

NOTE 1. REFER TO QR RECOMMENDED PRACTICE 1/92025 FOR WHEELSET PRESS PROCEDURES

NOTE 2. —

NOTE 3. FOR AXLE STAMPING & CENTRE DRILLING SEE A4-C.C.581

NOTE 4. GRIND THEN ROLL SUSPENSION JOURNALS IN ACCORDANCE WITH SPECIFICATION GET-2853

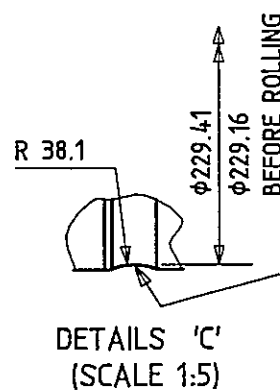
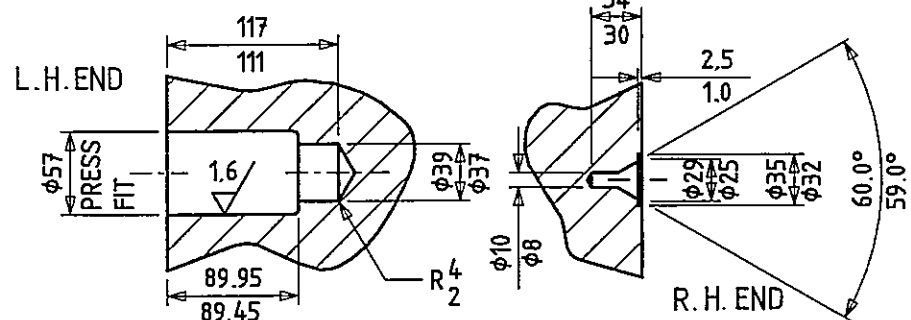
Ⓜ MATERIAL AND MANUFACTURING ACCORDING TO QR SPECIFICATION ES0080

Ⓜ NEW AXLES TO BE SUPPLIED WITH REDUCED SEAT LENGTH

6.3/ ALL OVER EXCEPT WHERE SHOWN

ENDS OF AXLE MUST BE MACHINED FLAT AND SQUARE TO CENTRELINE AND POLISHED FREE FROM TOOL MARKS

Ⓜ FOR AXLE, WHEEL AND GEAR ASSEMBLY SEE DRG A1-DEN 113



OFFICE OF THE MANAGER
ROLLINGSTOCK ENGINEERING
11 OCT 2002
LEVEL 5
RAIL CENTRE 2

ROLL STRESS RELIEF GROOVE TO GIVE FINISH COMPLETELY FREE OF TOOL MARKS & A HARDNESS INCREASE AT BOTTOM OF GROVE OF MIN 20 VICKERS HARDNESS SCALE UNITS

1460 CLASS 6-OFF PER LOCO
2100 CLASS 6-OFF PER LOCO
Ⓜ ALSO USED ON 2300 & 2450 CLASSES
Ⓜ ALSO USED ON 1502, 1550, 2130, 2141, 2150, 2170, 2400, 2470 CLASSES

Ⓜ FOR DETAIL OF MACHINE STRESS RELIEF GROOVES SEE DRG DES 58 (IF CRACKING OCCURS)

- HOLE BORED & REAMED CLEAR OF TOOLMARKS, TRUE WITH MACHINED SURFACE TO ACCOMODATE SPLINED BUSH
- BUSHING DRG. DEM67 PRESSED IN PLACE BEFORE FINISHING AXLE
- PRESS FIT NOT LESS THAN 0,038mm & NOT MORE THAN 0,076mm

ALL DIMENSIONS IN MILLIMETRES UNLESS OTHERWISE STATED

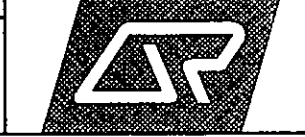
J	M.C. 10-10-2002	SAH 10/10/02	D.K.S. 10/10/02
CURRENT REV	DRAWN / DATE	CHECKED / DATE	APPROVED / DATE

CME W.A. CASTLEY
Per W.W.H.

ROLLINGSTOCK ENGINEERING DIVISION

DRAWN	R.S. 26-10-60	SCALE	1:10 & 1:5	REV
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1400, 1450, 1460 & 2100 CLASS
DIESEL ELECTRIC LOCOS DRIVING AXLE

CHECKED	JJ & WH 30-11-60	P-CC533	J
APPROVED	W.W.H.		
DATE	7-12-60		