

S. No. 40

MDTS-040  
Dated 3.1.97

Schedule of Technical Requirements of Head Stock Assembly  
on air type coaches.

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Prepared by

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3-1-97

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SCHEDULE OF TECHNICAL REQUIREMENTS OF HEAD STOCK ASSEMBLY ON ICF  
TYPE COACHES

1. SCOPE: This specification covers the technical requirements of head stock assembly for EOG coaches to assembly drawing no. CC12232 alt-a and SG coaches to assembly drawing no. CC12230 alt-b.
2. MATERIAL: Material of the components which are made up of corten steel to IRS.M.41-93 may be manufactured from IS: 2062-92, Fe 410 Wc. for sheets  $t > 5\text{mm}$ . and IS: 5986-92 Fe-330 for sheet  $t < 5\text{mm}$ .
3. QUALITY OF HEAD STOCK ASSEMBLY: Head stock assembly shall be fabricated either by MAG welding or by electric arc welding and must be free from welding defects. distortion and shrinkage losses must be avoided by suitable fabrication method using jigs and fixtures.
4. SAMPLING: Pilot sample of head stock to be offered to RCF for inspection. After approval and clearance of the sample bulk manufacturing is to be undertaken.
5. PROTECTION: Headstock assembly shall be protected as per RCF protection procedure order no. WI 100040.
6. PACKING: Headstock assembly should be supplied in suitable packing so that no damage may occur during handling.
7. INSPECTION: Dimension  $508 \pm 0.5 / -0.5$  is the interface dimension of draw gear general arrangement and shall be checked by GO and NO GO gauges.

SCHEDULE OF TECHNICAL REQUIREMENTS OF HEAD STOCK ASSEMBLY ON TCF  
TYPE COACHES

1. SCOPE: This specification covers the technical requirements of head stock assembly for EOG coaches to drawing no. CC12232 alt-C and SG coaches to drawing no. CC12230 alt-b.
2. MATERIAL: Material of the components which are made up of carbon steel to IRS.M.41-93 may be manufactured from IS: 2062-92, Fe 410 Wc. *for sheets t ≥ 5mm. And*
3. QUALITY OF HEAD STOCK ASSEMBLY: Head stock assembly shall be fabricated either by MAG welding or by electric arc welding and must be <sup>free</sup> from welding defects. Distortion and shrinkage <sup>losses</sup> must be avoided by using suitable <sup>fabrication method using</sup> jigs and fixtures. *A separate fixture*
4. SAMPLING: Pilot sample of head stock to be offered to RCF for inspection. After approval and clearance of the sample <sup>length</sup> manufacturing to be undertaken.
5. PROTECTION: Headstock assembly shall be protected as per RCF protection procedure order no. WI 100040.
6. PACKING: Headstock assembly should be supplied in suitable packing so that no damage may occur during handling.

IS: 5986-92  
Fe-330

IS: 1079: 2S  
Fe 330  
for sheet  
t ≤ 5mm

Inspection :- Dimension 508 ± 0.5 is the interface dimension of draw gear general arrangement and shall be checked by Go and NoGo gauges.