



SECTION-XX

BASED ON RDSO DRG. NO. SK.VL-292, REF-3

IS: 3073													
SURFACE	NUMBER	N <sub>1</sub>	N <sub>2</sub>	N <sub>3</sub>	N <sub>4</sub>	N <sub>5</sub>	N <sub>6</sub>	N <sub>7</sub>	N <sub>8</sub>	N <sub>9</sub>	N <sub>10</sub>	N <sub>11</sub>	N <sub>12</sub>
ROUGHNESS	Ra	0.25	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50
VALUUE TO	SYMBOL												
IS: 3037													

ALT. NO.	AUTHY	DESCRIPTION	DATED
④	DY CEE(D)		
③	DY CEE(D)		
②	DY CEE(D)		
①	DY CEE(D)		

# NOTE:-

- THIS SUPERSEDES DRG. NO. 06/1/15/53.
- ALTERNATIVE MATERIAL IS 2062 GR-B' (NORMALISED AND KILLED) CAN BE USED. THE MATERIAL SHOULD BE SUBJECTED TO ULTRASONIC TESTING AS PER ASTM A 435, TO ENSURE FREEDOM FROM ANY FLAW. IN CASE THE ULTRASONIC TESTING REVEALS ANY FLAW, THE MATERIAL SHOULD BE REJECTED.
- THE STEEL PLATES SHOULD BE OXYCUT ALONG THE GRAINS & SURFACE TO BE FINISHED SMOOTH & SHOULD BE FREE FROM GOUGING MARK/DAG LINES.
- STRESS RELIEVING SHOULD BE DONE AFTER FLAME CUTTING FOR STRESS RELIEVING RAISE THE TEMPERATURE SLOWLY UP TO 640°C & AFTER 4 HOURS OF SOAKING PERIOD, ALLOW TO COOL IN FURNECE UP TO 200°C IT SHOULD THEN BE ALLOWED TO COOL IN STILL AIR.
- AFTER MANUFACTURE THE MATL. SHOULD BE SUBJECTED TO MAGNETIC PERTICLE TEST AT PORTIONS MARKED 'X' TO ENSURE FREEDOM FROM CRACKS.
- STAMP 'MOD-1' IN 6mm LETTER SIZE ON BOTH FACE AT LOCATION SHOWN.
- ULTRASONICALLY TESTED MATL. SHOULD BE STAMPED WITH MANUFACTURER'S INITIALS, MONTH & YEAR OF MANUFACTURE SL. NO. FOR THE MONTH UNDER REFERENCE IN THREE DIGITS DRG. NO. IN 6mm LETTERS ON BOTH SIDE AT THE VISIBLE LOCATION SHOWN AS [ ] e.g. ABC-0107001, 06/2/15/68 UT FOR ULTRASONICALLY TESTED MANUFACTURED BY ABC IN JANUARY 2007 BEARING SL. NO. 001 AS PER DRG. NO. 06/2/15/68.
- THE MATL. SHALL BE SUPPLIED PAINTED WITH ONE COAT OF RED OXIDE PRIMER ON THE SURFACES EXPOSED TO AIR & THIN SPRAYED WITH COLOUR NO. 632 "DARK ADMIRALTY GREY" (IS:5 OF 1994).
- DIMNL. TOL:- AS PER CORP. STD. AA 023 02 08 COARSE GRADE UNLESS OTHERWISE STATED.

P222 125		COMPENSATING BEAM (MODIFIED)		4	STEEL	IS 2062 (NORMALISED)
REF. NO.	C&D NO.	PART SK. NO.	DESCRIPTION	NO. LOC.	MATL.	SPECN.
DRAWN	56		REFERENCE DRG. NO.			CHITTARANJAN LOCOMOTIVE WORKS
CKD. BY	56		06/1/15/61 & 77			
S/ELDO (M)	56		REF-3			
AME(D)	56					
DY CEE (D)	56					
DATE	30-03-07		COMPENSATING BEAM			USED FOR LOCO WAG/7
SCALE	1:5					DRAWING NO.
APPROVAL REF. NO.						06/2/15/68