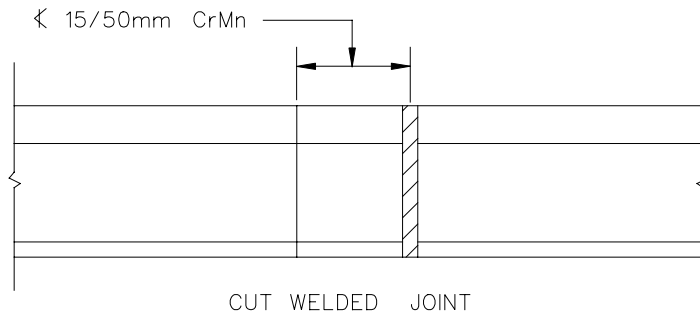
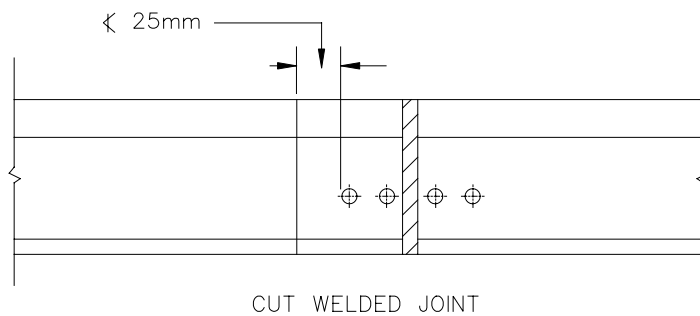


MINIMUM CUT DISTANCE FROM WELDED JOINTS

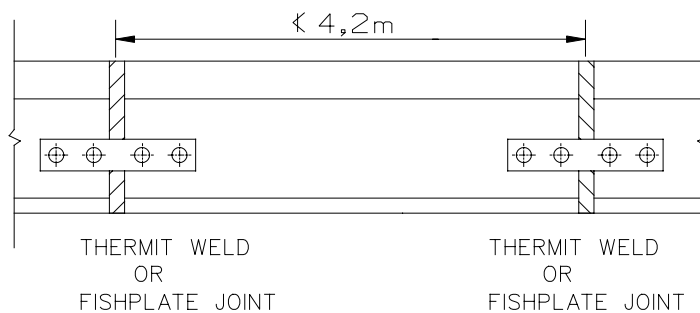


IF WELD IS DEFECTIVE, CUT RAIL NOT CLOSER THAN 15/50mm CrMn FROM THE CENTRE OF AN EXISTING WELDED JOINT. IF WELD IS SOUND, THE CUT MAY BE MADE THROUGH THE WELD.



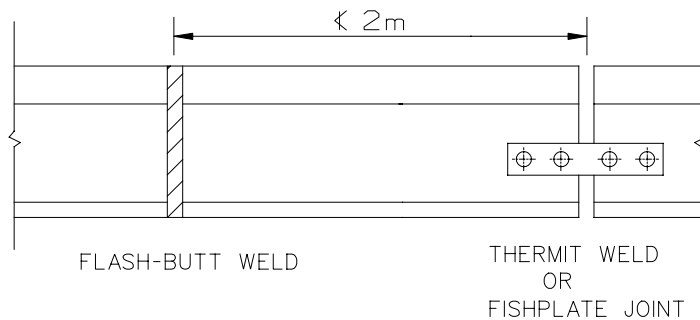
CUT RAIL NOT CLOSER THAN 25mm FROM THE SIDE OF AN EXISTING FISHPLATE HOLE.

MINIMUM DISTANCE BETWEEN RAIL JOINTS



MINIMUM DISTANCE BETWEEN THERMIT WELD/FISHPLATE JOINT AND THERMIT WELD/FISHPLATE JOINT MUST BE AT LEAST 4,2m.

EXCEPT IN THE CASE OF INSULATED JOINTS

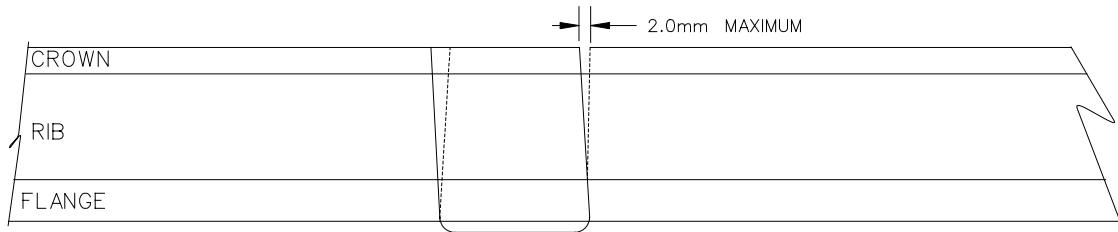


MINIMUM DISTANCE BETWEEN THERMIT WELD/FISHPLATE JOINT AND FLASH-BUTT WELD MUST BE AT LEAST 2m. ANY DEVIATION MUST BE APPROVED BY THE DEPOT ENGINEER PERSONALLY.

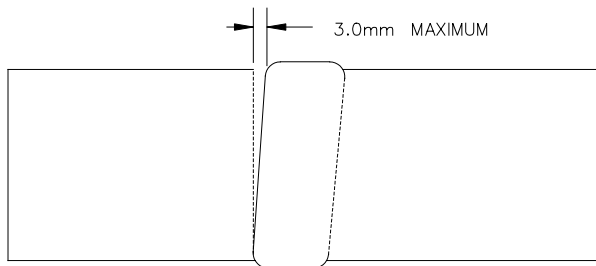
TOLERANCES FOR VERTICAL AND SQUARENESS OF MOULD ALIGNMENT

(All measurements must be done with an engineering square)

Vertical alignment is to be measured at the top of rail.

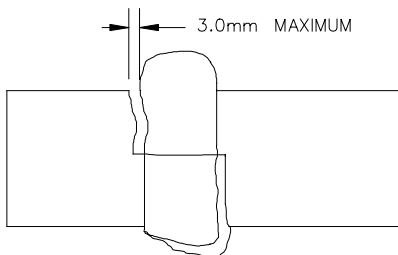


SQUARENESS



MOULD SQUARENESS AND ALIGNMENT ARE MEASURED AT THE WELD COLLAR ON THE UNDERSIDE OF THE RAIL.

MOULD ALIGNMENT



MISALIGNMENT IS MEASURED AT THE WELD COLLAR ON THE UNDERSIDE OF THE RAIL.