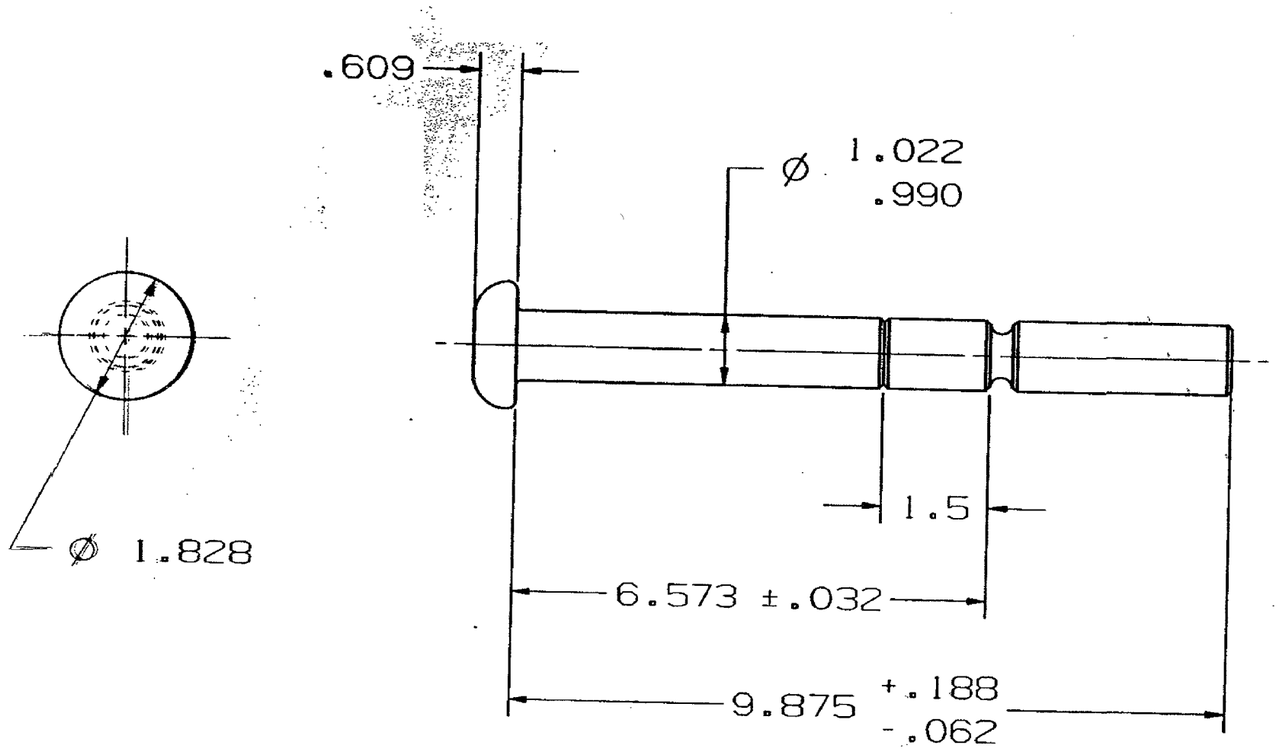
Signature Not Verified
Digitally signed by RAJESH KUMAR MISHRA
Date: 2026.06.13 11:27:18 IST
Reason: IREPS
Document
Location: IREPS-CRIS

Wt. /ASSLY.	f-1 FINISH ROUGH	(01) ROUGH CLEANING
	f-10 FLAME CUT	(1B) CHAMFERED
		(01A) 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
(a)	DRAWING REDRAWN.	DRAWING MADE IN DLW FORMAT	-Sd- 23/03/10		-Sd- 23/03/10
(b)	OEM PART NO ADDED	CORRECTION	-Sd- 01/02/13		-Sd- 01/02/13
(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. MEDIUM 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			



NOTE

GRIP RANGE : 5.00 – 5– 1/4 INCH

INSTALLED DATA:

SHEARING (MIN)	56,500 LBS
CLAMPING FORCE(MIN)	51, 500 LBS
TENSILE (MIN)	72,700 LBS

ⓒ NOTE

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

ⓕ ⓔ 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

QTY/LOCO–24 ⓔ

NO. OFF	DESCRIPTION & DIMENSION	ITEM	PART NO.	DRG. NO.	APPROX. Wt. /UNIT	MATERIAL	SPECIFICATION
24	LOCKBOLT-1 "	1	17160546	40078923	2.6 LBS	MEDIUM CARBON STEEL	SAE 4140H

GROUP : MOTOR TRUCK

SUPERSEDED BY

SUPERSEDES

WDG4, 4D/WDP4B, 4D LOCO

LOCKBOLT–1"

SCALE

CHECKED BY 31/12/24

PROJECTION

DRAWN BY 31.12.24

ALT. a b c d e f

बा.रे.का. BANARAS LOCOMOTIVE WORKS VARANASI

PART NO.17160546

PART NO.40078923

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.
23/12/24	31/12/24	