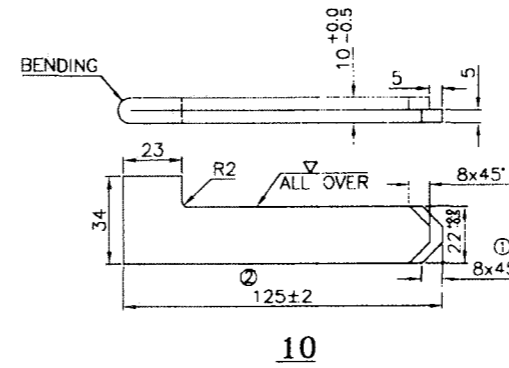


SECTION a-a



10

NOTE:-

- MATERIAL:**
FOR PIN:
STEEL TO IS:1875 CLASS-IV. INDUCTION HEATED AND QUENCHED TO OBTAIN A UNIFORM SURFACE HARDNESS OF ROCKWELL "C" 58 (MINIMUM). AFTER GRINDING THE EFFECTIVE CASE DEPTH MEASURED PERPENDICULARLY FROM FINISHED SURFACE TO POINT OF HRC 50 SHALL BE:

DIAMETER	CASE DEPTH	
	MINIMUM	MAXIMUM
LESS THAN 25.4 mm	0.1 x DIAMETER	0.15 x DIAMETER
25.4 mm OR GREATER	2.54 mm	3.8 mm

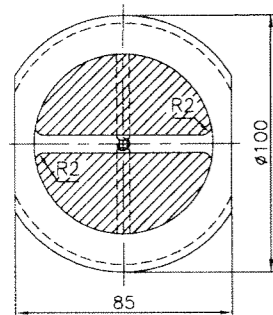
THE EXTREMITY OF PIN BODY END (PLAIN OR SHOULDERED PINS) SHOULD NOT HAVE ANY DISCONTINUITY. NO DISCONTINUITY ALLOWED WITHIN 3 mm (PREFERABLY WITHIN 6 mm) OF TRANSVERSE HOLE OR GROOVE OF PINS.

FOR METALLIC BUSH:

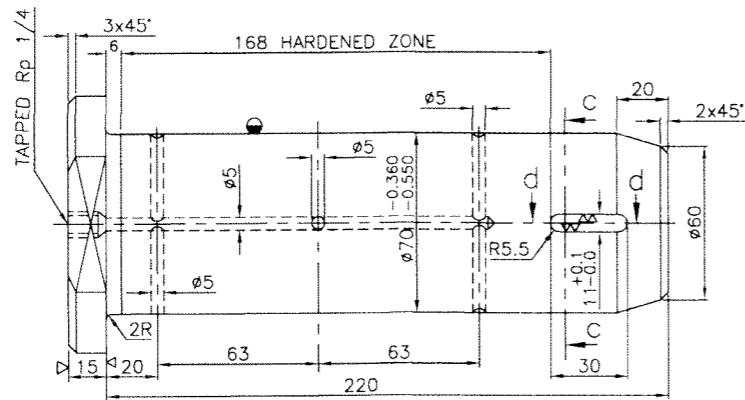
- STEEL TO IS:1875 CLASS-I. THE BUSHING SHALL BE CARBURRISED QUENCHED AND TEMPERED AT 177°C. THE SURFACE HARDNESS AFTER GRINDING SHALL BE ROCKWELL "C" 58 (MINIMUM). THE EFFECTIVE CASE DEPTH AFTER GRINDING SHALL BE:-
- | NOMINAL WALL THICKNESS | EFFECTIVE CASE DEPTH |
|---|----------------------|
| 3.175 mm TO THICKNESS LESS THAN 4.76 mm AND ABOVE | 0.76 mm TO 1.02 mm |
| | 1.02 mm TO 1.27 mm |

FOR NON-METALLIC BUSH:

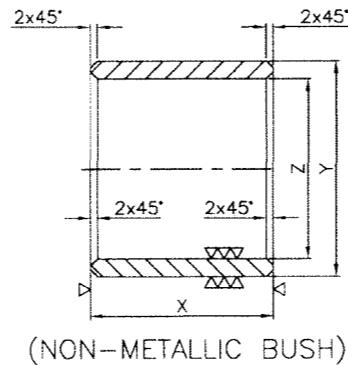
- POLYAMIDE. SELF LUBRICATING MATERIAL AS PER SPECIFICATION NO. RDSO/2007/EL/SPEC/0056
- THE MONOGRAM/NAME OF MANUFACTURER/MONTH OF MANUFACTURING SHOULD BE LEGIBLY EMBOSSED/ENGRAVED/MARKED ON ALL PIECES AT AN APPROPRIATE AND SAFE LOCATION.
 - COTTER SHOULD BE MANUFACTURED BY BENDING OF PLATE TO IS:2062 Gr. E250 (Fe410W)
 - THE COTTER SHOULD NOT BE REUSED ON LOCOMOTIVES.
 - BENT TEST ON SELECTED SAMPLES SHOULD BE CARRIED OUT AS FOLLOWS:
IN COLD CONDITION, THE WINGS OF COTTER SHOULD BE OPENED UP FOR HALF OF THE COTTER LENGTH AND THE WINGS THUS OPENED SHALL BE CAPABLE OF BEING BENT BACKWARDS WITHOUT SHOWING ANY SIGN OF FAILURE THROUGH AN ANGLE OF 180° UNTILL THE ENDS OF WINGS TOUCH THE BODY OF THE COTTER, AND THE INTERNAL RADII OF THE BENDS SHOULD NOT BE MORE THAN 5 mm.
 - IF SLACK APPEARS BETWEEN WASHER AND COTTER, STEP SIZE WASHERS (ITEM 9) OF 1/2/3 mm THICKNESS MAY BE USED.



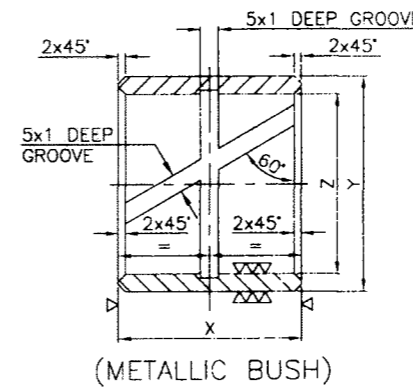
SECTION 'c-c'



1



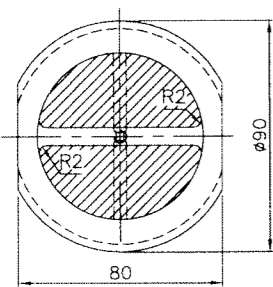
(NON-METALLIC BUSH)



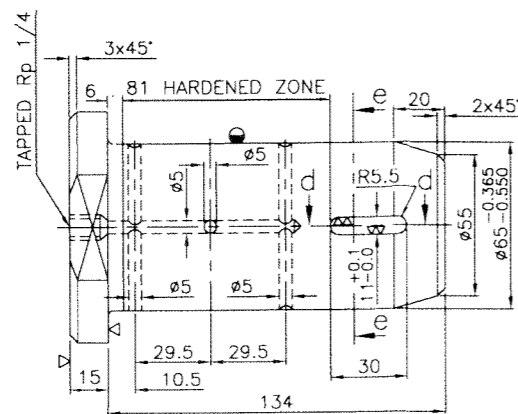
(METALLIC BUSH)

3,4&5

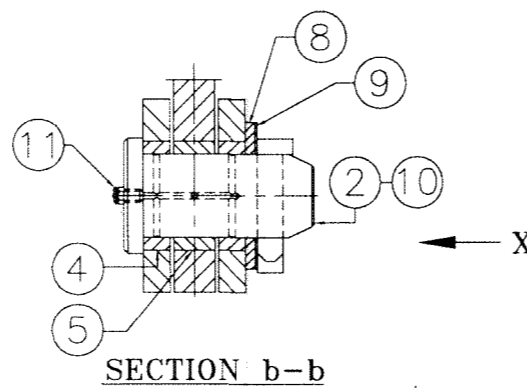
ITEM NO.	DIMENSIONS		
	X	Y	Z
3	80	ø85 +0.13	ø70 +0.00
4	20	ø75 +0.10	ø65 +0.00
5	32	ø75 +0.10	ø65 +0.00



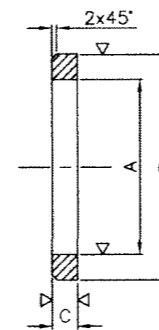
SECTION 'e-e'



2

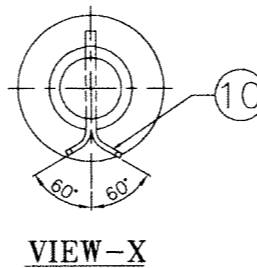


SECTION b-b



7&8

ITEM NO.	DIMENSIONS		
	A	B	C
7	ø71 +0.5/-0.0	ø120	10
8	ø66 +0.5/-0.0	ø115	9



VIEW-X

⊙ RADIUS R2 (MIN.) AT EDGE OF THE SLOT, SHOWN IN THE SECTIONS c-c, e-e & d-d MUST BE PREPARED BY SPECIAL TOOL, TO PRODUCE THE PERFECT AND SMOOTH PROFILE. SPECIAL ATTENTION SHOULD BE GIVEN AT THE TIME OF INSPECTION.

SECTION 'd-d'

ITEM NO.	DESCRIPTION	QTY	REF. DRG. NO.
11	GREASE NIPPLE	28	IS:4009
10	FLAT BENDED COTTER	28	SEE NOTE 3
9	STEP SIZE PUNCHED WASHER ø71/ø66	-	
8	MACHINED WASHER ø66	16	STEEL
7	MACHINED WASHER ø71	12	
6	BUSH	24	ITEM 2 OF SK.DL-4191
5	BUSH	16	
4	BUSH	32	
3	BUSH	12	SEE NOTE 1
2	PIN	16	
1	EQUALISER PIN	12	

REF: I.R. NO. PART NO. DESCRIPTION NO./ WT.(Kg) MATL. SPEC./ REF. DRG. NO. LOCO EACH

APPLICABLE FOR WAG7 LOCO

PIN ARRANGEMENT

SCALE: 1:5 REF.NO. ELEC. DTE's NOTE NO. EL/3.2.13/6 DATED 15/07/10 FIRST ISSUED

INDIAN RLYS DRG. NO. SK.VL-703 SUPERSEDES SUPERSEDED BY

ALT. NO. OF PLACES	REF. NO.	DESCRIPTION	ALT. NOTE NO.	SIGN.	DATE
③	1	MATERIAL OF NON-METALLIC BUSH REVISED	VDG-1086		JAN'16
②	3	DIM.125 WAS 150, NON-METALLIC BUSH DRAWN, SPECIAL NOTE ADDED.	VDG-955	R.Kr.	MAR'12
①	1	CHAMFER 8x45° ADDED.	VDG-884	A.MIS.	DEC'10

ALL DIMENSIONS ARE IN mm.

~	50	
▽	25	
▽▽	6.3	
▽▽▽	0.8	*SURFACE ROUGHNESS TO IS:3073
▽▽▽▽	0.1	WELDING SYMBOLS TO IS:813
SYMBOL	Raum (Max.)*	TOLERANCES ON UNTOLERANCED DIMENSIONS TO IS:2102(MEDIUM)

DRN. BY: Sd/-
CKD. BY: Sd/-
APPROVED BY: Sd/-
N.K. BARNAWAL
DIR/MP(Veh.)
DATE: JUL'10