

Government of India
Ministry of Railways
Research, Designs & Standards Organisation
Manak Nagar, Lucknow - 226 011

No. EL/3.2.5/J3

Dated 24.1.1992

Modification Sheet No. RDSO/WAM4/167

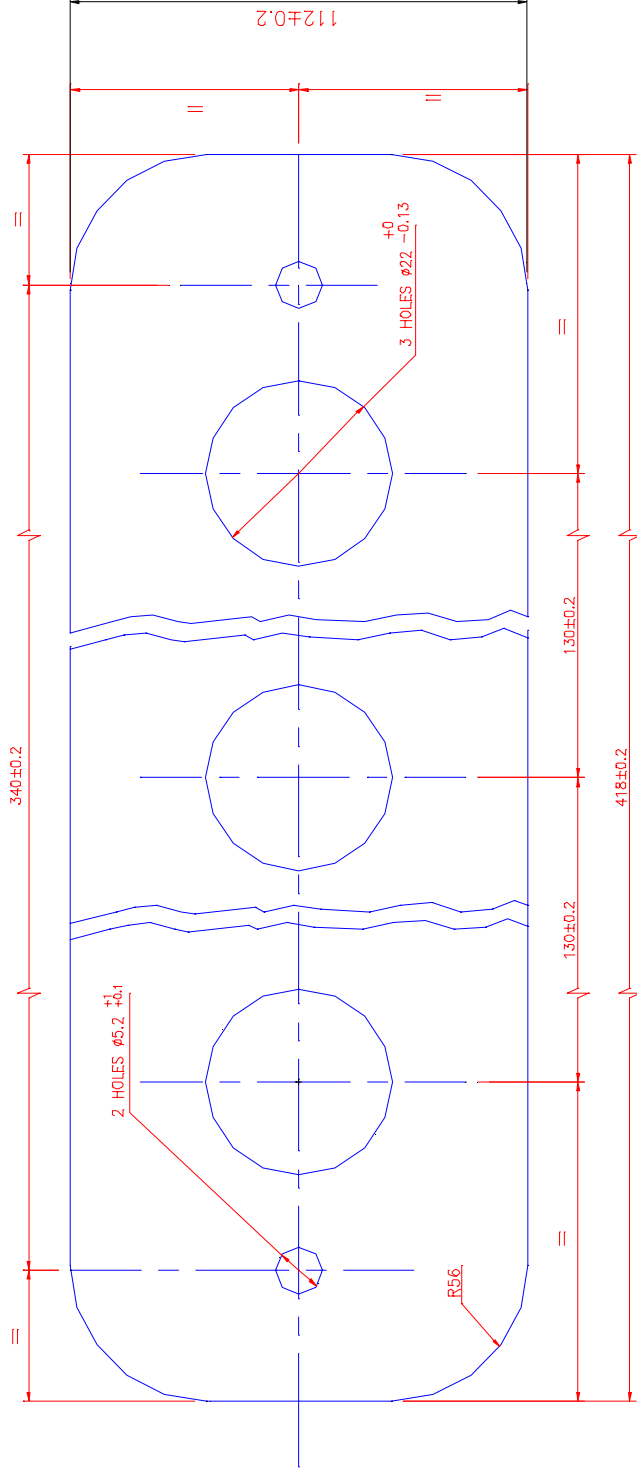
- 1. Title :** Modified adjustments punching for main pole core assembly of TAO - 659 Traction Motor.
- 2. Application :** All electric locomotives viz., WAM4, WAP1, WCAM1 & WAG5 fitted with TAO 659 Traction Motor.
- 3. Object :**
 - 3.1 :** At present adjustment punching for main pole is being provided as per CLW Drg. No.3 TWD.092.091. The adjustment punching have sharp corners and likely to damage insulation partly at the time of assembly of coils. The sharp corners are also contributing to the failure of coils earthed in service due to vibration.
 - 3.2 :** It is also observed that in some cases the adjustment punching are projecting over and above the main pole core punching both length wise as well as width wise. This also leads to partly damage of the coil insulation during assembly. The situation may also contribute to earthing of coils in service when coils are subjected to vibration.
 - 3.3 :** The present modification intends to adopt the modified profile of adjustment punching for main pole to ensure that there are no sharp corners and avoid any possible damage during assembly/service.
- 4. Details of Modification :**
 - 4.1 :** Remove the present adjustment punching from main pole core assembly by cutting the rivets of 55 mm dia.
 - 4.2 :** Provide the modified adjustment punching having no sharp corners and smooth profile as shown RDSO's DRG No.4080 rivet the same in core assembly.

- 4.3 : The modified adjustment punching should be dye punched and have smooth surface/edges.
- 4.4 : Please check adjustment punching is not projecting beyond core.
- 4.5 : Material for the adjustment punching should be get checked as per relevant specification before acceptance of the material. Thickness of the punching should be such so as to ensure air gap within the limits laid-down.
5. **Schedule of Implementation** : Check adjustment punching of main pole assembly and replace during annual over haul/repair.
6. **Material Required** : Adjustment punching for main pole as per RDSO's Drg. No. SKEL - 4080
7. **Source of suppliers supply** : Railways may procure the material from the existing who are supplying the convential adjustment punching for main pole.
8. **Agency for Implementation** :
i) All Traction Motors/POH Shops.
ii) All Electric Loco Sheds.
iii) All Loco POH Shops.
iv) All Production Units.
9. **Distributions:** As per list enclosed.

प्रवीण जैन

DA: As Above

(P.K.Jain)
for Director General/Electrical



NOTE:-

- 1. ALL DIMENSIONS ARE IN MM.
- 2. MATERIAL MAGNETIC STEEL SHEET TO IS: 648-1980, GRADE A1120
- 3. THICKNESS OF PUNCHING 1mm:±0.2mm.
- 4. ALL SHARP CORNERS TO BE ROUNDED OFF.
- 5. THE PUNCHING SHALL BE MANUFACTURED WITH DIE PUNCHING AND SHOULD BE FREE FROM BURRS, SHARP CORNERS ETC.
- 6. TOLERANCES ±0.5 WHERE NOT SPECIFIED.

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REF:-	SCALE:- 1:1	APPROVED:-	FOR D.G.
ADJUSTMENT PUNCHING FOR MAIN POLE OF TAO-659 TRACTION MOTOR.			
RDSO. ELECT. DTE. SKEL - 4080			

