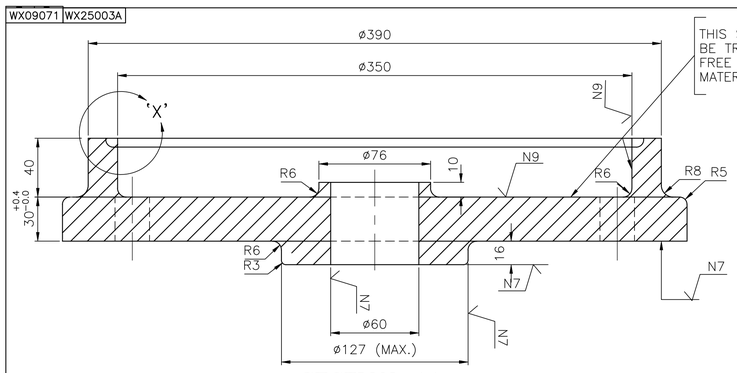
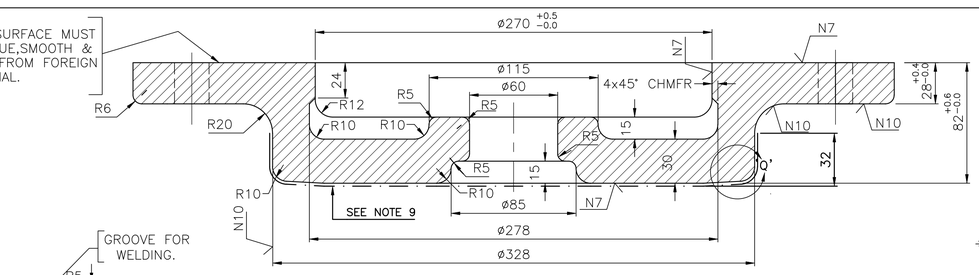
WX09071 WX25003A

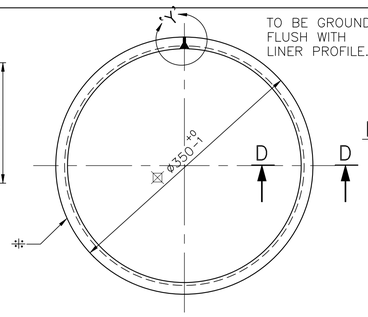


SECTION–AA

THIS SURFACE MUST BE TRUE,SMOOTH & FREE FROM FOREIGN MATERIAL.

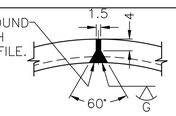


SECTION–BB

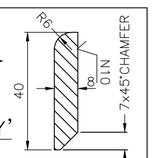


4

TO BE GROUND FLUSH WITH LINER PROFILE.

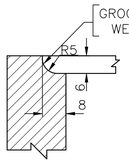


DETAIL AT 'Y'



SECTION–DD

GROOVE FOR WELDING.

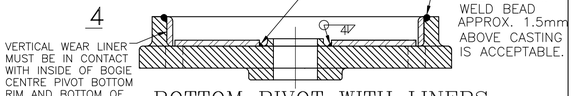


DETAIL AT 'X'

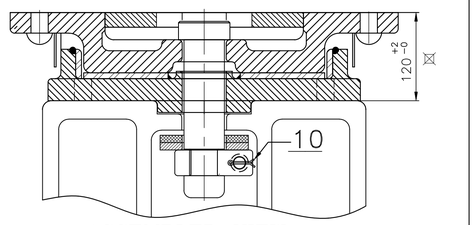
CONTINOUS WELD NOT TO EXTEND BEYOND TOP SURFACE OF HORIZONTAL WEAR LINER.

ALL ROUND WELD DO NOT GRIND WELD FLUSH. WELD BEAD APPROX. 1.5mm ABOVE CASTING IS ACCEPTABLE.

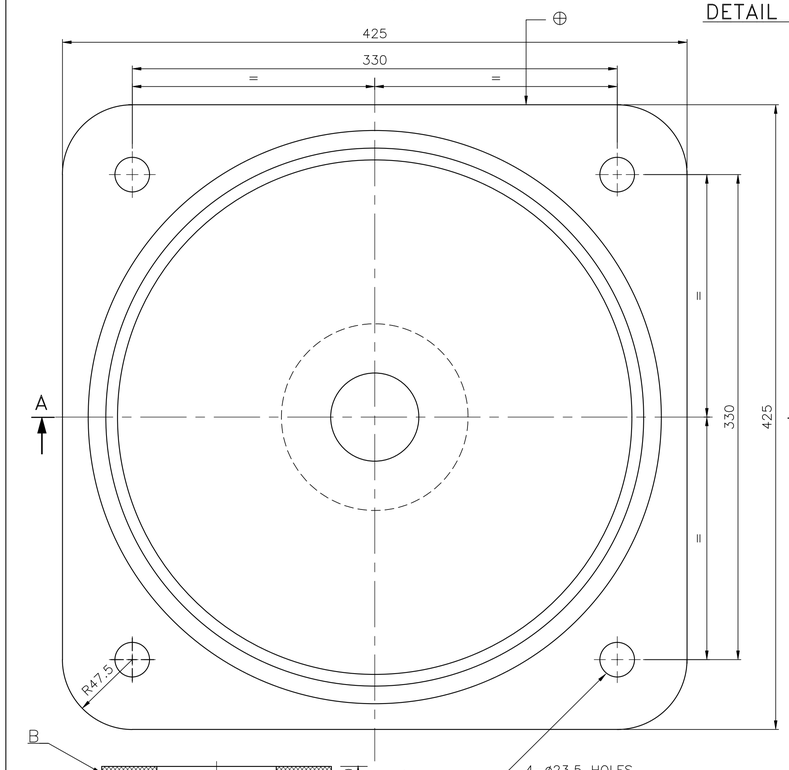
VERTICAL WEAR LINER MUST BE IN CONTACT WITH INSIDE OF BOGIE CENTRE PIVOT BOTTOM RIM AND BOTTOM OF THE RING MUST SEAT TIGHTLY BEFORE WELDING.

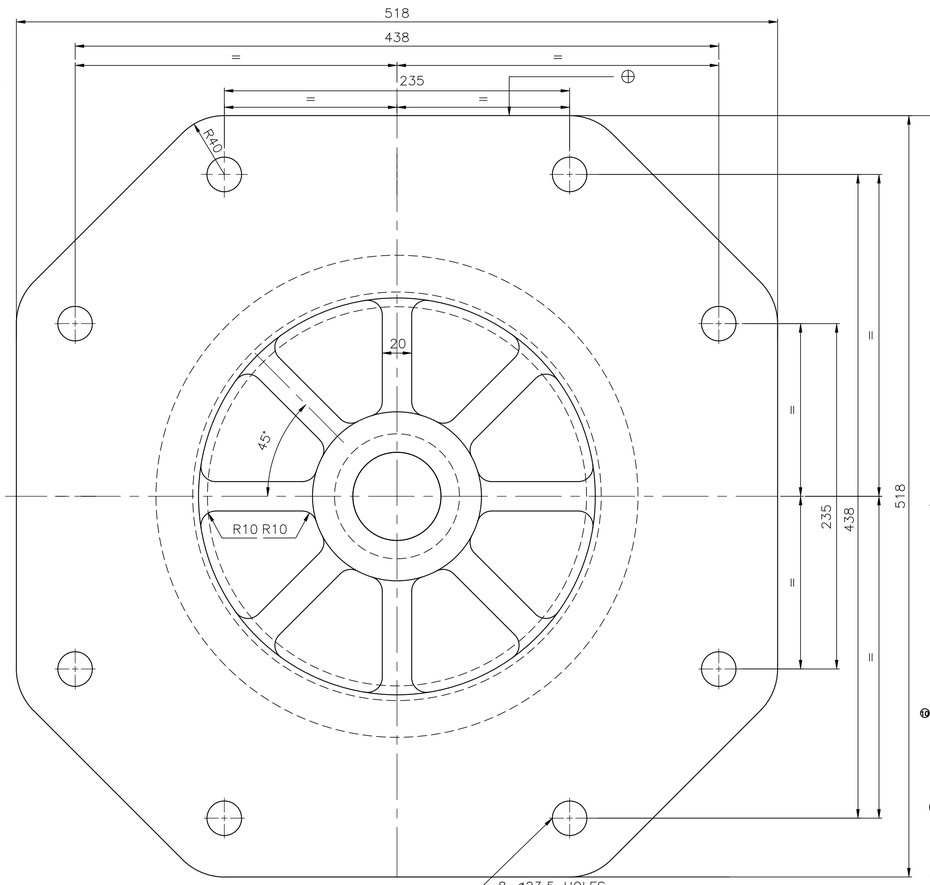


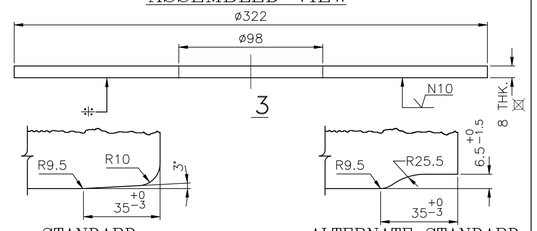
BOTTOM PIVOT WITH LINERS



ASSEMBLED VIEW



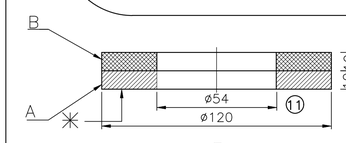




STANDARD

ALTERNATE STANDARD

B

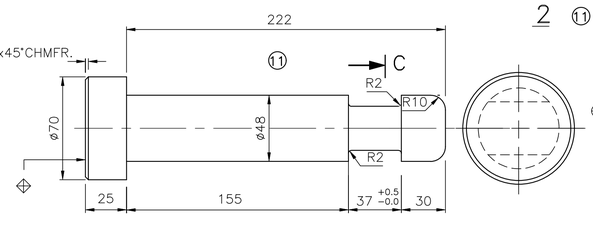


5

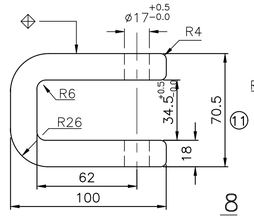
REF.LET	MATERIAL	SPECN.	COLOUR
A	STEEL	IS:2062 E–250A	RED PAINT (IS:5–CODE–538)
B	VULCANIZED NATURAL RUBBER BASED BLACK COMPOUND.	IS:5192	–

PART 'B' TO BE GLUED/BONDED TO 'A' IN A DIE.

9



6



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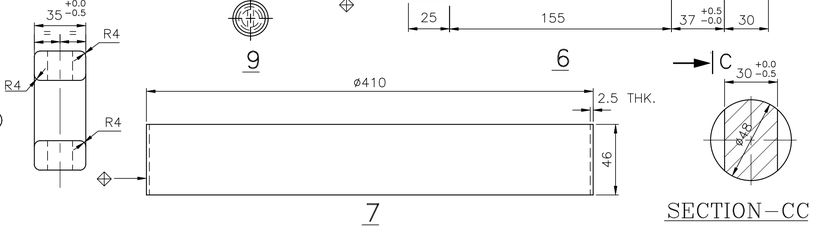

7

SECTION–CC

NOTE:–

1. SURFACE ROUGHNESS VALUES TO IS:3073.
2. MANUFACTURERS INITIAL, MONTH&YEAR TO BE FORGED IN 6mm SIZE & 0.5mm DEPTH,ALTERNATIVELY MONTH & YEAR OF MANUFACTURING CAN BE MARKED BY METAL LASER ENGRAVING/DOT PEEN IN 6mm SIZE & 0.2mm DEPTH MIN.
3. EMBOSS DRG.NO./ITEM NO.,MANUFACTURER'S INITIAL, MONTH & YEAR OF MANUFACTURE ON PART 'A' IN 6mm SIZE.
4. CENTRE PIVOT BOTTOM & TOP (ITEM 1 & 2) ARE TO BE PROCURED FROM SOURCES APPROVED BY R.D.S.O.
5. DRG.NO.,ITEM NO.,MANUFACTURER'S INITIAL,S.NO. OF CAST, MONTH & YEAR OF MANUFACTURING TO BE CAST IN 10mm RAISED LETTERS TYPE.
6. DIMENSION MARKED AS ☒ IS TO BE STRICTLY MAINTAINED.
7. SURFACE FINISH OF 'N7' ALL OVER, UNLESS OTHERWISE STATED.
8. MATERIAL FOR ITEM–3 AND 4:–
   A. MATERIAL SPECIFICATION TO IRS:R65–78
   B. MECHANICAL PROPERTIES AND CHEMICAL COMPOSITION SHALL CONFIRM TO IS:276–1969 Gr–1 EXCEPT HARDNESS.
   C. HARDNESS – AS PER SPCIFICATION IRS:R65–78

ENLARGED DETAIL AT 'Q'

9. HEAT TREATMENT THE HEAT TREATMENT CYCLE SUITABLY ADJUSTED BY MANUFACTURER TO ACHIEVE FULLY AUSTENITIC STRUCTURE.
10. SURFACE MARKED "— · —" THUS OF CENTRE PIVOT TOP (ITEM 2) SHALL BE SURFACE HARDENED UPTO DEPTH OF 3mm. VALUE OF HARDNESS SHALL BE 300 BHN MINIMUM AT 3 MM DEPTH.
11. MANUFACTURERS INITIAL, MONTH & YEAR OF MANUFACTURING SHALL BE MARKED BY METAL LASER ENGRAVING IN 6mm SIZE & 0.1mm DEPTH MIN. LINER SHALL BE FITTED IN SUCH A WAY THAT MARKING LIES ON OPPOSITE TO WEARING SURFACE.
12. MANUFACTURERS INITIAL, MONTH & YEAR OF MANUFACTURE TO BE MARKED BY METAL LASER ENGRAVING/DOT PEEN IN 3mm SIZE & 0.1 MM DEPTH.
13. MANUFACTURING & TESTING OF ITEM 6, 8 & 9 SHALL BE AS PER RDSO STR–WX25001 AND FOR ITEM–5 AS PER RDSO STR–WX23008.
14. ITEM–5 ALWAYS BE FITTED SUCH THAT RUBBER PART REMAINS ON TOP.
15. PERMISSIBLE DEVIATION ON NOMINAL DIM. OF CASTINGS SHALL BE AS PER IS:4897 CL–1 & FOR FORGINGS AS PER IS:3469 CLOSE QUALITY.

ITEM	DESCRIPTION & DIMENSIONS	NO.OFF PER BOGIE	REF.DRG	WT.OF ONE (KG)	MAT.& SPEC	REMARKS
12 10.	ø3.6X64 SPRING COTTERS PIN (R CLIP) OR ø(3.5–3.7)X50 SPLIT PIN	1	–		DIN:11024 OR IS:549 MAT.–STEEL	ZINC PLATED
11 9.	LOCK PIN	1	–		IS:1875 Cl–4 OR IS:2004 Cl–4	NORMALISED
11 8.	SHACKLE LOCK	1	–		IS:1875 Cl–4 OR IS:2004 Cl–4	NORMALISED
7.	DUST SHIELD	1	–		IS:1079–Gr.HR1	
11 6.	CENTER PIVOT PIN	1	–		IS:1875 Cl–4 OR IS:2004 Cl–4	NORMALISED
11 5.	WASHER	1	–		SEE TABLE	
4.	VERTICAL WEAR LINER	1	–		SEE NOTE–8	
3.	HORIZONTAL WEAR LINER	1	–		SEE NOTE–8	
2.	BOGIE CENTRE PIVOT TOP	1	–		M–201 Gr.'C'	HARDNESS 179–241 BHN
1.	BOGIE CENTRE PIVOT BOTTOM	1	–		M–201 Gr.'C'	HARDNESS 179–241 BHN

ALT.	ITEM	AUTHY.	DESCRIPTION	DATE	CKD	ASSEMBLY DRAWING
12	10	WD–25091	ALTERNATE PIN(COTTER PIN) ADDED	11/25		
11	5,6,8 & 9	WD–25015	DIMENSION REVISED IN ITEM NO.5,6,8&9. NOTE–2,3 REVISED. ITEM–10 & NOTE 12,13,14,15 ADDED.	03/25		
10	3,4	WD–23092	NOTE–11 ADDED.	11/23		
9	8,9&6	WD–23008	DIMENSION REVISED IN ITEM NO.8&9, NOTE 2 REVISED. MATERIAL CHANGED FOR ITEM NO.06	02/23		
8	3&4	WD–18058	NOTE–8 REVISED.	08/18		

SUPERSEDED BY			CASNUB 22HS, CASNUB 22HS(MOD–I) & IRF–108HS BOGIE
SUPERSEDES		DATE	
SCALE	PASSED		CENTRE PIVOT ASSEMBLY AND DETAILS
1:2	CHECKED	dixit.S.C 11/97	
1:2.5	DRAWN	sharma.s.k 11/97	
	TRACED		
	J.SHEET	WD–97049	
B.G.	R.D.S.O. [W]	GROUP	WD–97049–S/3

Signature Not Verified
Digitally signed by CHANDAN KUMAR CHOUDHARY
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