

NEW ZEALAND GOVERNMENT RAILWAYS	PISTON RODS	CODE No.13	
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EXISTING LOCO. CODE INSTRUCTIONS TO BE CANCELLED: 226, 320.

(1) PISTON RODS- Original Size of, Last Turning or Grinding Size of, Condemning Size of

[The sizes quoted in this table are superseded by those shown on Drawing Y.21195 until further notice.]

Class.	Original Diameter.	Drawing No	Last Turning or Grinding Size.	Condemning Size.
	Inches.		Inches.	Inches.
A - H.P.	2.375	3633	2.125	2.094
- L.P.	2.5	4056	2.25	2.219
A 409	3.5	3969	3.25	3.219
A (simple)	3.25	W. 15561	3.0	2.969
AA	3.25	Y. 20201	3.0	2.969
AB	3.25	W. 15330	3.0	2.969
B	2.75	2189	2.5	2.469
BA	2.75	4986	2.5	2.469
BB	3.0	5722	2.75	2.719
C	2.375	W. 15103	2.125	2.094
F	1.75		1.5	1.469
G	3.0	X. 10516	2.75	2.719
H (inside)	2.0	9256	1.75	1.719
H (outside)	2.25	9217	2.0	1.969
J, JA	3.25	X. 12418	3.0	2.969
K, KA, KB	3.75	X. 10693	3.5	3.469
Q	2.75	Z. 7337	2.5	2.469
U	2.75	1563	2.5	2.469
UB	2.75	Z. 7337	2.5	2.469
UC	3.0		2.75	2.719
W	2.375	1035	2.125	2.094
WA	2.375	2394	2.125	2.094
WAB	3.25	W. 15330	3.0	2.969
WB	2.375		2.125	2.094
WE	2.75		2.5	2.469
WF	2.375	3333	2.125	2.094
WG	2.75	4762	2.5	2.469
WW	2.75	5801	2.5	2.469
X - H.P.	2.75	4127	2.5	2.469
- L.P.	3.0	4127	2.75	2.719
X (simple)	3.0	W.15731	2.75	2.719

(2) PISTON RODS, Packing for

Metallic packings for piston rods must be in accordance with Drg. 20654, except where "patent" piston-rod packings are specifically authorized.

The material for metallic packings must be of the composition shown in group " O " of Code No.60.

(3) PISTON RODS- Material for, Turning and Grinding of

Piston rods must be made from special piston-rod steel to specification shown in group 7 (D) on Drg. W. 16298 (Materials used for Loco. Work, &c.) and must be turned and ground round and parallel.

(4) PISTON RODS, Welding of

~~Welding will only be permitted for building up the tapered fit of a rod, and must be done by the electric process. The rod must be pre heated before welding, and normalized when completed.~~

[The welding of piston rods under any circumstances is prohibited.]

[C.M.E.s 24/563 of 18.9.50]

(5) PISTON RODS, Bent

Bent piston rods must not be straightened and must be condemned.

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(6) PISTON RODS, Condemning of

Piston rods which are condemned must be deeply marked "X" with a cold set on the tapered end, so that it will be impossible for them to be used again.

(7) PISTON RODS, Re-turning and Regrinding of

When locomotives are received in workshops for "A" or "B" class repairs, piston rods must be reground. In cases where piston rods are irregular in shape they must be turned before regrinding.

(8) PISTON RODS, Examination of

Whenever piston rods are drawn from the crosshead they must be closely examined for any defects.

(9) PISTON RODS, Lubrication of

Each piston rod must be adequately lubricated with cylinder oil as near to the gland as possible by means of an oil cup. Where "patent" packings are fitted, the method of lubricating will be subject to special illustration.

(10) PISTON RODS, Branding of

All piston rods must bear the following brands on the crosshead end: Maker's name; W.R. number; Date in service.