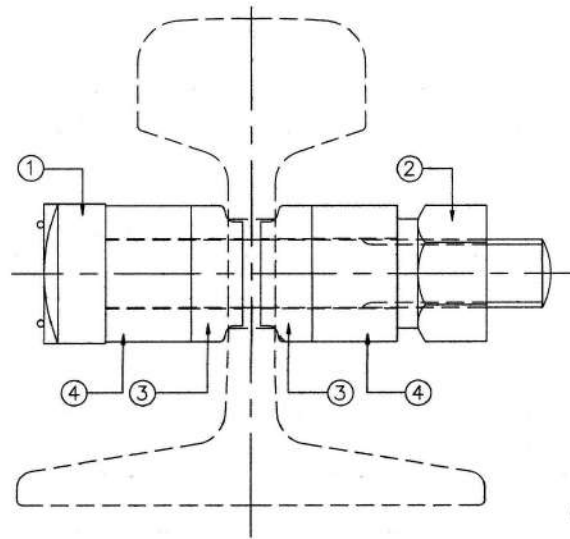
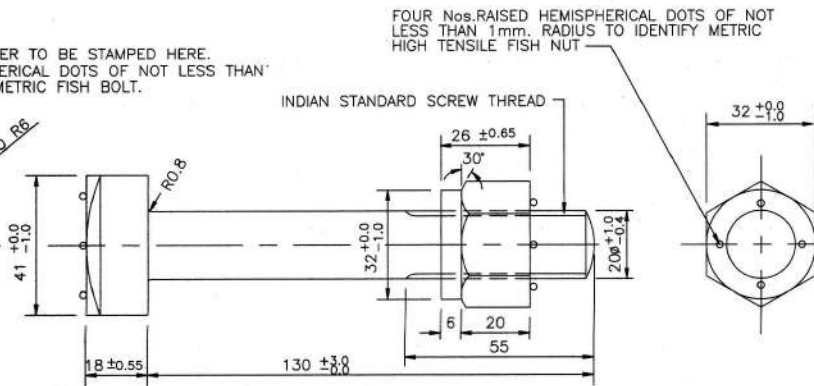
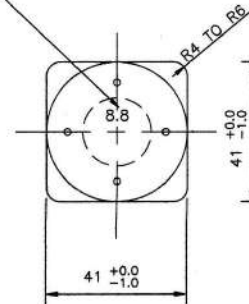


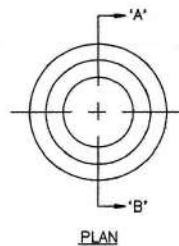


ASSEMBLY

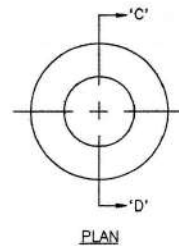
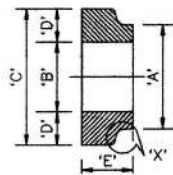
ISO GRADE 8.8, PART NUMBER TO BE STAMPED HERE.
FOUR Nos. RAISED HEMISPHERICAL DOTS OF NOT LESS THAN 1mm. RADIUS TO IDENTIFY METRIC FISH BOLT.



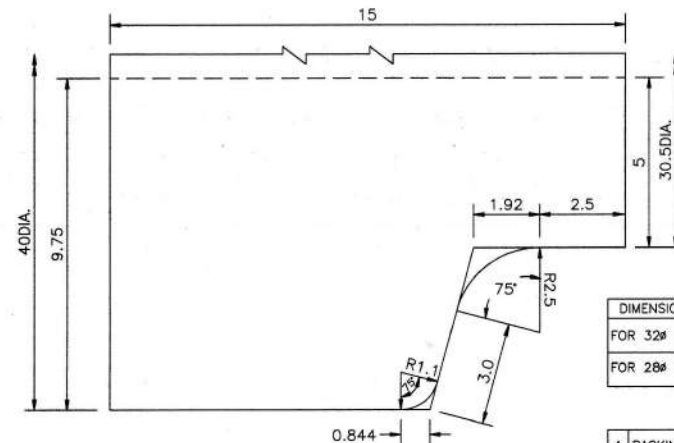
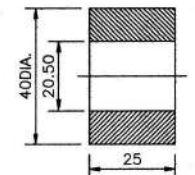
① & ② DETAILS OF NUT & BOLT



③ DETAILS OF CHAMFERING TOOL



④ DETAILS OF PACKING PIECE



DETAILS AT 'X'

DIMENSIONS	A	B	C	D	E
FOR 32 ϕ HOLE	30.5	20.5	40	9.75	15
FOR 28 ϕ HOLE	26.5	20.5	40	9.75	15

4. PACKING PIECE.	MILD STEEL	IS: 432-1982	2
3. CHAMFERING TOOL.	HIGH SPEED TOOL STEEL	IS: 7291-1981 (ANY GRADE)	2
1&2 BOLT & NUT 20mm.DIA.	HIGH TENSILE STEEL	IS: 1367-1991 (ANY GRADE)	1 EACH

ITEM No.	DESCRIPTION	MATERIAL	SPECIFICATION	No. OFF
R.	D.	S.	O.	
SPECIAL TOOL FOR CHAMFERING RAIL HOLES BY NUT AND BOLT (60Kg. 52Kg. & 90R RAILS)				
CANCELED/SUPSED. REVED.				
DRG. No. TM/0512				

- THE CHAMFERING BITS ARE SUITABLE FOR CHAMFERING HOLES OF DIA. 28 TO DIA. 32
- THIS DRAWING SUPERSEDES DRG. No.TM/2008
- AS AN ALTERNATIVE TO SQUARE HEADED BOLT HEXAGONAL HEADED HTS BOLT CAN ALSO BE USED.
- TORQUE OF 52Kg.M.(370 lbs Ft.) IS REQUIRED TO APPLY AN AXIAL FORCE OF 12.5t.
- SQUARE HEADED HIGH TENSILE FISH BOLT AND NUT IS TO BE USED. PART NUMBER TO BE STAMPED, RAISED OR DEPRESSED.
- CHAMFERING TOOL IS TO BE MADE FROM HIGH SPEED TOOL STEEL OF ANY ONE OF THE SEVEN GRADES CONFORMING TO IS: 7291-81 (HARDNESS AFTER HEAT TREATMENT TO BE R.C.62 MINIMUM.)
- ALL DIMENSIONS ARE IN MILLIMETRES.

TM-53 (REV.- 01)
IRS:T-28-73,
S:432 (Pt.I)- 82,
S:1363 (Pt.III)-91,
S:1367 (Pt.II)-79,
S:1367 (Pt.III)-91,
S:1367 (Pt.V)-80,
S:7291-81 (ANY GRADE)

1:10
1:1

NOTES

SPECIFICATION

SCALE

ALT

DESCRIPTION

AUTY

DRG. No. TM/0512