The Pr. Chief Mechanical Engineers
All Indian Railways

Sub: Marking details of CBC and its components
Ref: Board’s letters of even number dated 6.6.2016 & 16.02.2018

Vide Board’s letters u/r above, it was advised that CBC and its components must have the prescribed marking details available like manufacturer’s name, manufacture date etc., before they are fitted on wagons in ROH depots and/or POH shops on the railways. Non-availability of marking details on CBC & its components has also been made NTXR rejectable item w.e.f. 01.03.2018.

Some railways have raised following issues for implementation of above instructions:

a) In some of the supplies available in stock, marking details are being found to be incomplete or not available at all.

b) In some cases marking details are available as painted on the body of the component.

In light of above, it is advised that in all cases where marking details are found not to be in line with the specification and related reference drawings, the matter invariably should be reported to EDQA (Mech.)/RDSO for joint check and subsequent corrective action, who are the sole inspecting authority of CBC & its components including draft gears. A list containing the details w.r.t. specification and reference drawings is also enclosed herewith for information.

D/A: as above

Copy to:
EDQA (Mech), RDSO, Lucknow
ED/W, RDSO, Lucknow
NCO, IRCA, New Delhi
<table>
<thead>
<tr>
<th>Sl no</th>
<th>Item</th>
<th>Material</th>
<th>Manufacturing process</th>
<th>Reference drg.</th>
<th>Marking specified for WD-48-BD</th>
<th>Marking specified for WD-70-BD</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Coupler Body</td>
<td>AAR M201 Gr.E</td>
<td>Steel casting</td>
<td>SK-62724, alt 25</td>
<td>HTEA, Manufacturer’s code &amp; Serial no., Date, month &amp;year,</td>
<td>UHTE, Manufacturer’s code &amp; Serial no. Date, month &amp;year,</td>
</tr>
<tr>
<td>2</td>
<td>Knuckle</td>
<td>AAR M201 Gr.E</td>
<td>Steel casting</td>
<td>SK-62724, alt 25</td>
<td>HTEA, Manufacturer’s code &amp; Serial no. Date, month &amp;year,</td>
<td>UHTE, Manufacturer’s code &amp; Serial no. Date, month &amp;year,</td>
</tr>
<tr>
<td>3</td>
<td>Yoke</td>
<td>AAR M201 Gr.E</td>
<td>Steel casting</td>
<td>SK-62724, alt 25</td>
<td>HTEA, Manufacturer’s code &amp; Serial no. Date, month &amp;year,</td>
<td>UHTE, Manufacturer’s code &amp; Serial no. Date, month &amp;year,</td>
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<tr>
<td>4</td>
<td>Lock</td>
<td>AAR M201 Gr.E</td>
<td>Steel casting</td>
<td>SK-62724, alt 25</td>
<td>HTEA, Manufacturer’s code &amp; Serial no. Date, month &amp;year,</td>
<td>UHTE, Manufacturer’s code &amp; Serial no. Date, month &amp;year,</td>
</tr>
<tr>
<td>5</td>
<td>Knuckle thrower</td>
<td>AAR M-201 Gr. B or IS:1875 &amp;2004</td>
<td>For WD-48-BD Steel casting/Forging/ For WD-70-BD Investment casting/Forging</td>
<td>SK-62724, alt 25</td>
<td>IR, Manufacturer’s code, month &amp;year,</td>
<td>IR, UHT, Manufacturer’s code, month &amp;year,</td>
</tr>
<tr>
<td>6</td>
<td>Toggle</td>
<td>AAR M-201 Gr. B or IS:1875 &amp;2004</td>
<td>For WD-48-BD Steel casting/Forging/ For WD-70-BD Investment casting/Forging</td>
<td>SK-62724, alt 25</td>
<td>IR, Manufacturer’s code, month &amp;year,</td>
<td>IR, UHT, Manufacturer’s code, month &amp;year,</td>
</tr>
<tr>
<td>7</td>
<td>Universal lock lift lever connector</td>
<td>AAR M-201 Gr. B or IS:1875 &amp;2004</td>
<td>For WD-48-BD Steel casting/Forging/ For WD-70-BD Investment casting/Forging</td>
<td>SK-62724, alt 25</td>
<td>IR, Manufacturer’s code, month &amp;year,</td>
<td>IR, UHT, Manufacturer’s code, month &amp;year,</td>
</tr>
<tr>
<td>8</td>
<td>Lock lift lever hook</td>
<td>AAR M-201 Gr. B or IS:1875 &amp;2004</td>
<td>For WD-48-BD Steel casting/Forging/ For WD-70-BD Investment casting/Forging</td>
<td>SK-62724, alt 25</td>
<td>IR, Manufacturer’s code, month &amp;year,</td>
<td>IR, UHT, Manufacturer’s code, month &amp;year,</td>
</tr>
<tr>
<td>9</td>
<td>Knuckle Pin</td>
<td>IS:1875 &amp;2004</td>
<td>Forging</td>
<td>SK-62724, alt 25</td>
<td>Manufacturer’s code, month &amp;year,</td>
<td>Manufacturer’s code, month &amp;year UHT,</td>
</tr>
<tr>
<td>10</td>
<td>Yoke pin</td>
<td>IS:5517-42-Gr-4-Mo2</td>
<td>Forging</td>
<td>SK-62724, alt 25</td>
<td>Manufacturer’s code, month &amp; year In both end dipressed</td>
<td>Manufacturer’s code, month &amp;year UHT In both end</td>
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<tr>
<td>11</td>
<td>Shank wear plate</td>
<td>IS:3885</td>
<td>Plate cutting &amp; Heat treatment</td>
<td>SK-62724, alt 25</td>
<td>No marking specified</td>
<td>No marking specified</td>
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<tr>
<td>12</td>
<td>Remaining items</td>
<td></td>
<td></td>
<td></td>
<td></td>
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</tbody>
</table>
4. All markings shown to be raised unless otherwise specified.
5. Refer DRG No. WD-87004-S-1 for manufacturer's initials & markings on knuckle.
6. Coupler body (item 1 & 18) shall be supplied with wear plate (item 10) welded on to the coupler shank as shown.
7. For other requirements, refer to Indian Railway Schedule of Technical Requirement No. 48-80-08 and WD-70-80-10 (latest).
8. (i) For non-transition type CBC, coupler body shall be supplied as per item NO. 48-80-08 and WD-70-80-10 (latest) with RDSO DRG No. SK-62724 item 1
   (ii) For transition type CBC, coupler body shall be supplied as per item NO. 56-80-07 with RDSO DRG No. SK-62724 item 18
9. Stamping shall be done in both ends of yoke pin.
10. For WD-70-80-10 type CBC, stamping shall be done as 'UHTE' on the place of 'HTEA' for grade E components only.
11. For WD-70-80-10 coupler item 4 & 12 should be marked 'UHTE' after month & year.
12. For WD-70 80-10 coupler investment casting item 5, 6, 7 & 9 should be marked 'UHTE' after IR

Note of RDSO Drg. No. SK-62724 alt 26

3.5 Marking

3.5.1 All coupler components should have clear and legible manufacturers’ name in short code and batch No. etc., which shall remain legible throughout the entire service period as specified in RDSO Drawing No. SK - 62724 (latest alteration). Knuckle shall have the markings “for manufacturer’s name, serial number, month & year of manufacture etc. as shown in RDSO Drg. No. WD - 87004-S-1 (latest alteration).

3.5.2 The letter size and height of the raised letter shall be as specified in relevant RDSO drawing. The marking shall be done at the casting stage itself. The manufacturer will not be permitted to provide manufacturer's code and marking by electric arc welding in case these are not visible at casting stage. Grade E steel castings shall be identified by raised letter UHTE.

3.5.3 The coupler components found having illegible marking at the time of fitment in Railway Workshops, Maintenance depot or on Wagon Builders premises shall be treated as rejected and shall be replaced by the manufacturers free of cost. The cost of transportation shall be borne by the manufacturer.

Specification WD-70-80-10 Rev. 2
MANUFACTURER'S INITIALS AND MONTH & YEAR

DEPRESSED

Lock & hook

Connector

Yoke
NOTE:—

1. All marking letters shall be 2 UN raised, unless otherwise specified.
2. All indicated marking sizes are nominal.
3. When any of the markings are illegible, manufacturer must apply electric arc welding for distinct markings as specified.
4. Location of markings may be varied within indicated areas to suit manufacturer's practice.