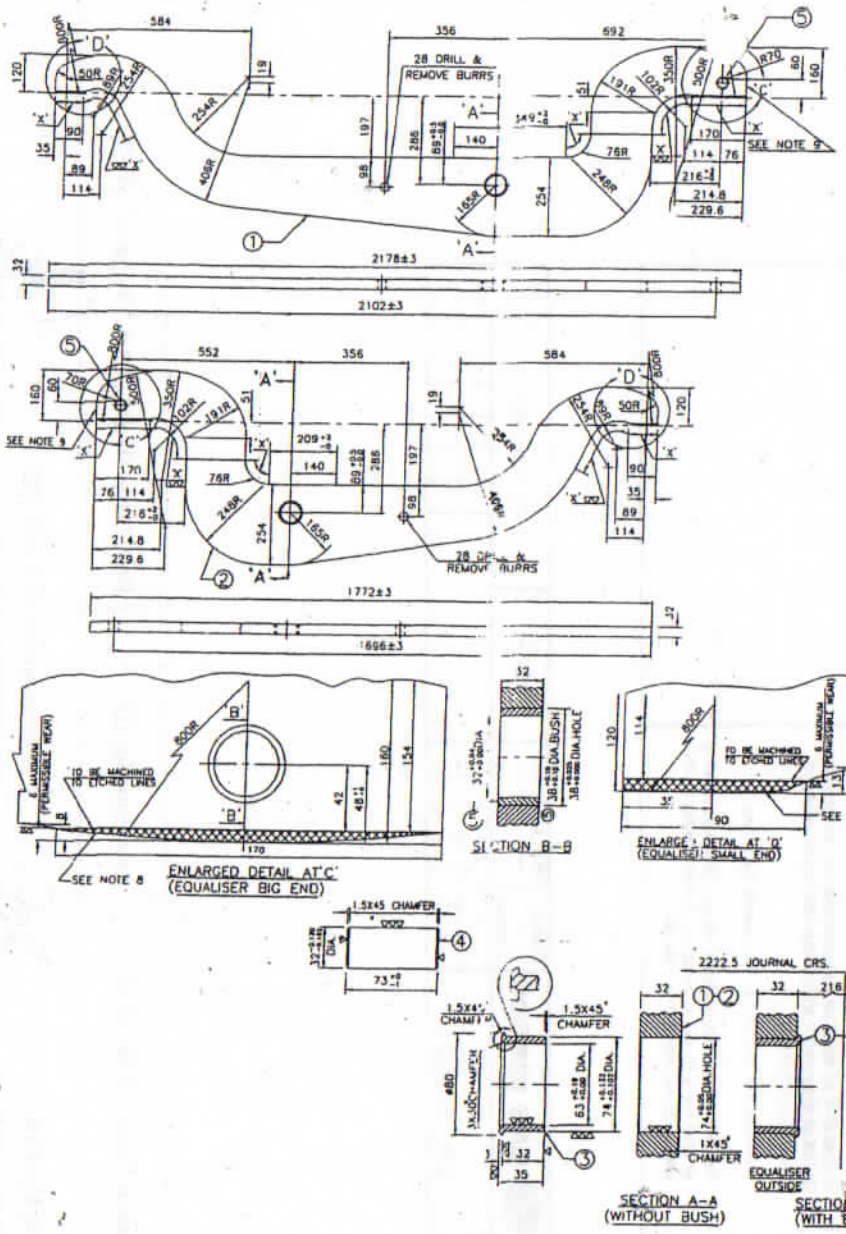

NOTES

1. EQUALIZER BEAM SHOULD BE CUT ALONG THE GRAINS FROM PLATES.
2. THE MATERIAL PROCURED FOR MANUFACTURE OF EQUALIZER BEAM (SHORT & LONG), SHOULD STRICTLY BE STEEL TO IS: 2062, 2011 Gr. E250 Cu, QUALITY 'C' (NORMALISED AND KILLED QUALITY). IT SHOULD BE SUBJECTED TO ULTRASONIC TESTING AS PER ASTM: A435 FOR PRESENCE OF ANY SUB-SURFACE FLAWS. IN CASE, THE ULTRASONIC TESTING REVEALS ANY FLAW, THE MATERIAL SHOULD BE REJECTED.
3. EQALIZER BEAM SHALL BE SUBJECTED TO MAGNETIC PARTICLE TEST AT LOCATION 'X' FOR DETECTION OF CRACKS, IF ANY. THE BEAM SHALL BE FREE FROM ANY DEFECT.
4. UNLESS OTHERWISE SHOWN ALL EDGES TO HAVE HAND GROUND FINISH.
5. HAND GRIND TO REMOVE ALL FLAME & TOOL MARKS-MAX: Ra µm 50 FINISH.
6. ALL NOTCHES, GOUGES TO BE GROUND SMOOTH AND SURFACE BLENDED. BUT SECTIONS AT SUCH POINTS MUST NOT BE UNDER WIDTH TOLERANCE. 3mm RAD ON ALL EDGES UNLESS OTHERWISE INDICATED.
7. HAND GRIND ALL OVER FLAT SURFACE TO REMOVE ROLLING SCALE BEFORE PAINTING FOLLOWED FROM LOCO NO- 23096 & ONWARD.
8. THE MATERIAL FOR PINS AND BUSHES STEEL Gr. 45C8 TO IS: 5517 SHALL BE IN NORMALISED CONDITATION WITH GRAIN SIZE 5 OR BETTER, HARDNESS: 183-223 BHN.
9. ULTRASONICALLY TESTED EQUALIZER BEAM SHOULD BE STAMPED WITH MENUFACTURER'S INITIALS MONTH AND YEAR OF MNUFATURE & SERIAL No. OF ITEM FOR THE MONTH UNDER REFERENCE IN THREE DIGITES & DRG. No. IN 6 mm LETTERS.
10. HARD FACING IS TO BE CARRIED OUT AS PER CODE OF PROCEDURE NO. MC-92 ISSUED BY R.D.S.O.
11. TOLERANCE: - ALL SECTION $^{+5}_{0}$

THICKNESS $^{+0.75}_{-0.25}$

5			BUSH	16	STEEL GR.45C8	IS: 5517 #	
4			PIN	16	STEEL GR.45C8	IS: 5517 #	
3			BUSH	16	STEEL GR.45C8	IS: 5517 #	
2			EQUALISER BEAM (SHORT)	8	STEEL	IS: 2062 GR.C	SEE NOTE 2
1			EQUALISER BEAM (LONG)	8	STEEL	IS: 2062 GR.C	
—	—	—	EQUALISER BEAM (LONG & SHORT)	—	—	—	—
निर्देश संख्या REF.NO.	ब्लाक एवं पिक्चर संख्या C & D NO.	अंग आरेखण संख्या PART DRG.NO.	वर्णन DESCRIPTION	संख्या/पिक्चर NO/LOCO	पदार्थ MATL	विशिष्टि SPECN	प्रति भार कि. ग्रा. NT. EACH IN KG.

आरेखित DRAWN	SACHCHIDANANDA
जाँचा CHKCRD	
अधिक्षक SUPDT	
कार्य आफिसर RDSO (D)	
स.प्र.वै. अधि. DY CEE (D)	
दिनांक DATE	18-9-2019
पैमाना SCALE	N.T.S.
अनुमोदन संदर्भ APPROVAL REF	

आरेखण संदर्भ
REF. ASSLY. DRG. NO.
RDSO DRG. No. SKVL-178, 01/1/15/17

EQUALISER BEAM (LONG & SHORT)

चित्तरंजन रेल इंजन कार खाना CHITTARANJAN LOCOMOTIVE WORKS

प्रयोग में WAM-4 & USED FOR WAG-5 LOCOS.

आरेखण संख्या DRAWING NO. 01/3/15/48 alt. 6

परिवर्तन संख्या/ALT.NO

6	Dy. CEE/DII	LONG+SHORT CLUBBED+UPDATED		
परिवर्तन संख्या ALT.NO.	प्राधिकार AUTHY	वर्णन DESCRIPTION	डिजिटल आद्याक्षर DATED INITIAL	

धातु-वेल्डन चिह्न IS:813 के अनुसार / WELDING SYMBOLS AS PER IS:813

सतह-रुक्षता का मान माप 3073 के अनुसार SURFACE ROUGHNESS VALUE TO IS:3073	पदांक GRADE NUMBER	सं1 N1	सं2 N2	सं3 N3	सं4 N4	सं5 N5	सं6 N6	सं7 N7	सं8 N8	सं9 N9	सं10 सं11 N10 N11	सं12 N12	
	Ra µm	0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5 25	50	
	चिह्न SYMBOL												

ORIGINAL

Signature Not Verified
Digitally signed by GURUDAS MANDAL
Date: 2022.04.19 07:24:46 IST
Reason: IRIMPS-CRIS
Location: New Delhi

dt.29.12.21