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भारत सरकार - रेल मंत्रालय
अनुसंधान अभिकल्प और मानक संगठन
लखनऊ - २२६०११
Government of India - Ministry of
Railways
Research, Designs & Standards
Organization, LUCKNOW - 226011

No. EL/3 2.172

Date: 17.07.2008

Modification Sheet No. ELRS/MS/0363 (Rev. '0')

Title:

Modification to strengthening the Top & Bottom mounting Lug of Magnet Frame of Hitachi Traction Motors (HS-15250A) of Electric Locomotives.

1.0 Object :

- 1.1. Hitachi (HS-15250A) Traction Motors of Electric Locomotives are nose suspended at one side and axle hung on other side. Gear case is supported on mounting lug with the bolts. During service, vibrations impacts are prevalent on mounting lug. Mounting lug of TM does not have any additional support and all impacts transfer to welded joint of lug in TM and subsequently, this causes development of cracks in bottom mounting lug.
 - 1.2. Railways are facing problem of development of cracks on gear case bottom mounting lug of magnet frame of Hitachi TM (HS 15250A) of Electric locomotives.
 - 1.3. This matter came into light in XXXII MSG held at SE Railway on 10th & 11th Jan. 2008 as CR added this new item. Group discussed this matter in detail and it was recommended to study corrective measures and to suggest remedial measures in line with ELS/Vzag for WAG 6C.
 - 1.4. After going through the study, it is concluded that an additional support is required to bottom mounting lug of magnet frame so that it can withstand successive vibrations during service. This need modification in bottom mounting lug of magnet frame.
 - 1.5. This modification has to be carried out in all magnet frames of Hitachi TM (HS 15250A) whenever they are taken out for overhauling.
- 2. Work to be carried out :**
- 2.1. To minimize the problem of cracks development on mounting lug , a triangular MS plate size 75 mm X 85 mm as RDSO Drg. No. SKEL-4736 (sheet-1) can be taken and welded in opposite side to mounting. This will provide additional support to the bottom mounting lug of TM and avoid the chances of cracks.

2.2. For Top mounting lug, a plate of thickness 30 mm as per RDSO Drg. No. SKEL-4736 (sheet-2) is required to be welded on top lug plate, facing the gear case.

2.3. CLW, PUs will also provide this strengthening triangular plate as per above RDSO's drawing in all new magnet frames.

3. Application :

All magnet frames of Hitachi Traction Motors type HS-1525CA of Electric Locomotives

4. Material Required:

Triangular plate as per RDSO drg no. SKEL-4736 (sheet-1)

5. Material Rendered Surplus : Nil

6. Modification Drawing No. :

SKEL-4736 Rev'0' (sheet 1,2 & 3)

7. Periodicity of Implementation :

7.1. When ever traction motors are taken out for IOH, AOH, POH in existing motors.

7.2. In all new manufacturing motors.

8. Agency of Implementation :


8.1. All Sheds & workshops

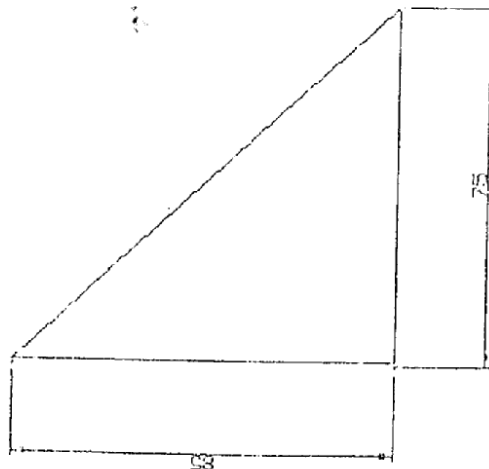
8.2. CLW, BHEL, CGL, KEC, REPL

9. Distribution:

As per enclosed list.

DA: as above


(Ganesh)
for Director General (Elec.)



WELD TO MAGNET FRAME

-1310N

1. ALL DIMENSIONS ARE IN MM
2. MATERIAL: STEEL TO IS2062
3. ONE SAMPLE SHOULD BE GOT APPROVED BY THE CONSIGNEE BEFORE BULK SUPPLY.

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NOTE:-
 1. ALL DIMENSIONS ARE IN MM
 2. MATERIAL: STEEL TO IS2062
 3. ONE SAMPLE SHOULD BE GOT APPROVED BY THE CONSIGNEE BEFORE BULK SUPPLY.

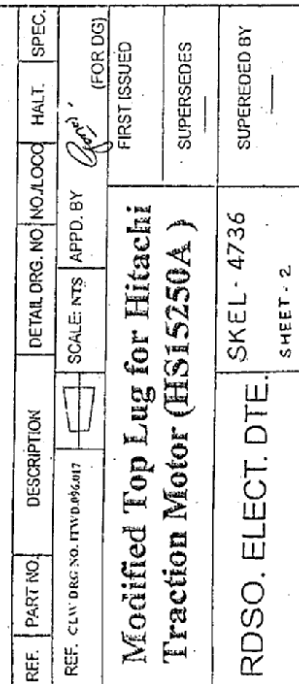
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REFNO.	PART NO	DESCRIPTION	QTY REQD	UNIT	HS.

RET.	SCALE IN	APPR BY	DATE

TRIANGULAR SUPPORTING PLATE
 FOR TM BOTTOM LUG OF HS.15250A

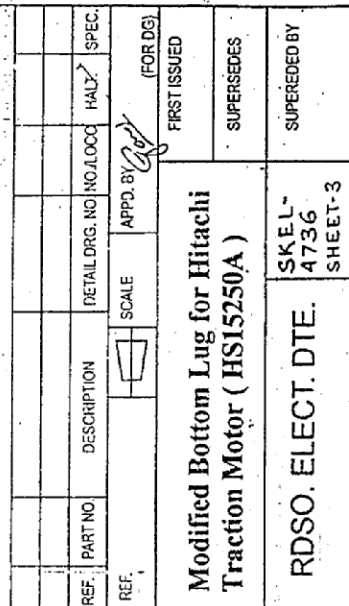
RDSIELECT.DTE	SKEL-4736 SHEET 1	APPROVED BY
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Note:

1. All dimensions are in mm.
2. Material: Steel to IS:2062

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1. All Dimensions are in mm
2. Material : Steel to IS:2062

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