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Digitally signed by GOPA KAUR SATHI
Date: 2026.01.09 18:16:31 IST
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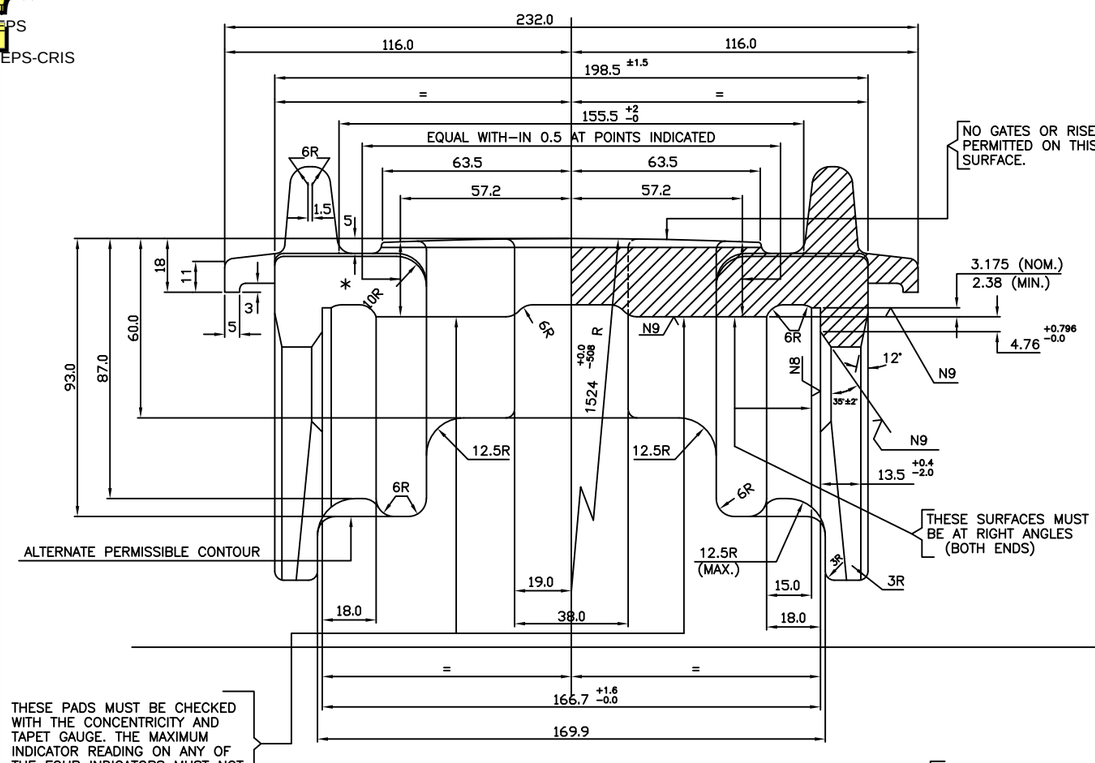
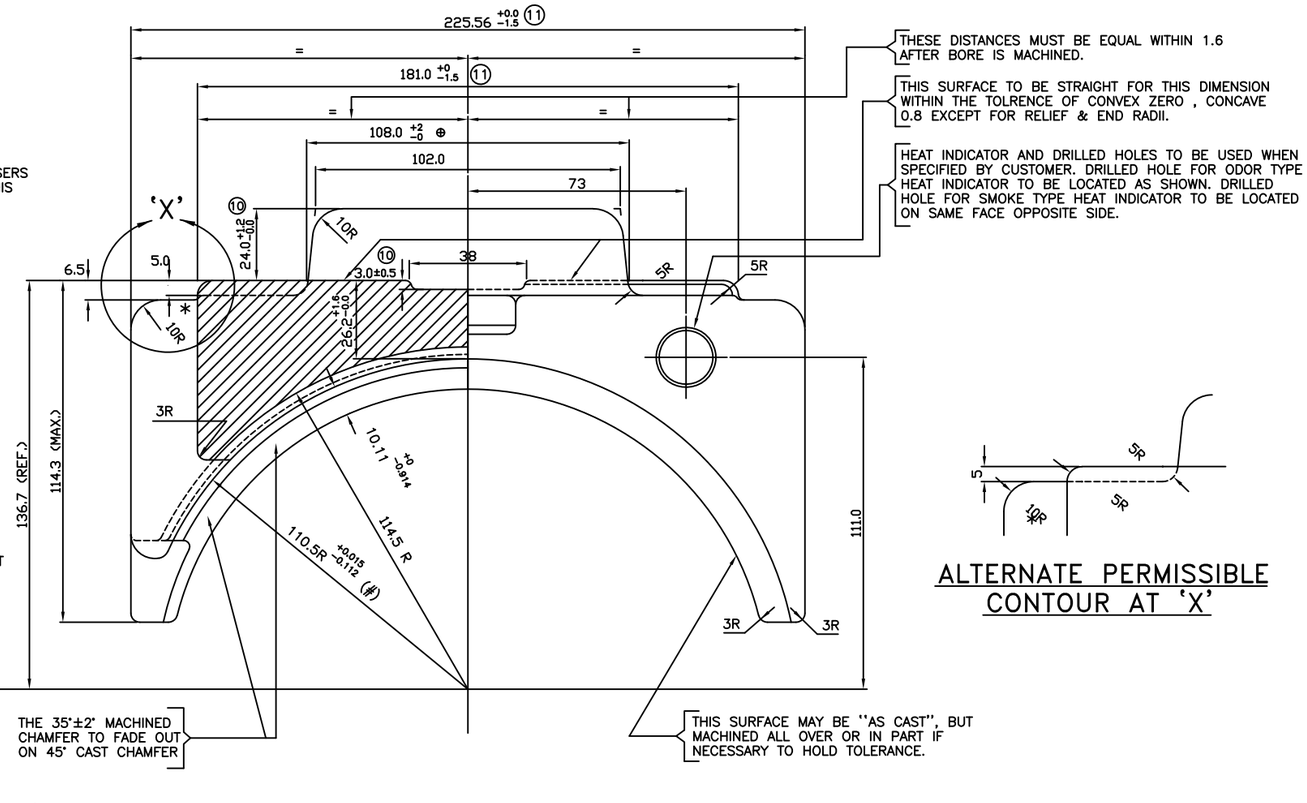
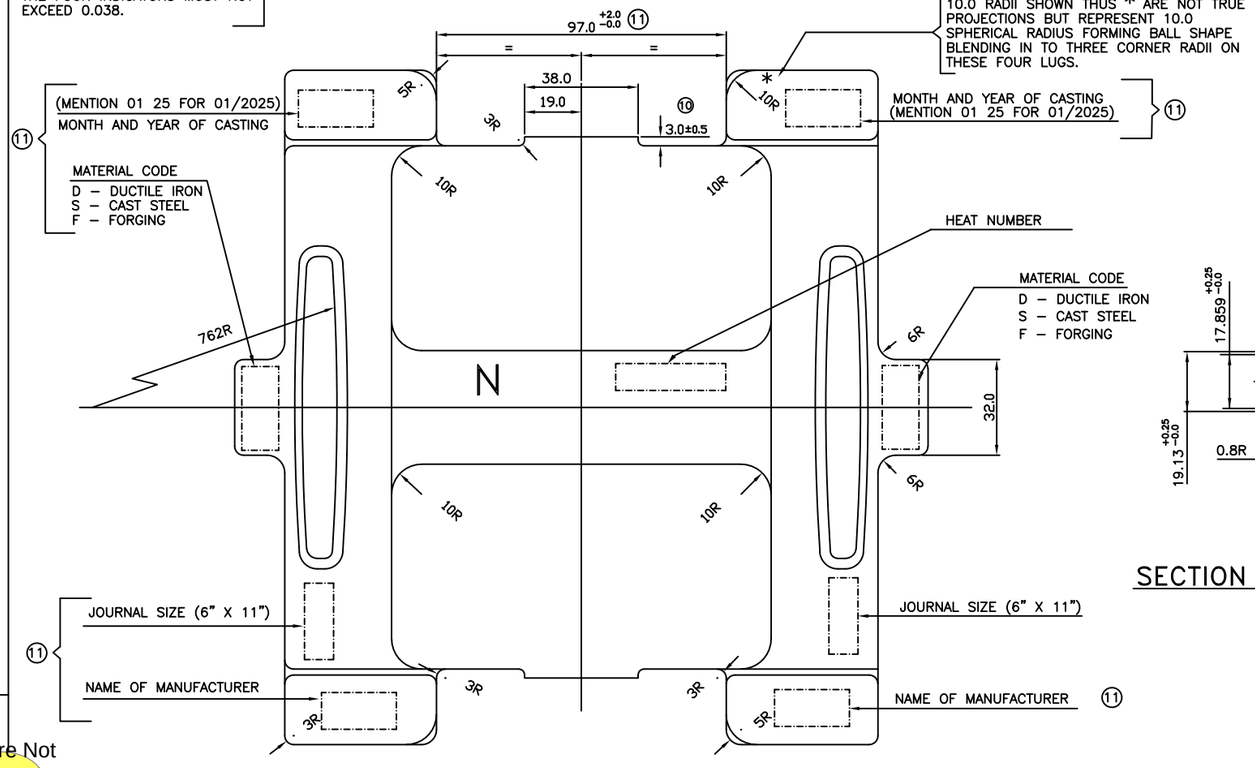


THESE PADS MUST BE CHECKED WITH THE CONCENTRICITY AND TAPET GAUGE. THE MAXIMUM INDICATOR READING ON ANY OF THE FOUR INDICATORS MUST NOT EXCEED 0.038.

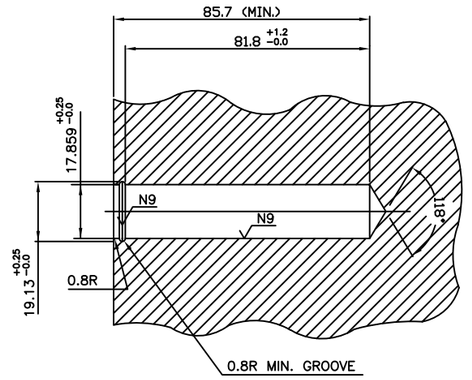


ALTERNATE PERMISSIBLE CONTOUR AT 'X'



10.0 RADII SHOWN THUS * ARE NOT TRUE PROJECTIONS BUT REPRESENT 10.0 SPHERICAL RADIUS FORMING BALL SHAPE BLENDING IN TO THREE CORNER RADII ON THESE FOUR LUGS.

MONTH AND YEAR OF CASTING (MENTION 01 25 FOR 01/2025) (11)



SECTION THROUGH HEAT INDICATOR

NOTE:–

1. ALL DIMENSIONS IN MILLIMETRES UNLESS OTHERWISE STATED.
2. ALL RAISED MARKINGS 1.6 mm. MAX. HEIGHT , 6.0 mm MIN.LENGTH.
3. MATERIAL:–
   (i) DUCTILE IRON CASTING –ASTM A – 536 , Grade 80–55–06; 217–255 HBW
   MICROSTRUCTURE:–GRAPHITE FORM AND DISTRIBUTION: 90% MINIMUM, SPHEROIDAL AND SEMI–SPHEROIDAL GRAPHITE, ASTM A247 TYPES I AND II, RANDOMLY DISTRIBUTED.
   MATRIX STRUCTURE: PEARLITIC–FERRITIC. NO PRIMARY CARBIDES ALLOWABLE.
   OR
   (ii) STEEL CASTING a) ASTM A – 148, Grade 80 – 40; 179–228 HBW
   OR b) A.A.R. M – 201, Grade C; 179–228 HBW
   OR
   (iii) STEEL FORGING A.A.R. M – 126, Grade C; 179–228 HBW

(11)

(12) OPTIONAL SURFACE HARDENING (APPLICABLE TO ALL MATERIALS):–
   (a) CROWN : 350–450 HBW, 1.5 – 5 mm DEPTH
   (b) THRUST SHOULDERS : 350–450 HBW, 0.76 – 3.81 mm DEPTH.
   (c) OUTER FACE OF ADAPTER SIDES : 380–420 HBW, 2.0 – 3.5 mm DEPTH.

4. INSPECTION SHALL BE AS PER THIS DRAWING IN CONJUNCTION WITH A.A.R. M–924.
5. RUST–RESISTANT COATING AS PER SPECIFICATION NO. IS:2074 SHALL BE USED FOR COATING THE MACHINED SURFACE AREA OF ADAPTER TO PREVENT RUSTING BEFORE DISPATCH. THE RUST –RESISTANT COATING MUST BE OF UNIFORM THICKNESS (25.4 MICRON MAXIMUM) (11)
6. DIMENSION MARKED THUS ⊕ TO BE GAUGED DURING INSPECTION.
7. (10) FOR UNTOLERANCED DIMENSIONS, THE TOLERANCES AS LAID DOWN IN ISO:8062–3 DCTG 10 SHALL BE FOLLOWED.
8. STRAIGHTNESS OF ADAPTER SIDES SHALL BE MAINTAINED WITHIN 0.5 mm
9. MACHINING SHALL BE DONE BY CNC MACHINE ONLY.
10. (11) (#) DIMENSION OF BORE RADIUS MUST BE VERIFIED TO BE WITHIN TOLERANCE ON 100% OF MANUFACTURED ADAPTER.

* SURFACE ROUGHNESS VALUE TO IS:3073	Gr.NUMBER	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12
	Ra µm *	0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50
	SYMBOL	▽▽▽▽			▽▽▽			▽▽			▽		

(12)	–	WD–25102	NOTE NO. 3 MODIFIED	12/25	––
(11)	–	WD–25001	TOLERANCES, MARKINGS & NOTE NO. 3 & 5 MODIFIED, NOTE NO. 8, 9 & 10 ADDED	01/25	––
(10)	–	WD–24047	TOLERANCES ADDED & NOTE NO. 7 ADDED	05/24	––
(9)	–	WD–20038	MONTH AND YEAR OF CASTING ARE ADDED	09/20	––
(8)	–	WD–19007	NOTE No. 3 MODIFIED	03/19	––
(7)	–	WD–17050	REVISED & REDRAWN	08/17	––
ALT.	ITEM	AUTHY	DESCRIPTION	DATE	ASSEMBLY DRG.

SUPERSEDED BY
SUPERSEDES DATE

SCALE			
1:1	PASSED	H.KATIYAR	09/89
	CHECKED	R.KUMAR	09/89
	DRAWN	R.K.TALWAR	06/89
	TRACED	GOPAL	08/92
	J.S.NO.	WD–89067	01/92

ADAPTER [NARROW JAW] CLASS 'E' 6''X11''

B.G. | R.D.S.O. [W] | GROUP | WD–89067–S/9

Wt. of adapter = 12.84Kg.

CHECKED

R.K.GAUR / 08 / ADP2

Signature Not Verified
Digitally signed by SHUBHAM SONKAR
Date: 2026.01.09 16:10:50 IST
Reason: IREPS-CRIS
Location: New Delhi