



- NOTES**
- ALL DIMENSIONS SHOWN ARE FINAL MACHINED DIMENSIONS
  - ALL THE WELDS ARE OF 16 mm SIZE FILLET UNLESS OTHERWISE SPECIFIED
  - ALL WELDS ARE TO BE DP TESTED FOR ROOT AND FINAL PASSES TO ENSURE WELD QUALITY
  - ALL PLATES ABOVE 16mm THICKNESS SHALL BE QUALIFIED BY U . T
  - APPROVED PAINTING SHALL BE FOLLOWED AS PER PURCHASE ORDER
  - STRESS RELIEVING IS TO BE CARRIED OUT AFTER COMPLETION OF ALL WELDING & BEFORE MACHINING.
  - UNLESS OTHERWISE SPECIFIED, ALL WELDING SHALL BE SUBJECT TO THE FOLLOWING TESTS:
    - 100% MT/PT FOR FILLET WELDS AFTER FINAL PASS.
    - 100% PT FOR GROOVE WELDS AFTER ROOT PASS AND FINAL PASS.
    - 100% UT/ RT FOR GROOVE WELDS AFTER FINAL PASS
  - HOLE IN PART NO.2 SHALL BE DRILLED IN SINGLE SETTING.
  - QUANTITY IS GIVEN FOR ONE ASSEMBLY ONLY. NUMBER OF ASSEMBLIES REQUIRED IS FOUR
  - CHECK THE STATUS OF THE DRAWING BEFORE FABRICATION / MACHINING

TOTAL WEIGHT : 2755 Kgs. (Approx)

S.NO	DESCRIPTION	MATERIAL	QTY	W.T	REMARKS
6	PLATE 400 x 220 x 40Thk	ASTM SA 517 GRADE F	4	110	
5	PLATE 400 x 150 x 40Thk	ASTM SA 517 GRADE F	2	42	
4	PLATE 510 x 120 x 20Thk	ASTM SA 517 GRADE F	4	38	
3	ROD Ø755 x Ø324 x 560Lg	ASTM SA 517 GRADE F	1	1588	
2	PLATE 830 x 660 x 80Thk	ASTM SA 517 GRADE F	2	600	
1	PLATE 1080 x 830 x 60Thk	ASTM SA 517 GRADE - F	1	377	

STATUS	SIGN	DATE
DISCUSSION / REVIEW		
TENDER PURPOSE		
FABRICATION		29/12
UNRESTRICTED	RESTRICTED	CONFIDENTIAL

DO NOT SCALE THE DRAWING  
 ASK IF IN DOUBT  
 UNLESS OTHERWISE SHOWN  
 ALL DIMENSIONS ARE IN MILLIMETERS  
 REMOVE SHARP EDGES & BURRS  
 CHAMFER 1 M.M. X 45°  
 MACHINING FINISH IN MICRONS :-  
 ∇ B - 25 ∇∇ 1.6 - 8  
 ∇∇∇ 0.025 - 1.6 ∇∇∇∇ < 0.025

DEVIATION FOR NON TOLERANCED DIMENSIONS (IS - 2102)	
DIAMETERS & LENGTHS UPTO & INCL 6 ±0.1	LENGTH IN M.M. OF SHORTER SIDE OF ANGLE UPTO & INCL.
6 - 30 ±0.2	1 - 6 ± 1'-00'
30 - 120 ±0.3	6 - 30 ± 0'-30"
120 - 315 ±0.5	30-120 ± 0'-20"
315 - 1000 ±0.8	120-400 ± 0'-10"
1000 - 2000 ±1.2	
2000 - 4000 ±2.0	
4000 & ABOVE ±3.0	

**SCEND**  
 SHAR CENTRAL DESIGNS  
 DESIGNED: K.S.P. Sathya  
 DES. CHKD: S.V.  
 DRAWN: V.V.R. 01.01.24  
 DRG. CHKO: K.S.P. Sathya  
 APPROVED: S.V.  
 SIGN. DATE

TITLE: YOKE FOR WHEEL BOGIE SYSTEM OF SLC PROJECT  
 GOVERNMENT OF INDIA  
 INDIAN SPACE RESEARCH ORGANISATION  
 SATISH DHAWAN SPACE CENTRE SHAR  
 SRIHARIKOTA  
 SCALE: 1 : 5  
 DRG. NO.: 10-MECH-12-8-28/A1/R1  
 SHEET 1 OF 1