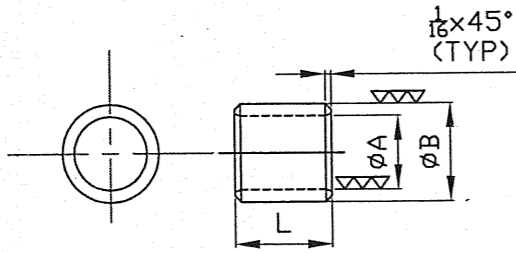


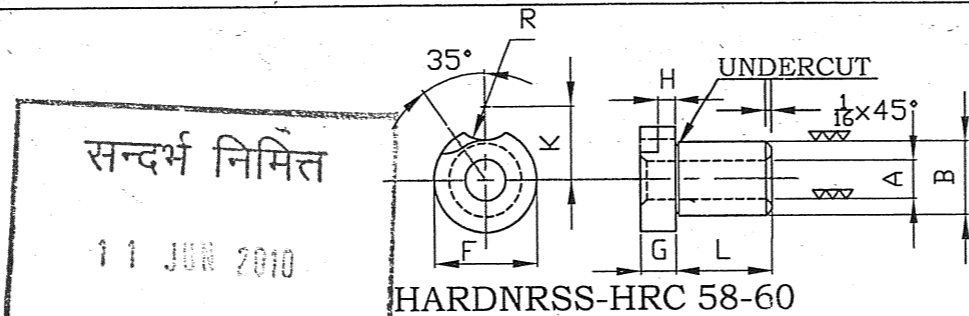
DRG. NO.-JD04AL0173



0509111523

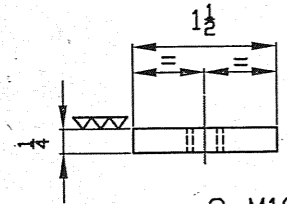
HARDNRSS-HRC 58-60

ITEM NO.	ØA	ØB	L
05	3/4 S.F.WITH #6	1 P.F.IN #1/A,3 & 25	2
09	3/4 S.F.WITH #10	1 P.F.IN #1/A	1
11	2 1/8 S.F.WITH #12 & 13	2 1/2 P.F.IN #1/A & 1/B	1 3/4
15	1 1/16 S.F.WITH #16	2 1/16 P.F.IN #1/A & 1/B	1 3/4
23	1 S.F.WITH #24	1 3/8 P.F.IN #1/A	1

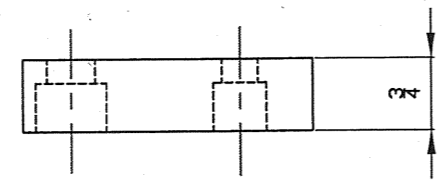


HARDNRSS-HRC 58-60

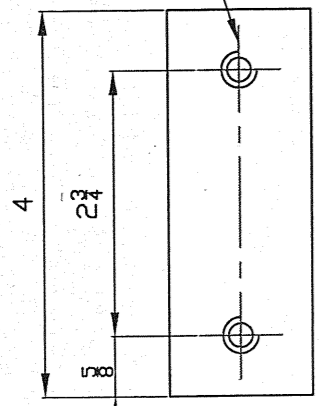
ITEM NO.	ØA	ØB	L	F	G	H	R	K
06	27 ^{+0.006} / ₆₄ ^{+0.002}	3/4 S.F.WITH #5	2	1 1/16	1/4	1/8	11/32	3/4
10	27 ^{+0.006} / ₆₄ ^{+0.002}	3/4 S.F.WITH #9	1	1 1/16	1/4	1/8	11/32	3/4
12	1 15 ^{+0.010} / ₃₂ ^{+0.004}	2 1/8 S.F.WITH #11	1 3/4	2 11/16	3/8	3/16	13/32	1 41/64
13	1.5000 ^{+0.005} ^{+0.002}	2 1/8 S.F.WITH #11	1 3/4	2 11/16	3/8	3/16	13/32	1 41/64
16	1 9 ^{+0.009} / ₃₂ ^{+0.003}	1 11/16 S.F.WITH #15	1 3/4	2 1/4	3/8	3/16	13/32	1 25/64
22	5 ^{+0.006} / ₁₆ ^{+0.002}	3/4 S.F.WITH #9	1	1 1/16	1/4	1/8	11/32	3/4
24	21 ^{+0.006} / ₃₂ ^{+0.002}	1 S.F.WITH #23	1	1 13/32	7/16	1/8	11/32	59/64
26	17 ^{+0.006} / ₃₂ ^{+0.002}	2 1/8 S.F.WITH #11	1 3/4	2 11/16	3/8	3/16	13/32	1 41/64



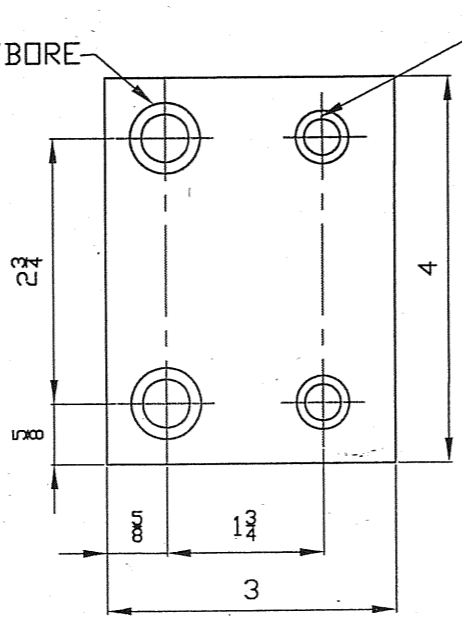
2-M10x1.5 DRILL & TAP HOLE THRU FOR #4



2-DRILL & C'BORE FOR #4



2-DRILL & C'BORE FOR #8



- NOTE:-**
- ALL DIMENSIONS IN INCHES / MM UNLESS OTHERWISE SPECIFIED.
 - BREAK ALL SHARP CORNERS 1/4"
 - STAMP ON DRG. NO. JD04AL0173 COMP. NO. 10020070
 - TOLERANCE ON DECIMAL DIMENSIONS NOT OTHERWISE SPECIFIED ±0.002" / 0.05MM FRACTIONAL ± 0.010" / 0.25 MM NOT CUMULATIVE
 - WELDMENT TO BE NORMALIZED.
 - MACHINE ALL OVER EXCEPT SHOWN

OLD DRG. NO.-JD(E)-139

02	26	SLIP BUSH(DRILL)	AISI-1090	02	SEE DETAIL
04	25	L-PLATE	IS:2062	01	SEE DETAIL
02	24	SLIP BUSH(DRILL)	AISI-1090	02	SEE DETAIL
02	23	LINER	AISI-1090	02	SEE DETAIL
02	22	SLIP BUSH(DRILL)	AISI-1090	02	SEE DETAIL
01	21	DOWEL(HRD & GRD)	AISI-1045	04	Ø 1/2 x 2" Lg
REDRAWN		CHECKED	Sr. S.E.	Sd/-	Sd/-
Sd/- V.S.SHARMA			Sd/- B.P.PANDEY	MALHOTRA /02/08	S.K.KATIYAR /02/08
06/02/08				WM/MOD/TLG	DY/CME/T

20 HARDNESS=HRC 45-50

OLD DRG. NO.-JD(E)-139

DO NOT SCALE THE DRAWING IF IN DOUBT ASK

GRADE NO.	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12
Ra UM	0.025	0.050	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50
SYMBOL	▽▽▽			▽▽			▽		▽		~	

19

ALT.	DESCRIPTION	DATE	INITIAL
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02	20	REST PAD	IS:1875, CL-IV	02	SEE DETAIL
02	19	REST PLATE	IS:2062	02	SEE DETAIL
01	18	SOC.HD.SCREW	AISI-1045	05	M16x1.5x2" Lg
04	17	CLAMP PLATE	IS:1875, CL-IV	05	SEE DETAIL
02	16	SLIP BUSH(DRILL)	AISI-1090	04	SEE DETAIL
02	15	LINER	AISI-1090	04	SEE DETAIL
01	14	LOCK SCREW	AISI-1045	06	M10x1.5x1/2" Lg
02	13	SLIP BUSH(REAM)	AISI-1090	02	SEE DETAIL
02	12	SLIP BUSH(DRILL)	AISI-1090	02	SEE DETAIL
02	11	LINER	AISI-1090	02	SEE DETAIL
02	10	SLIP BUSH(DRILL)	AISI-1090	26	SEE DETAIL
02	09	LINER	AISI-1090	31	SEE DETAIL
01	08	SOC.HD.SCREW	AISI-1045	18	M12x1.75x1 1/2" Lg
01	07	LOCK SCREW	AISI-1045	35	M8x1.25x3/8" Lg
02	06	SLIP BUSH(DRILL)	AISI-1090	05	SEE DETAIL
02	05	LINER	AISI-1090	05	SEE DETAIL
01	04	SOC.HD.SCREW	AISI-1045	10	M10x1.5x5/8" Lg
04	03	REST PAD	IS-1875, CL-IV	02	SEE DETAIL
04	02	L-PLATE	IS:2062	02	SEE DETAIL
03	01	WELDED CONSTR	-	01	SEE DETAIL
SHT NO.	REF. NO.	DESCRIPTION	MATL.	QTY PER SET	REMARKS

TITLE:- DRILL JIG FOR CYL. BLOCK (GEN END)
Mw.No.-972/HMS

TYPE OF LOCO. ALCO

USED ON:- 10020070/31-AA-71561

REF. NO. JD(E)-139

SCALE:- NTS

DATE:-02.02.2008

SHEET NO. 02 NO. OF SHEET 04

JIG AND TOOL OFFICE DIESEL LOCO WORKS VARANASI

DRAWN B.P.PANDEY 17/06/88 CHECKED R.C.MONDAL Sr. S.E. Sd/- A.K.ABID Sd/- H.P.SHARMA Sd/- ANIL SHARMA

DRG. NO. JD04AL0173