
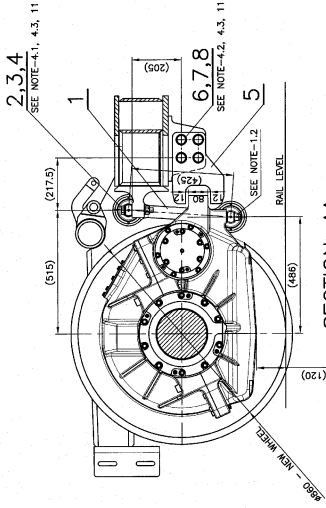
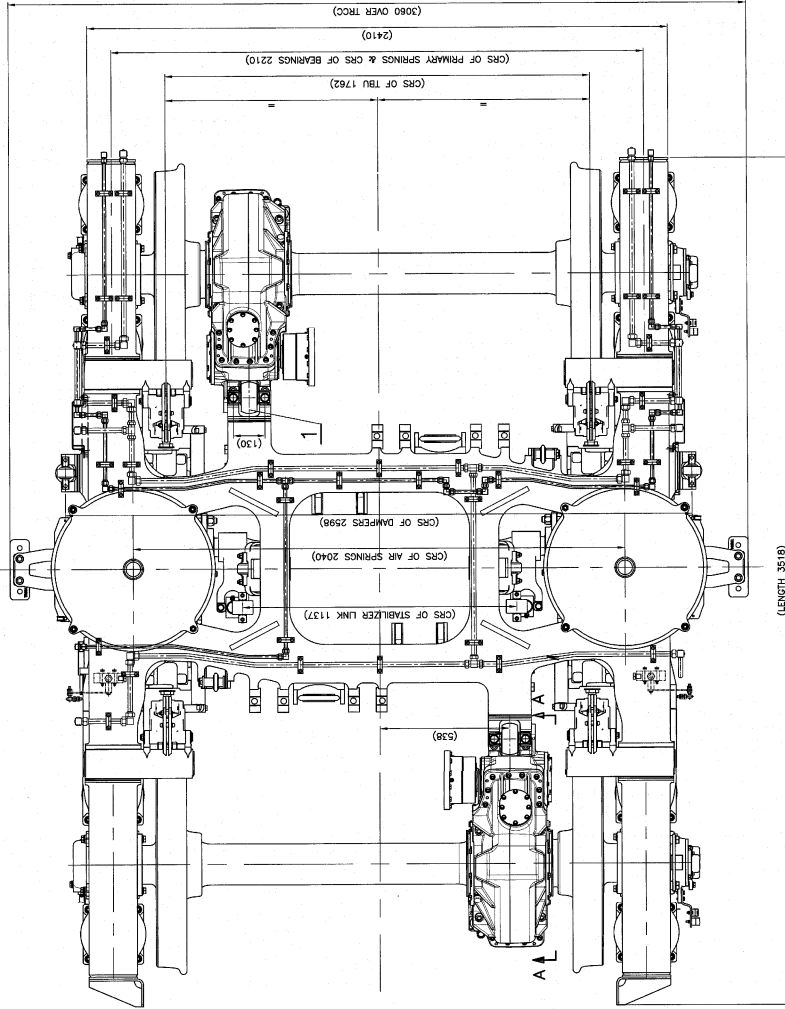


3D VIEW FOR REF.

ADDITIONAL INFORMATION DATE OF SUBMISSION STATUS OF ORDER	1 SET	001	FLEXIBLE COUPLING
	1 SET	001	REACTION ROD
	1 SET	001	GEAR BOX & COMPONENTS
DATE OF RECEIPT OF PRODUCT DATE OF DELIVERY OF PRODUCT	NA/00	REMARKS	DESCRIPTION
 <b>BAHART HEAVY ELECTRICALS LTD.</b> BIHAPAL			

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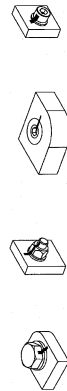





SECTION-AA

NOTE

- 1.1. REACTION ROD COMPLETE SUPPLIED BY M/S. TSV. M/S. MEDIA ALONG WITH MOTOR/GEAR BOX AND COVERED IN ELECTRICAL SCOPE.
- 1.2. ALL FASTENERS- SCREW, NUT, WASHER, ADJUSTMENT SHIMS FOR GEAR BOX SIDE ARE SUPPLIED BY M/S. TSV. M/S. MEDIA ALONG WITH MOTOR / GEAR BOX AND COVERED IN ELECTRICAL SCOPE.
2. ZINC ELECTROPLATED TO GRADE A3L OF ANNEX-E OF IS1387 (PART-ELEVEN).
3. TIGHTENING TORQUE:
  - 4.1) M24-10.9 - 450 Nm
  - 4.2) M24-10.9 - 745 Nm
  - 4.3) M24-10.9 - 745 Nm
4. AFTER TIGHTENING TORQUE APPLICATION, SUITABLY MARK WITH PERMANENT MARKER OR PAINT ON BOLT/SCREW, NUT FACE, WASHER AND PHET. THIS IS NECESSARY FOR INSPECTION/VERIFICATION/CHECKING IN SERVICE.
5. FOR ASSEMBLY OF REACTION ROD, INSTRUCTIONS OF M/S. TSV. M/S. MEDIA SHALL BE FOLLOWED.
6. BOLTS/SCREWS SHALL BE OF MAKE - TSV OR UNBRAND OR LIFE ONLY.
7. RUST PREVENTATIVE UNPAINTED EXPOSED SURFACES ON BOGE FRAME SHALL BE SUITABLY COATED WITH DIMENSIONS SHOWN ARE WITH TARE LOAD & NEW WHEEL.
8. DIMENSIONS SHOWN ARE WITH TARE LOAD & NEW WHEEL.
9. FS ALL STEEL LOCK NUT:
  - 9.1) SHALL BE AS PER DIN 6036 / DIN 6034
  - 9.2) SHALL BE OF MAKE M/S. FLAG & HONDEL, GERMANY
  - 9.3) SHALL BE OF MAKE M/S. FLAG & HONDEL, GERMANY
10. FOR ITEM-6, ALTERNATIVELY, HEXAGON HEAD BOLT - IS 1384 (Part-1)/ISO 4014-M24x100-10.9 - ZINC ELECTROPLATED MAY BE USED.
11. DURING ASSEMBLY, THREADS & BEARING SURFACES OF BOLT, SCREW AND NUT (ITEMS-2,4,6 & 8) SHALL BE SUITABLY APPLIED WITH ANTI-SIZE COMPOUND (MOLYKOTE 1000 or ANABOND NEVESEZ C-975).



ITEM	DESCRIPTION	QTY	REMARKS
1	REACTION ROD	1	SEE NOTE-11
2	REACTION ROD	1	SEE NOTE-11
3	REACTION ROD	1	SEE NOTE-11
4	REACTION ROD	1	SEE NOTE-11
5	REACTION ROD	1	SEE NOTE-11
6	REACTION ROD	1	SEE NOTE-11
7	REACTION ROD	1	SEE NOTE-11
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9	REACTION ROD	1	SEE NOTE-11
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99	REACTION ROD	1	SEE NOTE-11
100	REACTION ROD	1	SEE NOTE-11

MRW/MC-C-C-001			AMF/SME
ASSEMBLY DRAWINGS			
08-02-2019	30-11-2015	DATE OF LATEST UPDATE	DATE OF FIRST ISSUE
0	Num. All.		

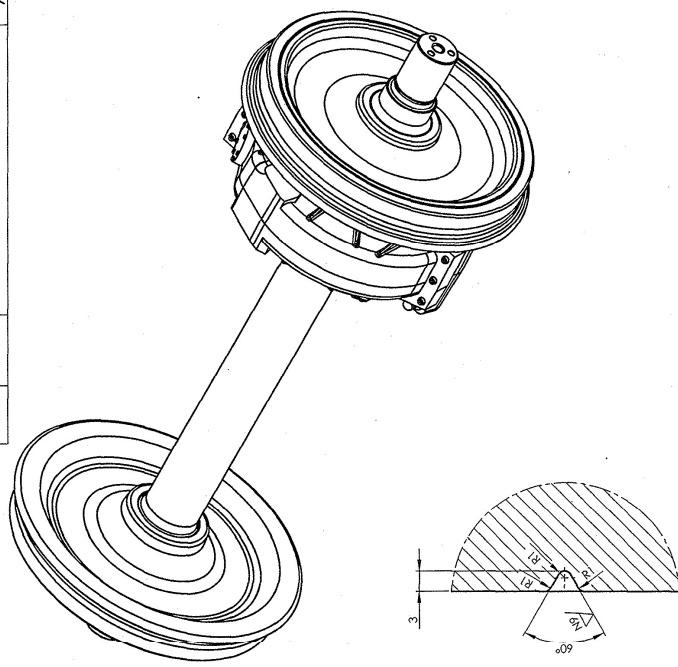
**NOTE**

1. ONLY LATEST ALTERATION (IF ANY) OF THE DRAWINGS SPECIFICATIONS SHALL BE FOLLOWED.
2. PRESSING ON PRESSURE FOR WHEEL SHALL BE FROM 77.2 TO 115.8 TONNES.
3. VARIATION IN TREAD CIRCUMFERENCE OF TWO WHEELS MOUNTED ON THE SAME AXLE SHALL NOT EXCEED 1.6mm.
4. POLISH ALL RADII UNTIL FREE FROM ALL TOOL MARKS AND SCRATCHES. BREAK ALL SHARP CORNERS.
5. STAMPING SHALL BE AS PER LATEST REVISION OF RD50/RSK-92114 AND ITS R-19 PART.
6. WHEEL & AXLE COMPLETE SHALL BE AS PER RD50 SPEC RS-19 PART.
7. FOR WHEEL PROFILE REFER LATEST REVISION OF RD50/RSK-91146.
8. FOR ASSEMBLY OF GEAR WHEEL & GEAR BOX, M/S MEDHA / M/s TSA'S INSTRUCTIONS SHALL BE FOLLOWED.
9. ITEM-3 TO BE SUPPLIED BY M/s. MEDHA / M/s TSA.
10. SURFACE PROTECTION SHALL BE AS PER DRG. NO. MRM/MC-Q-2005.

[illegible]

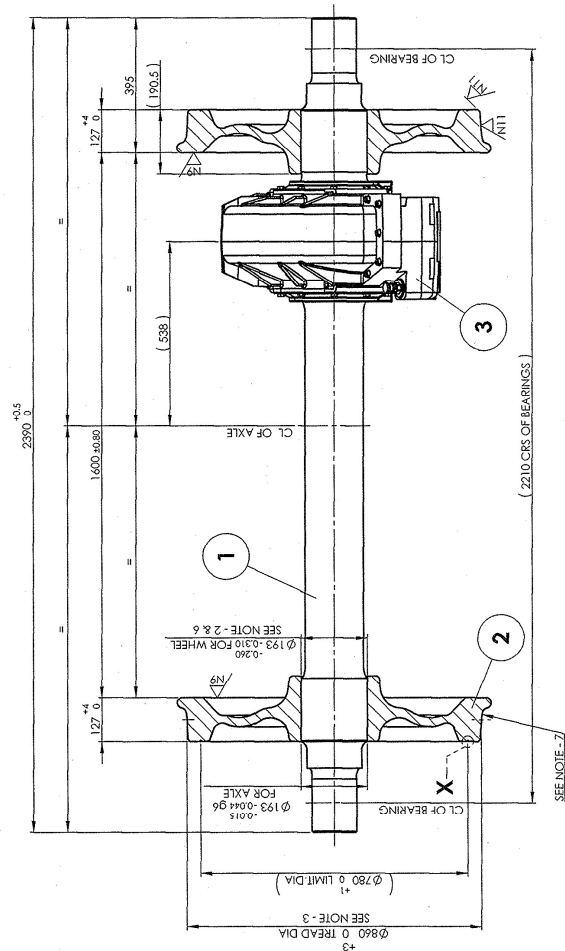
29-01-2016	15-09-2015	AME/SME
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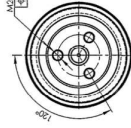
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**DETAIL X**  
**SCALE 2:1**

## SECTION A-A





1. ONLY LATEST ALTERATION/REVISION OF THE DRAWINGS & SPECIFICATIONS SHALL BE FOLLOWED.
2. POLISH ALL THREADS FROM ALL TOOL MARKS AND SCRATCHES. BLUNT ALL SHARP CORNERS.
3. THE THREADS ON THE FREE END SHALL BE AS PER IS 2478 PART 0 WITH TOLERANCE CLASS-6H
4. THE TOLERANCES ON THE DIMENSIONS SHALL BE AS PER IS 2875 PART 0 WITH TOLERANCE CLASS-6H
5. STAMPINGS SHALL BE AS PER DDWG/PC/221/14/11/15/16/17
6. THE MACHINED PORTIONS OF THE JOURNAL AND AXES SHOULD BE SUITABLY AND ADEQUATELY PROTECTED AGAINST DAMAGE DURING TRIP. \*  $\frac{167}{100}$  \* POUGHNESS VALUE AT

AXLE	QTY.	DESCRIPTION	DIMENSIONS	TOTAL	AXLWGT	AXLRATIO	486.59
					MAIL SPEC.	MAIL DROPS	REMARKS
SURFACE AREA IN SQ. FT.							
<p style="text-align: center;"><b>AXLE FINISHED</b></p> <p style="text-align: center;"><b>FOR 36 KOLKATA METRO MOTOR COACHES (WITH MEDHRA ELECTRICS)</b></p>							
MASS IN KG:							
SCALE							(1) Scale by kg
SIZE /							
1:1							CHD
ALTD							K.C. GONDARJAN
o							DRN
							K.G.NANDASAGAN