

**TECHNICAL SERVICE BULLETIN  
RAFNA RAILGEAR**

**ISSUE DATE:** December 3, 2013

**TSB NUMBER:** TSB-191

**HAZARD / URGENCY RATING**

<b>X</b>	<b>DANGER - Physical harm is possible if TSB is not observed or followed</b>
<b>X</b>	<b>WARNING - Equipment damage is possible if TSB is not observed or followed</b>
<b>X</b>	<b>CAUTION - Essential issue affecting operation, service, parts or installation</b>
<b>X</b>	<b>INFORMATIONAL - Advisory which may be of interest</b>

**APPLICABLE EQUIPMENT:**

R460 Rotary Front Railgear

**SUMMARY:**

There have been reports the front rubber spring, P/N R-5683, have been falling out of the front railgear while in the road position.

**IMPACT:**

Physical harm may be possible if this TSB is not followed.

**ACTION:**

**CORRECTIVE ACTION:**

There are four (4) nubs on the spring plates of the front railgear. Two (2) on each side. One (1) upper and one lower. One nub is ¾ inch and this nub is to be extended by 5/8 inch (See Drawing R-20076ERW attached) the other nub is 1-1/8 inch and is to be extended 5/8 inch (See Drawing R20076DRW attached)

**PROCEDURE:**

Lower the front railgear towards the floor into the rail position, do not fully deploy. Support the front axle and secure. Remove the two ¾ x 6-1/2" lower guide tube bolts at the axle, one at a time. Caution: ensure properly supported. The axle assembly is now free of the railgear unit and the springs can be removed to perform welding the nub extension (See drawing R460SPRW attached).

Once the extensions have been welded and cleaned the axle can now be reassembled. Place the spring on the lower nub, it should hold in place. Carefully align the axle ears with the inner guide tube and insert the ¾"x6-1/2" bolt, assemble and torque to required specifications.

The following Front Railgear Spring Nub Extension Kit should be used to repair units in question.

The kit, P/N K-R46RFSPRW, will consist of the following:

<b>Rafna Industries Ltd.</b>	3-Dec-13
<b>K-R46RFSPRW Front Railgear Spring Nub Extensions</b>	rev. A
<b>Rotary R-460</b>	

**Vehicle Application Chart**

Year	Make	Model #	Model	
Part Number	Description	# Req.	Remarks	Check
R-20076ERW	STUB EXTENSION	2	SHIP LOOSE	
R-20076DRW	STUB EXTENSION	2	SHIP LOOSE	
R-5683	TIMBREN SPRING	2	SHIP LOOSE	
TSB-191	TECHNICAL SERVICE BULLETIN	1		

G&B Specialties contact number for replacement parts:  
Phone 570-752-5901 Ext 135

G&B Specialties contact number for Technical assistance:  
USA Phone Number, 570-752-5901 Ext 127  
Cell Number 570-441-6988

G&B Specialties contact number for Technical assistance:  
Canada Phone Number 570-854-0482



G&G Specialties will supply all parts and up to \$150.00 maximum for labor, per vehicle, to do these repairs.

All parts will be shipped UPS Air.

For repairs in Canada please contact for parts:

Montreal Repair Center

2610 Jean Baptiste Deschamps

Lachine Quebec

Canada H8T 1C9

Contact, Gerry Webber

Phone 514-636-3115

Fax 514-636-8740

Email, [gwebber@wabtec.com](mailto:gwebber@wabtec.com)

For repairs in the United States please Contact for parts:

G & B Specialties

535 West 3<sup>rd</sup> Street

Berwick, PA. 18603

Contact, Jim Hutchison

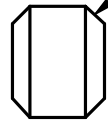
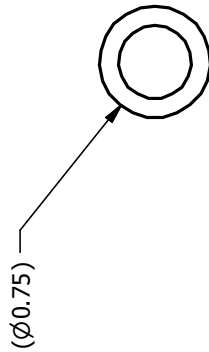
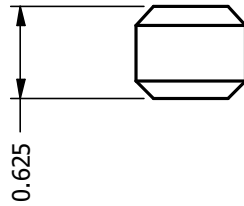
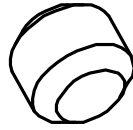
Phone 570-752-5901, extension 135

Fax 570-752-6397

Email, [jhutchison@wabtec.com](mailto:jhutchison@wabtec.com)

R:\RAFNA NEW\DRAWINGS\R20000\R20076ERW.dwg

MATERIAL: A36HR, 0.75" O.D. X 0.626" LG




0.13 X 45.0° Chamfer  
TYP (2)

REV		CHANGE	DATE	BY	APPD
A	RELEASE DRAWING		11/14/13	JL	APPD

DO NOT SCALE DRAWING		TOLERANCE ON FINISHED DIMENSIONS UNLESS OTHERWISE SPECIFIED		R.M.S. FINISH MAX DEPTH AS NOTED	
BASIC DIMENSIONS	FRACTIONS	2 PLACE DECIMALS	3 PLACE DECIMALS	1/16"	1/32"
UP TO 6 INCHES	+/- 1/64	+/- .02	+/- .005		
6" TO 24"	+/- 1/32	+/- .03	+/- .010		
ABOVE 24"	+/- 1/16	+/- .06	+/- .015		
ANGULAR DIMENSIONS	+/- 1/2°				

G & B SPECIALTIES INC.		DESIGN ~ ENGINEERING ~ MANUFACTURING	
 <b>G &amp; B SPECIALTIES INC.</b> MANUFACTURER OF QUALITY RAILROAD PRODUCTS BERWICK PENNSYLVANIA (570) 752-5901 . FAX (570) 752-6397		DESCRIPTION: <b>STUB EXTENSION</b>	
DESIGN AND ISURANCE FOR CONSULTATION PURPOSE ONLY. NO CONTENTS AND IS NOT TO BE COPIED, REPRODUCED OR DISCLOSED TO ANY OTHER PARTY WITHOUT WRITTEN CONSENT OF G & B SPECIALTIES INC.		REF:	

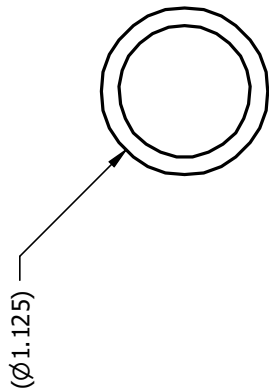
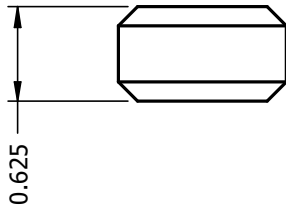
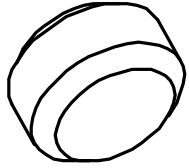
DRAWING NUMBER	DATE DRAWN	SHEET	PART NUMBER	REVISION
R20076ERW	11/14/2013	1 of 1	R-20076ERW	A

NOTES:  
 1. DEBURR  
 2. FINISH: NONE

ALL WELDS TO CONFORM TO AWS D1.1

R:\RAFNA NEW\DRAWINGS\R200000\R20076DRW.dwg  
MATERIAL: A36HR, 1.125" O.D. X 0.626" LG



0.13 X 45.0° Chamfer  
TYP (2)

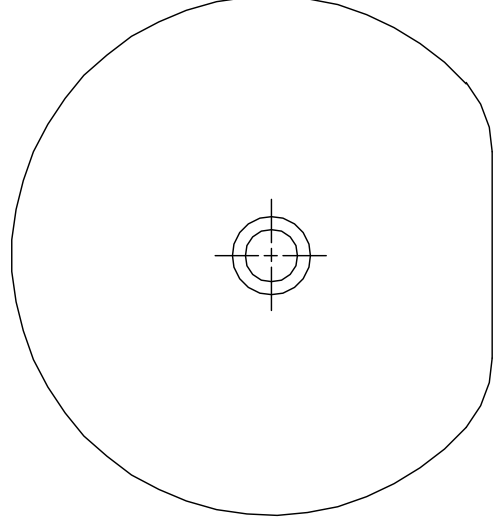
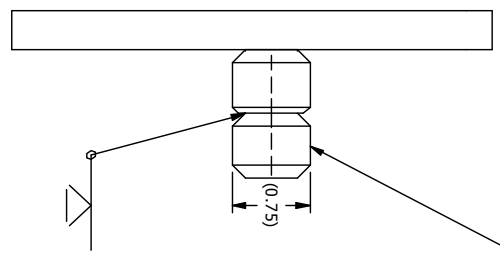
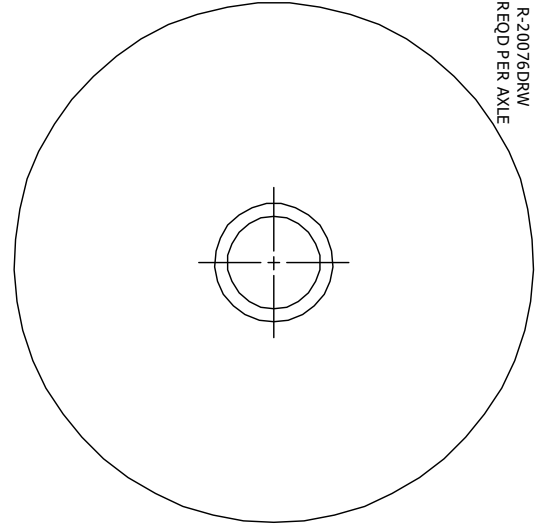
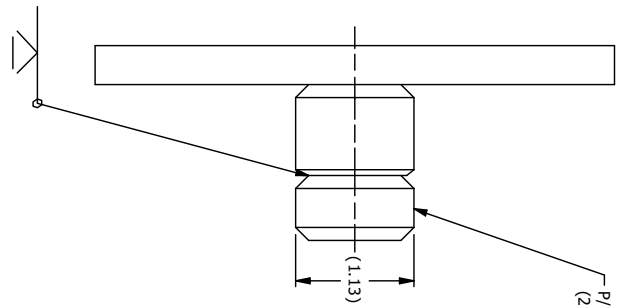
A		RELEASE DRAWING	11/14/13	JL	BY	APPD
REV		CHANGE	DATE	BY	REVISION	
DO NOT SCALE DRAWING		PRIMARY UNITS ARE INCH [SECONDARY UNITS ARE MILLIMETER]				
TOLERANCE ON FINISHED DIMENSIONS UNLESS OTHERWISE SPECIFIED		R.N.S. FINISH MAX EXCEPT AS NOTED				
BASIC DIMENSIONS		DECIMALS				
UP TO .6 INCHES		3 PLACE				
.6 INCHES TO 24"		2 PLACE				
ABOVE 24"		1 PLACE				
FRACTIONS		DECIMALS				
UP TO .1/64		+/- .02				
.1/64 TO .1/32		+/- .03				
.1/32 TO 24"		+/- .04				
ABOVE 24"		+/- .06				
ANGULAR DIMENSIONS		+/- 1/2				
TOLERANCE ON FINISHED DIMENSIONS UNLESS OTHERWISE SPECIFIED		R.N.S. FINISH MAX EXCEPT AS NOTED				
BASIC DIMENSIONS		DECIMALS				
UP TO .6 INCHES		3 PLACE				
.6 INCHES TO 24"		2 PLACE				
ABOVE 24"		1 PLACE				
FRACTIONS		DECIMALS				
UP TO .1/64		+/- .02				
.1/64 TO .1/32		+/- .03				
.1/32 TO 24"		+/- .04				
ABOVE 24"		+/- .06				
ANGULAR DIMENSIONS		+/- 1/2				
DRAWING NUMBER		DATE DRAWN	SHEET	REVISION		
R20076DRW	11/14/2013	1 OF 1	R-20076DRW	A		
G & B SPECIALTIES INC.		MANUFACTURER OF QUALITY RAILROAD PRODUCTS				
DESIGN ~ ENGINEERING ~ MANUFACTURING		BERWICK PENNSYLVANIA (570)752-5901, FAX (570)752-6397				
DESCRIPTION		STUB EXTENSION				
G&B SPECIALTIES INC. THE OWNER OF THIS DOCUMENT AND ITS CONTENTS IS NOT BEING RELEASED TO ANY OTHER PARTY WITHOUT THE WRITTEN CONSENT OF G&B SPECIALTIES INC.		PART NUMBER				
DRAWING NUMBER		R460.SPRINGS				
DATE DRAWN		R-20076DRW				
SHEET		1 OF 1				
REVISION		A				

NOTES:  
1. DEBURR  
2. FINISH: NONE

ALL WELDS TO CONFORM TO AWS D1.1

R:\RAFNA NEW\DRAWINGS\R200000\R20076DRW.dwg

P:\RAFAA NEW\DRAWINGS\SR200001\2460 SPRING P.L.T REWORK.kldw  
 MATERIAL: \_\_\_\_\_



- NOTES:  
 1. REMOVE WELD SPLATTER  
 2. FINISH: PAINT FLAT BLACK

R:\RAFAA NEW\DRAWINGS\SR200001\2200768RW.dwg

FROM MM UNITS X AXE INCH TO SECONDARY UNIT X AXE MILLIMETER		DO NOT SCALE DRAWING																
TOLERANCE ON FINISHED DIMENSIONS		FINISH																
DIMENSIONS		TOLERANCE																
0.00 TO 0.0625	FRACTIONS	3-ZIPK	3-ZIPK															
0.0625 TO 0.125	FRACTIONS	+/- .02	+/- .005															
0.125 TO 0.25	FRACTIONS	+/- .02	+/- .010															
0.25 TO 0.5	FRACTIONS	+/- .02	+/- .015															
0.5 TO 1.0	FRACTIONS	+/- .05	+/- .015															
ABOVE 1.0	FRACTIONS	+/- .10	+/- .015															
ABOVE 2"	FRACTIONS	+/- .10	+/- .015															
ANGULAR DIMENSIONS		+/- .10°																
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REV	DESCRIPTION	DATE	BY	APPD														
A	DRAWING RELEASE	1/14/2013	JL															
	CHANGE																	
DRAWING NUMBER: R480SPRV		DATE DRAWN: 1/14/2013																
SHEET: 1 OF 2		PART NUMBER: R480 AXLE																
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