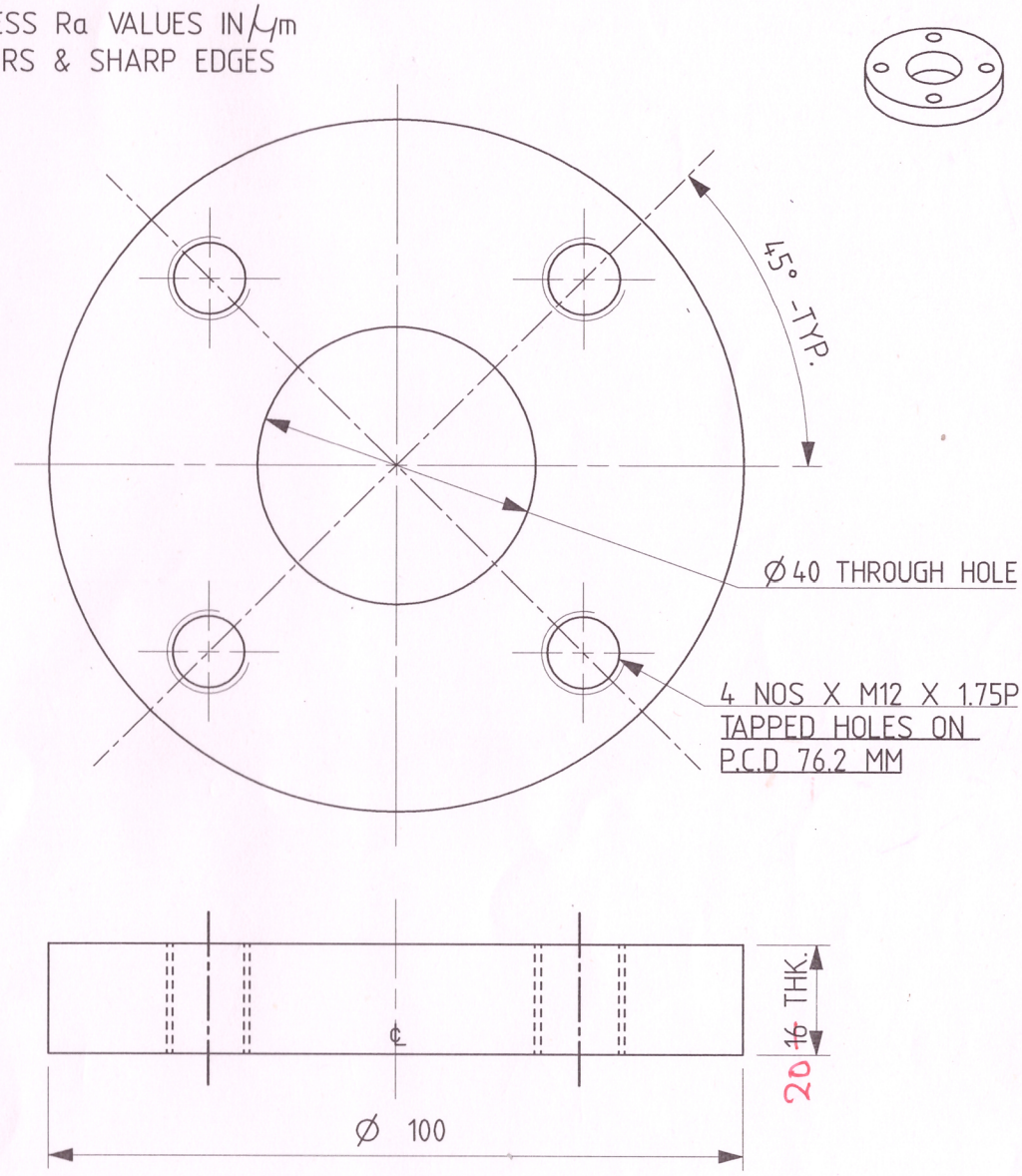
(66)

1209-08.430-531

SURFACE ROUGHNESS Ra VALUES IN μm
REMOVE ALL BURRS & SHARP EDGES



1. ALL DIMENSIONS ARE IN mm
2. NEXT ASSLY. DRG. NO-1209-08.330-532
3. C&D NO-/
4. QTY./LOCO-04 NOS.
5. USED FOR LOCO WAG-9HC, WAP-7
6. UNSPECIFIED TOLERANCE IN THE DIMENSIONS MENTIONED AT DRAWINGS TO BE FOLLOWED AS PER IS:2102 (PART 1):1993-TOLERANCE CLASS-MEDIUM OF TABLE-1

परिवर्तन संख्या ALT.NO	प्राधिकार AUTHY	वर्णन DESCRIPTION	दिनांकित बाद्यक्षर DATED INITIAL
1	DY.CEE	THICKNESS CHANGED TO 20 mm	

सतह – रुक्षता का मान भा. मा. 3073 / अ. मा. सं. 1302 SURFACE ROUGHNESS VALUE TO IS:3073 / ISO:1302	अनिर्दिष्ट सद्य – सीमा भा. मा. : 2102 / अ. मा. सं. : 2768 UNSPECIFIED TOLEARANCE TO IS : 2102 / ISO : 2768	TOL. CLS.
	धातु–वेल्डन चिन्ह भा. मा. : 813 / अ. मा. सं. :2553 WELDING SYMBOLS TO IS:813 / ISO:2553	

पदांक GRADE NO	सं1 N1	सं2 N2	सं3 N3	सं4 N4	सं5 N5	सं6 N6	सं7 N7	सं8 N8	सं9 N9	सं10 N10	सं11 N11	सं12 N12
Rz	0.16-0.3	0.5-0.7	0.9-1.1	1.5-2.0	2.5-3.8	5.0-6.3	9.0-12	16-25	30-40	50-63	75-100	160-250
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												

अभिकल्पित DGN	
जाँचा व.अ.अ. CHD SSE	Abu Naser
समीक्षित स.वि.अ. / व.वि.अ. REVIEWED AEE / SEE	
अनुमोदित उ.मु.वि.अ. APPROVED DYCEE	AMIT AGGA RWAL
दिनांक DATE	
रैखिक अनुपात SCALE	1:1
संदर्भ / REF.	ALT.-

चित्तरंजन रेलइंजन कारखाना
CHITTARANJAN LOCOMOTIVE WORKS, INDIA

पदार्थ MATL	STEEL	प्रति भार कि. ग्रा. WT. EACH IN KG	0.8
विशिष्टि SPECN	IS: 2062:2011 GR.-E250 QUALITY-C KILLED NORMALISED		

वर्णन DESCRIPTION: HORN MOUNT BASE

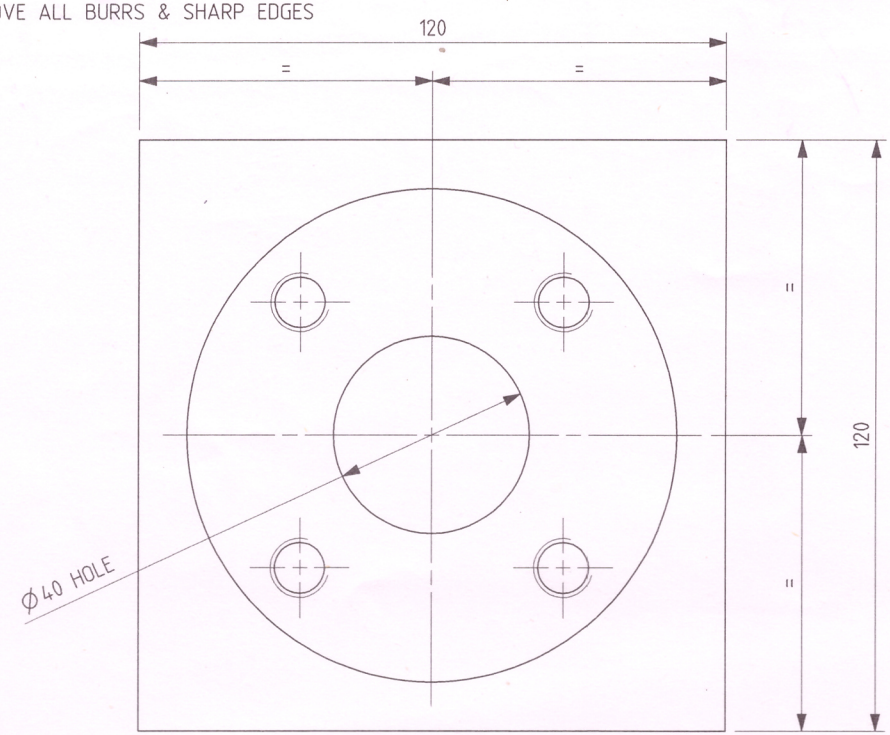
आरेखण संख्या DRAWING NO.: 1209-08.430-531

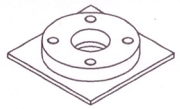
परिवर्तन संख्या ALTERATION. NO. | पर्ण SHEET 1 OF 1 | A4

RED WORK REDRAWN BY COE

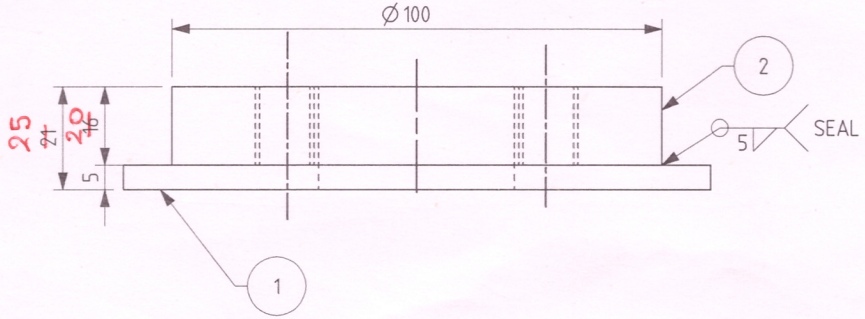
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SURFACE ROUGHNESS Ra VALUES IN μm
REMOVE ALL BURRS & SHARP EDGES





1. ALL DIMENSIONS ARE IN mm
2. NEXT ASSLY. DRG. NO-1209-08.030-512
3. C&D NO-/
4. QTY./LOCO-04 NOS.
5. USED FOR LOCO WAG-9HC, WAP-7
6. UNSPECIFIED TOLERANCE IN THE DIMENSIONS MENTIONED AT DRAWINGS TO BE FOLLOWED AS PER IS:2102 (PART 1):1993-TOLERANCE CLASS-MEDIUM OF TABLE-1



REF. NO.	C&D NO.	PART DRG. NO.	DESCRIPTION	QTY.	MATL	SPECN	WT. EACH IN K.G.
निर्देश संख्या	लागत एवं वितरण संख्या	अंग आरेखण संख्या	वर्णन	मात्रा	पदार्थ	विशिष्टि	प्रति भार कि. ग्रा.
2	/	1209-08.430-531	HORN MOUNT BASE	1	STEEL	IS: 2062:2011 GR.-E250 QUALITY-C KILLED NORMALISED	0.80
1	/	1209-08.430-529	HORN MOUNT	1	STEEL	IRS M41 GR. I	0.50

अभिकल्पित DGN	
जाँचा व.अ.अ. CHD SSE	Abu Naser
समीक्षित व.वि.अ. / व.वि.अ. REVIEWED AEE / SEE	
अनुमोदित व.मु.वि.अ. APPROVED DYCEE	AMIT AGGA RWAL
दिनांक DATE	
पैमाना SCALE	1:1

चित्तरंजन रेलइंजन कारखाना
CHITTARANJAN LOCOMOTIVE WORKS, INDIA

पदार्थ MATL	प्रति भार कि. ग्रा. WT. EACH IN KG 1.3
विशिष्टि SPECN	
वर्णन DESCRIPTION	HORN MOUNT ASSLY.
आरेखण संख्या DRAWING NO.	1209-08.330-532
परिवर्तन संख्या ALTERATION NO.	पर्ण SHEET 1 OF 1 A3

धातु–वेल्डन चिन्ह
भा. मा. : 813 / अ. मा. सं. :2553
WELDING SYMBOLS TO IS:813 / ISO:2553

सतह – रुक्षता का मान
भा. मा. 3073 / अ. मा. सं. 1302
SURFACE ROUGHNESS VALUE TO IS:3073 / ISO:1302

अनिर्दिष्ट सद्य – सीमा भा. मा. : 2102 / अ. मा. सं. : 2768
UNSPECIFIED TOLEARANCE TO IS : 2102 / ISO : 2768

ग्रेडांक GRADE NO.	सं1 N1	सं2 N2	सं3 N3	सं4 N4	सं5 N5	सं6 N6	सं7 N7	सं8 N8	सं9 N9	सं10 N10	सं11 N11	सं12 N12
Rz	0.16-0.3	0.5-0.7	0.9-1.1	1.5-2.0	2.5-3.8	5.0-6.3	9.0-12	16-25	30-40	50-63	75-100	160-250
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												

TOL. CLS.

परिवर्तन संख्या ALT. NO.	प्राधिकार AUTHY	वर्णन DESCRIPTION	दिनांकित आद्याक्षर DATED INITIAL
1.	Dy. CEE D-III	DIM 16 & 21 CHANGED TO 20 & 25 RESPECTIVELY.	

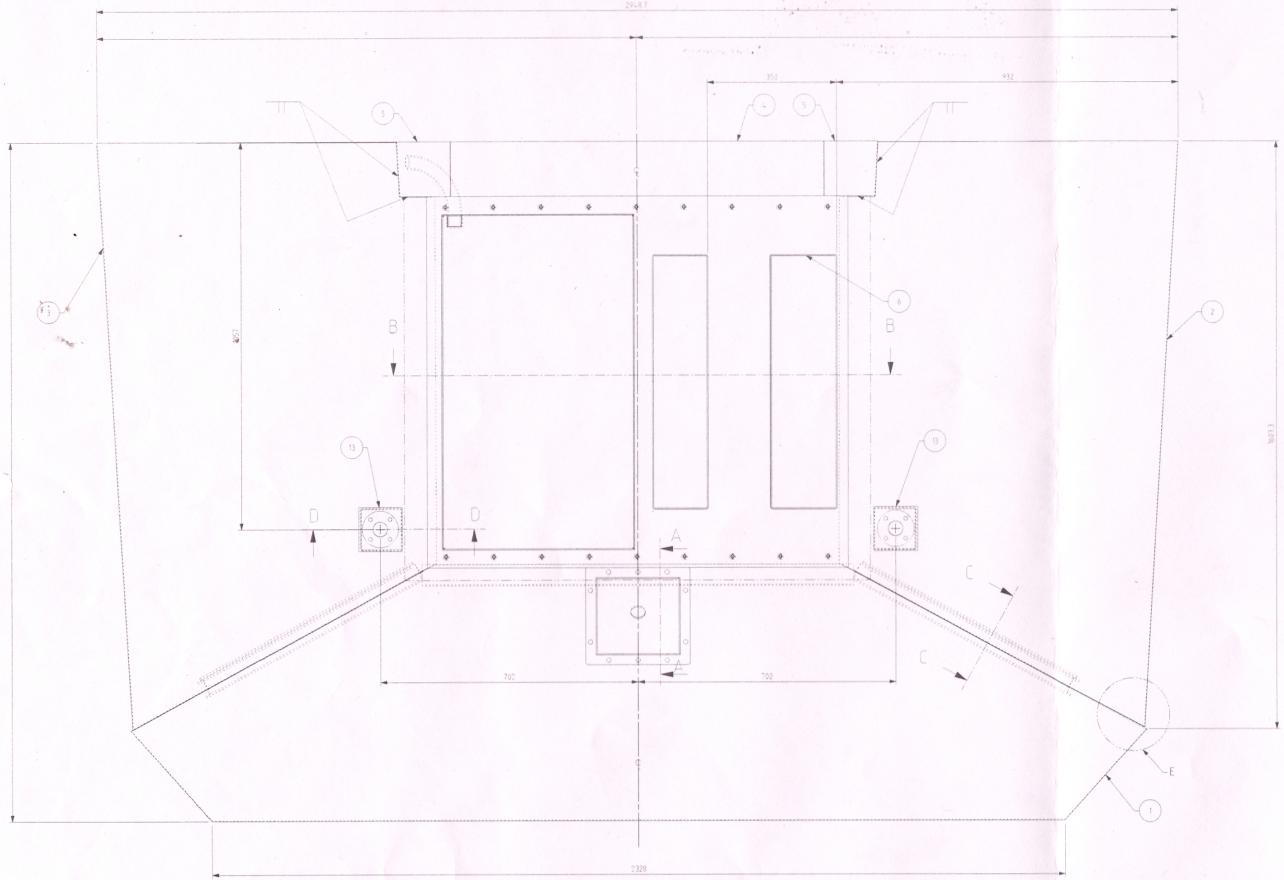
संदर्भ / REF.
ALT-

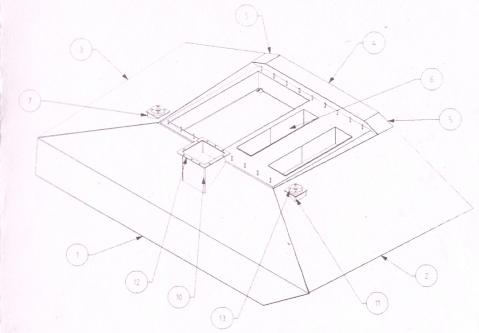
REDRAWN BY COE
RED WORK.

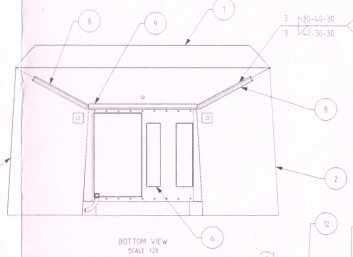
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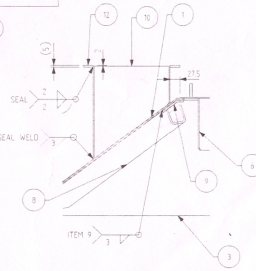
65

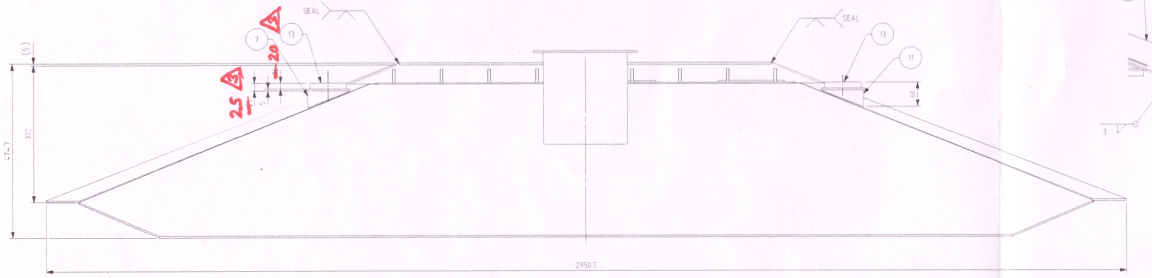
SURFACE ROUGHNESS Ra VALUES IN µm

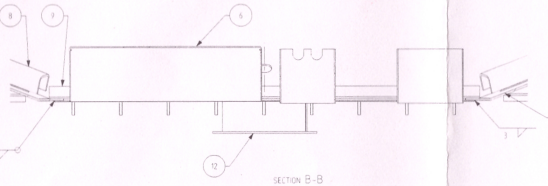


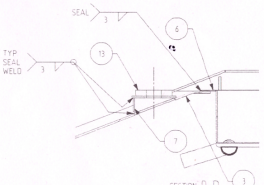


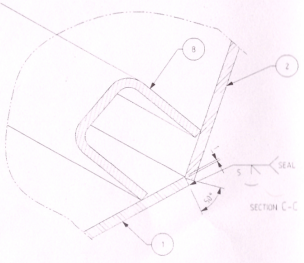


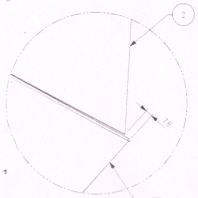












NOTE
1. ALL BURRS & SHARP EDGES ARE TO BE REMOVED.
2. WELDING SHALL BE IN ACCORDANCE WITH AS/NSA 1-1991 SP 1 IS:812 , IS:814 , IS:822
3. DRAWING TO BE READ IN CONJUNCTION WITH DRG. NO. 1209-08.030-293.
4. ALL DIMENSIONS ARE IN mm
5. NEXT LEVEL ASSEMBLY DRG. NO.1209-08.030-511
6. USED FOR LOCO-WAG-PHC/AAP-7
7. QTY/LOCO=2
8. UNSPECIFIED TOLERANCE IN THE DIMENSIONS MENTIONED AT DRAWINGS TO BE FOLLOWED AS PER IS:2102(PART 1):1993-TOLERANCE CLASS-MEDIUM OF TABLE-1

REF NO	C&D NO	PART DRG NO	DESCRIPTION	QTY	MATL	SPECIFICATION	WGT PER PC in KG
13	1	1209-08.330-522	HORN MOUNT ASSY	-			1.30
12	1	1209-08.430-528	FLASHER LIGHT MOUNT	1	STEEL	IRS M41 GR.1	1.02
11	1	1209-08.430-527	PEDESTAL FOR HORN LH	1	STEEL	IRS M 41 GR.1	9.23
10	1	1209-08.330-526	PEDESTAL FOR FLASHER LIGHT MOUNT	1	STEEL	IRS M 41 GR.1	1.57
9	1	1209-08.330-525	FRONT ANGLE PLATE	1	STEEL	IS:2062:2019 Gr E250 CU QUALITY-C, KILLED NORMALIZED	3.05
8	1	1209-08.330-524	U CHANNEL 1	2	STEEL	IS:2062:2019 Gr E250 CU QUALITY-C, KILLED NORMALIZED	3.66
7	1	1209-08.330-523	PEDESTAL FOR HORN RH	1	STEEL	IRS M 41 GR.1	9.23
6	1	1209-08.230-69	MODIFIED CAR A/C ROUGH TANK ASSEMBLY WITH DRAIN PIPE	1			43.32
5	1	1209-08.430-519	TOP SIDE PLATE FOR REAR WALL	2	STEEL	IRS M 41 GR.1	9.95
4	1	1209-08.330-515	ROOF TOP COVER PLATE FOR REAR WALL	1	STEEL	IRS M 41 GR.1	5.95
3	4	1209-08.330-516	MODIFIED ROOFSIDE RH. FOR AC UNIT	1	STEEL	IRS M 41 GR.1	47.83
2	1	1209-08.130-515	MODIFIED ROOFSIDE LH. FOR AC UNIT	1	STEEL	IRS M 41 GR.1	47.52
1	1	1209-08.130-514	ROOF FRONT SHEET FOR AC	1	STEEL	IRS M 41 GR.1	38.94

3	DY. CEE (PPM)	NOTE 9 ADDED. DIMN. 25 & 20 WERE 21 & 16 RESP.	

चितरंजन रेलइंजन कारखाना
CHITTARANJAN LOCOMOTIVE WORKS, INDIA

ROOF SHEET SUB. ASSEMBLY FOR AC

1209-08.030-512

9. Dummy HEX M12X.25 Lg. STEEL SCREW TO BE FITTED AT HOLES OF ITEM No. 13

RED WORK