



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



No. 2017/M(C)/138/2Pt1

(E-File no. 3325465)
New Delhi, Dated -03.01.2022

PCMEs
MCF, RCF and ICF

Director General
RDSO, Lucknow

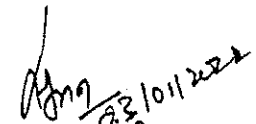
Sub: Modification in Control Arm support (Left & Right) for FIAT Bogies.

Ref: RCF's letter No. MD44121 Dated 11.12.2021.

Vide reference above, RCF in consultation with RDSO, MCF, ICF and manufacturers has issued the modification for the Control Arm support for Fiat Bogies.

Accordingly it is advised to implement the modifications and advise the cut-in date for information of all Zonal Railways & Board.

DA: As above.


(सुमन कुमार तीर्ती)
निदेशक / यांत्रिक इंजी./कोचिंग
रेलवे बोर्ड

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



2742105400
13/12/21

D942105400
14/12/2021

RECEIVED	15/12/21
RECD. ON	15/12/21

रेल डिब्बा कारखाना, कपूरथला

MD44121

Date: 11.12.2021

1. Executive Director Std./Carr, RDSO, Lucknow
2. EDME/Chg, Railway Board, New Delhi
3. CDE, MCF, Rai Bareli
4. CDE, ICF, Chennai

Sub: Modification in Control arm Support (Left & Right) for FIAT Bogies
Ref.: RDSO's Letter No. 03.12.2021 & discussion during VC meetings held on 06.12.2021

Design and drawings of Control arm support left & right of FIAT Bogies has been reviewed in consultations with RDSO, MCF, ICF, and the manufacturers to minimize cracks during service.

The following changes have been made to the Drawing No. LW03246 and LW03247 to reduce cracks during service:

1. New Material to grade S355J2G3;EN10250-2 & EN10254 has been specified.
2. Process: Reductions ratio and heat treatment process has been specified.
3. Inspection: Inspection parameters have been specified to arrest crack during inspection at component stage.
4. Surface Protection: Surface cleanliness and ROZC primer has been specified.
5. Marking: Size of marking reduced to 6mm from 10mm. Marking is to be ensured on machined chamfer side so that marking is visible after welding on bogie frame.

Copy of revised Drg No. LW03246 alt 'b' and LW03247 alt 'b' for Control arm support Left and Right of FIAT Bogie are being enclosed for information and necessary action please.

The respective agencies may kindly plan to cut-in to the revised drawings as per their own schedule.

AKHILESH
MISRA

Digitally signed by
AKHILESH MISRA
Date: 2021.12.11 12:42:25
+05'30'

(Akhilesh Misra)
Chief Design Engineer
RCF, Kapurthala

Copy for kind information to: _____

PCME, RCF, Kapurthala
PCME, MCF, Rai Bareli
PCME, ICF, Chennai

