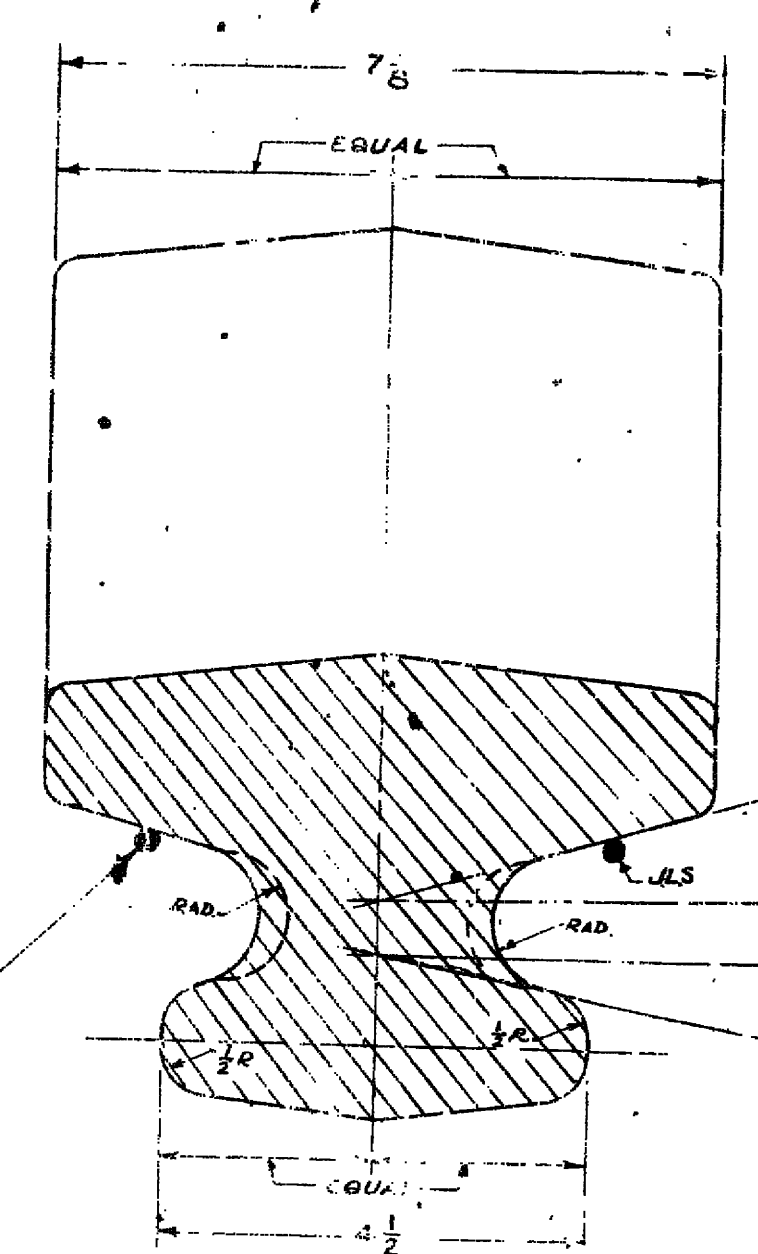
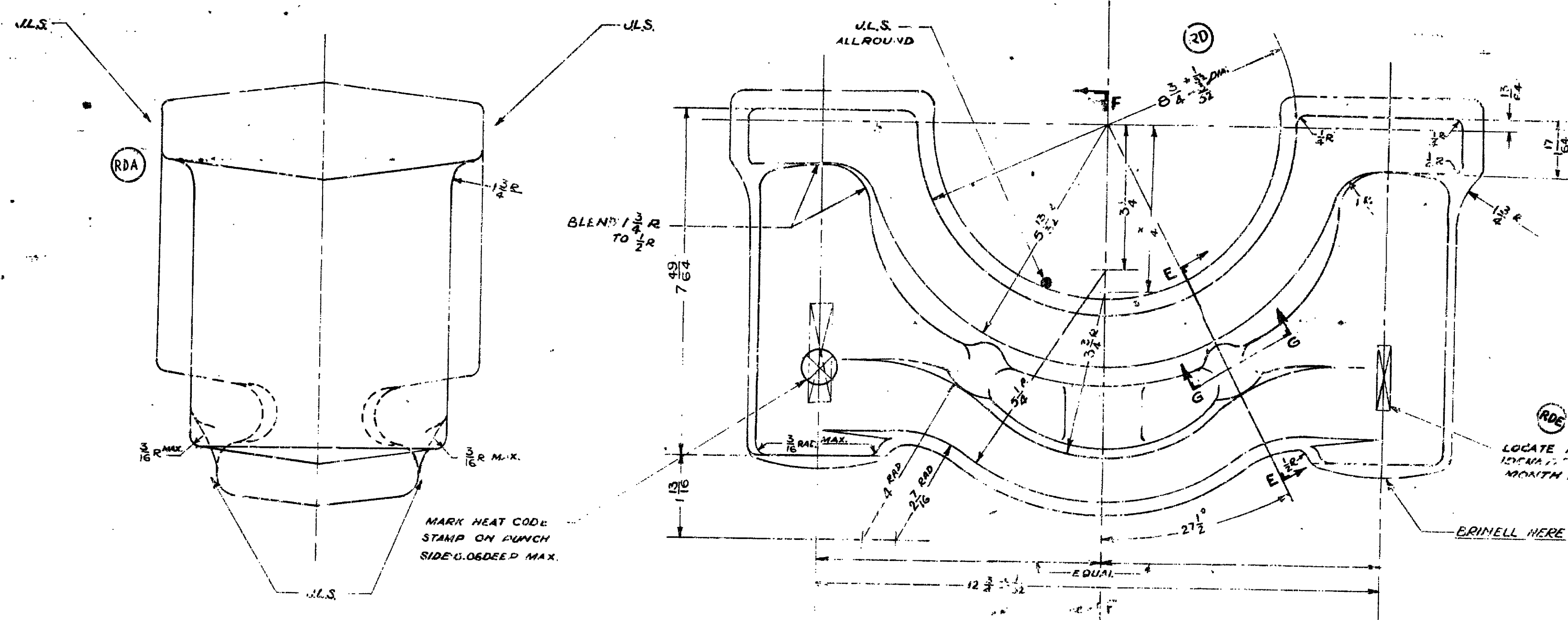
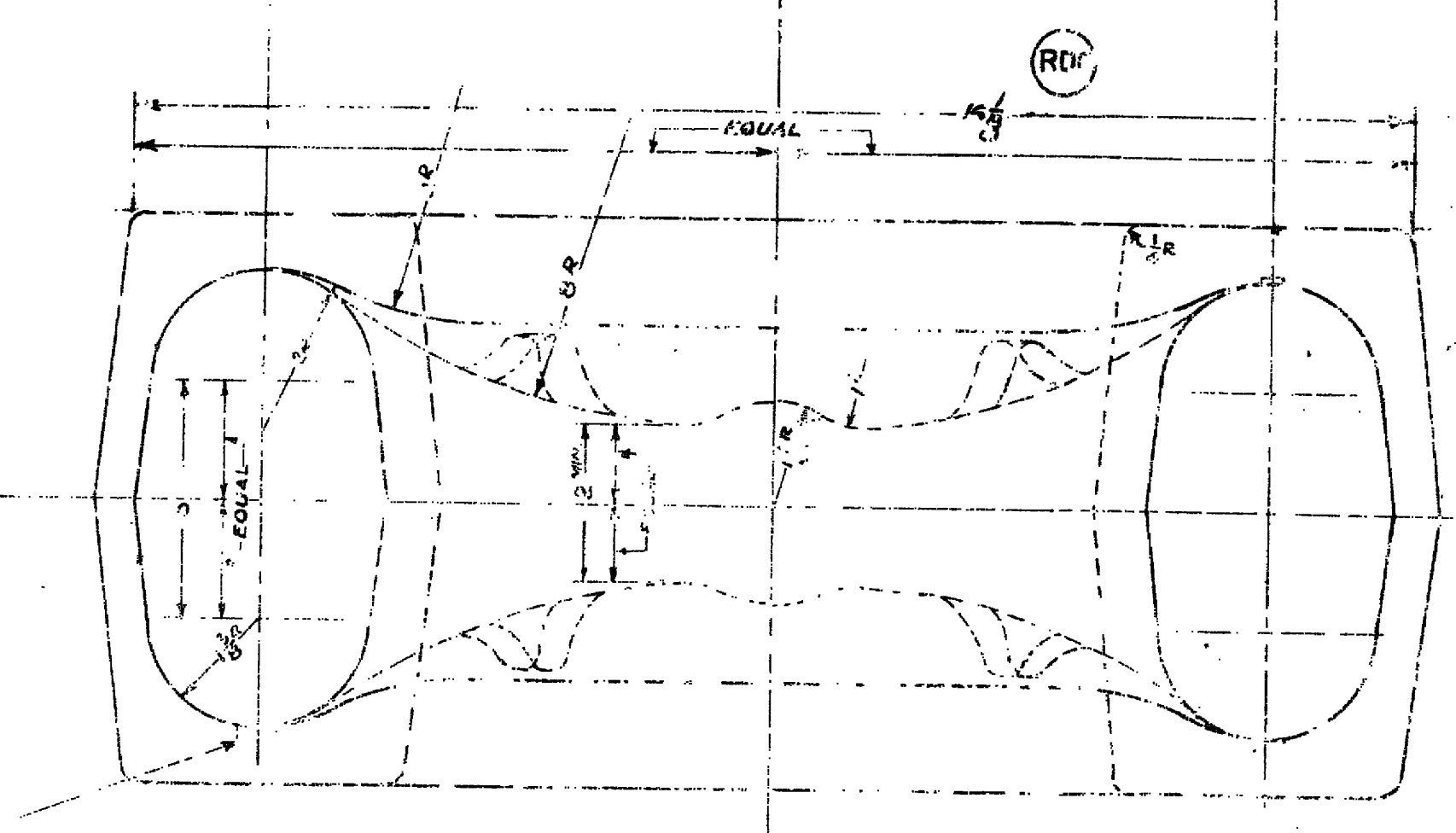


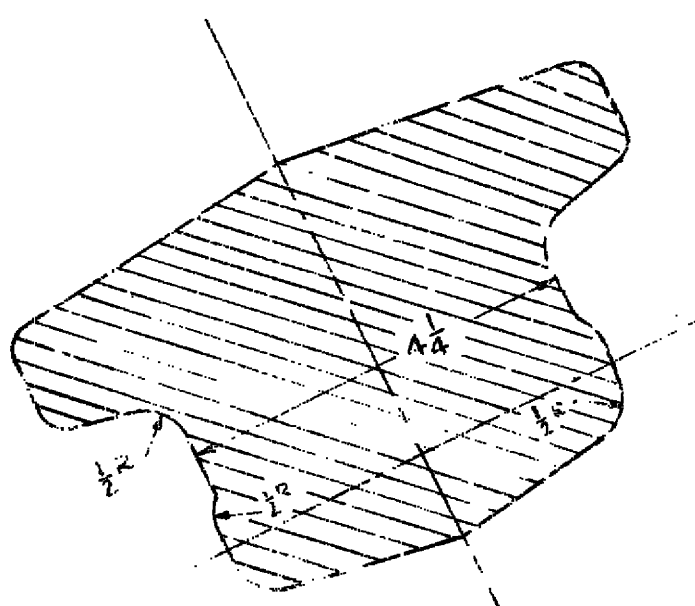
ALT.	ALTERATIONS	INITIAL
71 kg.	REVISED AND REDRAWN. ADDED TOLERANCES, NOTES AND U.L.S. ADDED TOL. FOR F. DIMENS. (D.C.N. 1/56/59)	
	CORRECTION (NO NOTICE)	
	ADDED MAGNIFLUX INSPECTION STD. 37 & 5474 (DLW/DI/94/1/E DATE 2-7-74)	
	LOCATION OF DIM 168 LG. CORRECTED D.C.N. ENG. 1/18/63/6 dt. 16.7.63.	
	SURFACE TOL. NOTE (1) & (2) REVISED. REF. NOTE NO. 444 m 65-2 dt. 3-10-61.	
	MANUFACTURER IDENTIFICATION CODE REVISED.	
	NOTE No. 3 REVISED.	
	NOTE No. 10 ADDED. REF: 1/26/ENH/100/12/01/100/1/20 dt. 3-12-67	



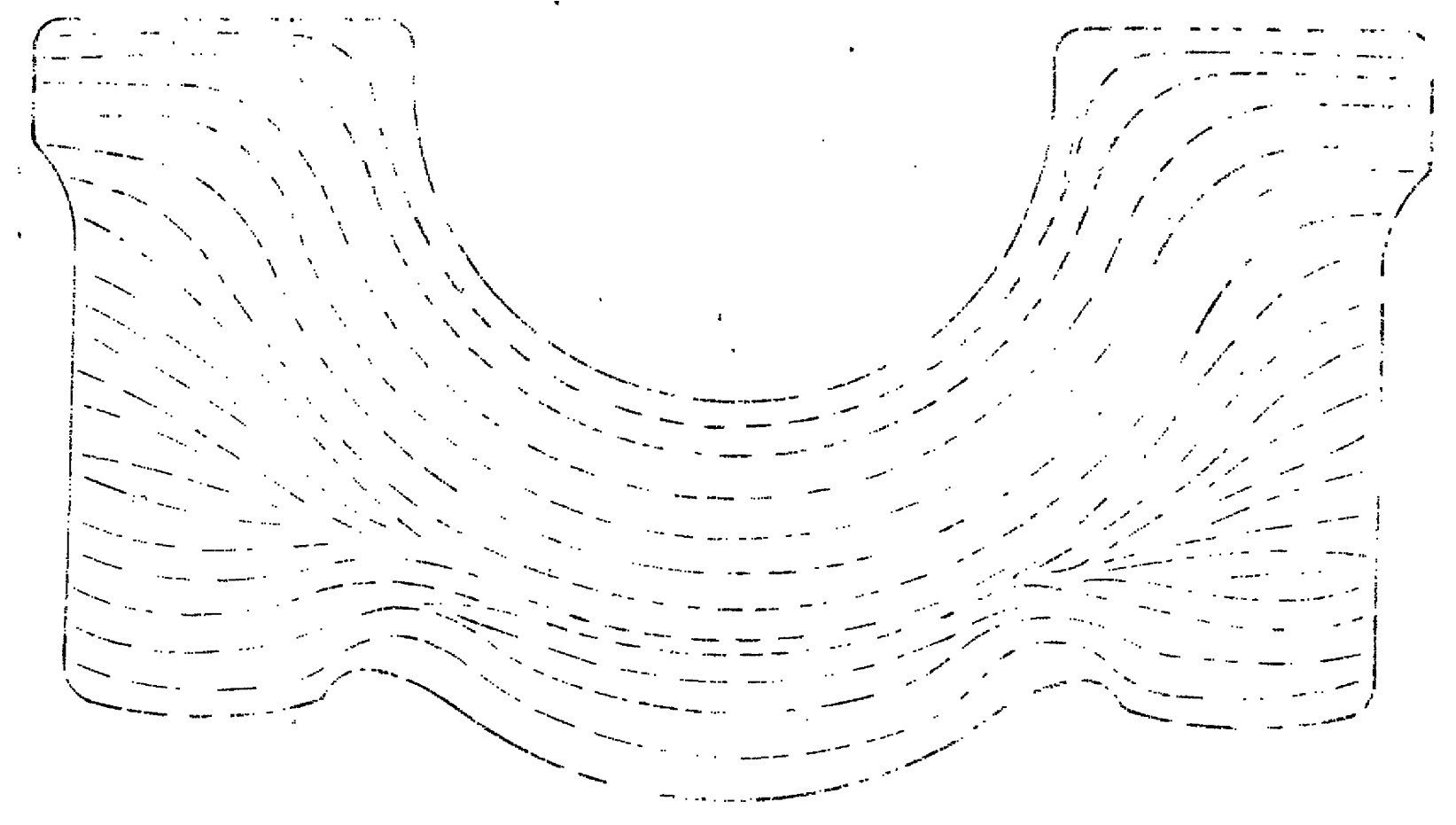
SECTION F-F



SECTION G-G



SECTION E-E



GRAIN FLOW

- DIMENSIONS AND TOLERANCES:-** (WHEREVER NOT SPECIFIED)
 - (i) DRAFT ANGLES 7° ± 0.5° WHEREVER SPECIFIED, THE SPECIFIED VALUE SHALL BE TAKEN AS MAXIMUM.
 - (ii) CORNER & FILLET RADII: 1/4 MAX. WHEREVER SPECIFIED THE SPECIFIED RADIUS SHALL BE TAKEN AS MAXIMUM.
 - (iii) THICKNESS TOLERANCE: ± 0.15
 - (iv) LENGTH: ± 0.3
 - (v) WIDTH: ± 0.3
 - (vi) SLASH EXTENSION: 2 MAX.
 - (vii) MISMATCH: 1/16 MAX.
 - (viii) FLASH THICKNESS: 1/2 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 NR 104 DIBS.

- JIG LOCATING SURFACES:-**
JIG LOCATING SURFACES MARKED 'U.L.S.' TO BE FORGED SMOOTH TRUE AND DIMENSIONALLY CLOSE.

- MATERIAL SPECIFICATIONS:-**
FULLY SILICON KILLED, FINE GRAINED OPEN HEARTH, FORGING QUALITY STEEL AS PER DLW SPECIFICATION No D81340.

- MATERIAL TREATMENT OF ROUGH FORGINGS:-**
NORMALISE, QUENCH AND TEMPER TO THE PHYSICALS FURNISHED IN THE DLW STANDARD SHEET NO. D81330 02, SHOT BLAST AND COAT WITH SUITABLE RUST PREVENTIVE.

- FORGING STANDARDS:-**
AS PER DLW STANDARD SHEET INDEX NO. 65,0010.

- TESTS:-**
CHEMISTRY, TENSILE, BRINELL, MICROSCOPIC, MAGNIFLUX AND MAGNIFLUX INSPECTION STD. 37 & 5474.

- GRAIN FLOW:-**
GRAIN FLOW AS SHOWN.

- SURFACE TOLERANCES:-**
 - (i) WHEREVER MACHINING IS CALLED ON THE DRAWING, DRESSOUTS OR SCALE PITS SHOULD NOT EXCEED 1/8 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.

- OTHER CONDITIONS:-**
ALL OTHER CONDITIONS NOT SPECIALLY MENTIONED HEREIN SHALL CONFORM TO DLW DRAWINGS AND FORGING STANDARDS F.G.S. 0010.

NOTE:-
10-MIL. GAP BETWEEN TEETH WITHOUT SERRATION AND SHALL LOCK FIT TO PART NO. 10142503.

RE-AFFIRMED
Signature and date: 17/5/74

SL. NO.	DESCRIPTION	DLW REF. DIB	MATERIAL	SPECIFICATION
1	10020469			
	MAIN BEARING CAP (CENTRE THRUST) FORGING DRG.			
	SCALE 1:1			
	DIESEL LOCOMOTIVE WORKS VARANASI			
	PART NO.			10140190
				14B-72059

ALL DIMENSIONS ARE IN INCHES.
DO NOT SCALE PRINT.