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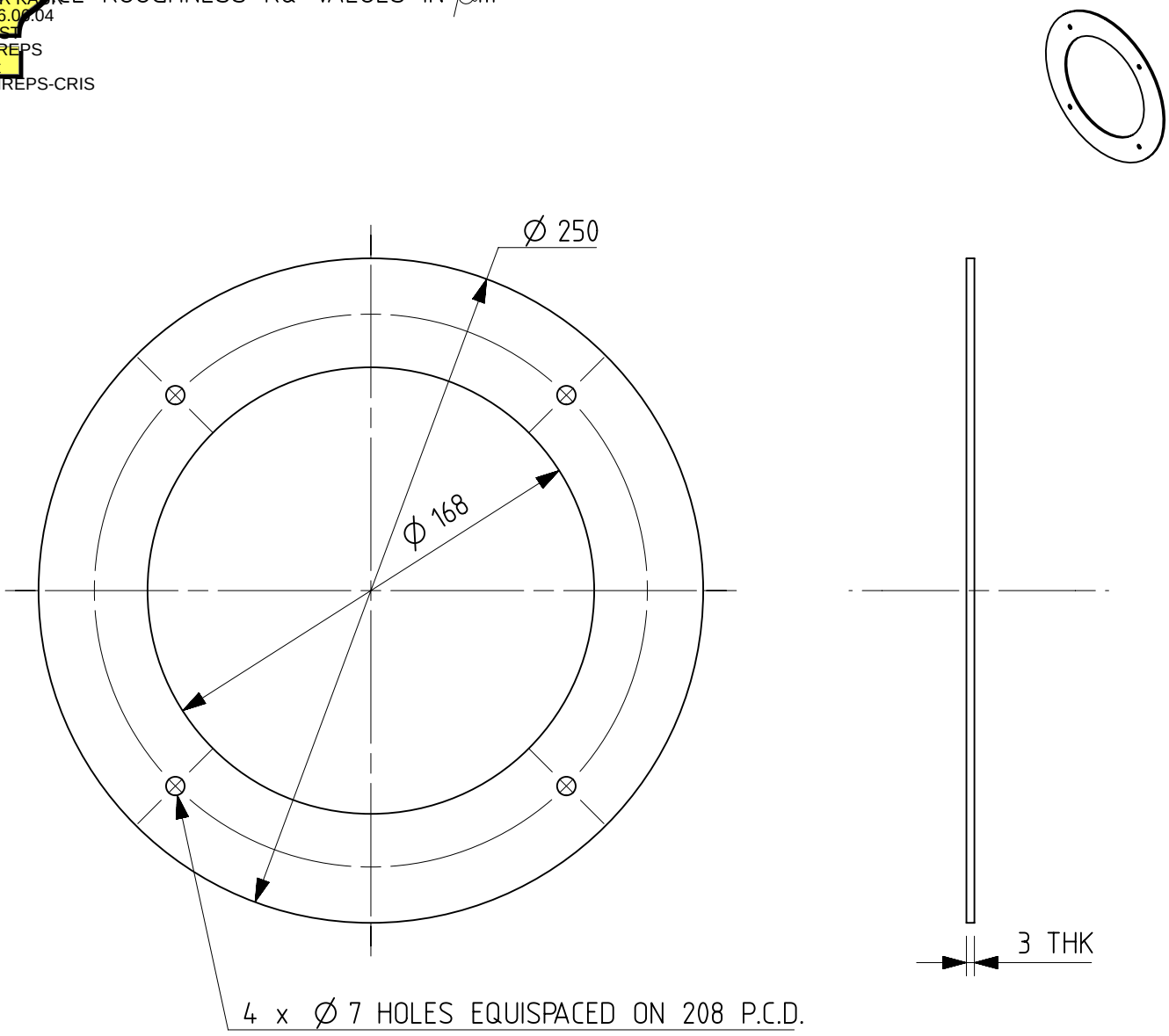
SURFACE ROUGHNESS Ra VALUES IN μm



1. ALL DIMENSIONS ARE IN mm
2. NEXT LEVEL ASSEMBLY DRG. NO. 1209-11.139-020, 1209-11.339-034 & 1210-11.139-015
3. USED FOR LOCO- WAG-9HC, WAP-7 & WAP-5
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
T318/137	2
T318/162	2
B318/079	2

परिवर्तन संख्या ALT.NO.	प्राधिकार AUTHY	वर्णन DESCRIPTION	दिनांकित आद्यक्षर DATED INITIAL
1	Dy.CEE/DI/Conv	NOTE 4 ADDED	

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

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
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												

अभिकल्पित DGN	
जाँचा व.अ.अ. CHD SSE	SHIB NARAYAN KUNDU
समीक्षित स.वि.अ. / व.वि.अ. REVIEWED AEE / SEE	
अनुमोदित उ.मु.वि.अ. APPROVED DYCEE	SYAMA PRASAD PATRA
दिनांक DATE	04-07-2022
रैखिक अनुपात SCALE	1:2.5
संदर्भ / REF.	IA112-00027 ALT.- 1

चित्तरंजन रेलइंजन कारखाना
CHITTARANJAN LOCOMOTIVE WORKS, INDIA

पदार्थ MATL	STEEL
प्रति भार कि. ग्रा. WT. EACH IN KG	0.6
विशिष्टि SPECN	IRS:M41 GR.I
वर्णन DESCRIPTION	FLANGE Ø 250 TRACTION MOTOR VENTILATION
आरेखण संख्या DRAWING NO.	1209-11.439-066
परिवर्तन संख्या ALTERATION. NO.	1
पर्ण SHEET	1 OF 1
	A4

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