

Government of India
Ministry of Railways
Research, Designs and Standards Organisation
ELECTRICAL DIRECTORATE,
MANAK NAGAR LUCKNOW 226011.

No.EL/3.2.82/DB1

Dt. 18.4.78

MODIFICATION SHEET NO. RDSO/WAM4/67

1. TITLE:

Fixing of neoprene gasket on the terminal box cover of motor type TAO 659.

2. APPLICATION:

WAM4 & WCAM1

3. OBJECT:

It has been reported by sheds that the original neoprene gaskets of the terminal box covers sometimes do not adhere to the M.S sheet of the cover. and as a result, sag and fall on the terminals. The correct procedure for repairing these covers is given below.

4. MODIFICATION REFERENCES:

CLW'S modification sheet No.CLW/TAO/659/1A CLW Drawing No. O.TWB.274.A1.2.

5. DETAILS OF MOFIFICATION:

5.1 Remove existing gasket of inspection cover.

5.2 Remove the rubber/existing adhesive from the inspection cover using wire brush.

5.3 Dip the inspection cover in dilute HCL with 10% concentration. Wash in water, clear wipe and dry for one hour and wire brush again. (HCL-Hydrochloric acid).

5.4 Clean the gasket (to Drg.No.2854) with petrol soaked in cotton waste.

5.51 Apply a thin layer of adhesive (Dunlop S-758) rapidly to both the prepared surfaces of the inspection cover and the rubber gasket, using a small metal, wood or hard-board scraper. Ensure complete and effective coverage. Allow solvent to evaporate for about 15 minutes.

5.6 Place the terminal box cover with coated surface facing upward and place the neoprene gasket with the coated surface downward accurately on the terminal box cover.

- 5.7 Place a felt mat out to the size of the steel pressure plate, over the neoprene gasket.
- 5.8 Place a steel pressure plate (Drg. No.2857) on the mat and keep the assembly pressed in the above manner for 24 hours.
- 5.9 Remove the pressure plate and felt mat, turn over the assembly and punch holes on the bonded neoprene gasket matching the bolt holes of the inspection covers.

6. **AGENCY FOR IMPLEMENTATION:**

Electric loco sheds.

7. **MATERIALS REQUIRED:**

Dunlop adhesive S758, 0.25 kg per motor Detergent.

Acid-HCL 10% concentration.

Pressure plate.

Gasket Neoprene sheet thickness 0.8 mm to ASTM/D735 Gr.SC 625 B

Petrol/White Spirit Brush.

8. **MATERIALS SURPLUS:**

Nil.

Encl.: SKEL - 2857 wam4/67

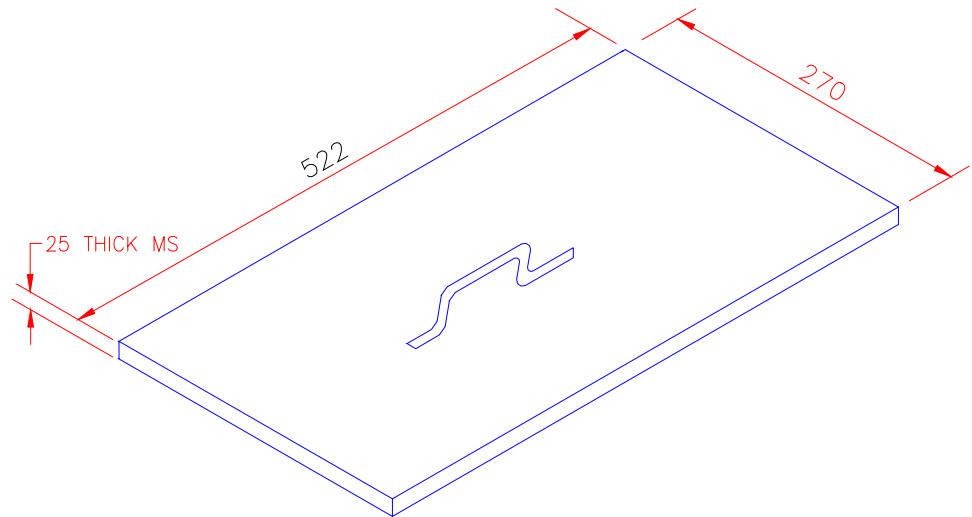


(R. P. Srivastava)
for Director General(Elect.).

ENCLOSURE TO MODIFICATION SHEET NO. RDSO/WAM4/67.



GASKET



PRESSURE PLATE

2.	PRESSURE PLATE	1.	MS.PLATE
1.	GASKET/* ASTM D735 GR.NO.SC6258	1.	POLYCHLORO PREME TO *
PART NO.	DESCRIPTION	QTY.	MATL/SPEC.

REF:- CLW DRG.NO.3TWD.092;131

SCALE:-NTS

APPD:

Signature
31/1/18

GASKET FOR TERMINAL COVER TAO 659 &
PRESSURE PLATE

RDSO ELEC. DTE. SKEL-2857

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D	<i>DP Singh</i>
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