



ALT. NO.	ALTERATION	INITIAL
MD	REVISED & REDRAWN. ADDED TOLERANCES TABLE AND JIG LOCATION SURFACES DIM. 1 1/8 REF. ANGLE DIM. 1 1/8 WAS 1/8 (DCN 1/88/80)	30/09/80
MCA	ADDED LOCATION FOR HARDNESS CHECK (NO NOTICE)	
MDB	ADDED HARDNESS 140 BHN (NO NOTICE)	25/02/79
MDC	HARDNESS 125-135 BHN WAS 140 BHN (REF. LTR. d/w.m.85.2, dt. 11.04.79)	11/04/79
MDI	HARDNESS WAS 125-135 BHN SURFACE TOL. NOTE (1) & (11) REVISED	28/10/81
MDE	MANUFACTURER IDENTIFICATION CODE REVISED	03/12/82
O	DIM. 7/8 WAS 7/8 DIM. 1/2 WAS 1/2 DIM. 1/4 WAS 1/4 (REF. COE/02/1/86, dt. 17/09/84)	17/09/84
b	(1) NOTE 11 ADDED (2) NOTE 12 ADDED	12/03/86
c	(1) DIM. R8 WAS R5/16 (2) DIM. 2" WAS 1 5/8" (3) FRONT & SIDE VIEW REVISED. (4) DIMENSIONS 1", R2, B & 2 1/4 ADDED. (5) BOTTOM VIEW ADDED. (REF. C.N.No. COE/EN/180q/120q/1/2003/01 dt. 01.01.03)	25/01/03
d	NOTE 4 REVISED (NO NOTICE)	

- NOTE:-
- DIMENSIONS AND TOLERANCES:-** (WHEREVER NOT SPECIFIED)
    - (I) DRAFT ANGLE AS NOTED IN DRG. TOLERANCE +2° -1°
    - (II) CORNER RADIUS: 1/4 ± 1/8
    - (III) FILLET RADIUS: 3/8 ± 3/16
    - (IV) THICKNESS TOLERANCE: +1/8, -1/32
    - (V) LENGTH: (SHRINKAGE & DIEWEAR) +3/16, -0
    - (VI) FLAT WITHIN: 0.003 PER INCH
    - (VII) FLASH THICKNESS: 1/2 MAX.
    - (VIII) MISMATCH: 1/16 MAX
    - (IX) ALL DIMENSIONS TAKEN TO THE POINT OF INTERSECTION, THUS:-
    - (X) THE TOLERANCES MENTIONED INDICATE THE MARGIN FOR VARIOUS DIMENSIONS, BUT CONTROL SHOULD BE EXERCISED TO ENSURE THAT THE FORGING WILL MACHINE TO FINISH DIMENSIONS MENTIONED IN THE MACHINING DRAWING.
  - JIG LOCATING SURFACES:-**  
JIG LOCATING SURFACE MARKED JLS TO BE FORGED SMOOTH, TRUE AND DIMENSIONALLY CLOSED.
  - MATERIAL SPECIFICATIONS:-**  
FULLY SILICON KILLED, FINE GRAINED, OPEN HEARTH, FORGING QUALITY STEEL EITHER TO AISI 1020 OR I.S. 2004 (98210.2 (04/2) WITH ALL OTHER CONDITIONS AS PER DLW MATERIAL STANDARD SHEET NO. DB0370.
  - PURCHASE CONDITIONS:-**  
FORGING NORMALISED TO DB0370ob, SHOT BLAST AND COATED WITH SUITABLE RUST PREVENTIVE.
  - FORGING STANDARDS:-**  
AS PER DLW STANDARD SHEET INDEX NO. F95.0010.
  - TESTS:-**  
CHEMISTRY, TENSILE, BRINELL, MICROSCOPIC, MACROSCOPIC AND MAGNIFLUX.
  - GRAIN FLOW:-**  
AS PER PART NO. 10141886.
  - SURFACE TOLERANCES:-**
    - (1) WHEREVER MACHINING IS CALLED ON THE DRG., DRESSDOUTS OR SCALE PITS SHOULD NOT EXCEED 1/2 OF THE MACHINING DIMENSIONS.
    - (2) DRESSDOUTS OR SCALE PITS ALLOWED ON SURFACE INTENDED TO USE AS FORGED MAY BE 1/3 OF THE THICKNESS TOLERANCE.
  - OTHER CONDITIONS:-**  
ALL OTHER CONDITIONS NOT SPECIALLY MENTIONED HEREIN SHALL CONFORM TO OUR DRAWINGS, AND FORGING STANDARD F.G.S. 0010.
  - HARDNESS:-**  
126-150 BHN.
  - DIMENSIONS 8 1/4 +3/16, -0, 7 11/16 +3/16, -0, & 8 1/16 +3/16, -0 TO BE CRITICALLY EXAMINED.**
  - REMOVE FLASH AND ENSURE SMOOTH RADIUS AT THE FILLET CORNER ON PARTING LINE.**

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 DLW/INDIAN RAILWAYS AND ANY UNAUTHORISED USE OF THE DRAWING WILL BE CONSIDERED ILLIGAL AND DLW/INDIAN RAILWAYS WILL HAVE RIGHT TO INITIATE LEGAL PROCEEDINGS AGAINST THE DEFAULTERS.

7/22/03	10021012
Dy.CME/D	10020019
DE/DEV.	
APPROVED BY	ASSLY. PART NO.

NO. OFF	DESCRIPTION & DIMENSION	ITEM	PART NO.	DRAWING No.	MATERIAL	SPECIFICATION
	GROUP CYLINDER BLOCK					
SUPERSEDED BY						
SUPERSEDES Alt. 'C'						
<b>SADDLE</b> (INT. MAIN BRG. FORGING DRG.)				SCALE	VERIFIED BY SSE/D	2/1/03
				PROJECTION	CHD.	2/1/03
				DRN.	2/1/03	
				ALT.	c d	
DIESEL LOCOMOTIVE WORKS VARANASI				PART NO. 10140025		
				DRG. NO: 31EE71261		