S.HO.

भारत सरकार **GOVERNMENT OF INDIA**
रेल मंत्रालय **MINISTRY OF RAILWAYS**
(रेलवे बोर्ड **RAILWAY BOARD)**

रेल भवन, नई दिल्ली- **110001,** तिथि
No. 2016/M (N)/172/1 **Rail Bhavan, New Delhi-110001, dated 06.03.2018**

The Pr. Chief Mechanical Engineers
All Indian Railways

Sub: Marking details of CBC and its components SM-18 SM-43
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

(AJAY NANDAN)
Exec. Director Mech. Engg. (Fr)
Railway Board

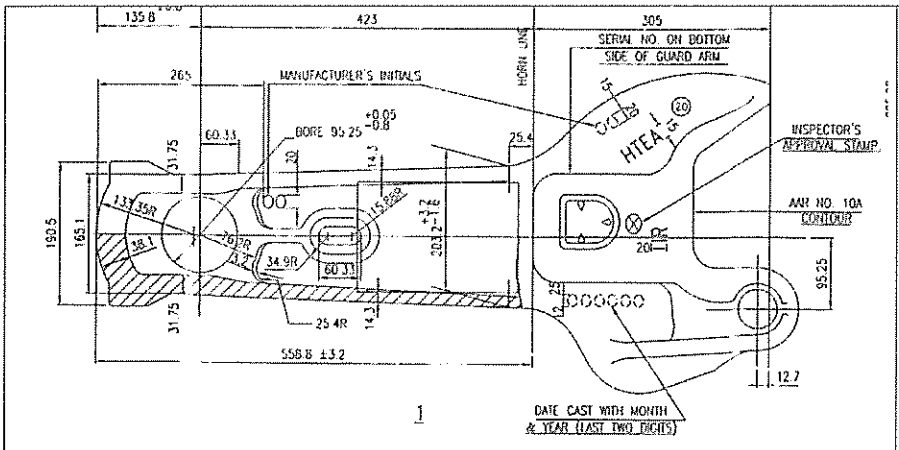
Copy to:
EDQA (Mech), RDSO, Lucknow
ED/W, RDSO, Lucknow
NCO, IRCA, New Delhi

7/3/18

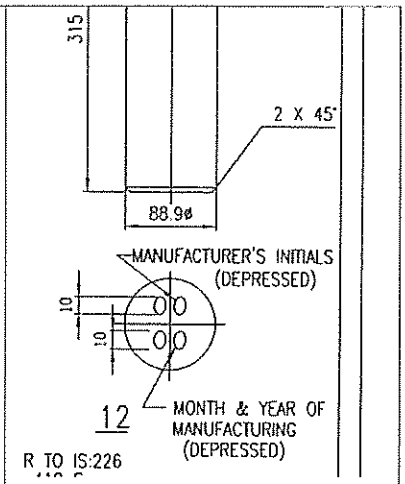
Table for marking of coupler components.

Sl no	Item	Material	Manufacturing process	Reference drg.	Marking specified for WD-48-BD	Marking specified for WD-70-BD
1.	Coupler Body	AAR M201 Gr.E	Steel casting	SK-62724, alt 25	HTEA, Manufacturer's code & Serial no., Date, month &year,	UHTE, Manufacturer's code & Serial no. Date, month &year,
2.	Knuckle	AAR M201 Gr.E	Steel casting	SK-62724, alt 25	HTEA, Manufacturer's code & Serial no. Date, month &year	UHTE, Manufacturer's code & Serial no. Date, month &year
3.	Yoke	AAR M201 Gr.E	Steel casting	SK-62724, alt 25	HTEA, Manufacturer's code & Serial no. Date, month &year	UHTE, Manufacturer's code & Serial no. Date, month &year
4.	Lock	AAR M201 Gr.E	Steel casting	SK-62724, alt 25	HTEA, Manufacturer's code & Serial no. Date, month &year	UHTE, Manufacturer's code & Serial no. Date, month &year
5.	Knuckle thrower	AAR M-201 Gr. B or IS:1875 &2004	For WD-48-BD Steel casting/ Forging/ For WD-70-BD Investment casting/Forging	SK-62724, alt 25	IR, Manufacturer's code, month &year	IR, UHT, Manufacturer's code, month &year
6.	Toggle	AAR M-201 Gr. B or IS:1875 &2004	For WD-48-BD Steel casting/ Forging/ For WD-70-BD Investment casting/Forging	SK-62724, alt 25	IR, Manufacturer's code, month &year	IR, UHT, Manufacturer's code, month &year
7.	Universal lock lift lever connector	AAR M-201 Gr. B or IS:1875 &2004	For WD-48-BD Steel casting/ Forging/ For WD-70-BD Investment casting/Forging	SK-62724, alt 25	IR, Manufacturer's code, month &year	IR, UHT, Manufacturer's code, month &year
8.	Lock lift lever hook	AAR M-201 Gr. B or IS:1875 &2004	For WD-48-BD Steel casting/ Forging/ For WD-70-BD Investment casting/Forging	SK-62724, alt 25	IR, Manufacturer's code, month &year	IR, UHT, Manufacturer's code, month &year
9.	Knuckle Pin	IS:1875 &2004	Forging	SK-62724, alt 25	Manufacturer's code, month &year	Manufacturer's code, month &year UHT
10.	Yoke pin	IS:5517-42-Gr-4-Mo2	Forging	SK-62724, alt 25	Manufacturer's code, month & year In both end dipressed	Manufacturer's code, month &year UHT In both end
11.	Shank wear plate	IS:3885	Plate cutting & Heat treatment	SK-62724, alt 25	No marking specified	No marking specified
12.	Remaining items				No marking specified	

Marking of coupler components specified in Drawing and specification



Coupler Body

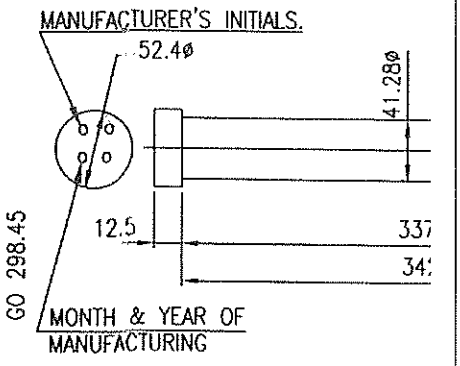


Yoke Pin

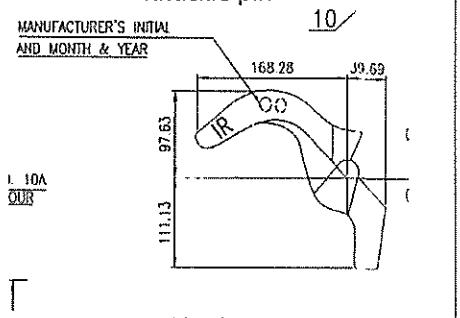
4. ALL MARKING SHOWN TO BE RAISED UNLESS OTHERWISE SPECIFIED.
5. REFER DRG.NO. WD-87004-S-1 FOR MANUFACTURER'S INITIALS & MARKINGS ON KNUCKLE.
6. COUPLER BODY (ITEM-1 & 18) SHALL BE SUPPLIED WITH WEAR PLATE (ITEM-10) WELDED ON TO THE COUPLER SHANK AS SHOWN.
7. FOR OTHER REQUIRMENTS, REFER TO INDIAN RAILWAY SCHEDULE OF TECHNICAL REQUIRMENT No. 48-BD-08 AND WD-70-BD-10 (LATEST).
8. (i) FOR NON TRANSITION TYPE CBC, COUPLER BODY SHALL BE SUPPLIED AS PER STR NO. 48-BD-08 AND WD-70-BD-10 (LATEST) WITH RDSO DRG. NO. SK-62724 ITEM-1

   (ii) FOR TRANSITION TYPE CBC, COUPLER BODY SHALL BE SUPPLIED AS PER STR NO. 56-BD-07 WITH RDSO DRG. NO. SK-62724 ITEM-18
9. STAMPING SHALL BE DONE IN BOTH ENDS OF YOKE PIN.
10. FOR WD-70-BD-10 TYPE CBC, STAMPING SHALL BE DONE AS 'UHTE' ON THE PLACE OF 'HTEA' FOR GRADE 'E' COMPONENTS ONLY.
11. FOR WD-70-BD-10 COUPLER ITEM- 4 & 12 SHOULD BE MARKED 'UHT' AFTER MONTH & YEAR
12. FOR WD-70 BD-10 COUPLER INVESTMENT CASTING ITEM- 5, 6, 7 & 9 SHOULD BE MARKED 'UHT' AFTER IR

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



Knuckle pin



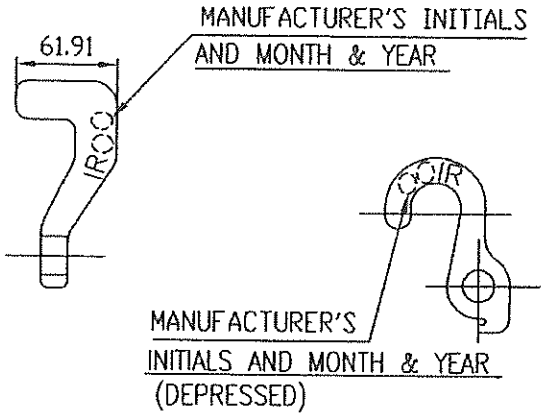
Knuckle thrower

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-I (latest alteration).

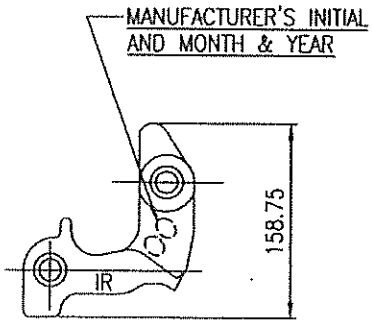
3.5.2 The letter size and height of the raised letter shall be as specified in relevant RDSO drawing. The marking shall be done at the casting stage itself. The manufacturer will not be permitted to provide manufacturer's code and marking by electric arc welding in case these are not visible at casting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



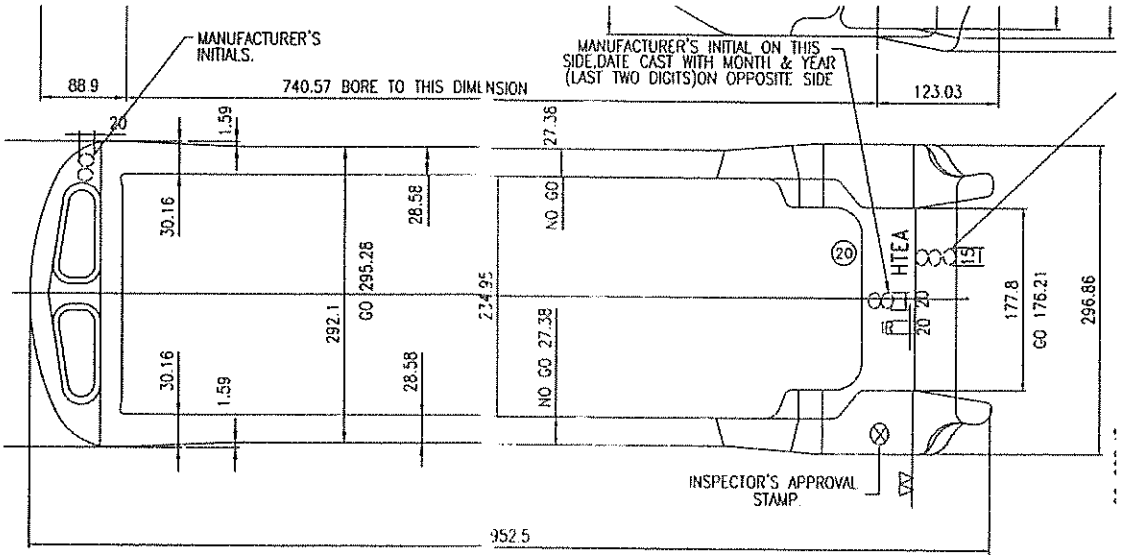
7

Lock & hook

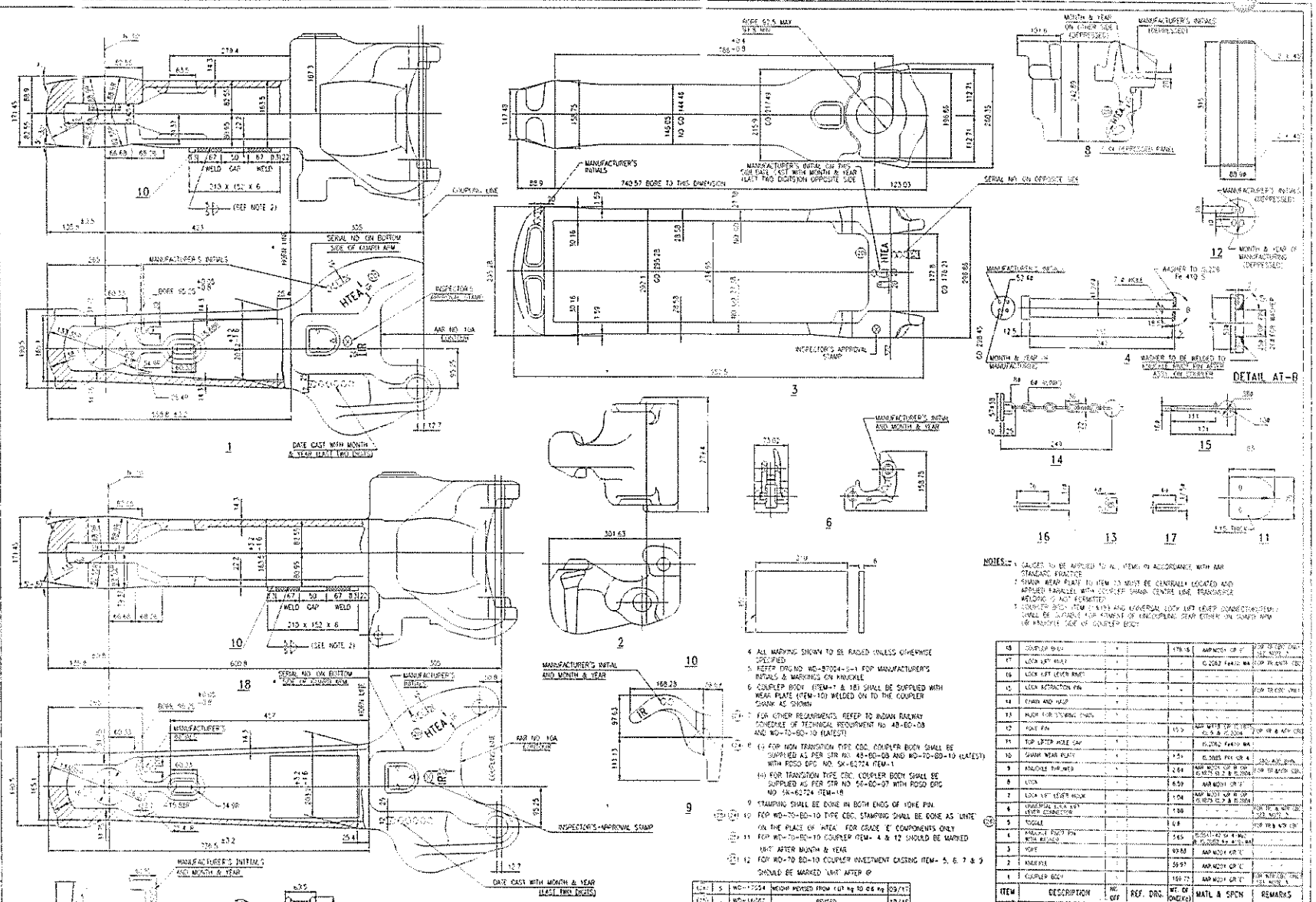


6

Connector



Yoke



NOTES:-
1. GAUGES TO BE APPLIED TO ALL ITEMS IN ACCORDANCE WITH AAR STANDARD PRACTICE.
2. SHANK WEAR PLATE TO ITEM 10 MUST BE CENTRALLY LOCATED AND APPLIED PARALLEL WITH COUPLER SHANK CENTRE LINE TRANSVERSE WELDING IS NOT PERMITTED.
3. COUPLER BODY, ITEM 18 (STD) AND UNIVERSAL LOCK LIFT LEVER CONNECTION (ITEM 7) SHALL BE SUITABLE FOR ATTACHMENT OF UNCOUPLING GEAR EITHER ON SHANK ARM OR KNUCKLE SIDE OF COUPLER BODY.
4. ALL MARKING 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-7 & 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. AB-80-08 AND WD-70-80-10 (LATEST).
8. (a) FOR NON TRANSITION TYPE CBC, COUPLER BODY SHALL BE SUPPLIED AS PER STR NO. AB-80-08 AND WD-70-80-10 (LATEST) WITH ROSD DRG NO. SK-62724 ITEM-1.
   (b) FOR TRANSITION TYPE CBC, COUPLER BODY SHALL BE SUPPLIED AS PER STR NO. SK-80-97 WITH ROSD 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 'UNTE' ON THE PLACE OF 'HTEA' FOR GRADE 'E' COMPONENTS ONLY.
11. FOR WD-70-80-10 COUPLER ITEM- 4 & 12 SHOULD BE MARKED 'UNT' AFTER MONTH & YEAR.
12. FOR WD-70 80-10 COUPLER INVESTMENT CASTING ITEM- 5, 6, 7 & 9 SHOULD BE MARKED 'UNT' AFTER 'P'.

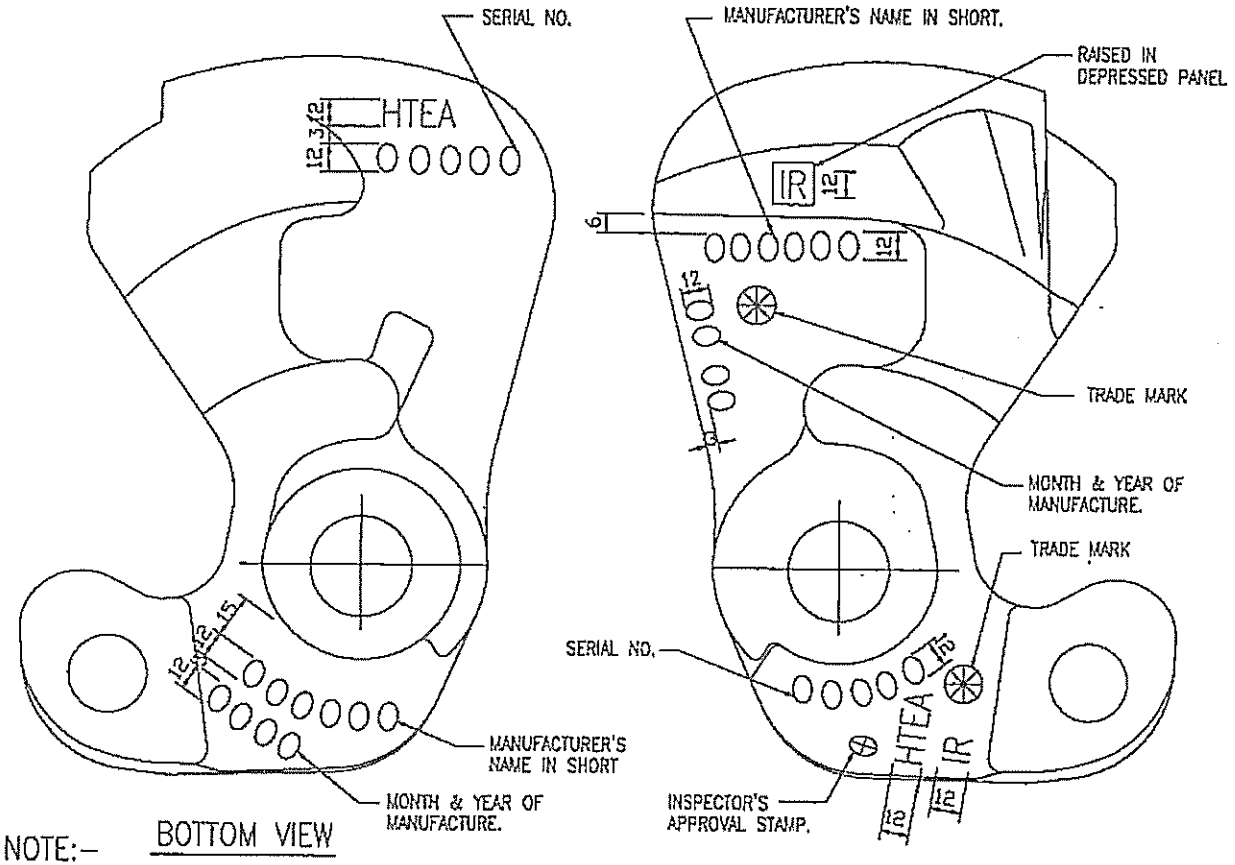
ITEM	DESCRIPTION	NO. OFF	REF. DRG.	WT. OF UNIT(Kg)	MATL & SPCN	REMARKS
18	COUPLER BODY	1		178.5	IMPROVED GR 'E'	TO BE CAST ONLY AS PER NOTE 3
17	LOCK LIFT LEVER	1			CL 2262 Fe410 WA	TO BE TO BOTH CBC
16	LOCK LIFT LEVER PIVOT	1			-	
15	LOCK RETRACTION PIN	1		1	-	FOR TYP CBC ONLY
14	CHAIN AND HOOK	1		-	-	
13	HOOK FOR UNCOUPLING CHAIN	1		-	-	
12	YOKE PIN	1		10.9	AAR MTD GR 'D' CAST AS PER IS 4026 & IS 2004	TOP YR & MFR CBC
11	TOP LIFTER WEAR SAP	1			CL 2262 Fe410 WA	
10	SHANK WEAR PLATE	1		9.24	IS 2062 Fe410 GR A	ONLY FOR BOTH CBC
9	KNUCKLE THR.PIN	1		2.84	AAR MCDX GR M OR IS 4026 GR 2 & IS 2004	TOP YR & MFR CBC
8	LOCK	1		6.59	AAR MCDX GR 'C'	
7	LOCK LIFT LEVER HOOK	1		1.04	AAR MCDX GR M OR IS 4026 GR 2 & IS 2004	
6	UNCOUPLING KEY PIVOT LEVER ASSEMBLY	1		1.98	-	FOR TYP CBC ONLY SEE NOTE 3
5	TOGGLE	1		0.8	-	TOP YR & MFR CBC
4	KNUCKLE PIVOT PIN WITH WASHER	1		7.45	IS 2062 GR 'A' FOR WASHER & AAR MCDX GR 'C' FOR PIN	
3	YOKE	1		93.88	AAR MCDX GR 'C'	
2	KNUCKLE	1		56.97	AAR MCDX GR 'C'	
1	COUPLER BODY	1		159.72	AAR MCDX GR 'C'	TOP YR MFR CBC SEE NOTE 3

SUPERSEDES SL					CENTRE BUFFER COUPLER FOR BOGIE WAGONS	
SUPERSEDED				DATE		
SCALE	FINISH	MATERIAL	CL	DR.	DETAILS FOR TRANSITION AND NON-TRANSITION C.B.C.	
	CHECKED	RAILWAY		DR.		
	DRAWN	DESIGN		DR.		
	TRACED			DR.		
B.G.		R.D.S.O. [W]		GROUP		SK.62724

C. No.	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12
ROUGH	0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50
SYMBOL	▽▽▽▽			▽▽▽			▽▽		▽			

SURFACE ROUGHNESS VALUE TO IS 3073.

ALT	ITEM	AUTHY	DESCRIPTION	DATE	ASSLY. DRG
(24)	5	WD-17554	WEIGHT REVISED FROM 157 kg TO 178 kg	09/17	
(23)	-	WD-16082	REVISED	12/16	
(22)	-	WD-16028	REVISED	06/16	
(21)	-	WD-15993	REVISED	12/15	
(20)	-	WD-15803	NOTE NO. 8 ADDED	09/15	
(19)	-	WD-15091	REVISED	10/08	WD-81010-S-03
(18)	-	WD-07531	MARKING CHANGED FROM 'HTT' TO 'HTEA'	05/07	SK-62709
(17)	-	WD-04034	REVISED	07/04	SK-62723



BOTTOM VIEW

TOP VIEW

S.NO.	MANUFACTURER'S NAME	IN SHORT
1	BURN STANDARD COMPANY LTD.	BS
2	BESCO LTD.	BESCO
3	BHILAI ENGINEERING CORPORATION LTD.	BECO
4	HINDUSTAN ENGINEERING INDUSTRIES.	HEI
5	ORIENT STEEL INDUSTRIES LTD.	OSIL
6	TITAGARH INDUSTRIES LTD.	TITA
7	TEXMACO LTD.	TEX
8	DATRE CORPORATION LTD.	DATRE
9	RANEKA INDUSTRIES LTD.	RIL
10	BRAITHWAITE & CO. LTD.	BWT
11	FRONTIER ALLOY STEEL LTD.	FAS
12	TITAGARH WAGON LTD.	TWL
13	JUPITER ALLOYS & STEEL (INDIA) LTD	JASIL
14	SIENA ENGINEERING PVT. LTD.	SN
15	RINE ENGINEERING PVT. LTD.	RN
16	ATUL ENGINEERING UDYOG.	ATUL
17	AD ELECTRO STEEL CO. PVT. LTD.	ADE

NOTE:-

1. ALL MARKING LETTERS SHALL BE 2 MM RAISED, UNLESS OTHERWISE SPECIFIED.
2. ALL INDICATED MARKING SIZES ARE MINIMUM.
3. WHEN ANY OF THE MARKING 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 MANUFACTURERS PRACTICE.

SUPERSEDED BY		
SUPERSEDES		DATE
SCALE	PASSED	
	CHKD.	
	DRAWN	G.HUSAIN 7/98
	TRACED	
	I.SHEET	

C.B.C. FOR BOGIE-WAGONS

MARKINGS ON KNUCKLE

⑧	–	WD-07051	REVISED	08/07	
ALT.	ITEM	AUTHORITY	DESCRIPTION	DATE	ASSLY. DRG.

B.G. | RDSO [W] | GROUP I | WD-87004-S-1