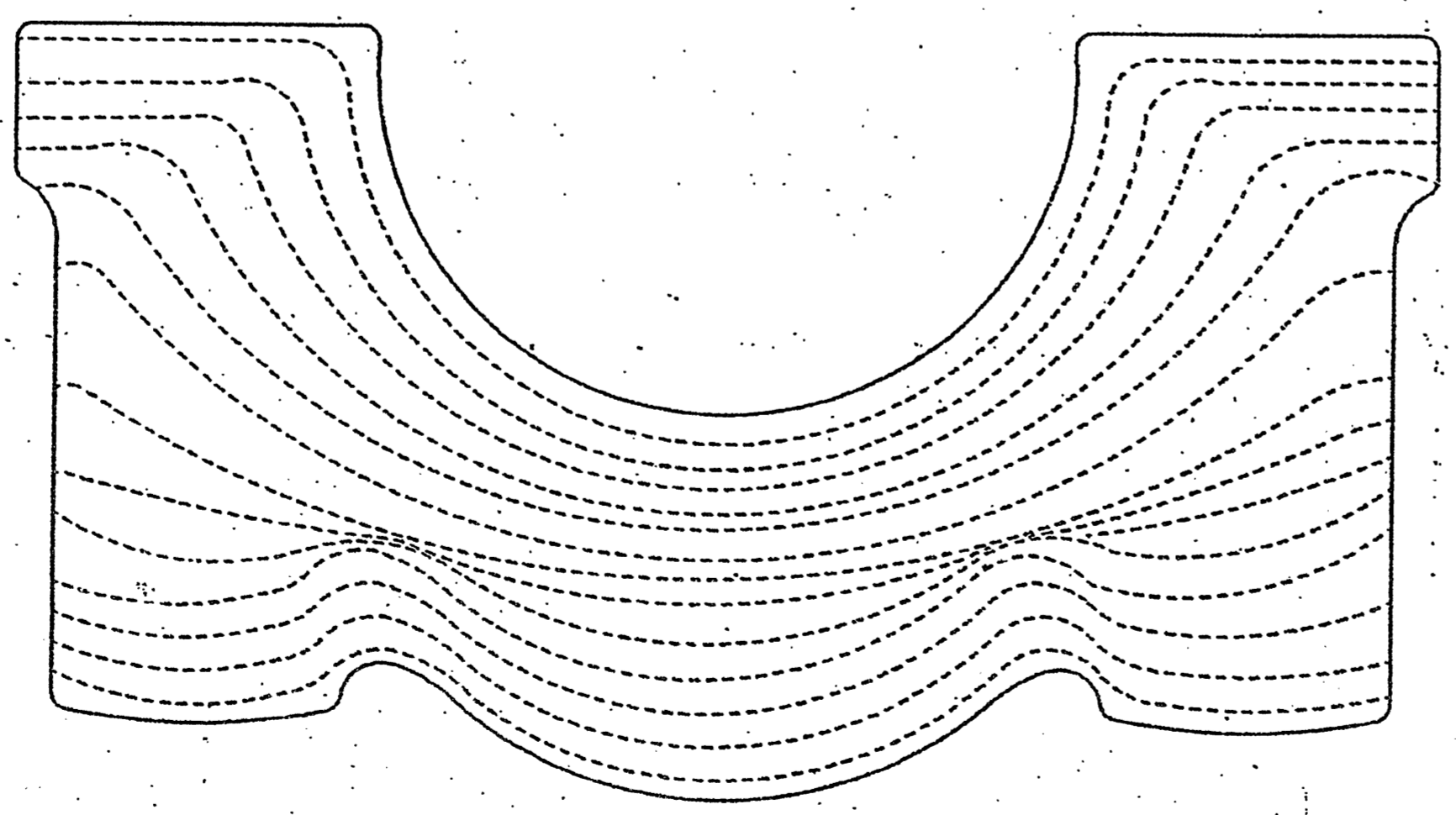
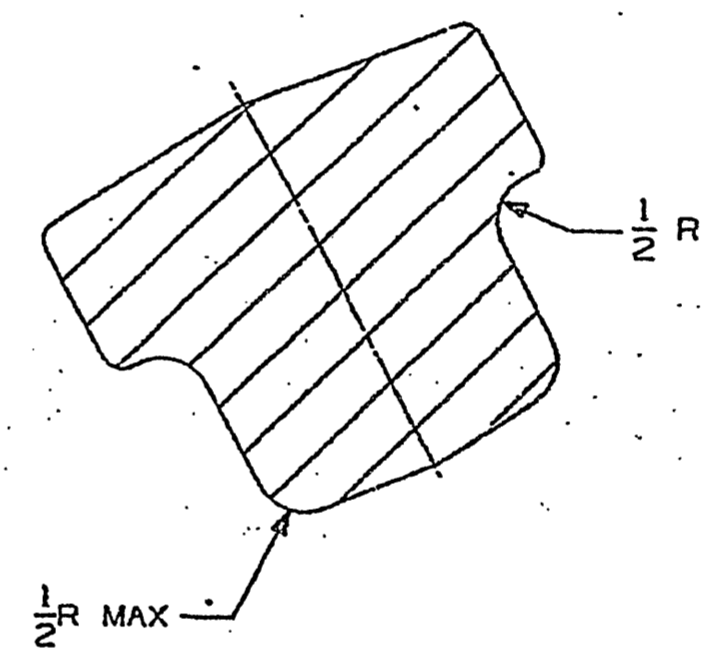
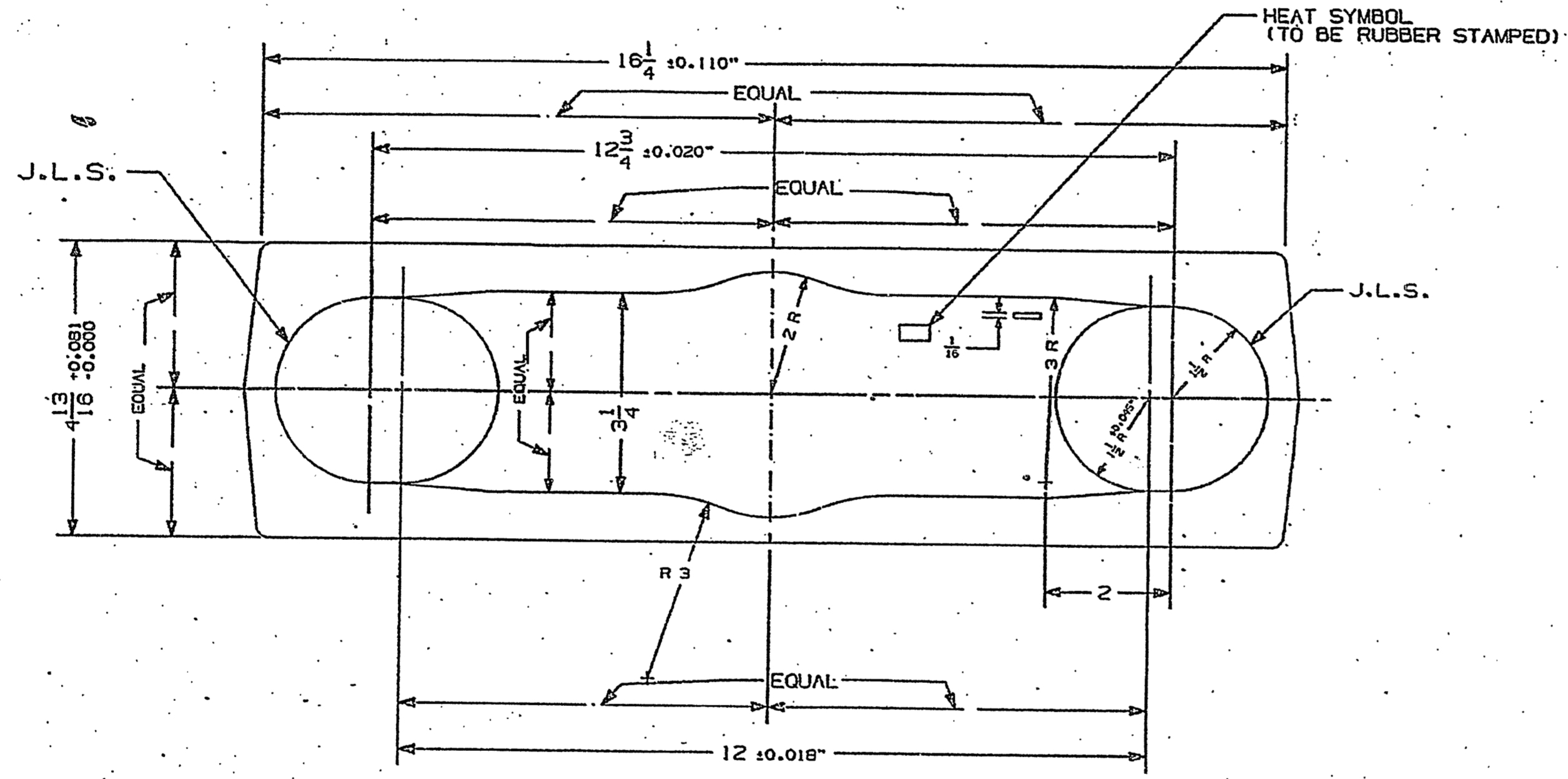
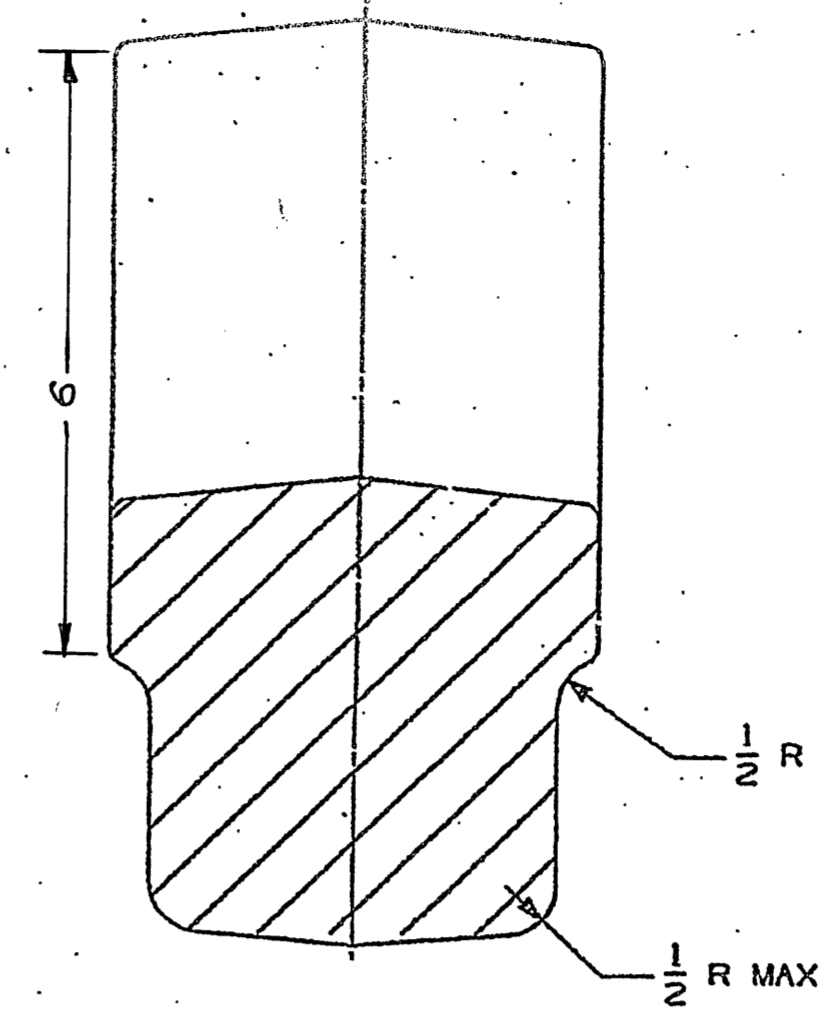
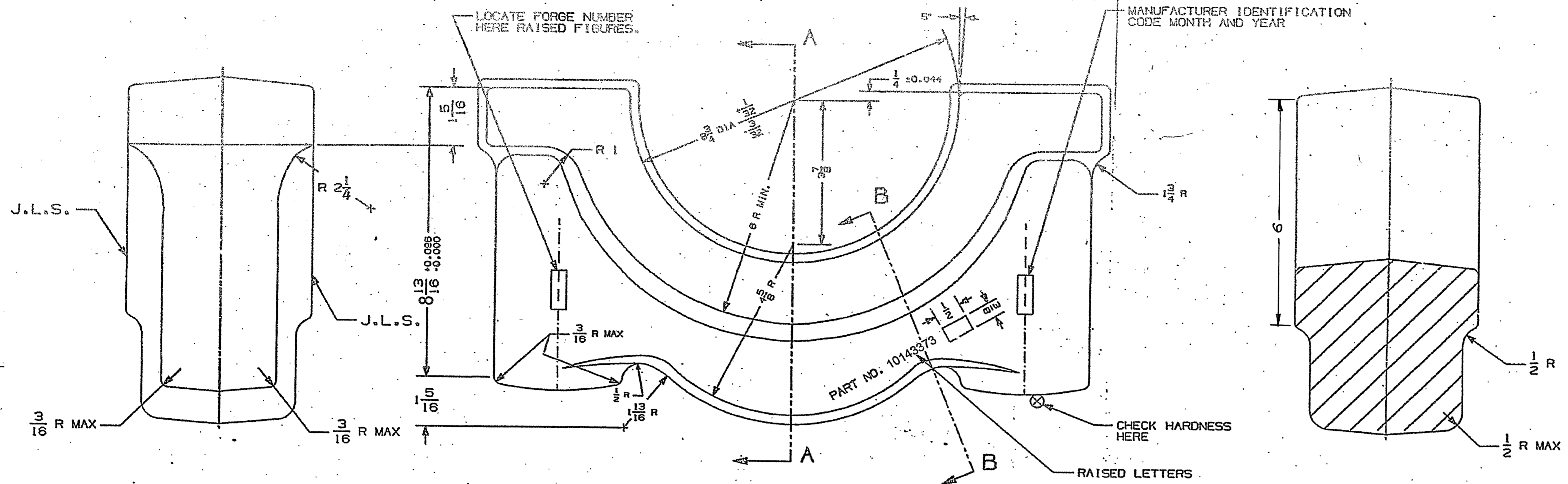


ALT. NO.	ALTERATIONS	CHD SSE	VALIDATED VMM/D	DATE
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1. DIMENSIONS AND TOLERANCES :- (WHEREVER NOT SPECIFIED)

- (i) DRAFT ANGLES : 0° TO 6° WHEREVER NOT SPECIFIED. WHEREVER SPECIFIED, THE SPECIFIED VALUE SHALL BE TAKEN AS MAXIMUM.
- (ii) CORNER & FILLET RAD : THESE SHALL BE KEPT AT A MAXIMUM OF 1/4" UNLESS OTHERWISE SPECIFIED
- (iii) THICKNESS TOLERANCE----- +0.081" -0.027"
- (iv) LENGTH AND WIDTH : SHRINKAGE-----±0.0015"/INCH. DIE WEAR :-----±0.084"
- (v) FLAT WITHIN :-----0.010"
- (vi) FLASH EXTENSION :-----1/8" MAX
- (vii) MISMATCH TOLERANCE :-----0.040"
- (viii) FLASH THICKNESS :-----3/8" TO 3/4"
- (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. 10143385.

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 AS PER DMW SPEC No. D81340.

4. MATERIAL TREATMENT OF ROUGH FORGING :-

NORMALISE QUENCH AND TEMPER TO THE PHYSICALS FURNISHED IN THE DMW STANDARD SHEET No. D81340db SHOT BLAST AND COAT WITH SUITABLE RUST PREVENTIVE.

5. FORGING STANDARDS :-

AS PER DMW STANDARD SHEET INDEX No. FG.S.0010.

6. TESTS :-

CHEMISTRY, TENSILE, BRINELL, MICROSCOPIC AND MAGNAFLUX AFTER PICKLING (MAGNAFLUX INSPECTION STD. 31P05674)

7. GRAIN FLOW :-

GRAIN FLOW AS SHOWN.

8. OTHER CONDITIONS :-

ALL OTHER CONDITIONS NOT SPECIFICALLY MENTIONED HEREIN SHALL CONFORM TO OUR DRAWINGS, 02P1800 SHEET No. F, MATERIAL STANDARDS AND FORGING STANDARDS F.G.S.0010.

9. M.B. CAP (MECH) WITHOUT SERRATION AND SHELL LOCK CUTOUT TO PART No. 10143397.

FOR MACHINING DRG. SEE PART No. - 10143385.

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED. IF TOLERANCES NOT STATED FRACTIONAL MACHINING DIMENSIONS ALLOW ± 0.010. DO NOT SCALE THE PRINT.

				STEEL FORGE, D81340	
NO. OFF	DESCRIPTION	ITEM	PART NO.	MATL & SPECN.	
		SUPERSEDES ALT. -	SCALE	VALIDATED	15 6/12 wmb
	10143385	LOCO DRG. OFFICE		SUPER CHD	14 6/12 sse
16 CYL. VEE ENGINE	MODIFIED MAIN BEARING CAP (INTER) DROP FORGING			CHD	-
				DRN.	JUN 12 JE
				DATE	DESGN INITIAL
DIESEL LOCO MODERNISATION WORKS PATIALA				ALT. NO.	
				10143373	