20 mm) (second revision)' in the black condition.
- 10.3 Any other screws used for other tools shall have the same nominal size as mentioned in the drawing. They shall conform to 15: 1365-1968 in the black condition.

Adopted 29 October 1971

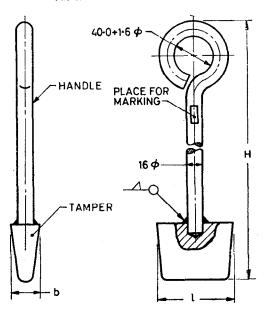
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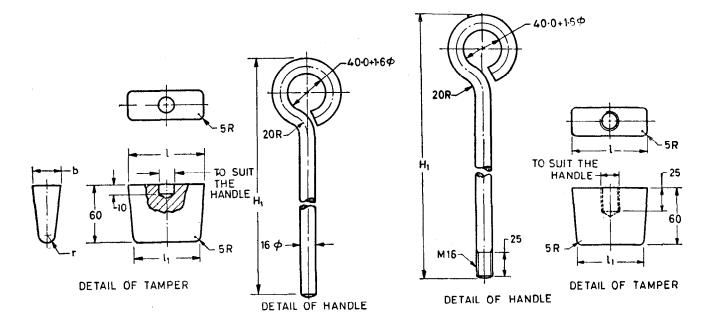
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TABLE I DIMENSIONS AND APPROXIMATE WEIGHTS OF HAND TAMPERS

(Clauses 3 and 10.1)

All dimensions in millimetres.





Designation of a hand tamper of height! 250 mm: Hand Tamper I 250 IS: 6482

Designation of a tamper of length \times breadth = 80 \times 30: Tamper 80 \times 30 IS; 6482

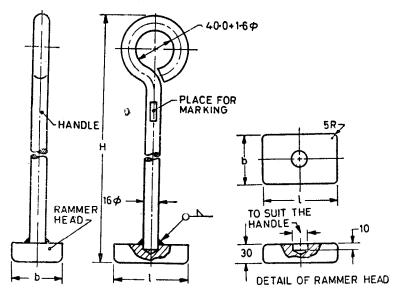
Designation of handle of length I 200 mm: Handle I 200 IS: 6482

Н	ı	Ь	I ₃	r	H ₁	Length of Handle When Straightened Out	Weight of Tamper, kg	Weight of Handle, kg	Weight Head, kg
1 250	80	30	70	8	I 200	I 345	3.0	2·10	0.9
I 600	100	40	90	10	I 550	I 675	4.0	2.65	1.35

Note - Handle may also be screwed into the tamper instead of welding.

TABLE 2 DIMENSIONS AND APPROXIMATE WEIGHTS OF RECTANGULAR HAND RAMMERS (Clauses 3 and 10.1)

All dimensions in millimetres.



Designation of rectangular hand rammer of height I 220 mm and length \times breadth — 100 \times 60: Rectangular Rammer I 250 IS: 6482 Designation of rammer head of length \times breadth = 100 \times 60: Rammer 100 \times 60 IS: 6482

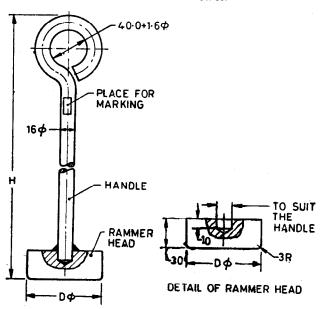
Н	1	ь	Weight of Rammer,	Weight of Head,
I 220 I 370	100 120	60 80	kg 3·5 4·86	kg 1·38 2·2

Note 1 — For detail of handle, see Table 1.

Note 2 — Handle may also be screwed into the rammer head.

TABLE 3 DIMENSIONS AND WEIGHTS FOR ROUND HAND RAMMER (Clauses 3 and 10.1)

All dimensions in millimetres.



Designation of a round hand rammer of height 1 220 mm: Round Rammer 1 220 IS: 6482

Designation of a round rammer head of diameter 80 mm:

Н	D	Weight of Rammer,	Weight of Hand,
! 220 ! 570	80	kg 3 27 4 46	kg • 7 •8

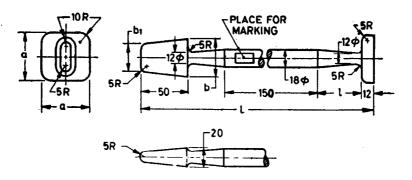
Note ! — For detail of handle, see Table 1.

Note 2 — Handle may also be screwed into the rammer head.

TABLE 4 DIMENSIONS AND WEIGHTS FOR COMBINED TAMPER AND RAMMER

(Clause 3)

All dimensions in millimetres.



Designation of a combined tamper and rammer of length — 300 mm, rammer area 50 \times 50 : Tamper Rammer 300 IS:6482

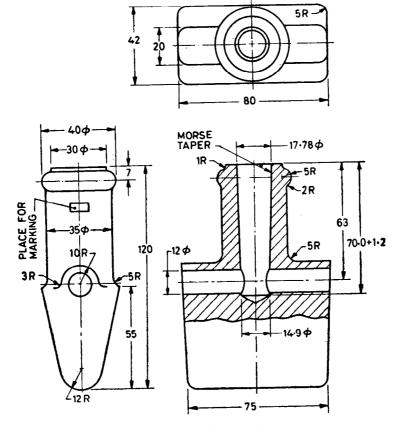
L	a	ь .	b 1	1	Weight of the Tool,
300 360	50 80	40 60	30 50	60 110	kg 0·80 1·32

TABLE 5 DIFFERENT TYPES OF SHOES FOR PNEUMATIC RAMMERS

(Clauses 3, 4.1 and 10.1)

All dimensions in millimetres.

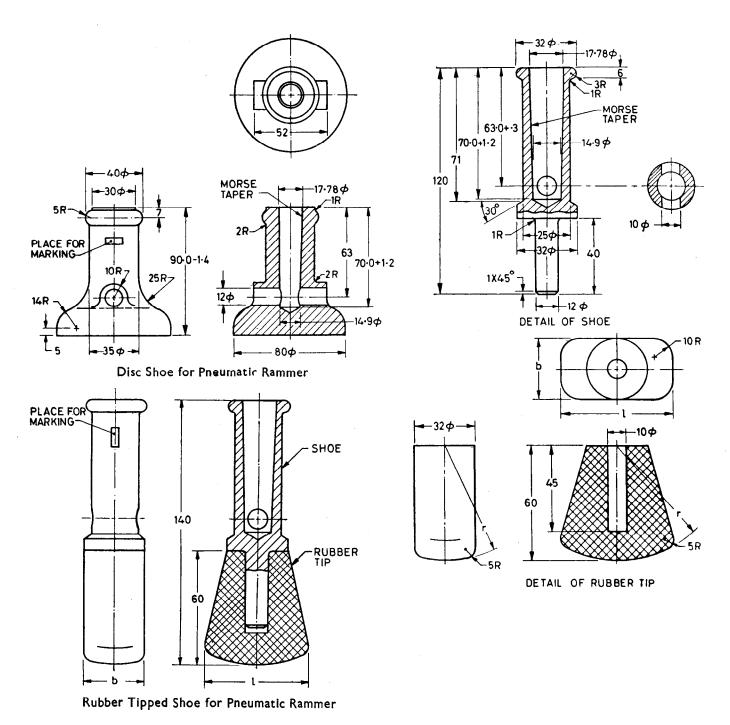
For dimensions see the respective figures.



V-Shoe for Pneumatic Rammer Weight 1:4 kg

(Continued)

TABLE 5 DIFFERENT TYPES OF SHOES FOR PNEUMATIC RAMMERS - Contd



Designation of rubber tip of area at the bottom = 60×32 : Rubber Tip — 60×32 IS: 6482

1	ь	r	Weight,
60	32	60	0.07
80	40	80	0.12
100	60	100	0.22