



भारत सरकार –रेल मंत्रालय
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Lucknow – 226011
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No. MW. PLNG.CSNB

Date: As Signed

The PCMEs
All Zonal Railways

AND

All LCCF- 20(C) (CONCOR) bogie manufacturers
(As per vendor list)

Sub: Modification in Side frame geometry at jaw location (Drg. No. CONTR – 9404-S/3) of LCCF – 20(C) (CONCOR) bogies.

Clearance between bogie components plays a critical role in the dynamic performance of the bogie. The matter has been examined by RDSO, and it has been decided to implement the following modifications at **Jaw Level** in LCCF–20 (C) bogies.

1. Modification in adapter-side frame clearances (Longitudinal Clearance between Side Frame and Adapter)

- 1.1. The longitudinal clearance between the adapter and pedestal jaw shall be maintained at:
 $3.0 \begin{smallmatrix} +1.5 \\ -1.0 \end{smallmatrix}$ mm
- 1.2. Accordingly, the existing dimension of $278 \begin{smallmatrix} +2 \\ -0 \end{smallmatrix}$ shall be modified to $273 \begin{smallmatrix} +1 \\ -0.5 \end{smallmatrix}$.
- 1.3. For new bogie manufacturing, liners of size $100 \times 90 \times 5$ mm thick shall be provided as per drawing no. CONTR – 9404 – S/3 Alt.8.
- 1.4. For existing bogie side frames, once the wear limit is reached during service, liners of size 100×90 of suitable thickness shall be used as per drawing no. WX-26003.

2. Introduction of stop lugs at side frame pedestal jaw top

- 2.1. To restrict longitudinal shifting of elastomeric pads, three stop lugs shall be provided at the top of the side frame pedestal jaw as a permanent feature of LCCF–20 (C) bogies.
- 2.2. The provision of these stop lugs should be ensured both during new bogie manufacturing and during maintenance of existing bogies.

3. Modification of pedestal jaw sides in side frame (Lateral Clearance between Side Frame and Adapter)

- 1.1. The lateral clearance between the adapter and pedestal jaw shall be maintained at:
 $11.5 \begin{smallmatrix} +1 \\ -1.5 \end{smallmatrix}$ mm.
- 1.2. Accordingly, the existing dimension of $105 \begin{smallmatrix} +3 \\ -1.5 \end{smallmatrix}$ shall be modified to $100 \begin{smallmatrix} +0 \\ -2 \end{smallmatrix}$ (Without liner) and $110 \begin{smallmatrix} +0 \\ -2 \end{smallmatrix}$ (With two 5 mm thick liners).

- 1.3. For new bogie manufacturing, liners of size $120 \times 25 \times 5$ mm thick shall be provided as per drawing no. CONTR – 9404 – S/3 Alt.8.
- 1.4. For existing bogie side frames, once the wear limit is reached during service, liners of size 120×25 of suitable thickness shall be used as per drawing no. WX-26003.
2. The above modifications have been incorporated in LCCF-20 (C) bogie side frame drawing no. CONTR-9404-S/3 Alt.8 and in Sketch no. WX-26003, which also details the procedure for carrying out the necessary modifications during maintenance of existing side frames.
3. All jaw liners, including pedestal jaw liners and pedestal side liners, shall be renewed during ROH and POH.
4. The prescribed wear limits shall be ensured during bogie maintenance. These limits are maintenance limits only and shall not be construed as safety limits. The limits have been defined on the premise that, when complied with during ROH and POH, bogie performance will remain satisfactory, taking into account the normal wear expected in service up to the next scheduled maintenance.
5. These instructions are under incorporation in the LCCF Bogie Maintenance Manual, G-112.

In view of the above, the modifications shall be implemented during new bogie manufacturing as well as during maintenance of existing bogies by 31.03.2026. Accordingly, all Zonal Railways and all LCCF-20 (C) (CONCOR) bogie manufacturers are advised to make necessary changes in their manufacturing and maintenance processes to ensure compliance.

DA:As Above

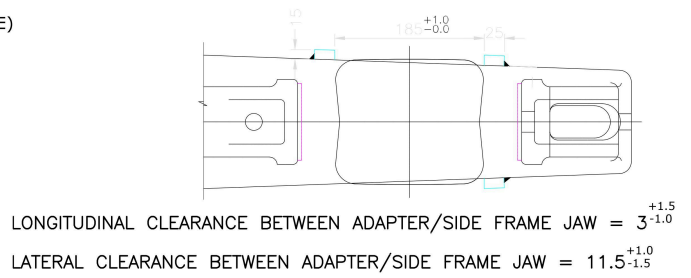
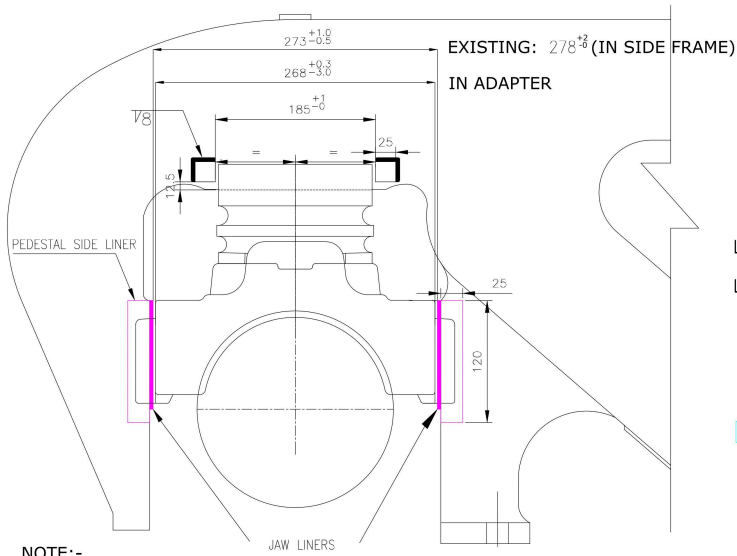
Digitally Signed by
Abhishek Kumar Gautam
Date: 02-02-2026 12:12:32
Reason: Approved
(A.K. Gautam)
Director/Wagon (Bogie)
for Executive Director/Wagon

Copy to:

1. **EDME (Freight)/ Railway Board** -for kind information, please.
2. **ED/QAM/Mumbai/Kolkata/New Delhi** – for kind information and necessary action please.

WX-26003

MODIFIED DIMENSIONS IN SIDE FRAME PEDESTAL JAW OF LCCF - 20(C) BOGIE



NOTE:-

1. STOP LUG:

- 1.1. STOP LUGS SHALL BE MADE FROM MILD STEEL BAR STOCK TO A DIMENSION OF 25 MM X 25 MM X 15 MM.
- 1.2. STOP LUG TO BE HELD TIGHTLY AGAINST PEDESTAL CROWN SIDES DURING WELDING.
- 1.3. WELD SHALL BE MADE ALONG THE TOP OF THE LUG AND BE BROUGHT ALONG THE OUTER EDGE AS SHOWN.

2. JAW LINERS:

- 2.1. DISTANCE BETWEEN PEDESTAL JAWS TO BE MODIFIED BY WELDING OF Si-Mn LINER (90X100) OF SUITABLE THICKNESS AS PER IS:3885 PT.I GR.IV (BHN 380-420) ON EACH SIDE OF SIDE FRAME JAW BY GMAW PROCESS AS PER LATEST IRS M-46/2020. WHENEVER NEEDED BOTH SIDES LINERS AT A JAW SHOULD BE RENEWED SIMULTANEOUSLY.
- 2.2. AT PEDESTAL SIDES, IF A 3 mm THICK SHIM CAN BE INSERTED BETWEEN CASTING & GAUGE AT ANY POINT, SUITABLE THICK Si-Mn LINERS (25X120) AS PER IS:3885 PT.I GR.IV (BHN 380-420) AT ALL FOUR SIDES OF THE PEDESTAL SHALL BE WELDED.
3. THE CASTING SURFACES MUST BE DRESSED BY USING SUITABLE METHOD AND MUST BE FREE FROM RUST, BURRS, WELD SPATTERS AND OTHER DEBRIS. THE SURFACE SHOULD BE STRAIGHT AND FLAT FOR FITMENT OF LINER WITHIN A TOLERANCE OF CONCAVE 0.75 MM & CONVEX 0.75 MM AND PERPENDICULAR TO THE ROOF SURFACE. BOTH THE JAW SURFACES MUST BE EQUIDISTANT FROM THE JAW CENTER WITHIN 0.5 MM.
4. FRICTION LINERS TO BE HELD TIGHTLY AGAINST JAW FACE/ JAW SIDES DURING WELDING & WELDING SHOULD BE DOWN HAND WITH 3.15 MM ELECTRODE.
5. PRECAUTIONS WHILE WELDING:- UNIFORM BEAD IS TO BE DEPOSITED. WEAVING IS NOT PERMITTED. FOLLOW EACH WELD DEPOSITION WITH LIGHT PEENING. WELD MUST NOT EXTEND BEYOND FACE OF LINER & EXCESSIVE MATERIAL SHOULD BE REMOVED BY GRINDING. PEDESTAL LINERS AND STOP LUGS SHALL BE WELDED BY GMAW WELDING PROCESS AS PER LATEST IRS M-46/2020.

ALT	ITEM	AUTHY.	DESCRIPTION	ASSEMBLY DRGS.
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ITEM	DESCRIPTION & DIMENSIONS	NO.OFF PER GAUGE	REF. DRG.	WT. OF ONE(Kg)	MATL & SPCN	REMARKS	
SUPERSEDED BY:		LCCF - 20(C) BOGIE					
SUPERSEDES		DATE					
SCALE	PASSED						
/	CHECKED						
	DRAWN						
	TRACED						
	J.SHEET						
B.G.	R.D.S.O	GROUP	WX-26003				
	[W]						

