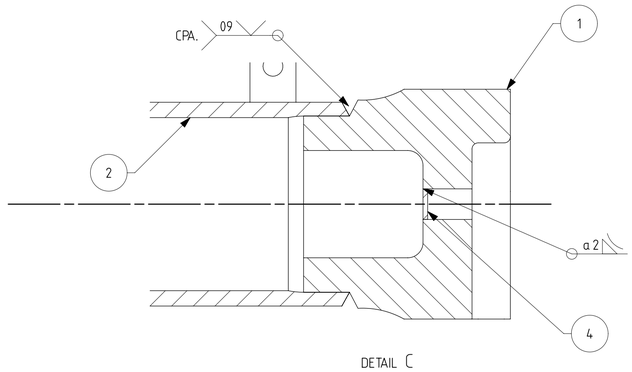
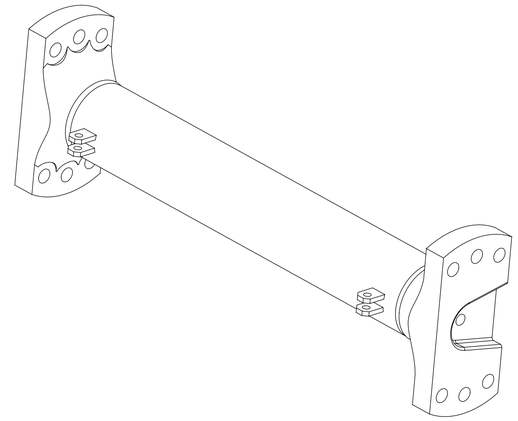
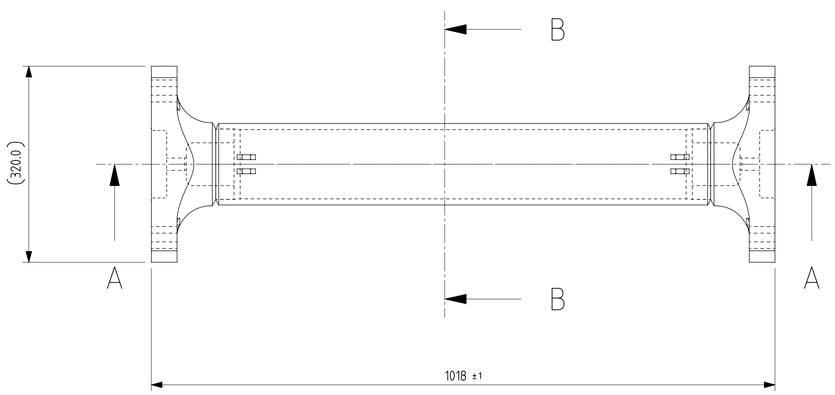
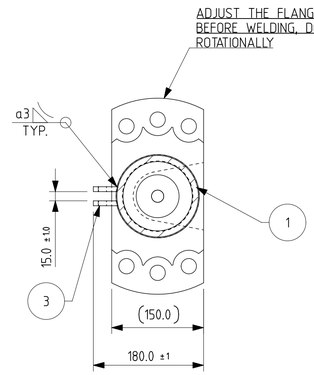


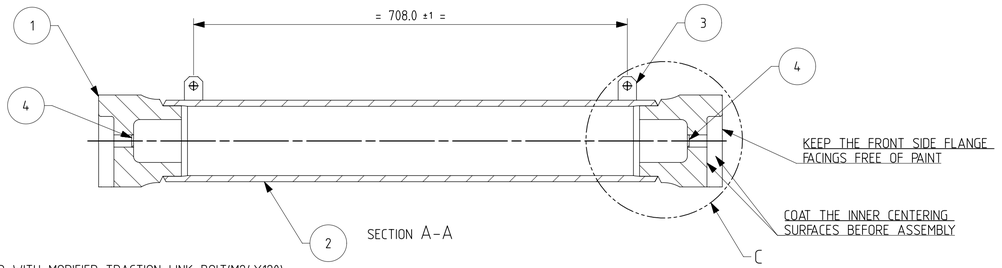
DETAIL C
SCALE 1:2







SECTION B-B



SECTION A-A

NOTES:
1. PUSH PULL ROD TO BE SUPPLIED WITH MODIFIED TRACTION LINK BOLT(M24X120) AS PER ISO 4017,GRADE 10.9 AND EXTRA 02 NOS PER LOCO QUANTITY TO BE SUPPLIED AS MANUFACTURING SPARE. THIS BOLT TO BE PROCURED ONLY FROM CLW'S APPROVED SOURCE FOR MS HARDWARES FOR 3 PHASE LOCOMOTIVE
2. MATERIAL : REFER TO RESPECTIVE DRG. IN THE TABLE
3. RADIOGRAPHY TEST OF WELDING JIONTS :
   a) 100% CHECKING BY RADIOGRAPHY.
   b) RADIAOGRAPHY TEST TO BE DONE AS PER AS 1554.5-1991. SUBJECT FURTHER TO :
   c) ACCEPTABLE CRITERIA FOR IRREGULARITIES :
      i) SIZE EACH LESS THAN OR EQUAL TO 1mm
      ii) TOTAL NUMBERS LESS THAN OR EQUAL TO 8 NOs (IN TOTAL WELDING LENGTH) EACH SIDE.
      iii) INNER DISTANCE GREATER THAN OR EQUAL TO 10mm.
4. SURFACE FINISH AFTER WELDING TO BE DONE WITH HAND GRINDING SLIGHTLY.
5 RADIOGRAPHY TEST OF WELDING JOINTS TO BE DONE ON 100% MATERIALS.
6. DPT & MPT TO BE DONE ON 100% PUSH-PULL ROD. WELDING AREA TO CHECK SURFACE CRACK & TO REMOVE WELDING VALLEY.
7. FINISH: STONE GREY-RAL 7030, PAINT ACCO. TO SPECS ES 1213 PART 1.
8. WELDING SHOULD BE DONE AS PER EN15085.
9. STRESS RELIVING SHOULD BE DONE AFTER WELDING
10. NEXT ASSLY. NO-1209-01-113-040
11. USED FOR LOCO- WAG-9HC, WAP-7
12. QTY./LOCO-02
13. UNSPECIFIED TOLERANCE IN THE DIMENSIONS MENTIONED AT DRAWINGS TO BE FOLLOWED AS PER IS:2102(PART 1):1993-TOLERANCE CLASS-MEDIUM.

RADIOGRAPHIC STANDARD LEVEL FOR TESTING OF WELDING TO BE FOLLOWED AS PER ASTME 390 AS MENTIONED BELOW:

S.NO.	TYPES OF DEFECTS	AS PER ASTME 390 REFERNCE RADIOGRAPHS
1	COARSE SCATTERED POROSITY	GRADE-II
2	FINE SCATTERED POROSITY	GRADE-II
3	CLUSTURED POROSITY	GRADE-II
4	LINEAR POROSITY	GRADE-II
5	SLAG INCLUSION	GRADE-II
6	TUNGSTEN INCLUSION	GRADE-II
7	INCOMPLETE PENETRATION, LACK OF FUSION , ANY TYP OF CRACK, UNDERCUT AND OTHER DEFECTS	NOT ALLOWED OF ANY GRADE

निर्देश संख्या REF. NO.	खाता एवं चित्रण संख्या C&D NO.	अंग आरेखण संख्या PART DRG. NO.	वर्णन DESCRIPTION	मात्रा QTY.	पदार्थ MATL	विशिष्टि SPECN	प्रति चार कि. ग्रा. WT. EACH IN K.G.
4	T212/	1209-01.413-010	SEALING PLATE	2	STEEL	IRS: M-41	0.02
3	T212/014	1209-01.413-009	PLATE	4	STEEL	IS:2062 GR. C	0.06
2	/	1209-01.313-035	MODIFIED WELDING TUBE	1			
1	/	1209-01.113-037	MODIFIED FLANGE FOR PUSH PULL ROD	2			

TENTATIVE

धातु–वेल्डन चिह्न भा. मा. : 813 / अ. मा. सं. :2553 WELDING SYMBOLS TO IS:813 / ISO:2553	अनिर्दिष्ट सह्य – सीमा भा. मा. : 2102 / अ. मा. सं. : 2768 UNSPECIFIED TOLERANCE TO IS : 2102 / ISO : 2768										TOL. ELS.
	परास GRADE NO.	परि N1	परि2 N2	परि3 N3	परि4 N4	परि5 N5	परि6 N6	परि7 N7	परि8 N8	परि9 N9	परि10 N10	परि11 N11	परि12 N12
	Rz	816-833	833-867	869-1111	1115-128	2.5-3.8	3.8-6.3	9.8-17	16-25	26-48	50-83	75-100	100-250
धरातल – खुरदरा का मान भा. मा. 3073 / अ. मा. सं. 1302 SURFACE ROUGHNESS VALUE TO IS:3073 / ISO:1302	Ra µm	0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50
	चिन्ह SYMBOL												

परिवर्तन संख्या AUT. NO.	प्राधिकार AUTHY	वर्णन DESCRIPTION	दिनांकित हस्ताक्षर DATED INITIAL

अभिकल्पित DSN	
जाँचा व.अ.अ. CHD SSE	
समीक्षित प.डि.अ. / यां.डि.अ. REVIEWED AEE / SEE	
अनुमोदित उ.मु.कि.अ. APPROVED DYCEE	
दिनांक DATE	
रेखिक अनुपात SCALE	1.5
चरखण्ड / REF.	ALT:-

चित्तरंजन रेलइंजन कारखाना
CHITTARANJAN LOCOMOTIVE WORKS, INDIA

पदार्थ MATL	प्रति भाग कि. ग्रा. WT. EACH IN KG
विशिष्टि SPECN	
वर्णन DESCRIPTION	MODIFIED PUSH PULL ROD
आरेखण संख्या DRAWING NO.	1209-01.113-038
परिवर्तन संख्या ALTERATION NO.	पृष्ठ SHEET 1 OF 1 — A1

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