

भारत सरकार Government of India  
रेल मंत्रालय Ministry of Railways  
रेलवे बोर्ड Railway Board

(E-File no. 3352629)

No. 2007/M(C)/137/16MustChange

New Delhi, Dated 05.10.2021

PCMEs  
ICF/MCF/RCF

ED / Carriage  
RDSO Lucknow

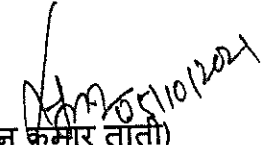
Sub: Failure of LHB Bogie rubber components under warranty.

Ref: SWR letter no. SWR/M/W/10-LA-Vol. II dated 21.09.2021 (copy enclosed)

Vide reference above, SWR has reported failure of Rubber Metal Bonded components of LHB Bogie which are under warranty which is self explanatory.

In this regard, it is advised to get the matter examined and take necessary action further under intimation to this office.

For information and necessary action please.

  
(सुमन कुमार तांती)  
निदेशक / यांत्रिक इंजी. को.  
रेलवे बोर्ड

C/-All PCMEs/Zonal Railways for kind information and necessary action please

दक्षिण पश्चिम रेलवे  
SOUTH WESTERN RAILWAY



प्रधान कार्यालय / Head Quarters' Office, Rail Soudha,  
यांत्रिक विभाग / Mechanical Branch,  
दूसरी तला, स्कन्ध पूरब, 2<sup>nd</sup> Floor, East Wing,  
गदग रोड, हुबल्लि / Gadag Road, Hubballi-580 020  
Tele: 065-25806/ 0836-2289890  
Fax: 0836-2289890

No. SWR/M/W/10-LA-Vol.II

दिनांक /Date: 21.09.2021

ED/Carriage  
RDSO/Lucknow

Sub: Failure of LHB Bogie components under warranty.

On SWR Mysore and Hubli Workshops are carrying out maintenance of LHB coaches including SS-1, SS-2 & SS-3. Mysore Workshop is carrying out these maintenance since last three years whereas Hubli Workshop has just recently started these maintenance work.

It is noticed that Rubber Metal bonded components (ball joint roll link, ball joint traction lever, axle box pivot bush, pad for secondary suspension etc.) are getting rejected due to failure of bonding between rubber component and metal. During my inspection to Mysore Workshop these components were shown.

As per "must change item list" for LHB coaches, these components to be changed in SS-2 schedules (after 36 months) in non-AC coaches and for AC coaches during SS-3 schedules (after 72 months) but these items are getting rejected during first schedule (SS-1 only).

Sl. No.	PL No.	Description	2020-2021			2021-2022 (Till Aug'21)		
			Total comp	Failed comp	%	Total comp	Failed comp	%
1.	33500010	Ball Joint Traction Lever	3888	1968	49.82	1544	909	58.87
2.	33500022	Ball Joint Roll Link	3888	1221	27.91	1544	439	28.43
3.	33503023	Pad for Secondary Suspension	1696*	368	26.69	600	252	42.00
4.	33500060	Axle Box Pivot Bush	3888	1016	26.13	1544	468	30.31

\*There were 212 coaches with coil spring in 2020-21 and 75 coaches during 2021-22.

Amst/cy  
28/9/21

106  
29/9  
Cdn/Carriage

Sh. Shilpa

SO/MK  
- please put up  
letter for ED/Carriage  
and RDSO/MS.  
28/9/21

It is found that failure of these components are very high in case of Ball Joint Traction Lever 50% and in case of other components it is 26% during 2020-21 and during current year is increasing. Such high premature failure of safety components is serious cause of concern.

Since these items are under warranty, letter is already sent to firms for replacement of these items, but there is no response from these firms.

You are requested to take up this matter with PUs i.e. ICF / MCF and firms which are supplying these components for replacement and quality supply.



( P.V. Barapatre )  
CWE/SWR

Copy to:

✓ EDME/Coaching – For information and necessary action please.

CWM/MYSS – He is requested to chase the matter with ICF and MCF and firms which have supplied these items and failed under warranty.

**FAILURE DETAILS OF RUBBER AND RUBBER METAL BONDED COMPONENTS -  
2021-22 ( APRIL to AUGT) DURING SHOP SCHEDULE - I (193 coaches)**

<b>01</b>	<b>Ball joint traction lever</b>			<b>PL. NO. 3350010</b>	
<b>Qty. Per Coach</b>		<b>Qty. of the Serviceable Item</b>	<b>Qty. of the Rejected Item</b>	<b>Total Qty. (193 Coach)</b>	<b>Rejection percentage</b>
<b>08</b>		<b>615</b>	<b>929</b>	<b>1544</b>	<b>60.16 %</b>
<b>Manufacture based failure details</b>					
<b>SL. NO.</b>	<b>Manufacturer</b>	<b>Qty. of the Serviceable Item</b>	<b>Qty. of the Rejected item</b>	<b>Total Qty. Each manufacturer</b>	<b>Rejection percentage</b>
01	BASANT RUBBERS	00	02	02	100 %
02	ARYAN	41	139	180	77.22 %
03	PRAG	103	251	354	70.90 %
04	BONY	106	244	350	69.71 %
05	PPI	42	80	122	65.57 %
06	GMT	195	170	365	46.57 %
07	MGN	16	08	24	33.33 %
08	AR	45	16	61	26.22 %
09	MTC	51	18	69	26.08%
10	BLOC	08	01	09	11.11 %
11	SGA	8	-	8	NIL
<b>02</b>	<b>Pad for secondary suspension</b>				<b>PL 3350034</b>
<b>Qty. Per Coach</b>		<b>Qty. of the Serviceable item</b>	<b>Qty. of the Rejected item</b>	<b>Total Qty. (76 Coach)</b>	<b>Rejection percentage</b>
<b>08</b>		<b>288</b>	<b>320</b>	<b>608</b>	<b>52.63 %</b>
<b>Manufacture based failure details</b>					
<b>SL. NO.</b>	<b>Manufacturer</b>	<b>Qty. of the Serviceable item</b>	<b>Qty. of the Rejected item</b>	<b>Total Qty. Each manufacturer</b>	<b>Rejection percentage</b>
01	AFW	-	40	40	100 %
02	PPI	4	8	12	66.66 %
03	WINLANE	8	16	24	66.66 %
04	PRAG	86	132	218	60.55 %
05	AR	04	04	08	50 %
06	TECSPAK	48	36	84	42.85 %
07	SURLON DUREL	138	84	222	37.83 %

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<b>03</b>	<b>Axle box pivot bush</b>			<b>PL NO. 33500060</b>
Qty. Per Coach	Qty. of the Serviceable Item	Qty. of the Rejected Item	Total Qty. (193 Coach)	Rejection percentage
8	1084	460	1544	29.79 %

**Manufacture based failure details**

SL. NO.	Manufacturer	Qty. of the Serviceable Item	Qty. of the Rejected Item	Total Qty. Each manufacturer	Rejection percentage
01	ARYAN	72	161	233	69.09 %
02	PRAG	195	223	418	53.34 %
03	BONY	180	60	240	25 %
04	PPI	56	16	72	22.22 %
05	GMT	325	-	325	NIL
06	MTC	128	-	128	NIL
07	WINLANE	16	-	16	NIL
08	MGN	32	-	32	NIL
09	AR	80	-	80	NIL

<b>04</b>	<b>Ball joint Roll link</b>			<b>PL NO. 3350022</b>
Qty. Per Coach	Qty. of the Serviceable item	Qty. of the Rejected item	Total Qty. (193 Coach)	Rejection percentage
08	1087	457	1544	29.59 %

**Manufacture based failure details**

SL. NO.	Manufacturer	Qty. of the Serviceable item	Qty. of the Rejected item	Total Qty. Each manufacturer	Rejection percentage
01	ARYAN	71	117	188	62.23 %
02	BONY	149	206	355	58.02 %
03	PRAG	182	91	273	33.33 %
04	PPI	72	15	87	17.24 %
05	GMT	266	26	292	8.90 %
06	MTC	218	2	220	0.90 %
07	BLOC	48	-	48	NIL
08	MGN	40	-	40	NIL
09	AR	41	-	41	NIL

*Signature*  
558/11458/1323

**Warranty Claim of LHB Rubber bonded metal component (Apr 2020 to JULY 2021)**

<b>Item (Apr 20-JULY 21)</b>	<b>Firm's Name</b>				
<b>Ball Joint Traction Lever</b>	<b>BONY</b>	<b>PRAG</b>	<b>ARYAN</b>	<b>PPI</b>	<b>GMT</b>
Raised warranty claim	856	966	317	173	146
Received	276	120	82	31	0
Pending claims	580	846	235	142	146
<b>Ball Joint Roll Link</b>	<b>BONY</b>	<b>PRAG</b>	<b>ARYAN</b>	<b>PPI</b>	
Raised warranty claim	695	586	198	35	
Received	214	115	33	6	
Pending claims	481	471	165	29	
<b>Axle Box Pivot Bush</b>	<b>BONY</b>	<b>PRAG</b>	<b>ARYAN</b>	<b>PPI</b>	
Raised warranty claim	257	885	246	24	
Received	68	111	39	0	
Pending claims	189	774	207	24	
<b>Pad For Secondary Suspension</b>	<b>PRAG</b>	<b>PPI</b>	<b>Durel</b>	<b>Tecspak</b>	
Raised warranty claim	352	4	56	36	
Received	44	0	0	0	
Pending claims	308	4	56	36	

*Arjun*  
SSB/PCO/BR3

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Manufacturer's Names		
SL. No	Description	Address
01	GMT	GUMMI METALL TECHNIK GmbH
02	GMT	GMT INDIA PVT .LTD
03	MTC	METALO CAUCHO POL MTC
04	PPI	POLIMER PRODUCT OF INDIA LTD. BANGLORE
05	PRAG	PRAG INDUSTRIES P LTD LUCKNOW
06	BLOC	SILENT BLOC UK LTD
07	MGN	MMGN C/CALVARIO MADRID
08	ARYAN	ARAYN EXPORTS LUCKNOW
09	BONY	BONY POLIMERS FARIDABAD
10	WINLANE	GUANGZHU WINLANE MATERIAL TECHNOLOGY CHINA
11	AR	AVADH RAIL INFRA LTD LUCKNOW
12	SGA	SOCIATIA GOMMA ANTI VIBRENTE ITALY
13	DUREL	SURLON DUREL SPRINGS PVT LTD JASOLA NEW DELHI
14	TECSPAK	MINOR ENTERPRISES USA