



भारत सरकार - रेल मंत्रालय  
अनुसंधान अभिकल्प और मानक संगठन  
लखनऊ - 226 011  
EPBX (0522) 2451200  
Fax (0522) 2450679

Government of India-Ministry of Railways  
Research Designs & Standards Organisation  
Lucknow - 226 011  
DID (0522) 2450115  
DID (0522) 2465310



No. SV.FIAT DAMPER

Date: 19.02.2021

**Principal Chief Mechanical Engineer**

1. Central Railway, HQ office, Mech. Branch, CSTM, Mumbai - 400 001
2. Eastern Railway, HQ office, Mech. Branch, Fairly Place, Kolkata- 700 001
3. Northern Railway, HQ office, Mech. Branch, Baroda House, New Delhi-110 001
4. Southern Railway, HQ office, Mech. Branch, Park Town, Chennai - 600 003
5. South Central Railway, HQ office, Mech. Branch, Secunderabad-500 071
6. South Eastern Railway, HQ office, Mech. Branch, Garden Reach, Kolkata-700 043
7. North Eastern Railway, HQ office, Mech. Branch, Gorakhpur-273 001
8. North East Frontier Railway, HQ office, Mech. Branch, Maligaon, Guwahati- 781 011
9. Western Railway, HQ office, Mech. Branch, Churchgate, Mumbai-400020
10. East Central Railway, HQ office, Mech. Branch, Hazipur-844 101
11. East Coast Railway, HQ office, Mech. Branch, Railway Complex, Bhubaneshwar- 23
12. North Central Railway, HQ office, Mech. Branch, Allahabad-211 001
13. North Western Railway, HQ office, Mech. Branch, Jaipur-302 006
14. South Western Railway, HQ office, Mech. Branch, Hubli- 580023
15. West Central Railway, HQ office, Mech. Branch, Jabalpur- 482 001
16. South East Central Railway, HQ office, Mech. Branch, Bilaspur- 495 004
17. Konkan Railway Corp. Ltd. Corporate office Belapur Bhawan Nawi Mumbai-400 614
18. Integral Coach Factory, Chennai - 600038
19. Rail Coach Factory, Kapurthala - 144 602
20. Modern Coach Factory, Rae Bareli - 229212


**Sub: Drawings of dampers for LHB coaches fitted with FIAT Bogie.**

**Ref: This office letter of even no. dated 17.12.2020.**

Vide letter under ref., draft drawings of FIAT Dampers, prepared by RDSO were issued to stake holders for their valuable comments. Now, on the basis of comments received from Railways and Vendors, RDSO has revised the draft drawings of FIAT dampers. These revised draft drawings (for 06 type of dampers) are enclosed herewith for valuable comments of stake holders.

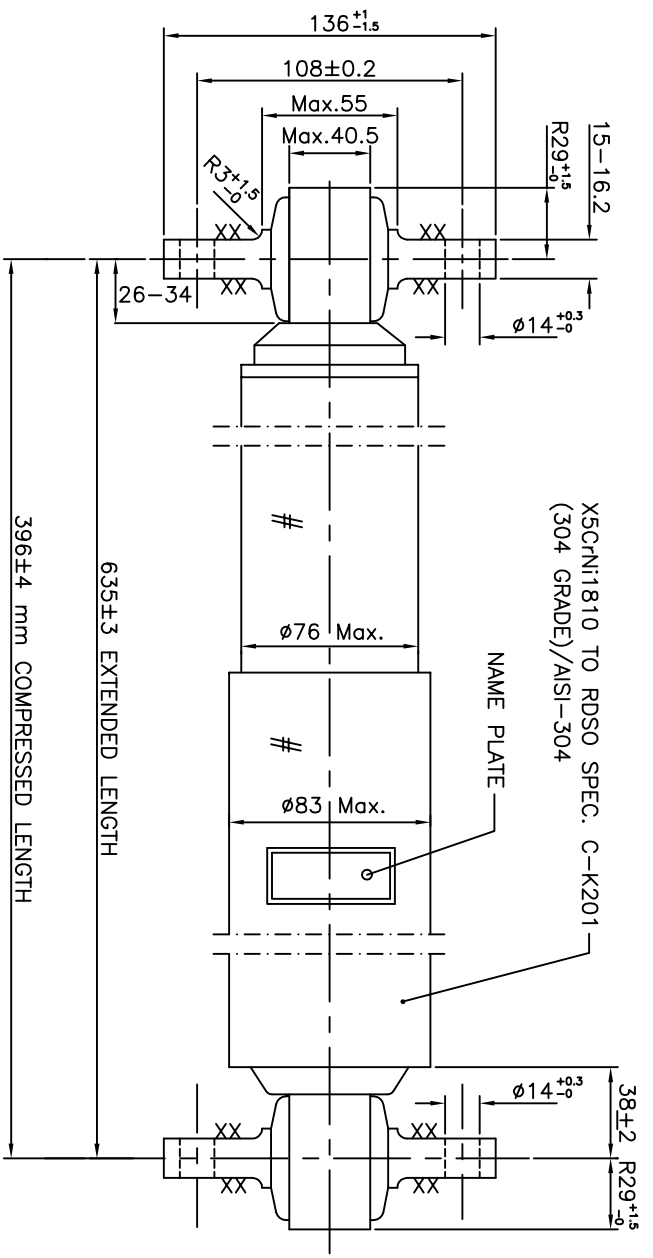
It is requested to submit your comments upto 01.03.2021 for finalisation of drawings.

**DA:As above**

  
(19-2-2021)  
Shobhit Pratap Singh)  
Joint Director/Carriage  
for Director General/Carriage

**Copy to:**

DME (Coaching), Railway Board, Rail Bhavan, New Delhi - 110 001.



- NOTE:-
1. # THE MANUFACTURER NAME OR CODE, RATED CAPACITY, TYPE OF DAMPER WITH RDSO DRG. No., SERIAL NO. & MONTH & YEAR OF MANUFACTURE SHALL ALSO BE MARKED IN 10 mm HEIGHT LETTERS BY PUNCHING OR ENGRAVING WITH MINIMUM DEPTH OF 0.25 mm ON DUST COVER / BARREL TUBE.
  2. NAME PLATE ALSO TO BE MOUNTED ON DUST COVER WITH ABOVE DETAILS.
  3. XX-SURFACES ZINCED & FREE OF PAINTING.
  4. DAMPER IS MOUNTED IN VERTICAL POSITION.
  5. DURING FITMENT ON BOGIE, NAME PLATE SHOULD BE DIAMETRICALLY OPPOSITE TO ENGRAVING / PUNCHING.
  6. PAINT SHADE TO RAL 3011 (BROWN RED) ON DAMPER WITH COVER.

DAMPER TESTING AT 23 ± 5°C

1	STROKE	50	mm
2	NO. OF REVOLUTIONS	38	min-1
3	VELOCITY	0.10	m/s
4	FORCE	405 ± 15%	Kg (WITHOUT ATTACHMENT)
5	TORSIONAL ANGLE	± 22' (Min.)	DEG
6	CARDANIC ANGLE	± 10' (Min.)	DEG
7	RADIAL STIFFNESS AT END CONNECTIONS	7225 - 24000	N/mm

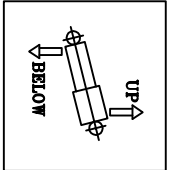
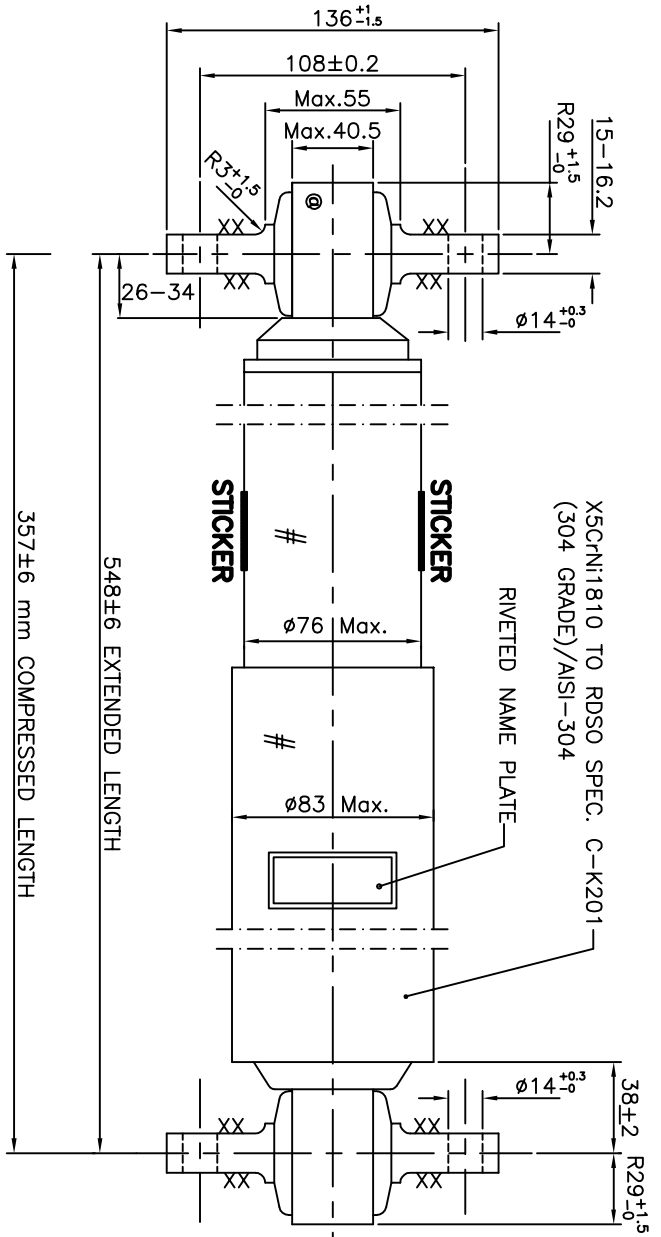
WIDE RANGE IN CHARACTERISTICS AND VARIOUS DIMENSIONS OF DAMPER HAS BEEN PROVIDED TO FACILITATE THE MANUFACTURER TO DESIGN AND MANUFACTURE THE QUALITY PRODUCT AS PER RDSO SPECIFICATION NO. RDSO/CG-18005 REV. (LATEST).

FIRM SHOULD SUBMIT THEIR DESIGN/ DRAWING WITH PROPER TOLERANCES (SUPPORTED BY IS/ISO STANDARD) IN CHARACTERISTICS AND DIMENSIONS. RANGE OF VARIOUS CHARACTERISTICS AND DIMENSIONS IN PARTICULAR DESIGN OF DAMPER OF A PARTICULAR SUPPLIER (WITH INCLUSION OF TOLERANCE, MENTIONED IN DRAWING) SHOULD NOT BE BEYOND THE RANGE SPECIFIED IN LATEST RDSO DRAWING AND RDSO STR NO. RDSO/CG-18005 (LATEST REVISION).

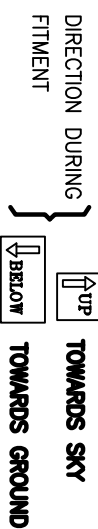
ALT. ITEM	AUTH.	DESCRIPTION	CKD.	DATE	CDIC NO.:-	B.G.	R.D.S.O. (CG)		RDSO/CG/DRG/DRAFT-1

ASSEMBLY DRGS. SUPERSEDED:-	INDIAN RAILWAYS
REFERENCE:-	LHB TYPE COACHES
	SECONDARY VERTICAL DAMPER FOR NON AC COACHES WITH FLAT BOGIE



**STICKER**



- \* MATERIAL OF STICKER SHOULD BE POLYESTER BASED WITH HIGH PERFORMANCE SELF ADHESIVE (WATER PROOF).
- \* STICKER BACKGROUND SHOULD BE ZINC YELLOW TO RAL 1018.
- \* COLOUR OF LETTERS AND SYMBOL SHOULD BE BLACK.
- \* SIZE OF STICKER SHOULD BE MIN. 8MM X 8MM.
- \* FONT SIZE ON STICKER SHOULD BE MIN. 10 MM.
- \* FONT STYLE ON STICKER SHOULD BE "ARIAL BLACK".
- \* STICKER SHOULD CORRELATE WITH "◎" AND "NOTE 7" OF DRAWING.

**NOTE:-**

1. # THE MANUFACTURER NAME OR CODE, RATED CAPACITY, TYPE OF DAMPER WITH R2SO DRG. NO., SERIAL NO. & MONTH & YEAR OF MANUFACTURE SHALL ALSO BE MARKED IN 10 mm HEIGHT LETTERS BY PUNCHING OR ENGRAVING WITH MINIMUM DEPTH OF 0.25 mm ON DUST COVER / BARREL TUBE.
2. NAME PLATE ALSO TO BE MOUNTED ON DUST COVER WITH ABOVE DETAILS.
3. XX-SURFACES ZINCED & FREE OF PAINTING.
4. DAMPER IS MOUNTED IN HORIZONTAL POSITION.
5. DURING FITMENT ON BOGIE, NAME PLATE SHOULD BE DIAMETRICALLY OPPOSITE TO ENGRAVING / PUNCHING.
6. PAINT SHADE TO RAL 9005 (BLACK) ON DAMPER WITH COVER.
7. ◎ MANUFACTURER SHOULD ENGRAVE THE WORD "DOWN" ON THE FACE OF CASING EYE WHICH WILL BE TOWARDS GROUND DURING FITMENT (SIZE OF ENGRAVING : MIN. 10 MM).

**DAMPER TESTING AT 23±5°C**

1	STROKE	50	mm
2	NO. OF REVOLUTIONS	115	min-1
3	VELOCITY	0.30	m/s
4	FORCE	8000±15% (WITHOUT ATTACHMENT)	N
5	TORSIONAL ANGLE	±22° (Min.)	DEG
6	CARDANIC ANGLE	±10° (Min.)	DEG
7	RADIAL STIFFNESS AT END CONNECTIONS	7225-24000	N/mm

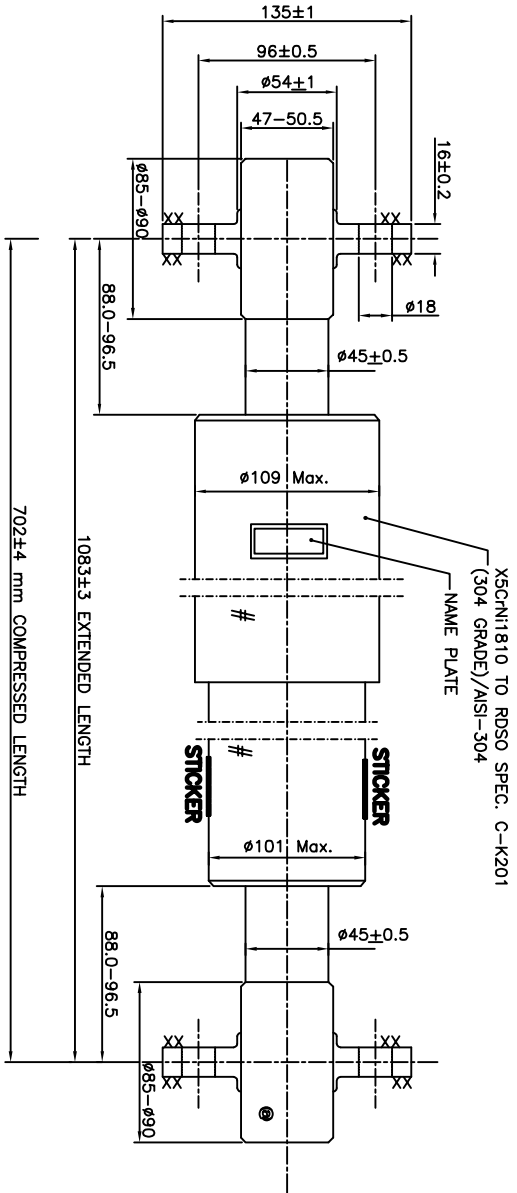
WIDE RANGE IN CHARACTERISTICS AND VARIOUS DIMENSIONS OF DAMPER HAS BEEN PROVIDED TO FACILITATE THE MANUFACTURER TO DESIGN AND MANUFACTURE THE QUALITY PRODUCT AS PER R2SO SPECIFICATION NO. R2SO/Cs-18005 REV. (LATEST).  
 FIRM SHOULD SUBMIT THEIR DESIGN/ DRAWING WITH PROPER TOLERANCES (SUPPORTED BY IS/ISO STANDARD) IN CHARACTERISTICS AND DIMENSIONS. RANGE OF VARIOUS CHARACTERISTICS AND DIMENSIONS IN PARTICULAR DESIGN OF DAMPER OF A PARTICULAR SUPPLIER (WITH INCLUSION OF TOLERANCE, MENTIONED IN DRAWING) SHOULD NOT BE BEYOND THE RANGE SPECIFIED IN LATEST R2SO DRAWING AND R2SO STR NO. R2SO/Cs-18005 (LATEST REVISION).

ALT.	ITEM	AUTH.	DESCRIPTION	CKD.	DATE	CDIC NO.:-	B.G.	R.D.S.O. (CG)	FOR FLAT BOGIES WITH AIR SPRING	R2SO/CG/DRG/DRAFT-6

ASSEMBLY DRGS. SUPERSEDED BY:-	INDIAN RAILWAYS
REFERENCE:-	LHB TYPE COACHES
	SECONDARY LATERAL DAMPER
	FOR FLAT BOGIES WITH AIR SPRING

ASSEMBLY DRGS. SUPERSEDED BY:-	INDIAN RAILWAYS
REFERENCE:-	LHB TYPE COACHES
	SECONDARY LATERAL DAMPER
	FOR FLAT BOGIES WITH AIR SPRING

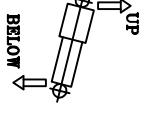
ASSEMBLY DRGS. SUPERSEDED BY:-	INDIAN RAILWAYS
REFERENCE:-	LHB TYPE COACHES
	SECONDARY LATERAL DAMPER
	FOR FLAT BOGIES WITH AIR SPRING



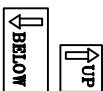
X50C/N1810 TO RDSO SPEC. C-K201  
(304 GRADE)/AISI-304

NAME PLATE

**STICKER**



DIRECTION DURING  
FITMENT



TOWARDS SKY

TOWARDS GROUND

- \* MATERIAL OF STICKER SHOULD BE POLYESTER BASED WITH HIGH PERFORMANCE SELF ADHESIVE (WATER PROOF).
- \* STICKER BACKGROUND SHOULD BE ZINC YELLOW TO RAL 1018.
- \* COLOUR OF LETTERS AND SYMBOL SHOULD BE BLACK.
- \* SIZE OF STICKER SHOULD BE MIN. 8MM X 8MM.
- \* FONT SIZE ON STICKER SHOULD BE MIN. 10 MM.
- \* FONT STYLE ON STICKER SHOULD BE "ARIAL BLACK".
- \* STICKER SHOULD CORRELATE WITH "⊕" AND "NOTE 7" OF DRAWING.

NOTE:-

- # THE MANUFACTURER NAME OR CODE, RATED CAPACITY, TYPE OF DAMPER WITH RDSO DRG. No., SERIAL NO. & MONTH & YEAR OF MANUFACTURE SHALL ALSO BE MARKED IN 10 mm HEIGHT LETTERS BY PUNCHING OR ENGRAVING WITH MINIMUM DEPTH OF 0.25 mm ON DUST COVER / BARREL TUBE.
- NAME PLATE ALSO TO BE MOUNTED ON DUST COVER WITH ABOVE DETAILS.
- XX-SURFACES ZINCED & FREE OF PAINTING.
- DAMPER IS MOUNTED IN HORIZONTAL POSITION.
- DURING FITMENT ON BOGIE, NAME PLATE SHOULD BE DIAMETRICALLY OPPOSITE TO ENGRAVING / PUNCHING.
- PAINT SHADE TO RAL 7012 (BASALT GREY) ON DAMPER WITH COVER.
- ⊕ MANUFACTURER SHOULD ENGRAVE THE WORD "DOWN" ON THE FACE OF CASING EYE WHICH WILL BE TOWARDS GROUND DURING FITMENT (SIZE OF ENGRAVING : MIN. 10 MM).
- MAXIMUM COMPRESSIVE FORCE ON RUBBER PART= 20KN(APPROX.).

DAMPER TESTING AT 23±5°C

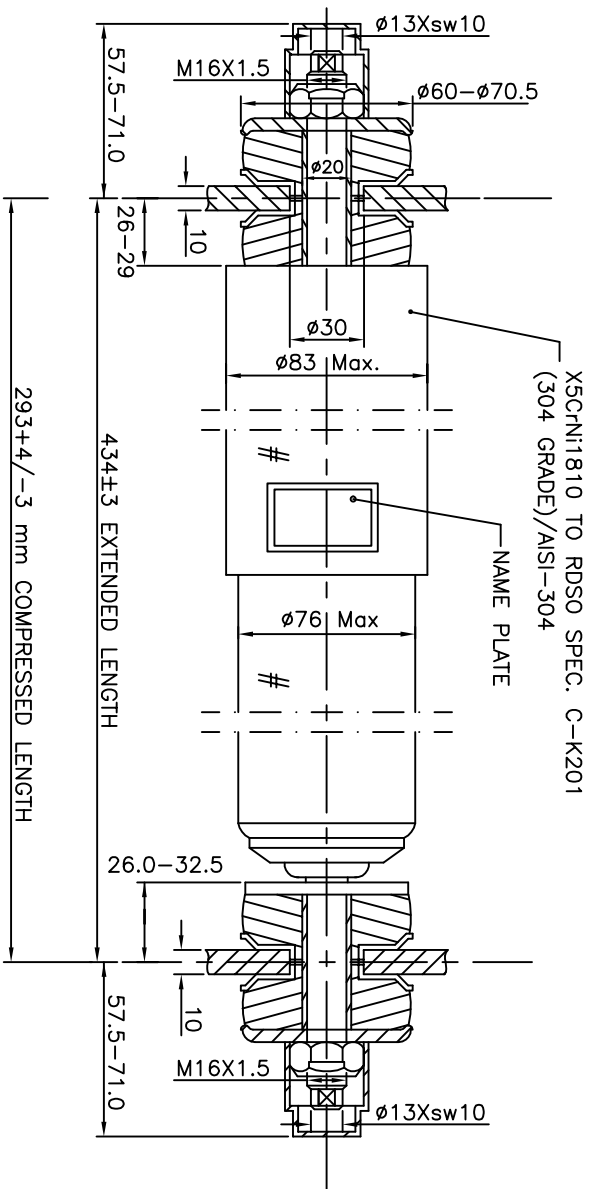
STROKE	NO. OF REVOLUTIONS	VELOCITY	FORCE	TORSIONAL ANGLE	CARDANIC ANGLE	RADIAL STIFFNESS AT END CONNECTIONS
1	25	76	0.10	11000±15% (WITHOUT ATTACHMENT)	±9.5° (Min.)	±9° (Min.)
2	76	0.10	11000±15% (WITHOUT ATTACHMENT)	±9.5° (Min.)	±9° (Min.)	50 - 70
3	76	0.10	11000±15% (WITHOUT ATTACHMENT)	±9.5° (Min.)	±9° (Min.)	50 - 70
4	76	0.10	11000±15% (WITHOUT ATTACHMENT)	±9.5° (Min.)	±9° (Min.)	50 - 70
5	76	0.10	11000±15% (WITHOUT ATTACHMENT)	±9.5° (Min.)	±9° (Min.)	50 - 70
6	76	0.10	11000±15% (WITHOUT ATTACHMENT)	±9.5° (Min.)	±9° (Min.)	50 - 70
7	76	0.10	11000±15% (WITHOUT ATTACHMENT)	±9.5° (Min.)	±9° (Min.)	50 - 70

VIBE RANGE IN CHARACTERISTICS AND VARIOUS DIMENSIONS OF DAMPER HAS BEEN PROVIDED TO FACILITATE THE MANUFACTURER TO DESIGN AND MANUFACTURE THE QUALITY PRODUCT AS PER RDSO SPECIFICATION NO. RDSO/CG-18005 REV. (LATEST).

FIRM SHOULD SUBMIT THEIR DESIGN/ DRAWING WITH PROPER TOLERANCES (SUPPORTED BY IS/ISO STANDARD) IN CHARACTERISTICS AND DIMENSIONS. RANGE OF VARIOUS CHARACTERISTICS AND DIMENSIONS IN PARTICULAR DESIGN OF DAMPER OF A PARTICULAR SUPPLIER WITH INCLUSION OF TOLERANCE, MENTIONED IN DRAWING SHOULD NOT BE BEYOND THE RANGE SPECIFIED IN LATEST RDSO DRAWING AND RDSO STR NO. RDSO/CG-18005 (LATEST REVISION).

ALT. ITEM	AUTH.	DESCRIPTION	CKD.	DATE	CDIC NO.:-	B.G.	R.D.S.O. (CG)	RDSO/CG/DRG/DRAFT-5

ITEM	DESCRIPTION & DIMENSIONS	% OFF	REF.DRG.	Wt. of ONE (KG)	INTL. & SPEC. REMARKS
1	DAMPER				
SUPERSEDED BY:-					
ASSEMBLY DRGS. SUPERSEDED:-					
REFERENCE:-					
	SME P				
	I2 C				
	D				
	U.S.				
INDIAN RAILWAYS					
LHB TYPE COACHES					
YAW DAMPER FOR ALL TYPE OF LHB COACHES FITTED					
FIAT BOGIES					



NOTE:-

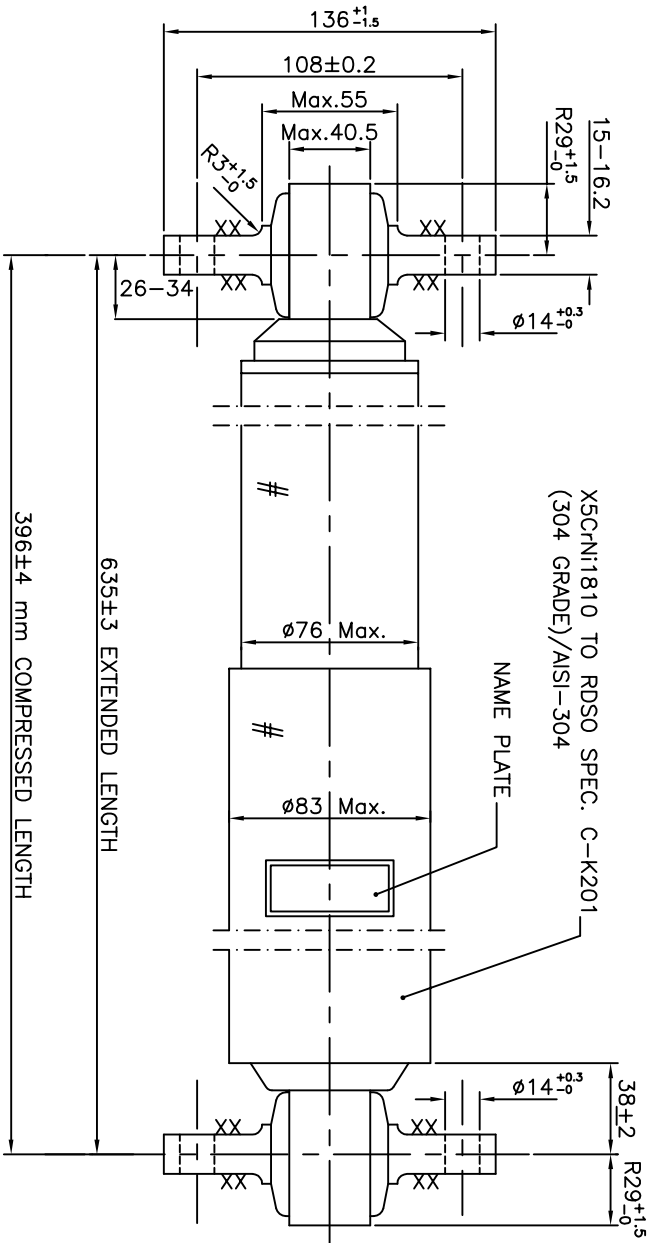
1. # THE MANUFACTURER NAME OR CODE, RATED CAPACITY, TYPE OF DAMPER WITH RDSO DRG. No., SERIAL NO. & MONTH & YEAR OF MANUFACTURE SHALL ALSO BE MARKED IN 10 mm HEIGHT LETTERS BY PUNCHING OR ENGRAVING WITH MINIMUM DEPTH OF 0.25 mm ON DUST COVER / BARREL TUBE.
2. NAME PLATE ALSO TO BE MOUNTED ON DUST COVER WITH ABOVE DETAILS.
3. DURING FITMENT ON BOGIE, NAME PLATE SHOULD BE DIAMETRICALLY OPPOSITE TO ENGRAVING / PUNCHING.
4. PAINT SHADE TO RAL 7012 (BASALT GREY) ON DAMPER WITH COVER.

DAMPER TESTING AT 23.±5°C

1	STROKE	50	mm
2	NO. OF REVOLUTIONS	115	min-1
3	VELOCITY	0.30	m/s
4	FORCE	4250±15% (WITHOUT ATTACHMENT)	N
5	CARDANIC ANGLE	±8° (Min.)	DEG
6	AXIAL STIFFNESS AT END CONNECTIONS	3200-5200	N/mm

WIDE RANGE IN CHARACTERISTICS AND VARIOUS DIMENSIONS OF DAMPER HAS BEEN PROVIDED TO FACILITATE THE MANUFACTURER TO DESIGN AND MANUFACTURE THE QUALITY PRODUCT AS PER RDSO SPECIFICATION NO. RDSO/CG-18005 REV. (LATEST).  
FIRM SHOULD SUBMIT THEIR DESIGN/ DRAWING WITH PROPER TOLERANCES (SUPPORTED BY IS/ISO STANDARD) IN CHARACTERISTICS AND DIMENSIONS. RANGE OF VARIOUS CHARACTERISTICS AND DIMENSIONS IN PARTICULAR DESIGN OF DAMPER OF A PARTICULAR SUPPLIER (WITH INCLUSION OF TOLERANCE, MENTIONED IN DRAWING) SHOULD NOT BE BEYOND THE RANGE SPECIFIED IN LATEST RDSO DRAWING AND RDSO STR NO. RDSO/CG-18005 (LATEST REVISION).

ALT. ITEM	AUTH.	DESCRIPTION	CKD. DATE	CDIC NO.:-	B.G.	R.D.S.O. (CG)		RDSO/CG/DRG/DRAFT-4
1		DAMPER						
ASSEMBLY DRGS. SUPERSEDED BY:-				INDIAN RAILWAYS				
LHB TYPE COACHES				LHB TYPE COACHES				
REFERENCE:-				PRIMARY VERTICAL DAMPER FOR ALL LHB COACHES FITTED WITH PLAT BOGIES				
SME P								
C								
D								
U.S.								



NOTE:-

1. # THE MANUFACTURER NAME OR CODE, RATED CAPACITY, TYPE OF DAMPER WITH RDSO DRG. No., SERIAL NO. & MONTH & YEAR OF MANUFACTURE SHALL ALSO BE MARKED IN 10 mm HEIGHT LETTERS BY PUNCHING OR ENGRAVING WITH MINIMUM DEPTH OF 0.25 mm ON DUST COVER / BARREL TUBE.
2. NAME PLATE ALSO TO BE MOUNTED ON DUST COVER WITH ABOVE DETAILS.
3. XX-SURFACES ZINCED & FREE OF PAINTING.
4. DAMPER IS MOUNTED IN VERTICAL POSITION.
5. DURING FITMENT ON BOGIE, NAME PLATE SHOULD BE DIAMETRICALLY OPPOSITE TO ENGRAVING / PUNCHING.
6. PAINT SHADE TO RAL 6027 (LIGHT GREEN) ON DAMPER WITH COVER.

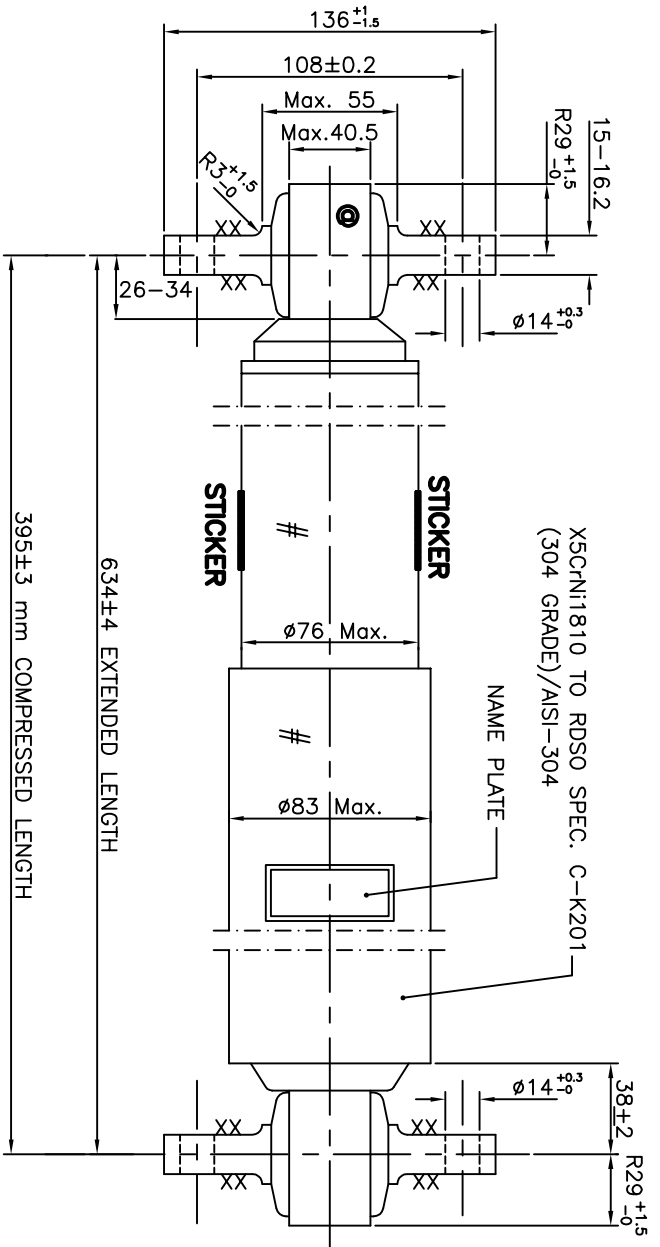
DAMPER TESTING AT 23 ± 5°C

1	STROKE	50	mm
2	NO. OF REVOLUTIONS	76	min-1
3	VELOCITY	0.20	m/s
4	FORCE	3500 ± 15% (WITHOUT ATTACHMENT)	N
5	TORSIONAL ANGLE	± 22 (Min.)	DEG
6	CARDANIC ANGLE	± 10 (Min.)	DEG
7	RADIAL STIFFNESS AT END CONNECTIONS	7225 - 24000	N/mm

VIDE RANGE IN CHARACTERISTICS AND VARIOUS DIMENSIONS OF DAMPER HAS BEEN PROVIDED TO FACILITATE THE MANUFACTURER TO DESIGN AND MANUFACTURE THE QUALITY PRODUCT AS PER RDSO SPECIFICATION NO. RDSO/CG-18005 REV. (LATEST).

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ALT. ITEM	AUTH.	DESCRIPTION	CKD.	DATE	CDIC NO.:-	B.G.	R.D.S.O. (CG)		RDSO/CG/DRG/DRAFT-3
					ASSEMBLY DRGS. SUPERSEDED BY:-	INDIAN RAILWAYS			
					REFERENCE:-	LHB TYPE COACHES			
					1:2	C	SECONDARY VERTICAL DAMPER FOR		
					D		LHB AC COACHES HAVING FLAT BOGIE		
					U.S.				
					1	DAMPER			
					ITEM DESCRIPTION & DIMENSIONS	% OFF	REF.DRG.	Wt. of ONE (KG)	Wt. & SPEC. REMARKS



NOTE:-

1. # THE MANUFACTURER NAME OR CODE, RATED CAPACITY, TYPE OF DAMPER WITH RDSO DRG. No., SERIAL NO. & MONTH & YEAR OF MANUFACTURE SHALL ALSO BE MARKED IN 10 mm HEIGHT LETTERS BY PUNCHING OR ENGRAVING WITH MINIMUM DEPTH OF 0.25 mm ON DUST COVER / BARREL TUBE.
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4. DAMPER IS MOUNTED IN HORIZONTAL POSITION.
5. DURING FITMENT ON BOGIE, NAME PLATE SHOULD BE DIAMETRICALLY OPPOSITE TO ENGRAVING / PUNCHING.
6. PAINT SHADE TO RAL 7012 (BASALT GREY) ON DAMPER WITH COVER.
7. @ MANUFACTURER SHOULD ENGRAVE THE WORD "DOWN" ON THE FACE OF CASING EYE WHICH WILL BE TOWARDS GROUND DURING FITMENT (SIZE OF ENGRAVING : MIN. 10 MM).

DIRECTION DURING FITMENT

- \* MATERIAL OF STICKER SHOULD BE POLYESTER BASED WITH HIGH PERFORMANCE SELF ADHESIVE (WATER PROOF).
- \* STICKER BACKGROUND SHOULD BE ZINC YELLOW TO RAL 1018.
- \* COLOUR OF LETTERS AND SYMBOL SHOULD BE BLACK.
- \* SIZE OF STICKER SHOULD BE MIN. 8MM X 8MM.
- \* FONT SIZE ON STICKER SHOULD BE MIN. 10 MM.
- \* FONT STYLE ON STICKER SHOULD BE "ARIAL BLACK".
- \* STICKER SHOULD CORRELATE WITH "Ø" AND "NOTE 7" OF DRAWING.

DAMPER TESTING AT 23±5°C

1	STROKE	50	mm
2	NO. OF REVOLUTIONS	115	min-1
3	VELOCITY	0.30	m/s
4	FORCE	8000±15%	N
5	TORSIONAL ANGLE	±22' (Min.)	DEG
6	CARDANIC ANGLE	±10' (Min.)	DEG
7	RADIAL STIFFNESS AT END CONNECTIONS	7225 - 24000	N/mm

VIDE RANGE IN CHARACTERISTICS AND VARIOUS DIMENSIONS OF DAMPER HAS BEEN PROVIDED TO FACILITATE THE MANUFACTURER TO DESIGN AND MANUFACTURE THE QUALITY PRODUCT AS PER RDSO SPECIFICATION NO. RDSO/CG-18005 REV. (LATEST).

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RANGE OF VARIOUS CHARACTERISTICS AND DIMENSIONS IN PARTICULAR DESIGN OF DAMPER OF A PARTICULAR SUPPLIER (WITH INCLUSION OF TOLERANCE, MENTIONED IN DRAWING) SHOULD NOT BE BEYOND THE RANGE SPECIFIED IN LATEST RDSO DRAWING AND RDSO STR NO. RDSO/CG-18005 (LATEST REVISION).

ALT. ITEM	AUTH.	DESCRIPTION	CKD. DATE	CDIC NO.:-	B.G.	R.D.S.O. (CG)		RDSO/CG/DRG/DRAFT-2

ASSEMBLY DRGS. SUPERSEDED:-	SOURCE P	INDIAN RAILWAYS
REFERENCE:-	C	LHB TYPE COACHES
	D	SECONDARY LATERAL DAMPER FOR
	J.S.	ALL COIL FLAT BOGIE