ALT. NO.	ALTERATION	INITIAL
(a)	R.E. TRACED (NO NOTICE)	
(b)	SURFACE TOL. NOTE "(b) (ii)" REVISED. HARDNESS WAS 125-155 BHN. REF. NOTE NO. dlw.m-65.2 DT.- 3-10-91	
(c)	MANUFACTURER IDENTIFICATION CODE REVISED.	

SECTION M-M

SECTION L-L

SECTION "N-N"

SECTION "K-K"

SYMMETRICAL ABOUT ℄

BLEND BOTH ENDS

'JLS' ON OPPOSITE FACE.

© LOCATE MANUFACTURER IDENTIFICATION CODE, MONTH & YEAR.

(ALSO LOCATE HEAT SYMBOL) HERE

LOCATE D.L.W. PART NO. 10140049 RAISED FIG

CHECK HARDNESS HERE

DRAFT ANGLES INDICATED THUS

SYMMETRICAL ABOUT ℄

FLATNESS TO BE CONTROLLED ON SURFACES 'A' AND 'B'.

1. DIMENSIONS AND TOLERANCES (WHEREVER NOT SPECIFIED)

(i) DRAFT ANGLES AS NOTED IN DRG. TOLERANCE $^{+2°}_{-1°}$
(ii) CORNER RADII — $\frac{1}{4} \pm \frac{1}{8}$
(iii) FILLET RADII — $\frac{1}{4} \pm \frac{1}{8}$
(iv) THICKNESS TOLERANCE — $^{+\frac{5}{32}}_{-0}$ $0 \pm \frac{3}{16}$
(v) LENGTH (SHRINKAGE & DIEWEAR) — $^{+\frac{3}{16}}_{-\frac{1}{16}}$
WIDTH (SHRINKAGE & DIEWEAR) — $^{+\frac{3}{16}}_{-\frac{1}{16}}$
(vi) FLAT WITHIN — $\frac{1}{16}$ MAX.
(vii) FLASH THICKNESS — $\frac{3}{32}$ MAX. FLASH EXTN. $\frac{3}{8}$ MAX.
(viii) MISMATCH — $\frac{1}{16}$ 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 FORGINGS WILL MACHINE TO 'FINISH DIMENSIONS' MENTIONED IN THE MACHINING PART NO. 10140037.

2. JIG LOCATING SURFACES :-
JIG LOCATING SURFACES MARKED 'JLS' TO BE FORGED SMOOTH, TRUE AND DIMENSIONALLY CLOSE.

3. MATERIAL SPECIFICATIONS :-
FULLY SILICON KILLED, FINE GRAINED, OPEN HEARTH FORGING QUALITY STEEL EITHER TO AISI C1021 OR I.S. 2004 (1962) CL 2 (GR/E) WITH ALL OTHER CONDITIONS AS PER D.L.W. MATERIAL STANDARD SHEET NO. D 80370.

4. PURCHASE CONDITIONS :-
FORGINGS NORMALISED TO D' 80370 a, b, SHOT BLAST, AND COATED WITH SUITABLE RUST PREVENTIVE.

5. FORGING STANDARDS :-
AS PER D.L.W. STANDARD-SHEET INDEX NO. FBS 0010.

6. TESTS :-
CHEMISTRY, TENSILE, BRINELL, MICROSCOPIC, MACROSCOPIC AND MAGNAFLUX.

7. GRAIN FLOW :-
AS PER PART NO. 10141686 (ONLY FLOW LINES)

(b) 8. SURFACE TOLERANCES :-
(i) WHEREVER MACHINING IS CALLED ON THE DRG. DRESSOUTS OR SCALE PITS SHOULD NOT EXCEED 1/2 OF THE MACHINING DIMENSIONS.
(ii) DRESSOUTS OR SCALE PITS ALLOWED ON SURFACES INTENDED TO USE AS FORGED MAY BE 1/4 OF THE THICKNESS TOLERANCE.

9. OTHER CONDITIONS :-
ALL OTHER CONDITIONS NOT SPECIALLY MENTIONED HERE IN SHALL CONFORM TO OUR DRAWINGS, AND FORGING STANDARD F.G.S. 0010.

10. HARDNESS :-
(b) 126-156 BHN.

NO. OFF	DESCRIPTION.	ITEM REF. PART.	SEE NOTE MATERIAL	SPECN.
	SUPERSEDED BY			
	SUPERSEDES		35-88	
1	10020469	D.E. (DEV.)	DYCME(D).	
			3-5-88	SDO.
			6-4-88	CHD.
				DRN.
			17-3-88	TRD.

16 CYL. VEE-ENGINE.

SADDLE
(CTR. MAIN BRG.)
(FORGING DRAWING)

SCALE :-

DIESEL LOCOMOTIVE WORKS
VARANASI

PART NO. 10140049

151 Kg.
ROUGH FORGING Wt.