

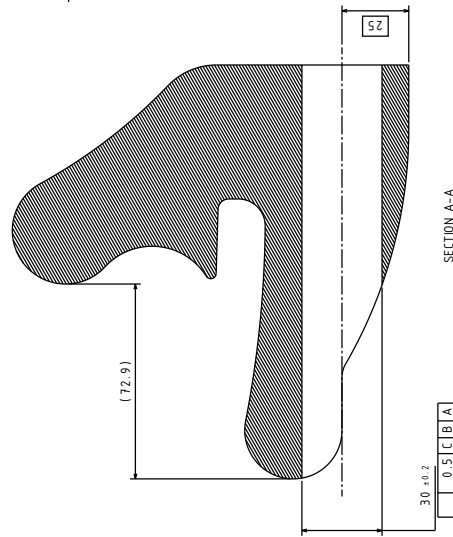
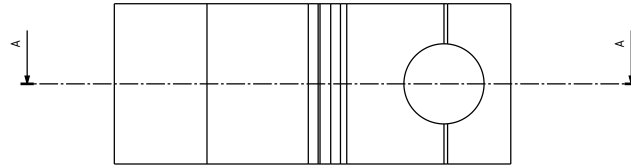
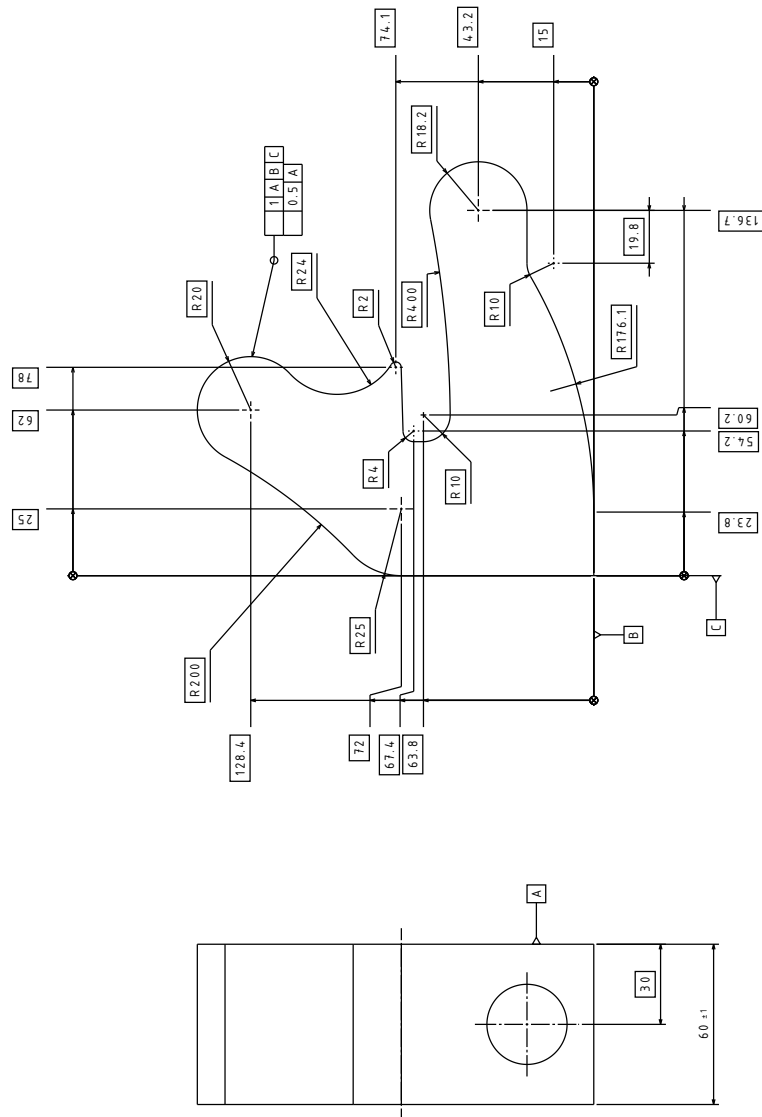
NOTE ON TOLERANCING

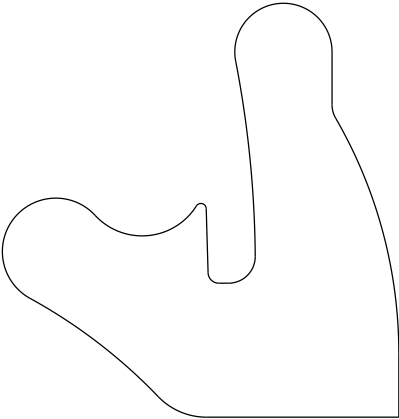
FLAME CUT TOLERANCES ARE ACCEPTABLE EXCEPT IN THE SMALL AREAS INDICATED WHERE MACHINING MAY BE REQUIRED TO ACHIEVE ACCEPTABLE ALIGNMENT WITH MATING COMPONENTS.

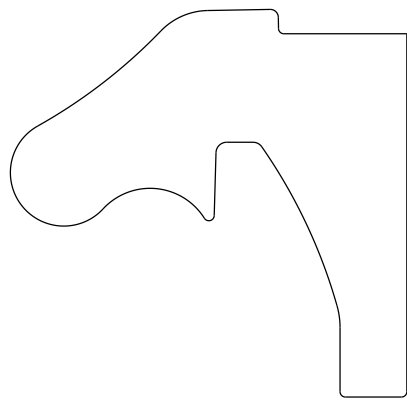
REMAINDER OF PROFILE SHOULD BE CONSIDERED MINIMUM MATERIAL REQUIREMENT WITH PROFILE LINE ALLOWED TO EXCEED DIMENSION BY UP TO 3mm.

THROAT THICKNESS DIMENSION SHOWN ABOVE IS PRIMARY CHECK DIMENSION

PROJECT Rail Clamp		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN MILLIMETERS SURFACE FINISH: TO BE INDICATED SEE NOTES		FINISH COLOUR: SOURCE: Flame-cut profile		PAINTED YELLOW		CEBUT AND BREAK SHARP EDGES		DO NOT SCALE DRAWING		REVISION 10	
Stock Size		Span		NAME		ORGANISATION		DATE		TITLE Mk8 clamp part 2			
Stock Length		HEAVY		CUT		CUT							
Vendor		CUT		APPRO		APPRO							
Vendor No.		Weld Used		W/G		W/G							
Configuration		Defect		Q.A		MATERIAL BS EN 10210-2 S355				DWG NO. 30091421		A3	
QTY REQD										SCALE: 1:2		SHEET 3 OF 3	
Client		Codiun Rail		Third angle Projection		WEIGHT: 4105.31		7		8		9	

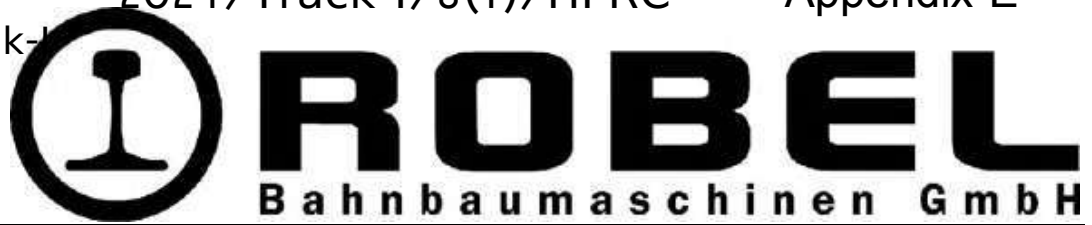
[illegible]





Appendix-D**PHOTOGRAPHS OF HPRC CLAMPS-ROBEL IN FIELD TRIALS****Fig. Robel Ver. 13****Fig. Robel Ver. 06**

PHOTOGRAPHS OF HPRC CLAMPS-CODIUN IN FIELD TRIALS**Fig. Codiun MK8****Fig. Codiun MK2 T5848**



Installation and Operating Instructions

Rail Clamps

68.05 / Version 13 (orange)



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These instructions were issued taking into consideration
the latest technology at the time of printing.
They are subject to change due to new developments.
Dimensions and weights are approximate.
Some photos show special designs.

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Installation and Operating Instructions / Executive Summary

ATTENTION: This executive summary is no substitute for knowledge of the content of the full installation and operating instructions.

- Remove ballast under the rail in the clamping area.
- Clean all contact areas of the fishplates, rails and rail clamps.
- Mount at least two sets of rail clamps.
- Tightening torque of all screw connections: 580 [Nm].



Figures 1 and 2: Installation

When installing the rail clamps the following procedure has to be adhered to:

1. In order to ensure a tight fit of the fishplates after installation the rail fastenings on the adjacent sleepers have to be loosened such that a tight-fit installation of the fishplates is possible. This has to be done after the ballast has been cleared between the sleepers. The fishplate locking mechanism (fishplates and clamps) has to be tightened securely during installation. The fishplates have to be bashed with a sledge hammer and the hexagonal nuts tightened with a torque of **580 Nm** using a torque spanner. (Caution: Do not bash the rail clamps)
2. After the first train has passed the fishplates have to be re-bashed with a sledge hammer and the required torque of 580 Nm has to be checked using a torque spanner.



Figures 3 and 4: Installation examples

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