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DIESEL LOCO MODERNISATION WORKS, PATIALA

AXLE PRESSING RECORD OF DETC

Date of pressing: a) Wheel _____ Axle No.: _____
b) Bull Gear _____ Axle Type: **DETC**

Sr. No.	Parameter	Bull gear	Collar (Gear End)	Wheel (Gear End)	Wheel (Free End)
1.	Seat size	193.994 – 194.016 mm	193.38- 193.42 mm	192.956 – 193 mm	192.956 – 193 mm
	Observation				
2.	Bore size	193.80-193.83 mm	193.28-193.32 mm	192.69- 192.74mm	192.69- 192.74mm
	Observation				
3.	Interference reqd.	0.160-0.216 mm	0.06 - 0.12 mm	0.230-0.270	0.230-0.270
4.	Specified Pressure (tonnes)	58 – 76T	8 – 10T	77.2 - 115.6T	77.2 - 115.6T
	Obtained Pressure(tons)				
5.	i) Distance between wheel to wheel (1598 ± 0.5 mm) on Rough wheels :				
6.	Traceability	S.No.: Make:	NA	BS S.N. Type: Make: Cast No.	BS S.N. Type: Make: Cast No.

Pressed by: _____

Decision :

Conforming/Non-conforming

Signature of Sect. I/c

Name: _____

Designation: _____

Date: _____

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DIESEL LOCO MODERNISATION WORKS, PATIALA

SUSPENSION TUBE RECORD DETC

Date of tube mounting : _____

Axle no. _____

(GE-Gear End, FE- Free End)

S.N.	Parameter	Specified value	Recorded value
1.	Type of taper roller bearing GE FE (Write make of the bearing)	- -	
2.	Taper roller Bearing seat size GE FE Ref. Drg. No. DMU/DPC ₅ -0-2-505	$\phi 199.949$ +0.080 mm + 0.109 mm $\phi 198.298$ +0.080 mm + 0.109 mm	
3.	Taper roller Bearing Bore size GE FE	$\phi 199.949-198.974$ mm $\phi 198.298-198.325$ mm	
4.	Torquing of bolt i) M.10x 30mm ii)M.12 X60 mm ii) M.12x70mm	245-295 KG Cm 418-503 Kg Cm 418-503 Kg Cm	
5.	End play of tube	0.050-0.254mm	
6.	Quantity of grease GE FE	1000gm 500 gm	Filled/Not filled

Suspension tube No. & make :

Suspension tube mounted by

Decision:**Conforming /Non-conforming**

Signature of Section I/c: _____

Date: _____

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DIESEL LOCO MODERNISATION WORKS, PATIALA

AXLE BOX MOUNTING RECORD DETC

Date of axle box mounting : _____ Axle no. _____

(GE-Gear End, FE- Free End)

S.N.	Parameter	Specified value	Recorded Value
1.	Axle Journal Size – GE FE	140.043 to 140.068 mm	
2.	Brg. Bore Size – GE FE	139.975 to 140.00 mm	
3.	Interference – GE FE	0.043 to 0.093mm	
4.	Axle Advancement – GE FE	24-26mm	
5.	Radial Clearance – GE FE	NBC- 0.085-0.160mm FAG- 0.080-0.130mm	
6.	Qty. of grease – GE FE	2.25 Kg/ Brg. Ref. ICF/SK-0-2-015	Filled/Not filled
7.	Torquing of bolts i) M-16 X 1.5 (6H) mm	12 Kg m Ref. DRG. EMU/M-0-2-001	
8.	Make of roller Bearing GE FE		

Axle box mounted by: _____

Decision:

Conforming /Non-conforming

Signature of Section I/c: _____

Date: _____

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DIESEL LOCO MODERNISATION WORKS, PATIALA

FRAME FURNISHING (DETC Bogies)

Frame No.: _____ PL No. _____ Make: _____

PO No. and date _____ Date: _____

S.N	Parameters	Observation Made (Tick)
1	Brake Rigging fitment	Done/Not done
2	2 Nos. parking brake Cylinders fitment	Done/Not done
3	4 Nos. Brake Cylinders fitment	Done/Not done
4	Brake shoe and brake beam fitment	Done/Not done
5	2 Nos. Reservoir fitment	Done/Not done
6	Brake Cylinder Piping and its clamping	Done/Not done
7	Parking B.C. Piping and its clamping	Done/Not done
8	Under Slung Piping and its clamping	Done/Not done
9	Air Spring Piping and its clamping	Done/Not done
10	Dust Shield (8 Nos.) assembly	Done/Not done
11	Crown packing plate fitment	Done/Not done
12	1 Nos. bolster fitment	Done/Not done Make _____
13	02 Nos. Parking Brake Cylinders fitment	Done/Not done Make _____
14	2 Nos. Vertical Dampers, 2 Nos. Lateral Dampers fitment and troquing to 20kgfm	Done/Not done Make _____
15	02 Nos. Air Springs fitment	Done/Not done Make _____
16	Lateral Stop Clearance between Bolster & Bogie Frame: 40±2mm on both sides	1. _____ mm 2. _____ mm

Decision:

ACCEPTED/ NOT ACCEPTED

SIGNATURE _____

DESIGNATION: _____

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**DIESEL LOCO MODERNISATION WORKS, PATIALA
TRACTION MOTOR AND AXLE ASSEMBLY**

DETC No. _____

Railway _____

Shed _____

I. PANTO BOGIE: FRAME NO. _____

Sr. No.	Date	Traction motor no	Traction motor make	Traction motor PO No. and date	Axle No.	Backlash 0.200mm to 0.700mm	Gear Case Make	Torquing M 30 bolts 1260 Nm Yes/No	Remarks
1.									
2.									

II. RADIATOR BOGIE: FRAME NO. _____

Sr. No.	Date	Traction motor no	Traction motor make	Traction motor PO No. and date	Axle No.	Backlash 0.200mm to 0.700mm	Gear Case Make	Torquing M 30 bolts 1260 Nm Yes/No	Remarks
3.									
4.									

ACCEPTED / NOT ACCEPTED

Sign. of Section Incharge

Date: _____

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DIESEL LOCO MODERNISATION WORKS, PATIALA
BOGIE PRE-RUN TEST RECORD

Bogie Frame No.: _____ (Panto/ Radiator)

Date of testing : _____

Run Test Done from _____ hrs. to _____ hrs

Ambient Temperature: _____

Sr. No.	Parameter to be checked	Traction Motor No-1/3		Traction Motor No.-2/4	
		Pinion End	Free End	Pinion End	Free End
1.	Qty. of Cardium Compound added (6 Kg)		N.A.		N.A.
2.	Leakages in gear case (Yes/No)		N.A.		N.A.
3.	Axle Box Temperature (Max. Atm.Temp.+50° C)				
4.	Suspension tube bearing Temp. (Max. Atm.Temp.+50° C)				
5.	Tr. Motor Bearing Temp. (Max. Atm.Temp.+50° C)				
6.	Any Abnormal Sound (Yes/No)				

Remarks if any:

Confirming / Non confirming

Sign. of Section Incharge

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FORMAT FOR BOGIE STAIC LOADTESTING (All dimensions in mm)

Ref. Drg. No. 199-9-0-510 Alt-g

Bogie Type:	Panto Side (Front Bogie)	Date of Inspection							
Bogie Frame No.:		Bogie Frame Make:							
PARAMETERS	SPECIFIED	ACTUAL							
		R1	R2	R3	R4	L1	L2	L3	L4
Axle Box Spring height with CR	245±3mm								
AXLE BOX LUG CLEARANCE	35±5mm								
COMPENSATING RING THICKNESS	PANTO SIDE: 6mm								
CROWN CLEARANCE	23±3mm	R1		R2		L1		L2	
BOGIE FRAME CORNER HEIGHT	688±5mm	R1		R2		L1		L2	

Accepted / Not accepted

Sign. of Section Incharge
 Date: _____

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FORMAT FOR BOGIE STAIC LOADTESTING (All dimensions in mm)

Ref. Drg. No. 199-9-0-510 Alt-g

Bogie Type:	Radiator Side (Rear Bogie)	Date of Inspection							
Bogie Frame No.:		Bogie Frame Make:							
PARAMETERS	SPECIFIED	ACTUAL							
		R5	R6	R7	R8	L5	L6	L7	L8
Axle Box Spring height with CR	245±3mm								
AXLE BOX LUG CLEARANCE	35±5mm								
COMPENSATING RING THICKNESS	RAD SIDE: 8mm								
CROWN CLEARANCE	23±3mm	R3		R4		L3		L4	
BOGIE FRAME CORNER HEIGHT	688±5mm	R3		R4		L3		L4	

Accepted / Not accepted

Sign. of Section Incharge
 Date: _____

Sr No.	Description of Item	Standard Value
1	Height of Buffer from Rail level	1080 to 1105
2	Wheel gauge	1600±1mm
3	Wheel dia.	952 ⁺³ ₋₆ mm
4	Wheel base	2896 mm
5	Clearance between Axle crown & bogie	23±3 mm
6	Clearance between Bolster crown & bogie	
7	Height of Rail guard from rail level	141 mm
8	Height of cattle guard from rail level	206 (+6, -0)
9	Bogie to body clearance	
10	Rail to bogie clearance	688±5 mm
11	Bolster safety strap	
12	Bolster CD	
13	Axle safety strap	35±5 mm
14	Axle CD spring	
15	Wheel profile	
	a) Flange thickness	127 ⁺⁴ ₋₀ mm
	b) Root radius	R14.5mm (Ref. Sketch No. 91146)
16	Diameter difference of wheel on same axle	0.5mm
17	Diameter difference of different axle	5.0 mm on same bogie
18	Bogie to bogie	14783
19	Gap between brake block & wheel	
20	Buffer length	613mm