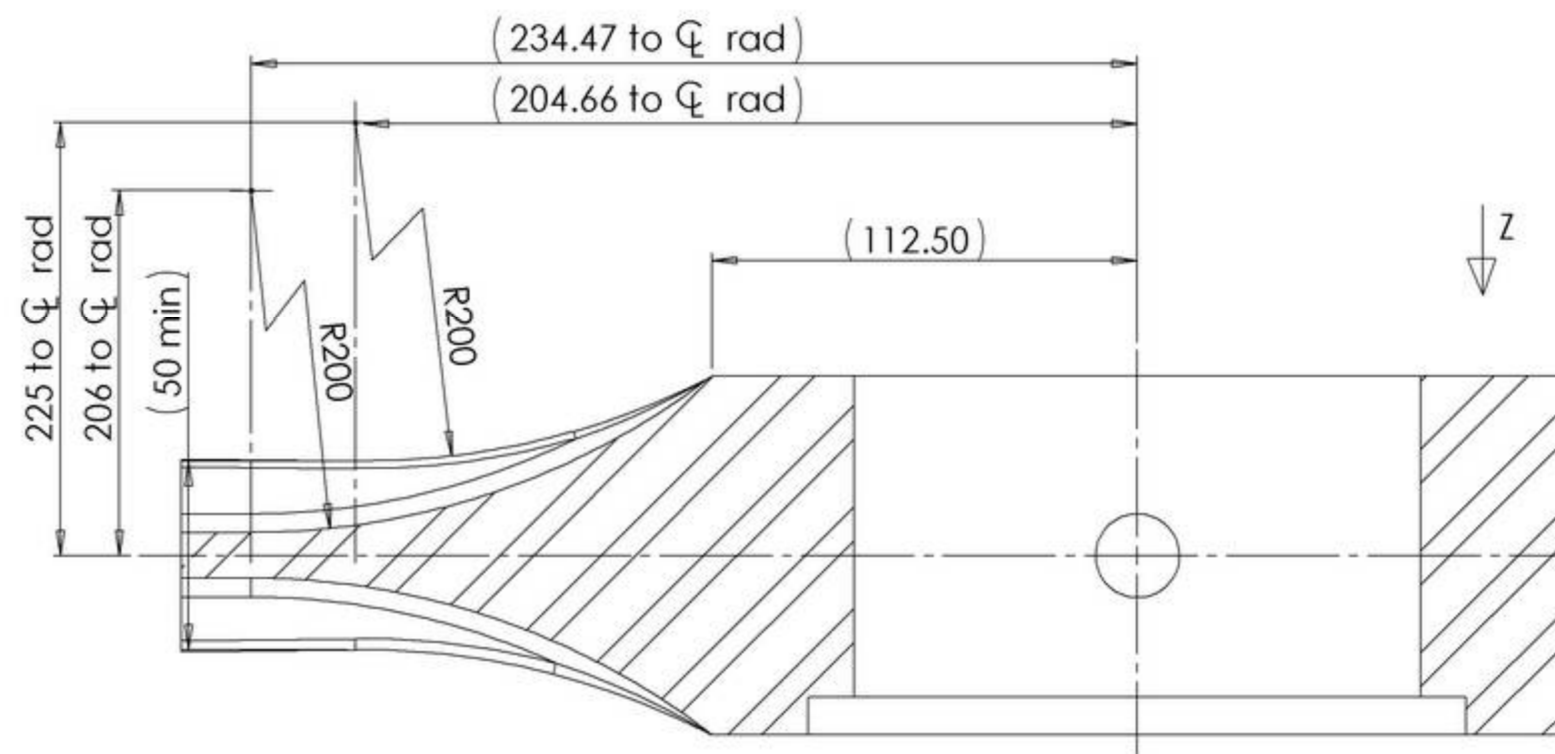
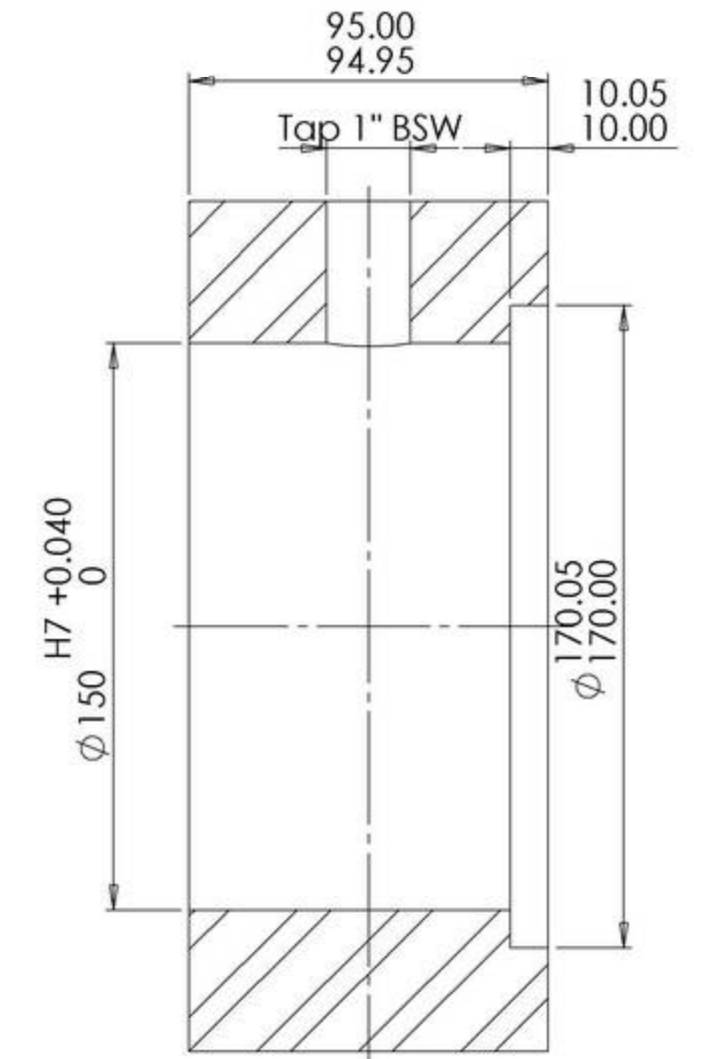
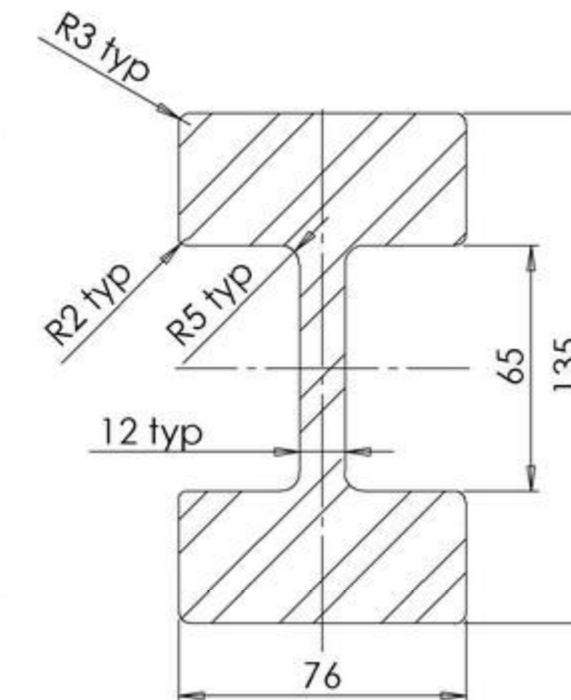
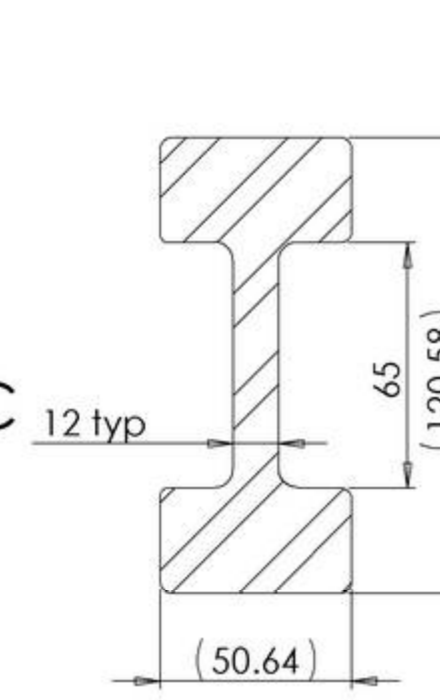
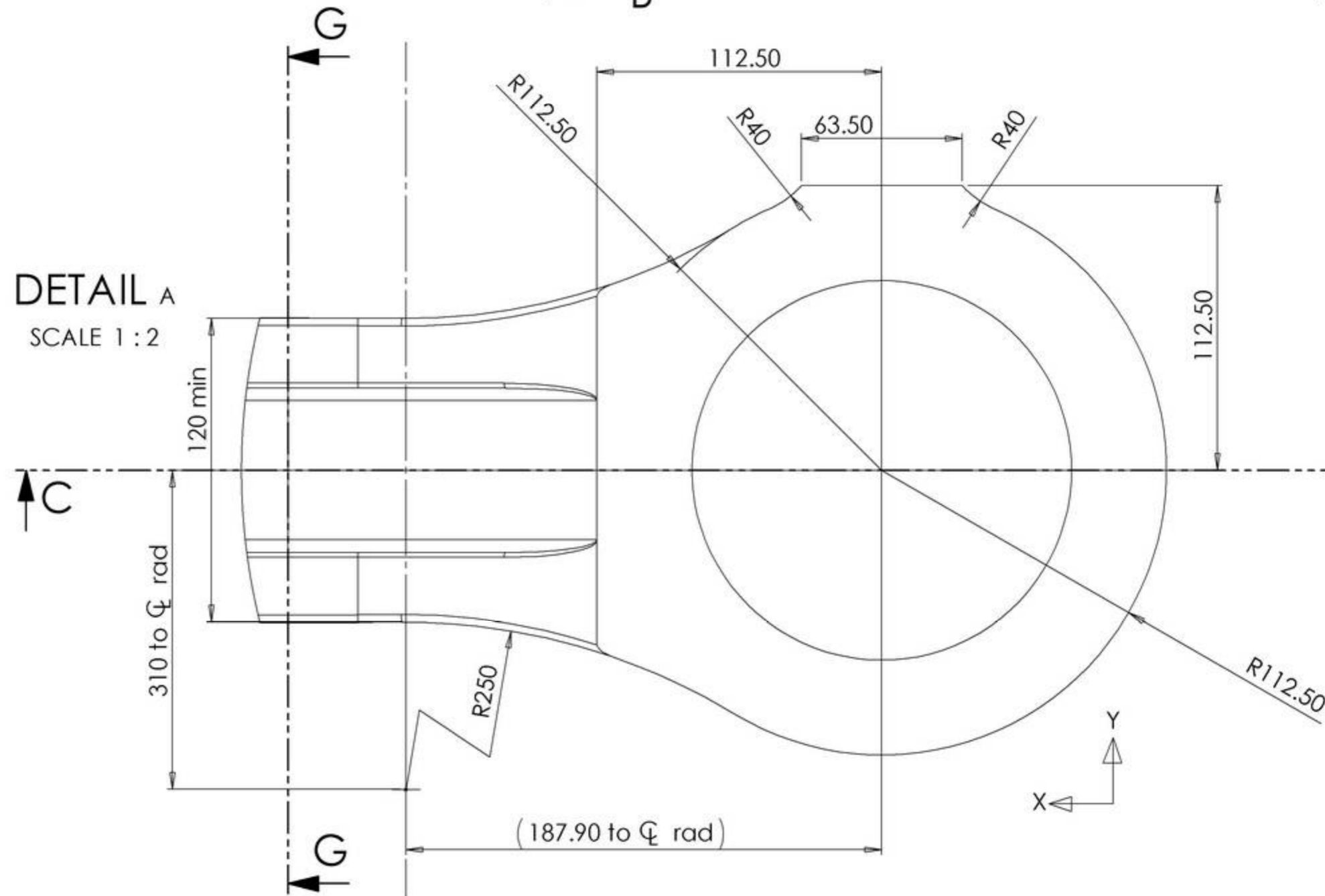
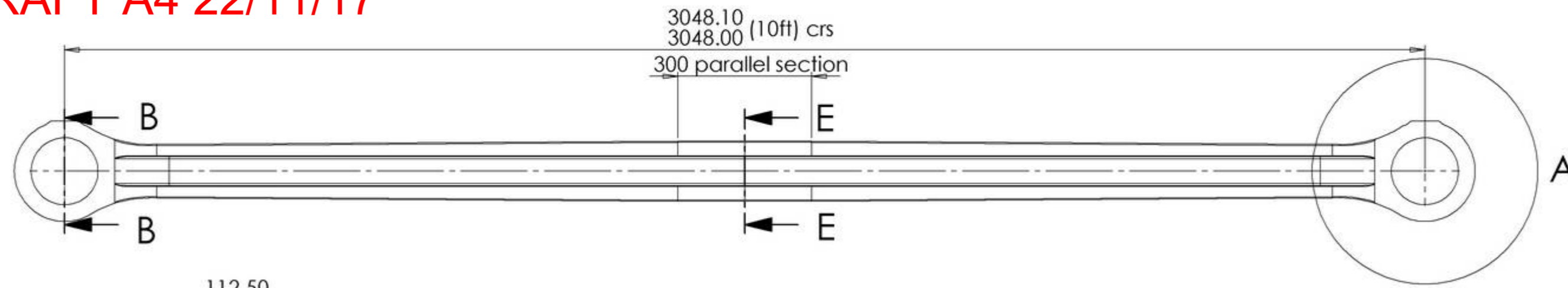


DRAFT A4 22/11/17



Notes:

1. The rod has a parallel section in the centre. Each side of this are tapered sections which finish tangentially to the radii into the rod eye. Transition between parallel and tapered sections to be blended. The section of the flute is constant along the length of the rod.
2. Rod blanks are to be forged.
3. Rod surface to be machined all over. Surface texture (unless stated otherwise) to be N7 (Ra 1.6 microns) machined. After machining all surfaces to be dull polished to Ra 0.8 microns. All polishing marks must run along the length of the rod.

NDT and Inspection:

1. Material mill certificates must be supplied.
2. Prior to cutting the base material shall be ultrasonically tested to EN 10160 level S2 and, round the boss areas E4, to ensure freedom of defects.
3. Samples must be cut from the two of the principle axes of the blank forging for tensile testing as follows:
  - Longitudinally, X direction – 2 off, one from each end.
  - In the Y direction (across the slab width), one from each end clear of the coupling rod bearing boss
4. Samples are to be clearly identified with their location and axis.
5. Tensile testing across the slab grain to be no less than 5% below the minimum of the longitudinal sample.



SECTION C-C  
SCALE 1:2

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN MILLIMETERS		METRIC THREAD TOLERANCES: INTERNAL G/H EXTERNAL g/h		FINISH: None		DO NOT SCALE DRAWING		DEBUR AND BREAK SHARP EDGES	
SURFACE FINISH: Ra 3.2 MICRONS		MACHINING TOLERANCES: LINEAR: ±0.1 mm ANGULAR: ±1.0 Deg		FABRICATION TOLERANCES: UP TO 500mm: ±1.0 500 TO 2000mm: ±2.0 OVER 2000mm: ±4.0		INTERNAL CORNERS: R0.25/0.4		CUSTOMER REF: LNWR George V SLT	
ALL DIMENSIONS ARE FINISHED DIMENSIONS									
DRAWN: J Keyte		SIGNATURE: [Signature]		DATE: xx/xx/xx		MATERIAL: BS 970: 60S36 (En 16 S)		TITLE: Coupling Rod Machining	
CHKD: T Mcmenamin		DATE: xx/xx/xx		USED ON:		DWG NO. SL-1053-1042		SHEET SEE A2	
APPVD: TM		DATE: xx/xx/xx		PROJECTION: THIRD ANGLE		SCALE: NTS		SHEET 1 OF 1	
CUST:		Keyte Smith Ltd		WEIGHT: kg					
Keyte Smith Ltd of Kingham, Nottinghamshire owns the copyright of this drawing which is supplied in confidence and must not be used for any purpose other than that for which it is supplied, and must not be reproduced without permission of the owners.									