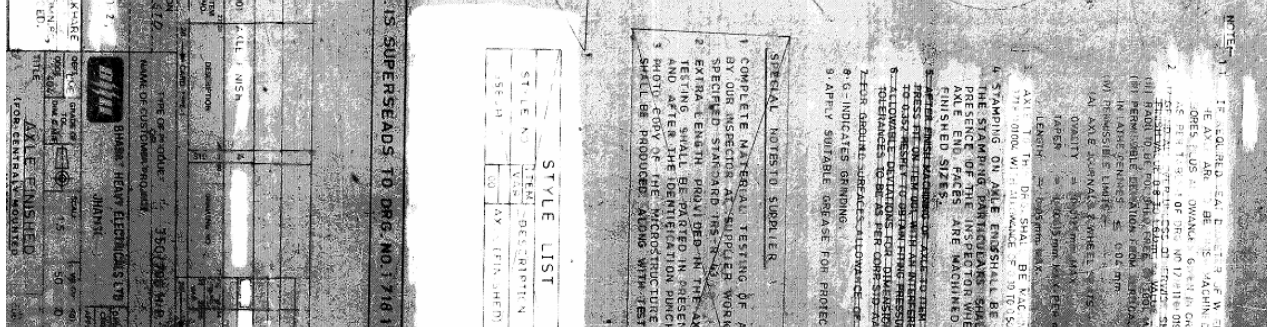
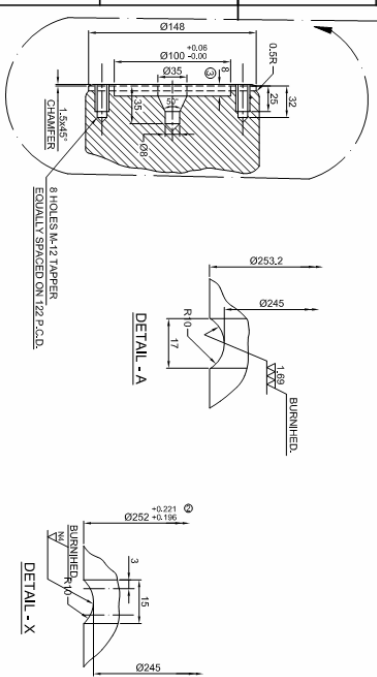






WELDING SYMBOLS TO BS813													DRAWING		REFERENCE ASSC. L/DWG. NO.																													
													CHECKED		Sd		CHITRAKARNJAN																											
													SLIP DT.		Sd		LOCOMOTIVE																											
													SWED.		Sd		WORKS																											
													DY.CEED		Sd		USED FOR LOCO																											
													DATE		15.1.91		WAG 7 (5000 HP)																											
													SCALE		1:5, 1:1		DRAWING NO.																											
													APPROVAL REF. NO.				06/2117/3																											
SURFACE													NUMBERS		Roughness																													
ROUGHNESS													R _a <u>4.0</u>		VALUE TO																													
SYMBOL													SYMBOL																															
<table><tr><td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td><td>7</td><td>8</td><td>9</td><td>10</td><td>11</td><td>12</td><td>13</td></tr><tr><td>0.025</td><td>0.05</td><td>0.1</td><td>0.2</td><td>0.4</td><td>0.8</td><td>1.6</td><td>3.2</td><td>6.3</td><td>12.5</td><td>25</td><td>50</td><td></td></tr></table>													1	2	3	4	5	6	7	8	9	10	11	12	13	0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50							
1	2	3	4	5	6	7	8	9	10	11	12	13																																
0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50																																	
AXLE													FINISHED																															
DRAWING NO.													06/2117/3																															

NOTE:-

1. WORK TO THIS DRG. FROM 1ST WAGET 15000 TYP 11000 & ONWARDS FITTED WITH HIGH ADHESION BOGLE.
2. GRIND ALL OVER UNLESS OTHERWISE SHOWN TO OBTAIN A SURFACE FINISH VALUE (OF 0.4 TO 1.6 um (Rm value))
3. REMOVE ALL SHARP CORNERS AND RAO11 TO BE POLISHED UNTIL FREE FROM TOOL MARKS AND SCRATCHES.
4. FOR ROUGH MACHD, AALE REFER TO DRG. NO. 06/02/11/C, A.D. NO. 20/09/2020
5. FOR ASEA, ARABEENT AND OTHER MOTIONS REFER TO DRG. NO. 06/01/11/1.

* THE WHEEL, SEAT, GEAR SEAT AND COLLAR SEAT SHOULD BE GRIND TO SUCH SIZE WHICH WILL GIVE THE SPECIFIED PRESSING IN FORCE. THE TOLERANCES SPECIFIED FOR THESE DIMENSIONS AND INTERFERING OBTAINABLE ARE FOR INITIAL GUIDENCE ONLY. WHEN PRESSING SHOULD ESTABLISH ITS OWN PRACTICE TO GRIND THESE SEATS DEPENDING ON SURFACE FINISH, LUBRICANT USED AND OTHER ENVIRONMENTAL FACTORS SO AS TO GET THE SPECIFIED PRESSING IN FORCE.