



भारत सरकार –रेल मंत्रालय
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Government of India - Ministry of
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Research Designs & Standards
Organisation Lucknow – 226011
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No. MW/APB/BMB/Escorts

Dated: 04.07.2023

A.

1. ED(QAM)/Mumbai
2. ED(QAM)/Kolkata
3. ED(QAM)/NDLS

B. CRSEs (Freight)

1. Central Railway, C.S.T., Mumbai – 400 001
2. Eastern Railway, Fairlie Place, Kolkata – 700 001
3. East Central Railway, Hajipur – 844 101
4. East Coast Railway, Rail Vihar, B-2, Chandrashekherpur, Bhubaneswar – 751 023
5. Northern Railway, Baroda House, New Delhi -110 001
6. North Central Railway, Subedargunj, Allahabad -211 033
7. North Eastern Railway, Gorakhpur-281 001
8. Northeast Frontier Railway, Maligaon, Guwahati -781 001
9. North Western Railway, Near Jawahar Circle, Jaipur – 302 017
10. Southern Railway, NGO Annexe, Park Town, Chennai – 600 003
11. South Central Railway, Rail Nilayam, Secunderabad – 500 371
12. South Eastern railway, Garden reach, Kolkata – 700 043
13. South East Central Railway, RE Office Complex, Bilaspur – 495 004
14. South Western Railway, Club Road, Keshwapur, Hubli – 560 023
15. West Central Railway, Opposite Indira Market, Jabalpur – 482 001
16. Western Railway, Churchgate, Maharishi Karve Marg, Mumbai – 400 020

Sub: Work instruction related to Escorts design BMBS.

1. Please find enclosed the work instructions regarding:
 - a) Visual check of BMBS beam end liner
 - b) Visual checks for BMBS bell crank lever
 - c) Welding of BMBS safety chain
2. It is requested that the above instructions may be followed during fitment/ maintenance of Escorts design BMBS.

Encl: As above.

Digitally Signed by
(S. K. Sharma)
Shailendra Kumar Sharma
Director Stds. Wagon (CD)
Date: 04-07-2023 17:56:53
Reason: Approved



Escorts Kubota Limited
(Formerly Escorts Limited)

Work Instruction

WI no.: WI-BMBS -
BC -004

Rev. no. 00

Date: 29.06.2023

Page 01 of 01

Visual Check of BMBS Beam end Liner

Checkpoints:



1. Check Beam end liner condition in bogie pocket

2. Ensure liner is fixed properly and must not be worn out / damaged.



1. If liner is found worn out / damaged then; replace the liner (including both screws)

Prepared By: Arun Chauhan

Approved By: Rajkumar Saini



Escorts Kubota Limited
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Work Instruction

WI no.: WI-BMBS -
BC -003

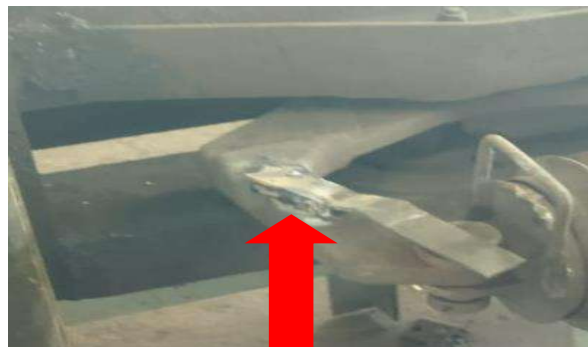
Rev. no. 00

Date: 12.06.2023

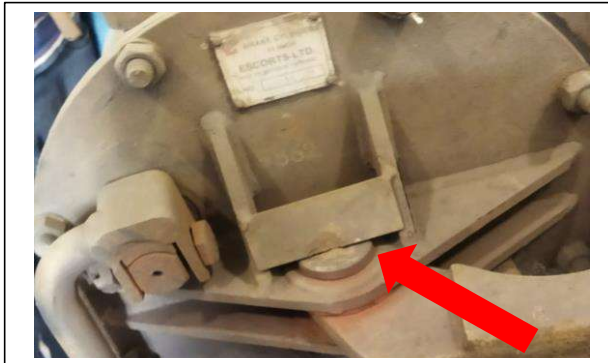
Page 01 of 02

Visual checks for BMBS Bell Crank Lever

Checkpoints:



1. APD should be Tag welded with Bell crank Lever. **Not Full Welded.**
2. In case full length welding is found; change the Bell crank lever.



1. Check for Gap between APD & Pin (Dia. 24 X Length 70 mm).
2. Gap should be minimum 5 mm.
3. If gap is less; then rework APD (Re-weld it, and check gap with slip gauge).



1. Check for Pin size and make; it should be Escort make and standard size should be 24*70 mm.

Prepared By: Arun Chauhan

Approved By: Rajkumar Saini



Escorts Kubota Limited
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Work Instruction

WI no.: WI-BMBS -
BC -003

Rev. no. 00

Date: 12.06.2023

Page 01 of 02

Visual checks for Bell Crank Lever- BMBS

Checkpoints:



1. Pins connecting Push Rods with Bell Crank Lever (LH & RH) should not foul with Primary beam while Brakes are applied/released.
2. While welding APD free movement of pins should be ensured.



1. Check visual crack on the Bell crank Lever near Centre Pivot Pin.
2. If Crack is observed; then replace the part.



1. Check that Holes on the Bell Crank Lever are not oblong.
2. If observed; then replace the part.

Prepared By: Arun Chauhan

Approved By: Rajkumar Saini



Escorts Kubota Limited
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Work Instruction

WI no.: WI-BMBS -
BC -001

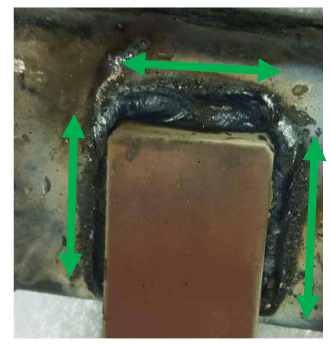
Rev. no. 01

Date: 29.06.2023

Page 01 of 01

Welding of BMBS - Safety Chain

Checkpoints:



1. Minimum welding bead of 3mm to be done around the bracket.

2. Length of Bracket; 65 ± 5 mm to be covered during welding



Not-OK welding

In case of improper welding; to be re-done as per following:

1. Weld area to be clean from rust, Oil, and paint before welding
2. Welders shall be qualified under the welder qualification procedure contained in AWS 15.1 latest revision or equivalent
3. 3 mm welding shall be done around bracket as per below drawing sketch and photograph.
4. Arc welding electrode shall be used of grade E309 for MS to SS material and E7018, E 6013 for MS to MS material or any other equivalent grade

Prepared By: Arun Chauhan

Approved By: Rajkumar Saini