

2. Procedure for removing motor support:

(i) Bogie frame should be kept up side down and motor support should be on the top for ease of replacement/welding.

(ii) 4 motor support situated on the transom of bogie should be removed by cut-off grinding wheel slowly to avoid excessive heating.

(iii) Pivot support sub-assembly base is to be removed first by oxy-gas cutting. This cut should be 10mm above the weld joints of 18mm base plate. Heat input to the bogie should be avoided during oxy-gas cutting suitably. The left out material (10mm) of structure should be removed by cut-off grinding wheel slowly to avoid heating in bogie frame.

3. Procedure for fixing motor support on bogie transom (4 Nos.):

> Finished modified two nos. motor support to CLW drawing No. 1209-01-412-186 will be tack welded in middle of frame using tack welding fixture maintaining distance shown in Fig- 3.

1. X dir. 64.5 mm
2. Y dir. 1155 mm (35+1120)
3. Z dir. 163 mm
4. Sequential Mig welding will be carried slowly using heavy duty Welding Fixture so that distance is arrested and dimensional accuracy with centre line is maintained in X, Y, Z, direction.

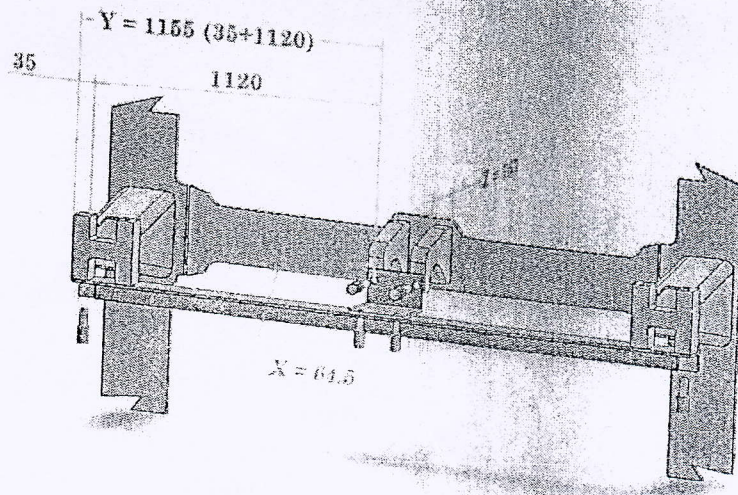


Fig -3

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