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Digitally signed by RAJESH KUMAR MISHRA
Date: 2026.06.15 11:56:40 IST
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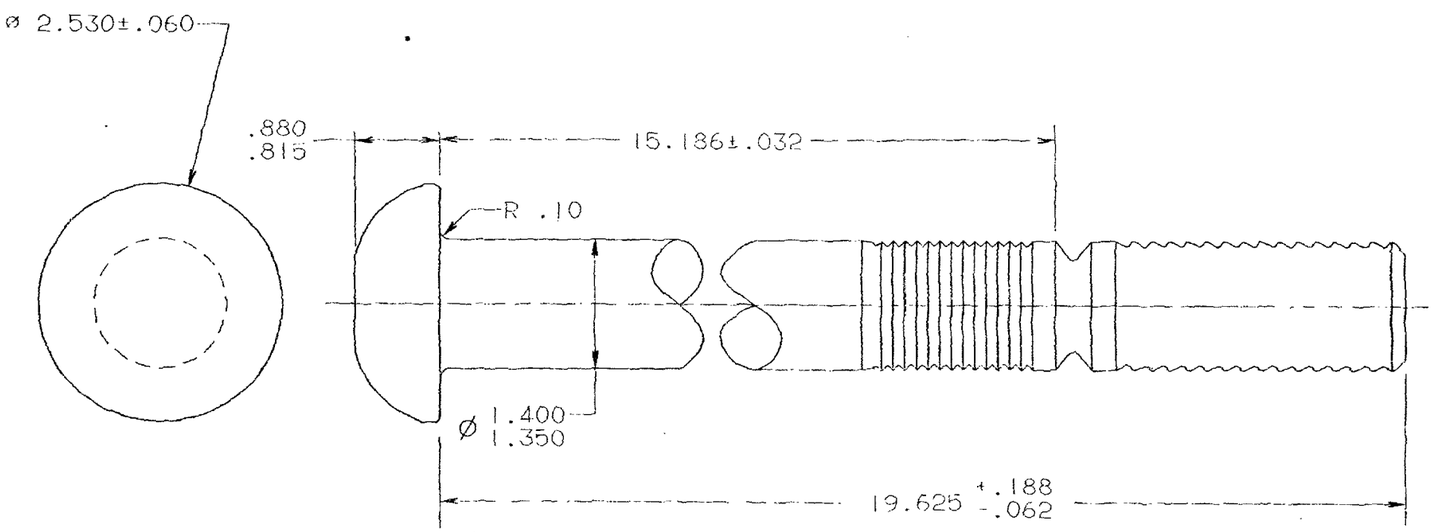
Wt. /ASSLY.	f-1 FINISH ROUGH	(01) ROUGH CLEANING
	f-10 FLAME CUT	(1B) CHAMFERED
		(01b) BURRS REMOVED

SURFACE ROUGHNESS VALUE TO IS: 3073

GRADE.NO	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12
Ra µm	.025	.050	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50
SYMBOL	▽▽▽			▽▽▽			▽▽			▽		~

ALT.NO.	ALTERATION	REASON	CHECKED BY SSE/VEH	VERIFIED BY ADE/BOGIE	APPROVED BY Dy CDE/VEH
(b)	DRAWING REDRAWN.	DRAWING MADE IN DLW FORMAT	-Sd- 23/03/10		-Sd- 23/03/10
(c)	NOTE ADDED	QUALITY IMPROVEMENT	-Sd- 16/12/15		-Sd- 16/12/15
(d)	NOTE 1 & 2 REVISED	CORRECTION	-Sd- 20/03/18		-Sd- 20/03/18
(e)	1. CARBON STEEL CHANGED TO SAE 4140H 2. NOTE REVISED 3. OEM DELETED	1 CORRECTION 2. IS 1367 (PART -18) ADDED	-Sd- 30/10/23	-Sd- 30/10/23	-Sd- 30/10/23
(f)	ALLOY STEEL (IS 1367, PART -3 ADDED)	MODIFICATION	31/10/24	Revised 3/12/24	03/12/24



GRIP RANGE : 12.875 MIN. TO 13.500 INCH MAX

(f) (e) MATERIAL : SAE 4140 H OR ALLOY STEEL (IS 1367, PART 3)

(i) TO ACHIEVE THE DESIRED PROPERTIES SUITABLE ALLOYING ELEMENTS MAY BE ADDED

(ii) LOCK BOLT SHALL BE SUITABLY HEAT TREATED TO ACHIEVE INSTALLED MECHANICAL PROPERTIES

INSTALLED DATA:

SHEAR (MIN)	100,000 LBS
CLAMPING FORCE (MIN)	85, 000 LBS
TENSILE (MIN)	129,500 LBS

(c) NOTE

(e) (d) 1. IDENTIFICATION MARKING AND PACKING : IS 1367 (PART 18)

QTY/LOCO-04 (e)

NO. OFF	DESCRIPTION & DIMENSION	ITEM	PART NO.	DRG. NO.	APPROX. Wt. /UNIT	MATERIAL	SPECIFICATION
04	LOCKBOLT-1 3/8"	1	19331095	40022085		CARBON STEEL	SAE 4140H
	GROUP : MOTOR TRUCK				SUPERSEDED BY		
					SUPERSEDES		

WDG4, 4D/WDP4B, 4D LOCO

LOCKBOLT-1 3/8"

SCALE | CHECKED BY 31/10/24

PROJECTION | DRAWN BY 03/12/24

ALT. a b c d e f

THIS DRAWING IS A PROPERTY OF BLW/INDIAN RAILWAYS AND ANY UNAUTHORISED USE OF THE DRAWING WILL BE CONSIDERED ILLEGAL AND BLW/INDIAN RAILWAYS WILL HAVE RIGHT TO INITIATE LEGAL PROCEEDINGS AGAINST THE DEFAULTERS.

ALL DIMENSIONS ARE IN INCHES
ISSUING AUTHORITY : SSE/RECORDS

Dy CDE/VEH	ADE/ BOGIE	ASSLY. PART NO.
03/12/24	3/12/24	

ब.रे.का. BANARAS LOCOMOTIVE WORKS VARANASI

PART NO.19331095

PART NO.40022085