

SCAN

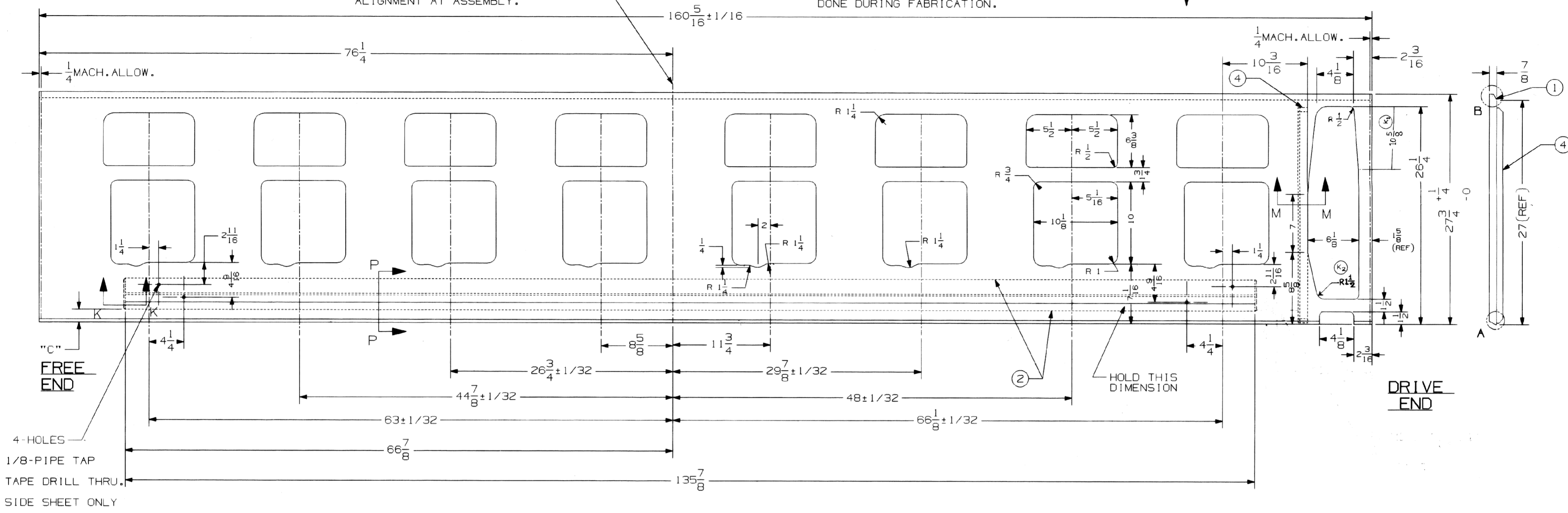
ALT. NO.	ALTERATION	VERIFIED BY SSE/D	INITIAL
(F)	DRAWING REDRAWN		
(G)	a) PRESSURE 60-80 PSI TO BE RETAINED FOR 1/2 hr. MIN. AT ELEVATED TEMP 60°C WAS 35-40 PSI. b) GMAW WELDS WAS T3 TYPE REE CDE IENG I6 CYL I2 CYL / 2002/001 Dt. 06/01/2002		
(H)	ADDED GAP 'D' BETWEEN TWO ANGLES AND WELDING REVISED.		
(J)	MISC-119 WAS 15:2062 G-B. REF: E.A. No. 146-M 65-117, 01-23-11-04		
(K)	IDIM. 10 5/8 ADDED. 2. DIM. R 1 1/2 ADDED.		
(L)	1. DIM. 1 1/2 AND 1 1/4 DELETED. 2. 1-HOLE 1 3/8 DIA. DRILL THRU DELETED. REF: C-18 NO CDE IENG I6 CYL I2 CYL / 2013/02 DT. 02.02.13		

PRICK PUNCH THIS LINE FOR A DISTANCE OF APPROX. 1 FROM EACH EDGE ON BOTH SIDES FOR ALIGNMENT AT ASSEMBLY.

NOTE: THIS EDGE PREPARATION TO BE DONE DURING FABRICATION.

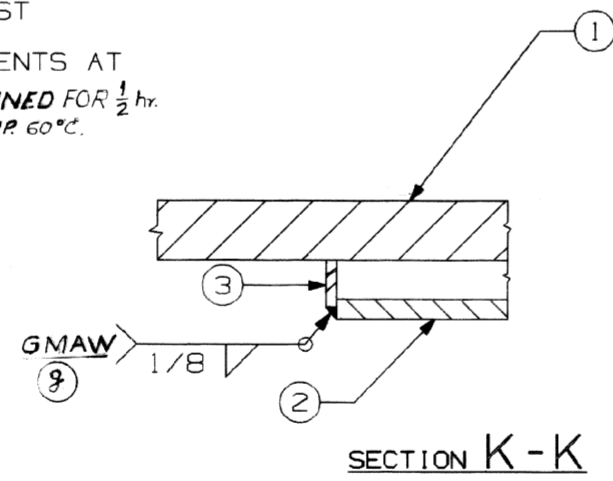
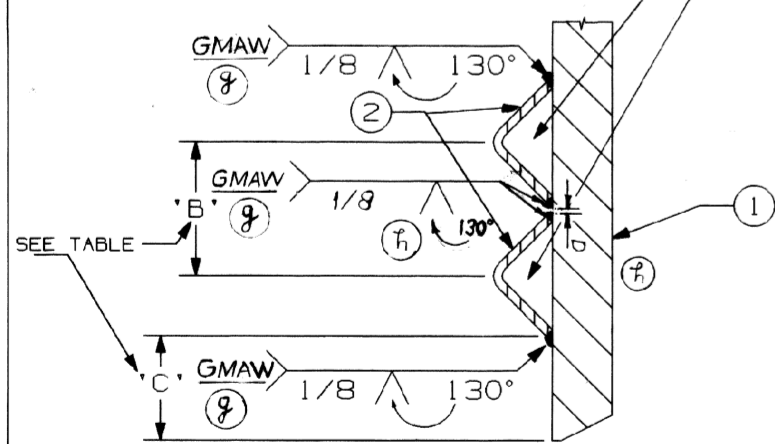
PERMISSIBLE ALTERNATE FULL SIZE DETAIL.

DETAIL 'B'



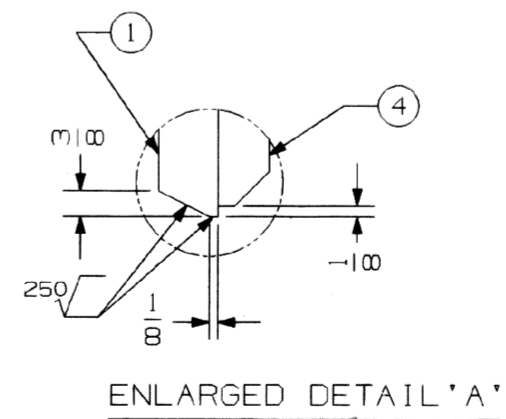
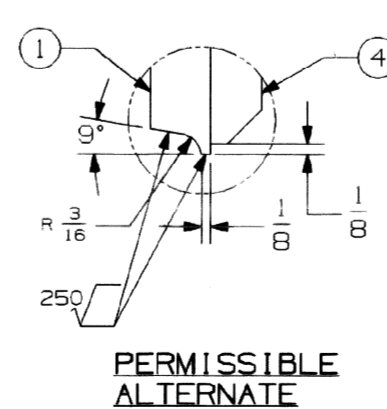
NOTE: HYDROSTATIC TEST THESE COMPARTMENTS AT 60-80 PSI TO BE RETAINED FOR 1/2 hr. MIN. AT ELEVATED TEMP 60°C.

NOTE: -
1. 1000√ ALL CUT SURFACES UNLESS OTHERWISE NOTED.
2. DIMENSION SHOWN DO NOT INCLUDE ALLOWANCE FOR CUTTING OR WELDING SHRINKAGE.
3. SHOT BLAST ITEM 2 BEFORE WELDING.



TABLE

ANGLE USED	"B"	"C"	"D" (GAP)
1/4 x 1/4 x 1/8	1 31/32	1 0/8	13/64
35mm x 35mm x 5mm	2 1/4	1 1/8	19/64



ALL DIMS. ARE IN INCHES OTHERWISE NOTED.
IF TOLERANCES NOT STATED FRACTIONAL MACHINING DIMENSIONS ALLOW ± 0.010.
DO NOT SCALE THE PRINT.
ISSUING AUTHORITY: SSE/RECORDS

THIS DRAWING IS A PROPERTY OF OIL/INDIAN RAILWAYS AND ANY UNAUTHORISED USE OF THE DRAWING WILL BE CONSIDERED ILLIGAL AND OIL/INDIAN RAILWAYS WILL HAVE RIGHT TO INITIATE LEGAL PROCEEDINGS AGAINST THE DEFAULTERS.

APPROVED BY	SME/D	10020019
		ASSLY. PART NO.

NO. OFF	DESCRIPTION & DIMENSION	ITEM	PART NO.	DRAWING No.	MATERIAL	SPECIFICATION
	WELD STRIP	4	10191203	31071286-1	STL. PL.	
	END SEAL	3	10190120	31071555-1	STL. PL.	
	ANGLE 1 1/2 x 1 1/2 x 1 3/8 Lg.	2	11151432			IS:226 Gr B
	SIDE PLATE	1	10191239	31871557-1	STL. PL.	MISC-119

GROUP: WELDED CYLINDER BLOCK

SUPERSEDED BY

SUPERSEDES: ALT. 'e'

SCALE

VERIFIED BY SSE/D

PROJECTION

CHD.

DRN.

ALT. (F) (G) (H) (J)

PART NO. 10020032

DRG. NO: 31B71557

16 CYL. VEE ENGINE

DIESEL LOCOMOTIVE WORKS VARANASI

U6-SOL 10