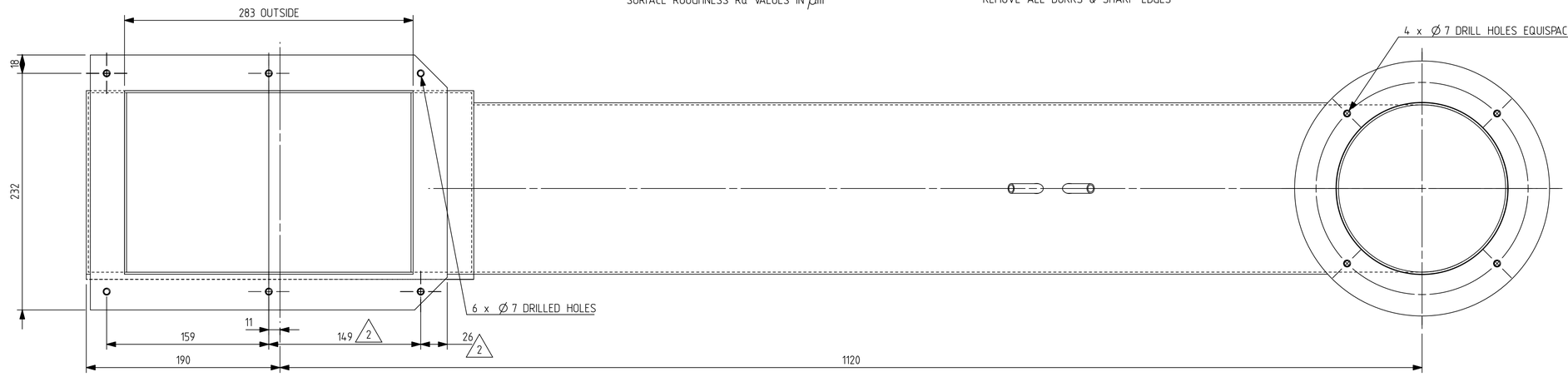
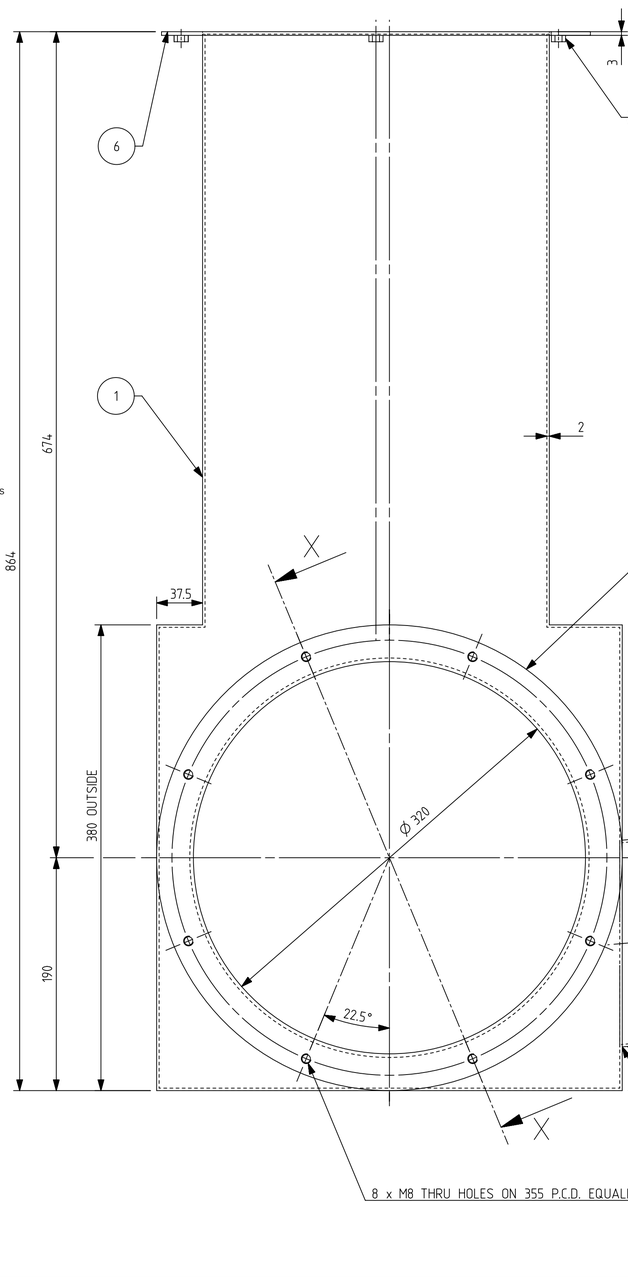
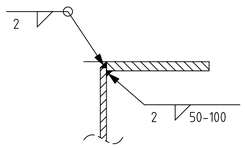
SURFACE ROUGHNESS Ra VALUES IN μm

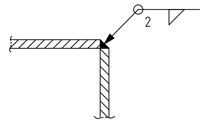
REMOVE ALL BURRS & SHARP EDGES

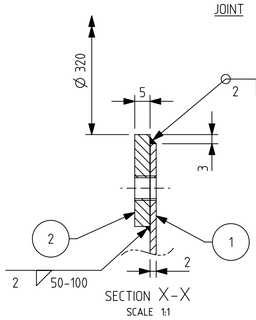




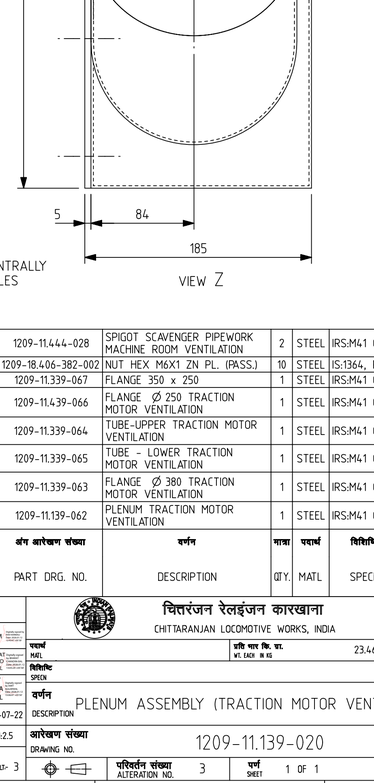


FLANGE / BODY CONNECTION
SCALE 1:1

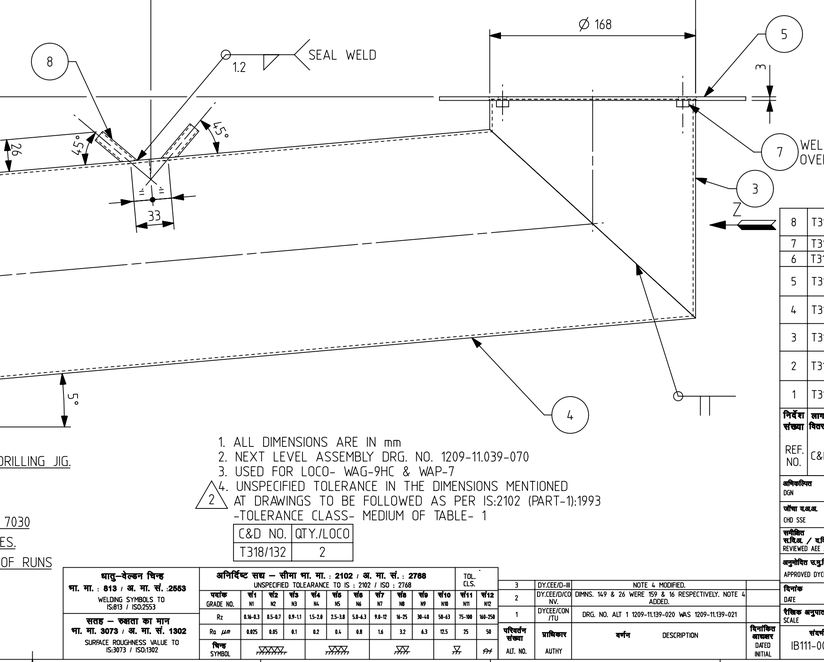




SECTION X-X
SCALE 1:1



VIEW Z



NOTES:-

1. HOLES ON FLANGE OF THE PLENUM ASSEMBLY TO BE DONE BY DRILLING JIG.
2. WELDING TO BE DONE AS PER IS: SPECN.
3. ALL HEX NUTS TO BE WELDED ON FLANGE AS SHOWN.
3 4. FINISHED PRODUCT IS TO BE PAINTED STONE GREY AS PER RAL 7030 WITH PRIME COAT OF 150 MICRON & FINISH COAT OF 210 MICRONES.
5. ALL PAINT WORK SHALL BE UNIFORM APPREANCE AND BE FREE OF RUNS PEELS AND OTHER DEFECTS.
6. FOR OTHER DETAILS REFER TECH.SPECN. NO. CLW/MS/3/099.
7. TO BE SUPPLIED IN A SET AS PER TECH SPECN.

1. ALL DIMENSIONS ARE IN mm
2. NEXT LEVEL ASSEMBLY DRG. NO. 1209-11.039-070
3. USED FOR LOCO- WAG-9HC & WAP-7
2 4. UNSPECIFIED TOLERANCE IN THE DIMENSIONS MENTIONED AT DRAWINGS TO BE FOLLOWED AS PER IS:2102 (PART-1):1993 -TOLERANCE CLASS- MEDIUM OF TABLE- 1

C&D NO.	QTY./LOCO
T318/132	2

धातु–वेल्डन चिन्ह 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. CLS.	
	ग्रेड GRADE NO.	घ1 H1	घ2 K2	घ3 h3	घ4 h4	घ5 h5	घ6 h6	घ7 h7	घ8 h8	घ9 h9	घ10 h10	घ11 h11	घ12 h12	
	Rz	0.16-0.3	0.5-0.7	0.9-1.1	1.5-2.0	2.5-3.0	5.0-6.3	9.0-12	16-25	36-48	58-63	75-100	140-250	
चराव — रुक्षता 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	प्राधिकार	वर्णन DESCRIPTION	परिवर्तित वाराखर DATED INITIAL
3	DY.CEE/D-III	NOTE 4 MODIFIED.	
2	DY.CEE/D/CO NV.	DIMNS. 149 & 26 WERE 159 & 16 RESPECTIVELY. NOTE 4 ADDED.	
1	DY.CEE/CON /TU	DRG. NO. ALT 1 1209-11.139-020 WAS 1209-11.139-021	
ALT. NO.	AUTHY		

8	T318/139	1209-11.444-028	SPIGOT SCAVENGER PIPEWORK MACHINE ROOM VENTILATION	2	STEEL	IRS:M41 GR.I 0.01
7	T318/138	1209-18.406-382-002	NUT HEX M6X1 ZN PL. (PASS.)	10	STEEL	IS:1364, PT-3
6	T318/237	1209-11.339-067	FLANGE 350 x 250	1	STEEL	IRS:M41 GR.I 0.83
5	T318/137	1209-11.439-066	FLANGE Ø 250 TRACTION MOTOR VENTILATION	1	STEEL	IRS:M41 GR.I 0.60
4	T318/135	1209-11.339-064	TUBE-UPPER TRACTION MOTOR VENTILATION	1	STEEL	IRS:M41 GR.I 7.71
3	T318/136	1209-11.339-065	TUBE - LOWER TRACTION MOTOR VENTILATION	1	STEEL	IRS:M41 GR.I 0.83
2	T318/134	1209-11.339-063	FLANGE Ø 380 TRACTION MOTOR VENTILATION	1	STEEL	IRS:M41 GR.I 1.30
1	T318/133	1209-11.139-062	PLENUM TRACTION MOTOR VENTILATION	1	STEEL	IRS:M41 GR.I 12.06
निर्देश संख्या	प्रापण एवं वितरण संख्या	अंग आरेखण संख्या	वर्णन	मात्रा	पदार्थ	विशिष्टि	प्रति भाग कि. ग्रा.
REF. NO.	C&D NO.	PART DRG. NO.	DESCRIPTION	QTY.	MATL	SPECN	WT. EACH IN K.G.

अधिशासित DGM		चितरंजन रेलइंजन कारखाना CHITTARANJAN LOCOMOTIVE WORKS, INDIA	
वरीय उ.अ.प्र. CHD SSE	RAVI KARM ALI	पदार्थ MATL	प्रति भाग कि. ग्रा. WT. EACH IN KG 23.46
पुनरीक्षित प.मु.नि.अ. / म.नि.अ. REVIEWED AEE / SSE	BHAMAK CHAND PA BAL	विशिष्टि SPECN	
अनुमोदित प.मु.नि.अ. APPROVED DYCEE	AMIT AGGA RWAL	वर्णन DESCRIPTION	PLENUM ASSEMBLY (TRACTION MOTOR VENTILATION)
दिनांक DATE	21-07-22		
रैखिक अनुपात SCALE	1:2.5	आरेखण संख्या DRAWING NO.	1209-11.139-020
		परिवर्तन संख्या ALTERATION NO. 3	पृष्ठ SHEET 1 OF 1 A1

IB111-00051 ALT- 3

Signature Not Verified
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