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January 24, 1994

CC-223.6.09.1

SUBJECT: Centerplate Gages for Reconditioned Bolsters

Mr. J. C. Devanney  
President  
Winchester Industries, Inc.  
P.O. Box 917  
41 Meadow Street  
Winsted, CT 06098


Dear Mr. Devanney:

As you are aware, we currently have no centerplate gages for M-214<sup>4</sup> reconditioned bolsters. We have, in the past, been very dependent on TMEC to provide drawings related to truck design. In this instance, they are reluctant to do so in that they consider the M-214 Reconditioners as competitors and as such, are not anxious to assist them.

Accordingly, I would like to request your assistance in developing these gages and drawings. If you are willing to do so, the procedure would be for you to develop the gages and then submit them to the Committee for approval and for inclusion in M-214. It would be advantageous if the Gage Manufacturers could cooperate on this effort.

Would you please review this request and advise if you are willing to participate in this effort.

Sincerely,



L. S. Davis

LSD/va

cc: J. W. Clowers



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March 24, 1994

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**SUBJECT: Bolster Bowl Restoration Gages**

Mr. J. C. Devanney  
President  
Winchester Industries, Inc.  
P.O. Box 917  
41 Meadow St.  
Winsted, CT 06098

Dear Mr. Devanney:

Please refer to your letter of January 24, 1994. The following comments were received regarding the subject gages:

Drawing W880 Rev. A - Bolster Depth "GO" & "NO GO" Gage-

The "NO GO" portion of this gage can be used to check the maximum allowable bowl depth requirements of M-214, Paragraph 3.3.2.2.2.

- The "GO" and "NO GO" portion of this gage can be used to check the minimum and maximum allowable bowl depth requirements of M-214, Paragraph 4.3.2.1.2.

- With regard to reconditioned bolsters, since the bowl diameter will be restored to the M-214 requirements of +1/8", -0", as shown as Dimension "G" on EC-1150-D and EC-1154-A, it is recommended that the Diameter "A" dimension be as follows:

<u>Nominal Dia.</u>	<u>DIM. "A"</u>
12"	11.969"
14"	13.969"
15"	14.969"
16"	15.969"

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Drawing W880 Rev. A - Bolster Depth "GO" & "NO GO" Gage ( Continued)

This will insure that the gage will "GO" into the bowl, and is in agreement with the Centerplate "GO" gage shown on EC-1126-H, on page D-75 of Manual Section D. In addition, it is recommended that the gage be made so it can check the full circumference of the bowl. This can be accomplished by adding a second piece, having the same dimensions the first piece, i. e., as shown on Drawing W880, and oriented 90 degrees to the first piece. The resulting gage would be rotated to check the circumference of the bowl. A note to this effect should be added to the drawing. It is recommended that Paragraphs 4.3.2.1.1 and 4.3.2.1.2 be revised by adding the following: **"The diameter of the reconditioned centerplate bowl to comply with the requirements of Figure VI, EC-1150 and EC-1154, Dimension "G".**" Note. the tolerances for Dimension "G" are not shown on EC-1150.

- It is suggested that a gage application note be added to the drawing as follows:

NOTE:

- GAGE CHECKS MAXIMUM AND MINIMUM ALLOWABLE DEPTH, AND MINIMUM ALLOWABLE DIAMETER, OF RECONDITIONED CENTER BOWL.
- GO SIDE OF GAGE MUST GO INTO CENTER BOWL, SEAT ON TOP OF RIM AND BE ROTATED ONE-HALF TURN.
- NO GO SIDE OF GAGE MUST NOT SEAT ON TOP OF RIM.

Drawing W882 Rev. A - Bolster Scrap Or Rework Gage

- This gage can be used to check the maximum allowable bowl depth requirements of M-214, Paragraphs 2.3.7 and 4.3.2.1.1. Since it will be applied to worn centerplate bowls to determine if they can be reused or reconditioned, Dimension "A" can remain as shown.

- Gage identification should be changed from "W880" to W882" to agree with the Drawing Number.

- Since the limiting condition is "greater than", it is suggested that Dimension "B" be increased by 0.015" (1/64") to ensure that bowl depths at the limit are not rejected. For example W882-1, Dimension "B" would be 1.391; W882-2, Dimension "B" would be 1.453; etc.

Drawing W882 Rev. A - Bolster Scrap Or Rework Gage

- A gage should be added for the 16" Diameter, 2" Nominal Depth bowl as follows, taking in the above comments:

Mr. J. C. Devanney  
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W882-7      16" DIA      2" NOMINAL DEPTH      A=16      B=2.328

- It is suggested that the gage application note be revised as follows:

NOTE:

-GAGE CHECKS MAXIMUM ALLOWABLE DEPTH OF WORN CENTER BOWL.

-GAGE MUST NOT SEAT ON TOP OF RIM WHEN ROTATED ONE-HALF TURN.

-IF GAGE DOES NOT SEAT, IT MAY BE RECONDITIONED PER AAR STANDARD S-305.

-IF GAGE SEATS ON TOP OF RIM, BOLSTER IS SCRAP.

Drawing W883 Rev A - Center Bowl Dia. Gage

- This gage can be used to check the maximum allowable bowl diameter requirements of M-214, Paragraph 3.3.2.2.1. In this case the limiting condition is "less than" and the "A" Dimensions shown are appropriate.

- It is suggested that the gage application "NOTE" be revised as follows:

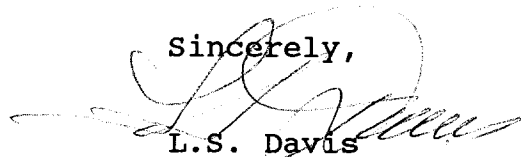
NOTE:

-GAGE CHECKS MAXIMUM ALLOWABLE CENTER BOWL DIAMETER  
-IF GAGE CAN GO INTO THE CENTER BOWL, BOLSTER CANNOT BE CLASSIFIED AS SECONDHAND AND MUST BE RECONDITIONED BEFORE REUSE.

These are only suggestions and please don't feel bound by them in any way. I would like to know your decision though.

One other thing, before I retire, I would like to come up with a gage numbering system for those gages which do not have an EC- number. Any suggestions that you might have would be appreciated.

Sincerely,



L.S. Davis  
Manager Equipment &  
Construction Engineering