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RAIL COACH FACTORY, KAPURTHALA
(Coach Alteration Instruction)

CAI/RCF/MECH/R-SS/006

MD46251

Date: 20 06 2006

1. **Description:** OEM Vent and Vacuum Valves in overhead 30 liters water tank to avoid air locking in water circulation system in RCF stainless steel coaches (Rajdhani Rake).
2. **Drawing No:**

S. No.	Description	Drawing No. & alt
1	Water Tanks 30ltrs	LW63150 alt. 'b'

3. **Reason for alteration:** To overcome the problems of air locking in water circulation system.
4. **Coach type:** RCF Stainless Steel coaches.
5. **To be carried out:** During IOH/POH or unscheduled repair in sick line.
6. **Special Instructions:**
 - a. Dismount the existing (old) valve from over head 30 ltrs Water Tank.
 - b. Fit the Original Equipment Manufacturer's valve.

Address of OEM Vent And Vacuum Valves manufacturer:

1. SANHA Kainer GmbH & Co. KG
Im Teelbruch 80
45219 Essen, Germany
phone: 0049-2054-925-0
Fax: 0049-2054925-260
E-mail: info@sanha.com
Website: www.sanha.com or www.nirosan.de/catalog/

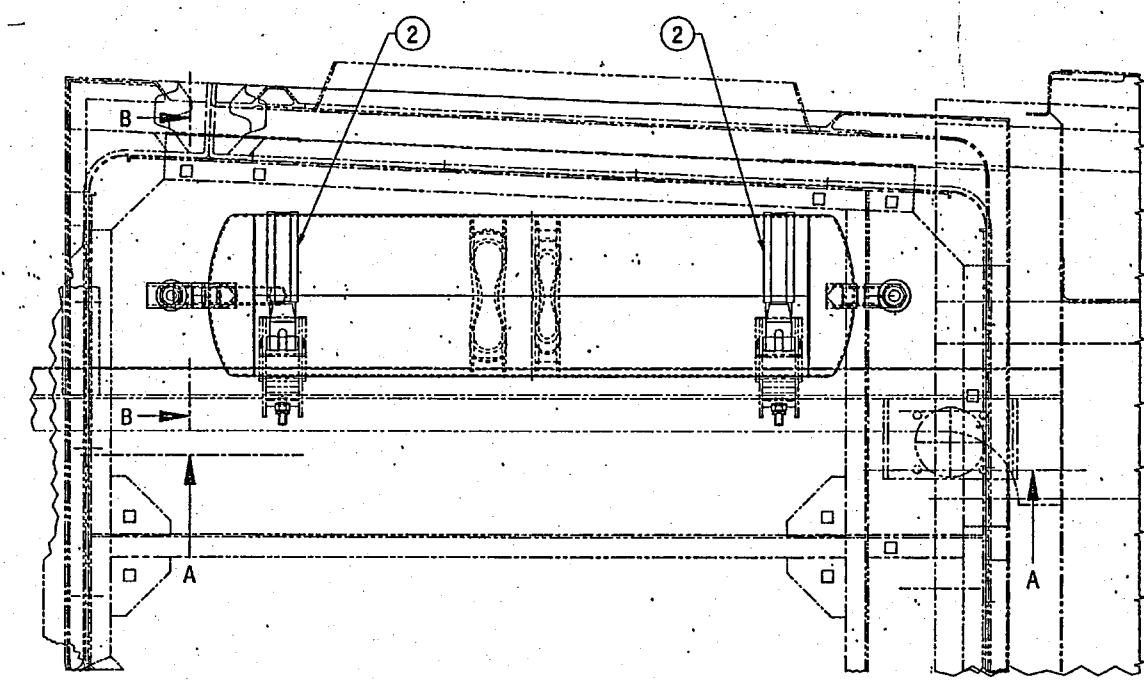
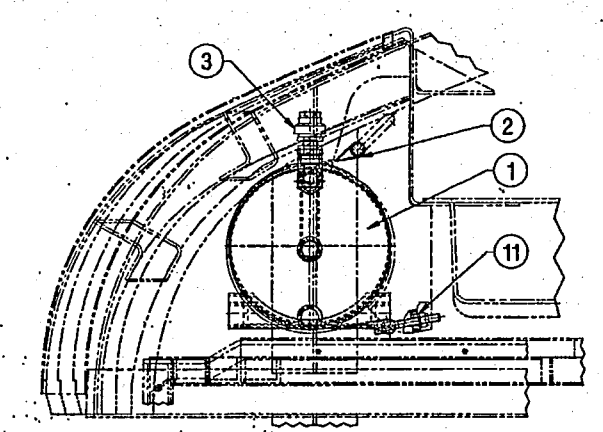
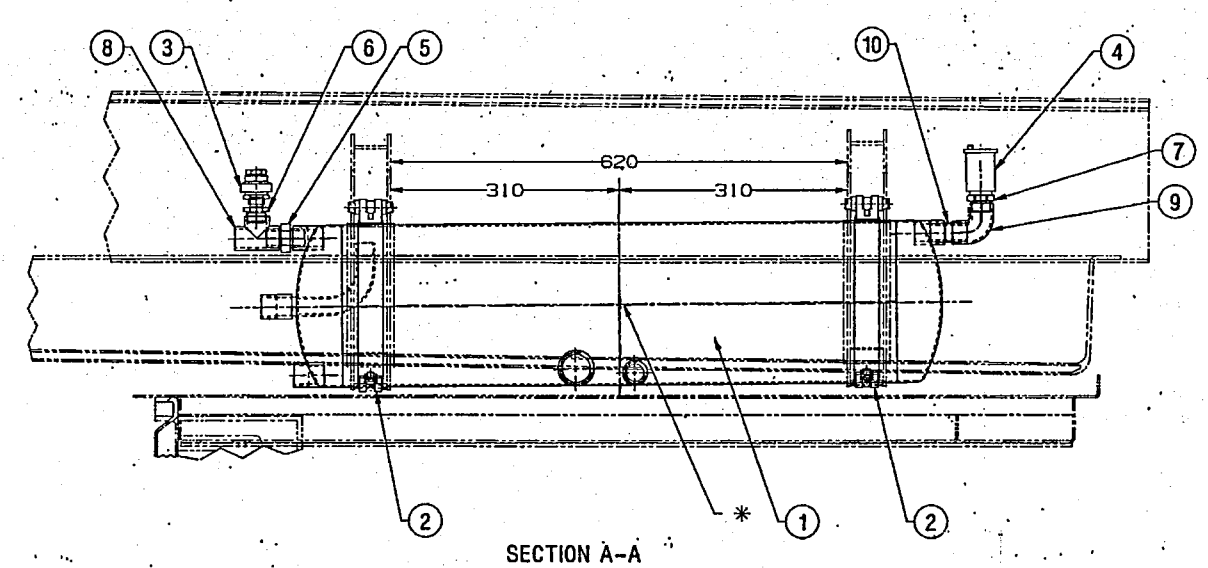
2. M/s HANS-H.VOSS TULPENWEG 2-25524
ITZEHOF-EDENDORF GERMANY
TEL: (04821) 41409, FAX: 41014


For General Manager (Mech.)

Encls:

LW63150 alt. 'b'

ALT. NO.	ALT. DATE	ZONE	ALTERATIONS	AUTHORITY
a	17/11/2004	116	Description of item no.7 was hexagon reduction 20x10 bore spec. was IS:1239-PT2-92 Tab.27, AISI304	Dy.CME/TOT
		K15	Description of item no.4 was vent valve G3/8"	
		G10	NOTE 2 MODIFIED AND NOTE 8 ADDED.	
b	25/05/2006	110, E6	NOTE NO.9 ADDED IN THE DRAWING	SME/DEV



- NOTE 1: VACCUM VALVE IS A UNIDIRECTIONAL VALVE THAT OPERATES TO RELEASE VACCUM CREATED IN THE TANK BY CONSUMING WATER OF THE TANK.
2. PURG-O-MAT AUTOMATIC FLOAT AIR VENT VALVE IS A VALVE THAT RELEASE AIR PRESSURE WITHOUT ANY LEAKAGE OF WATER.
3. FOR ALL CONNECTION BETWEEN THE THREADED FITTINGS OF NON CORRODING STEEL THE EXTERNAL THREADS HAVE TO BE WRAPPED WITH HEMP AND COVERED WITH SEALING PASTE; PRODUCT-NEO PERMIT UNIVERSAL OF M/S LERCH & CO.
4. ALL OTHER SCREW CONNECTION/BOLT CONNECTION, WITH OR WITHOUT NUTS, OF STAINLESS STEEL ARE TO BE GREASED WITH MOLYKOTE (MOLYBDENUM DISULPHIDE).
5. THE CUT-OUT IN WATER TANKS COMPONENTS FOR OUTLETS SHALL BE CUT BY PROFILE CUTTING ONLY.
6. THE FOLLOWING TESTS SHALL APPLIED TO PROTOTYPE OF WATER TANK (I) DIMENSIONAL CHECKING. (II) WATER TIGHTNESS (III) AIR TIGHTNESS WITH A AIR-PRESSURE OF 50000 Pa (IIII) TESTING OF STAINLESS STEEL USED FOR MANUFACTURING.
7. THE BULK MANUFACTURE SHALL BE UNDERTAKEN ONLY AFTER THE APPROVAL OF PROTOTYPE.
8. THE PURG-O-MAT AUTOMATIC FLOAT AIR VENT VALVE AND SHUT-OFF-VALVE CAN BE PROCURED FROM M/S HANS-H. VOSS TULPENWEG 2-25524 ITZEHOE-EDENDORF GERMANY TEL. (04821) 41409 FAX 41014
9. WATER TANK SHALL BE MARKED USING STAINLESS STEEL NAME PLATE SIZE 2X80X120 MM SHOWING MAKE, PO DETAIL, DATE OF MANUFACTURING ETC AT * MARKED LOCATION OR OTHER SUITABLE LOCATION BY TAG WELDING.

Not to be
Entered
in
the
Drawing
5 JUN 2006
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11	MACHINED WASHER A10.5	2	NIL	IS: 2016-1967 140HV-A2	NIL
10	BARREL NIPPLE 20 BORE X54	1	NIL	IS: 1239-PT2-92 TAB. 2, AISI304	THREAD ISO 7/1
9	ELBOW 90 DEGREE 20 BORE	1	NIL	IS: 1239-PT2-92 TAB. 8, AISI304	THREAD ISO 7/1
8	EQUAL TEE FEMALE THREAD 20 BORE	1	NIL	IS: 1239-PT2-92 TAB. 8, AISI304	THREAD ISO 7/1
7	HEXAGON REDUCTION 3/4"x3/8"	1	NIL	IS: 1879-87 TAB. 7.1, AISI304	THREAD ISO 7/1
6	HEXAGON REDUCTION 20x15 BORE	1	NIL	IS: 1239-PT2-92 TAB. 27, AISI304	THREAD ISO 7/1
5	HEXAGON DOUBLE NIPPLE 20 BORE	1	NIL	IS: 1239-PT2-92 TAB. 28, AISI304	THREAD ISO 7/1
4	PURG-O-MAT AUTOMATIC FLOAT AIR VENT VALVE WITH SHUT-OFF VALVE HAVING THREADS DEP 3/4"	1	NIL	MADE IN GERMANY BY HANS-H. VOSS	SEE NOTE 2 AND 8
3	VACCUM VALVE G1/2"	1	4FWP237.0. 30.046.003	NIL	SEE NOTE 1
2	TAUT BAND WITH RUBBER PROFILE	2	LW63152	NIL	NIL
1	ROOF WATER TANK 30L	1	LW63139	NIL	NIL

WELD LENGTH	ITEM	DESCRIPTION & DIMENSIONS	GROUP	DETAIL DRG	MATL. & SPEC.	REMARKS
NIL	N	LAVATORY & ITS FITTINGS	FILE	W63150	ALT: a	
WEIGHT	KG	//nas/dev/ashk/tank/lw63150b.prt (3D)				
NIL	KG	ROOF WATER TANK 30-L				
S. AREA	M ²	MOUNTING FOR LHB COACHES				
NIL	M ²	RAIL COACH FACTORY, KAPURTHALA				
LENGTH/DIA	M	INDIAN RAILWAYS STANDARD				
NIL	M	REF. DRG. 1 10113.0.30.110.006				
WIDTH/THICK.	M	PL NO. 01158650				
NIL	M	DRG. NO. LW63150				
HEIGHT	M	ALT. 6				
NIL	M	SIZE (A SHEET) 1/1				