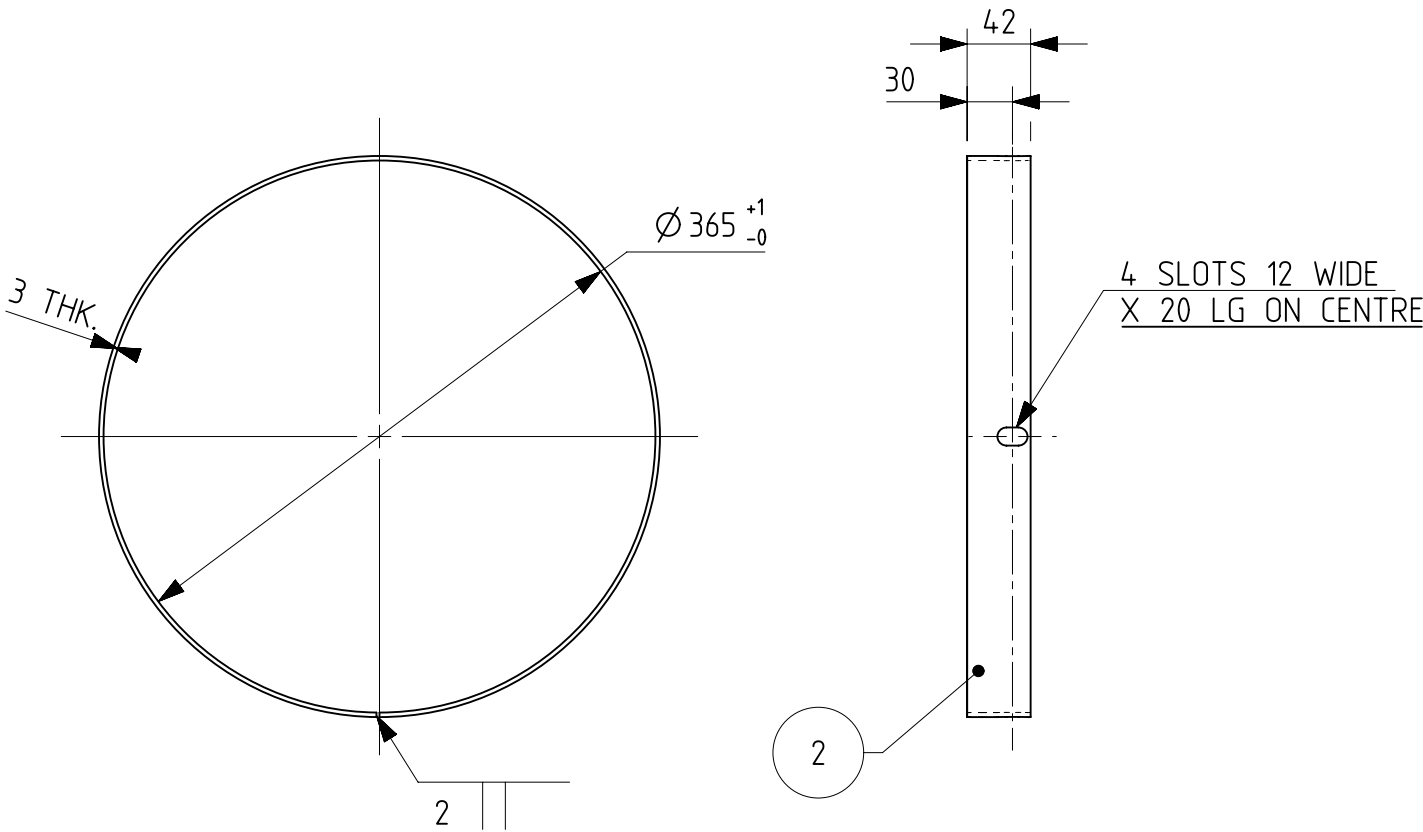


SURFACE ROUGHNESS Ra VALUES IN μm



NOTE:-

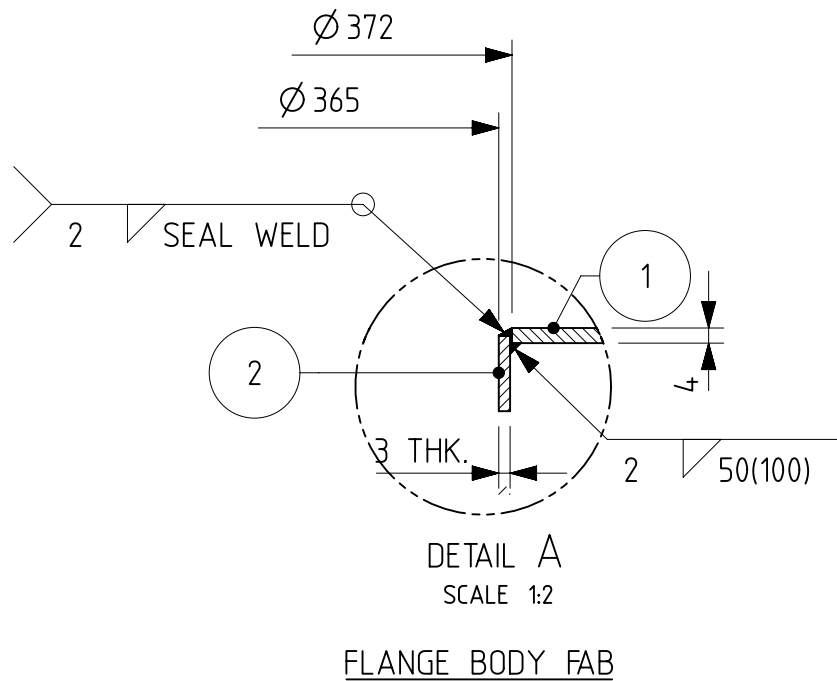
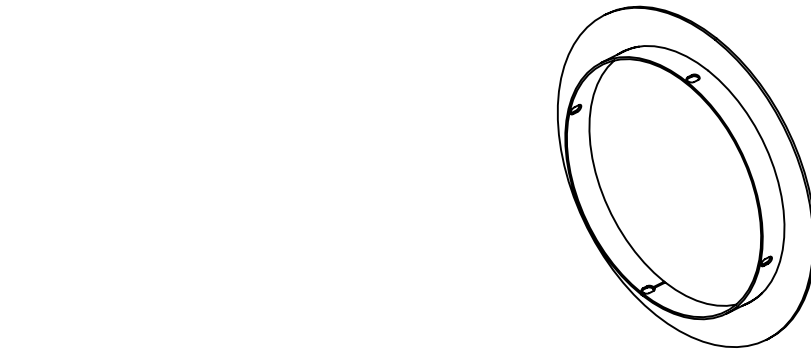
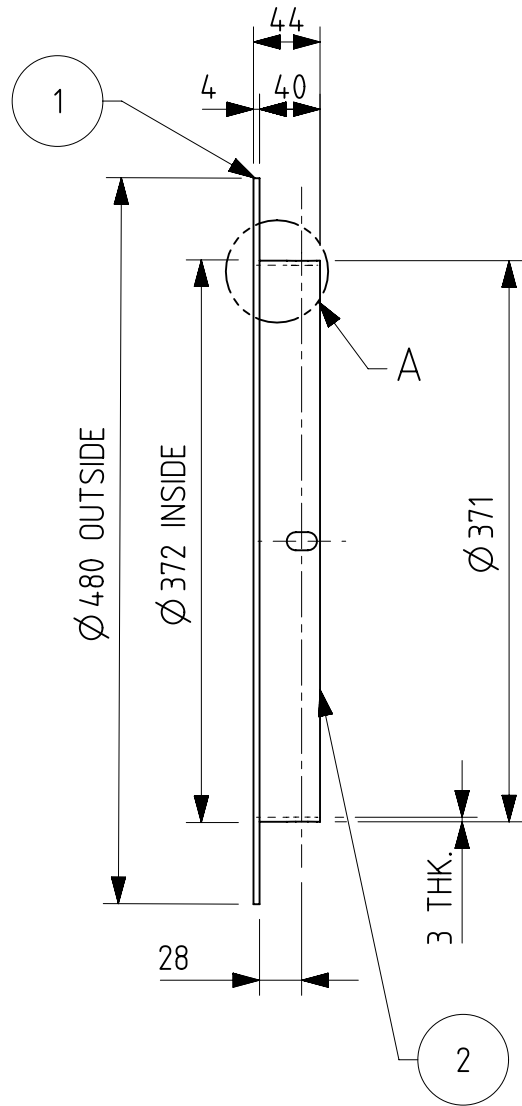
1. SURFACE SHALL BE SMOOTH TRUE AND FINISHED.
2. THIS ASSLY IS DESIGNED TO SLIDE OVER DUCT BEND ASSEMBLY TO DRG NO. 1209-11.244-035,A TIGHT FIT IS REQUIRED CHECK FIT PRIOR TO PAINTING.
3. ASSLY TO BE FINALLY PAINTED WITH STONE GREY COLOUR AS PER RAL7030.
4. FOR OTHER TECHNICAL DETAILS REFER TECH SPECN NO. CLW/MS/3/099.
5. THIS ASSEMBLY IS TO BE SUPPLIED IN A SET.
6. THIS ASSEMBLY IS ALSO APPLICABLE FOR WAP-5 LOCO & TO BE SUPPLIED IN A SET AS PER TECH. SPECN. NO. CLW/MS/10/048 ALT.-3 & ANNEXURE B.

1. ALL DIMENSIONS ARE IN mm
2. NEXT LEVEL ASSEMBLY DRG. NO. 1209-11.144-078
3. USED FOR LOCO- WAG9HC, WAP-7, WAP-5

C&D NO.	QTY./LOCO
T323/110	2
B323/055	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

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



2	B323/057	T323/112	1209-11.344-075	RING- SLIP JOINT	1	STEEL	IRS: M41 GR.-I	1.14
1	B323/056	T323/111	1209-11.444-074	FLANGE Ø 480 MACHINE ROOM VENTILATION	1	STEEL	IRS: M41 GR.I	2.27
निर्देश संख्या	लागत एवं वितरण संख्या	लागत एवं वितरण संख्या	अंग आरेखण संख्या	वर्णन	मात्रा	पदार्थ	विशिष्टि	प्रति भार कि. ग्रा.
REF. NO.	C&D NO. FOR WAP-5	C&D NO. FOR WAG-9HC	PART DRG. NO.	DESCRIPTION	QTY.	MATL	SPECN	WT. EACH IN K.G.

अधिकृतित DGN				चितरंजन रेलइंजन कारखाना CHITTARANJAN LOCOMOTIVE WORKS, INDIA	
जॉचा व.अ.अ. CHD SSE				प्रति भार कि. ग्रा. WT. EACH IN KG	3.41
समीक्षित स.वि.अ. / व.वि.अ. REVIEWED AEE / SEE		वर्णन DESCRIPTION		SLIP JOINT RING ASSEMBLY (FOR MACHINE ROOM VENTILATION)	
अनुमोदित उ.यु.वि.अ. APPROVED DYCEE		आरेखण संख्या DRAWING NO.		1209-11.344-043	
दिनांक DATE	11-11-21	परिवर्तन संख्या ALTERATION NO.		2	
रैखिक अनुपात SCALE	1:5	पुर्ण SHEET		1 OF 1	
संदर्भ / REF. IA116-00089 ALT- 2		परिवर्तन संख्या ALTERATION NO.		2	
दिनांकित DATED INITIAL		परिवर्तन संख्या ALTERATION NO.		2	