

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

Ref : EL/3.2.30/DC2

Dated : 25May, 1978

Modification Sheet No. RDSO/WAM4/58

1. **Title of modification :**
Modification to connecting air line (1922) of SMGR for tap changer N-32 of M/s HBB to avoid air leakage.
2. **Application to class of locomotives :**
All locos fitted with N-32 tap changers.
3. **Object of modification :**
A few cases have been reported by the Railway in which the nipple provided on both ends of air line (1922), a press fit joint, becomes loose resulting in heavy air leakage. To prevent such failures, it is proposed that the joints be brazed.
4. **Modification Drawing :**
Nil.
5. **Agency of implementation :**
Railways : On locos in service
CLW : On locos under production
6. (a) **Material rendered surplus :** Rupatum - 43 solder.
Rupatum flux.
(b) **Material to be carried out :** Nil
7. **Work to be carried out :**
Clean both surfaces to be brazed, that is the pipe and nipple with smooth file or emery paper. Heat the pipe and nipple to dull red heat using oxyacetylene flame. Braze the two components together using Rupatum 43 solder and flux.
8. **Reference :** BBC maintenance manual AM 91001E Drg. No. 6.1-19.
9. **Distribution :** As per list attached.



DA. One list.

(Ramesh Chandra)
for Director General (Elec)