




- 5.6 All sharp edges, burrs and slag to be removed.
- 5.7 Metal shall not be affected/corroded when exposed in 100% relative humidity or Ambient temperature 80 deg C or heavy rainfall (upto next POH-9 years).
- 5.8 Any gouging, crack or detrimental defects in the products is not acceptable.
- 5.9 All the hardware items shall be of steel conformed to IS:1364, S8.8, P10.9, P10, IS: 1367 Part-III, Pt.II, Pt.XI Gr-A, IS:3063, DIN6924, Chromium plating /Zn-passivation as and when required. Supply to be taken from approved sources of CLW.
- 5.10 Dimensional tolerance required as per IS:2102 as and where not mentioned in the drg.

6. MANUFACTURE:

- 6.1 Steel used in manufacturing COMPLETE SHELL ASSLY will be as per the drawing mentioned in the material specification column of cost & detail book (C&D Book) as reference for modified CLW drawing.
- 6.2 Profiles shall be prepared on CNC Profile cutting Machine.
- 6.3 Central Under-frame Assly shall be machined on a planomillar machine.
- 6.4 Proper and smooth welding to be done to avoid distortion.
- 9 6.5 Flatness, parallelity, verticality shall be within limits. Waviness of the side wall panels will not be allowed beyond +/- 6 mm. +/- 3 mm.
- 6.6 After fabrication remove all grease, grime, oil, dust and surface contamination, weld spatter and slag before painting.
- 6.7 Surface preparation to be done i.e. abrasion blast clean before protective coating. All surfaces shall be cleaned from surface contamination incurred during the abrasive blasting.
- 6.8 Jig & fixtures and template to be used to maintain the geometry of the fabricated assly. Special care should be taken while drilling the holes and making the slots so that their positions conforms to the dimensions (with tolerance) as shown in the assly drawing. Pre drilled holes to be done as per the drawing. Jig & Fixture to have a precise dimensions.
- 6.9 Scratch, dent or any sort of damage is not acceptable on the finished product.
- 6.10 Work procedure, sequence of work, use of fixtures, quality checking to be followed CLW procedure.
- 6.11 During installation of Doors / Windows / Wind screen / Wiper Assly. / Driver Desk Assly. Proper hardware and sealant shall be used as per the following drawings.
 - (i) Cab Side Window (LHS & RHS) IB081-00345 Alt. 10
 - (ii) Cab Side Door (LHS) IB091-00010 Alt. 7
 - (iii) Cab Side Door (RHS) IB091-00009 Alt. 8
 - (iv) Machine Room door IA091-00002 Alt.11
 - (v) Wind Screen Assly. IB081-00348 Alt. 8
 - (vi) Protection Grill Assly. IB-081-00348 Alt. 8
 - (vii) Driver Desk Assly. IB081-00346 Alt. 8
 - (viii) Wiper Assly. IB081-00466 Alt. 8

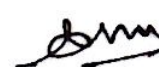
PREPARED BY  SSE/DRG	CHECKED BY  SSE/D	SPECN. FOR COMPLETE SHELL ASSLY FOR WAG-9/ WAG-9H/ WAG-9HC / WAP-7 LOCO	APPROVED BY  DY.CEE/D/CONV	ELDO (Mech) CHITTARANJAN LOCOMOTIVE WORKS NO.: CLW/MS/3/152 ALT-8 9
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ALTERATION RECORD SHEET- 2 of 2

SPECN FOR COMPLETE SHEEL ASSLY. FOR WAG-9/WAG-9H/WAG-9HC/WAP-7 LOCO

Alt. No.	Date of Alteration	Reason of Alteration	Approved by	Remarks
8.	31-08-2018	<p>1. This Specification modified.</p> <p>2. Included items in Annexure-A- Sl. No.1, 9, 10, 11 at Para 2.1.2 and added Para 2.1.3</p> <p>3. Items included in Annexure-B- Sl. No. 8, 9, 10, 11,12 at Para 2.3.2 and added Para 2.4.</p> <p>4. CB coupler and High Capacity draft gear are deleted from the scope of supply at Annexure A and B. which to be fitted after taking free supply from IR.</p>	<i>Amita</i>	Approved by PCEE on 31/08/2018 at PP-22 of file No.ELDD/3610 Shell specification- for WAG9/WAG9H/WAG9HC /WAP-7. Locomotive shell
9.	.03.2022	To change allowed waviness of sidewall from +/- 6mm to +/- 3mm at para 6.5 of Page 3/5 for better aesthetic view of loco.		As decided by competent authority.

PREPARED BY <i>Niraj Kumar</i> SSE/DRG	CHECKED BY  SSE/D	SPECN. FOR COMPLETE SHEEL ASSLY FOR WAG-9/ WAG-9H/ WAG-9HC / WAP-7 LOCO	APPROVED BY <i>Amita</i> DY.CEE/D/CONV	ELDO (Mech) CHITTARANJAN LOCOMOTIVE WORKS NO.: CLW/MS/3/152 ALT-8/9
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