

TRUCK FRAME TRAMMING AND PEDESTAL ALIGNMENT

To check truck frame tram and the alignment of pedestals, the following procedure is suggested:

1. Positioning Truck Frame: On a faceplate or other level surface, invert the truck frame and level with jacks at spring location.
2. Horizontal Pedestal Alignment: The bottom of the pedestals were machined to a common plane or base line. Check the horizontal alignment of all pedestals with a straight edge. The normal out of plane service limit is 1/8", that is, the vertical distance from the bottom of one pedestal to the bottom of any pedestal should be checked for leaning.
3. Pedestal Lean: Each pedestal should be checked for leaning condition to determine out of square position. The pedestals are checked using a straight edge or square.
4. Transverse Pedestal Spacing: The transverse pedestal spacing refers to the dimension between the inside machine surfaces of pedestal legs on opposite sides of the truck. The nominal tolerance is + or - 1/16".
5. Longitudinal Alignment: The longitudinal alignment of the pedestal liners on the inside of the pedestal legs, can be checked with a straight edge. Liners are to be in longitudinal alignment within 1/16".
6. Wheel Base Spacing: Wheel base spacing is the measured longitudinal distance between pedestal legs. For a service limit, the machined faces of pedestals on one side of truck frame are not to exceed 1/8" from opposite side of frame. The wheel base on one side of truck frame to be within 1/8" of wheel base on other side of truck frame.
7. Tramming Truck Frame: The truck pedestals are trammed to determine if they are in correct alignment with each other, that is to determine if the distance between pedestals are within the allowable dimension service limit.

Tram marks (Small punch indications) were located on the bottom of each pedestal at time of original inspection. These marks are generally located approximately 1/2" in from the face of pedestal and the inner side of pedestal. Tramming is accomplished by using a trammel beam to measure between diagonal tram marks. The service limiting dimension or difference in length of diagonal is 1/8".

Top View

Pedestal Leg

1.

3.

5.

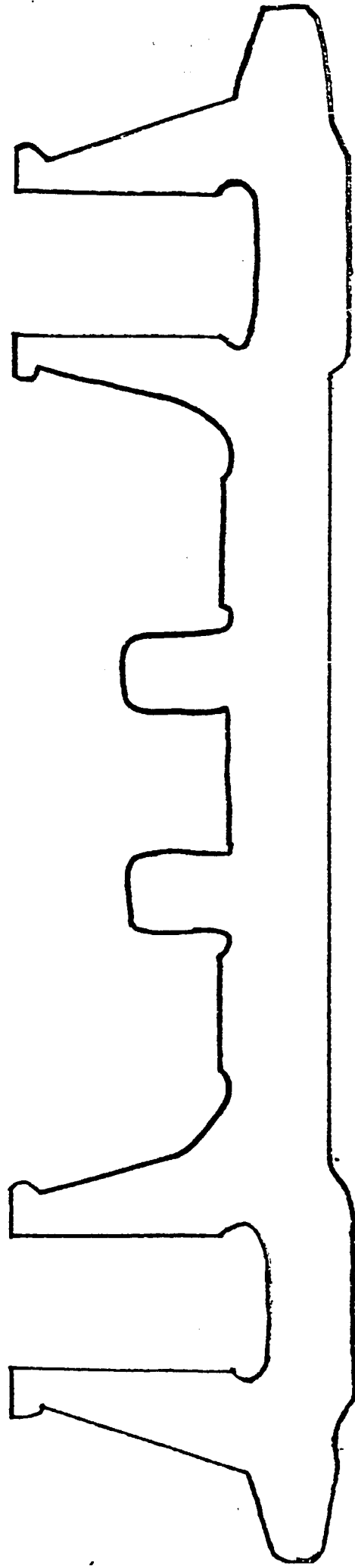
7.

6.

8.

2.

4.



Side View

Truck Frame

Top View

Pedestal Leg

Step // 1

1.

3.

5.

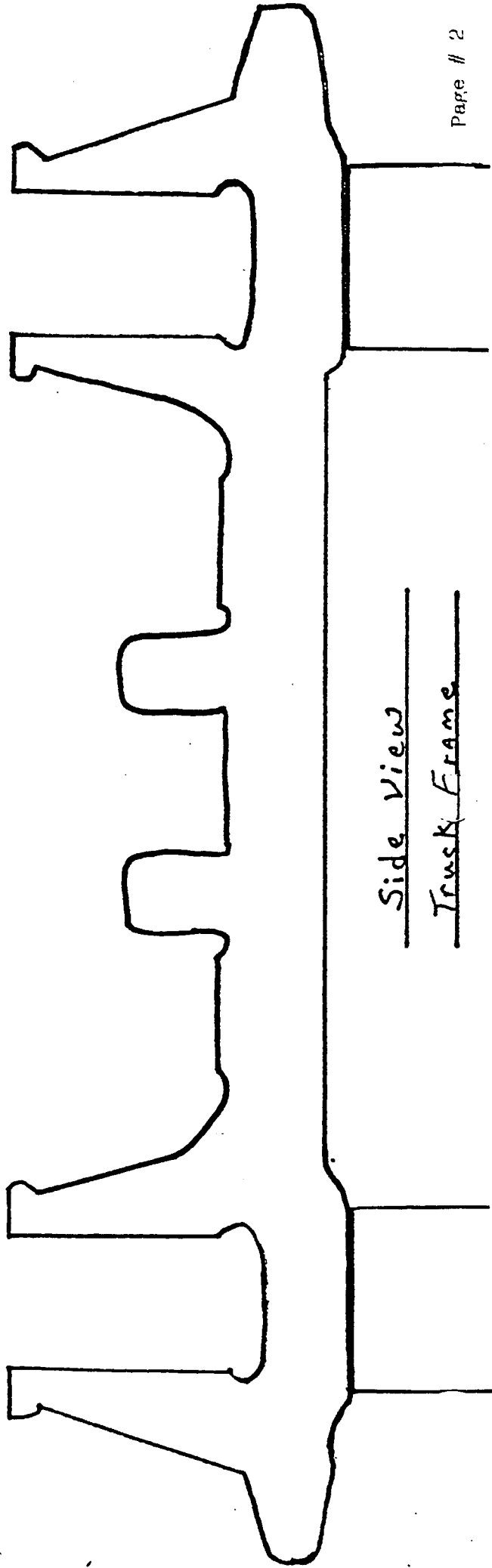
7.

6.

8.

2.

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Side View

Truss Frame

Top View

Pedestal Leg

Step # 2

1.

3.

5.

7.

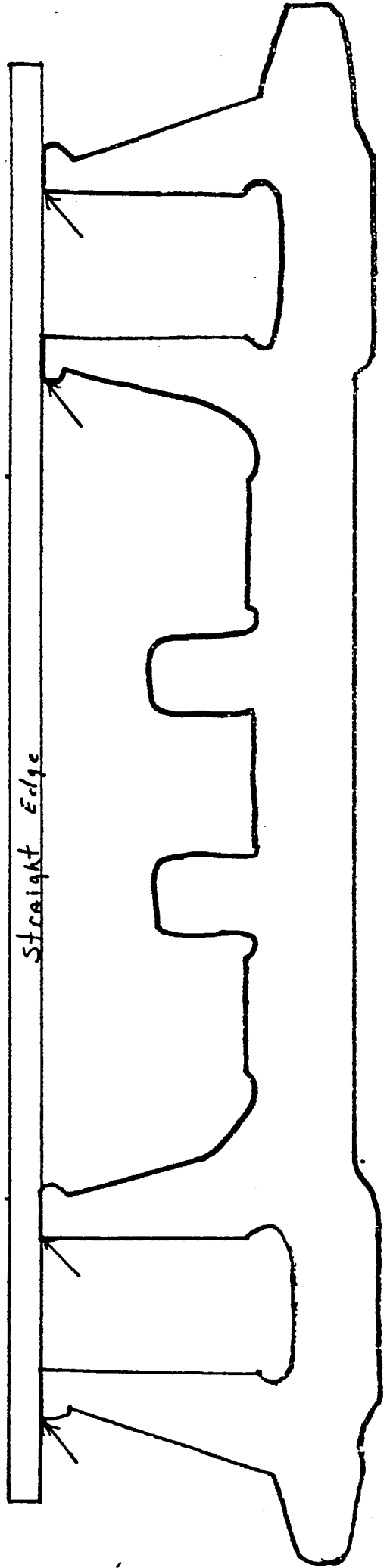
6.

8.

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Tolerance: 1/8"



Side View

Trusk Fraas

Top View
Pedestal Leg

Step # 3

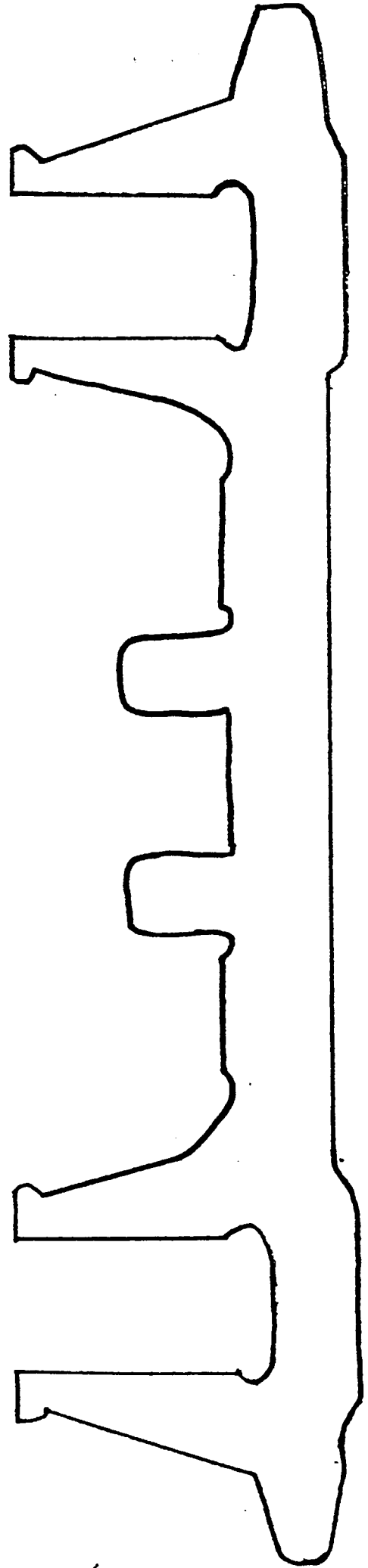
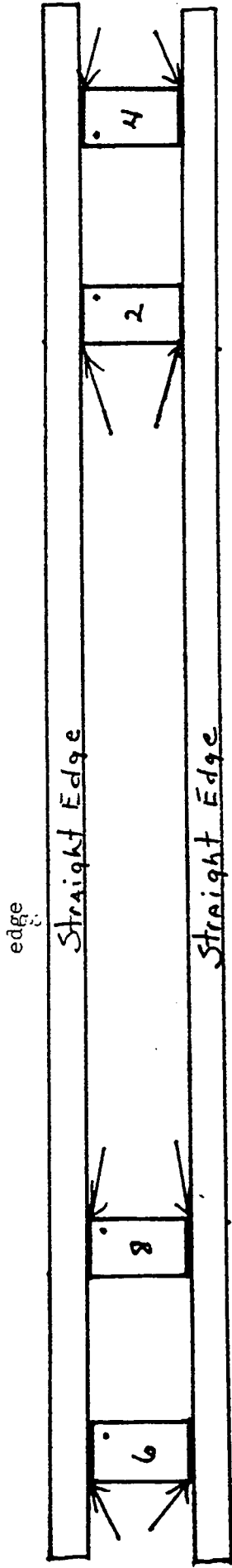
1.

3.

5.

7.

Pedestal Lean: this can be checked
with a level, square or a straight
edge

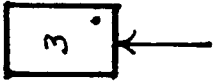
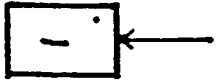


Side View
Truck Frame

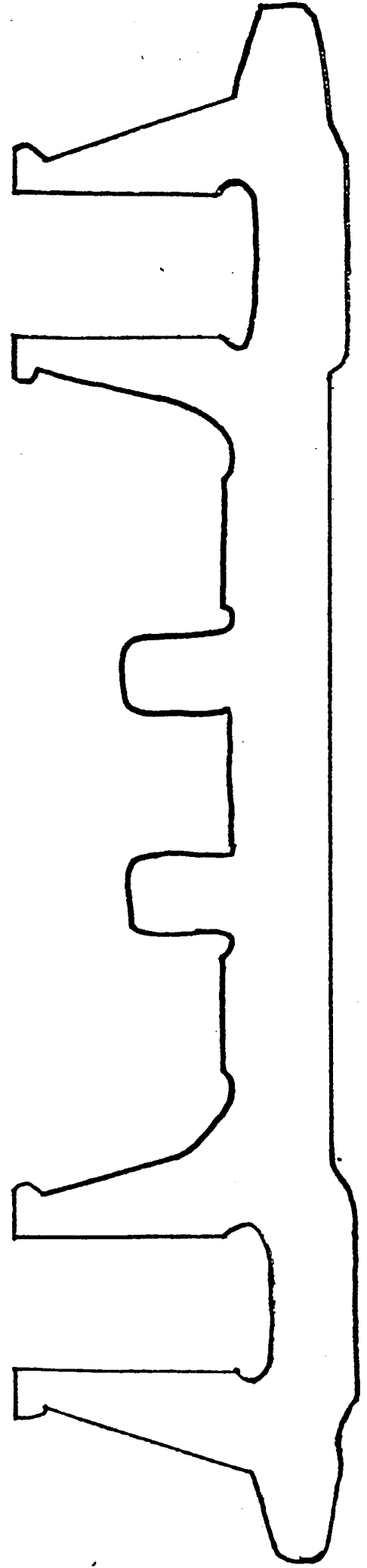
Top View

Pedestal Leg

Step # 1



Tolerance for - 1/16"



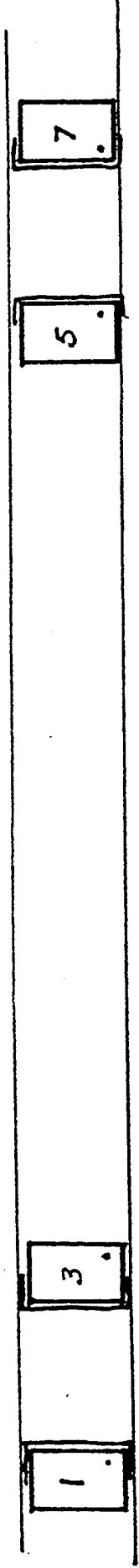
Side View

Truck Frame

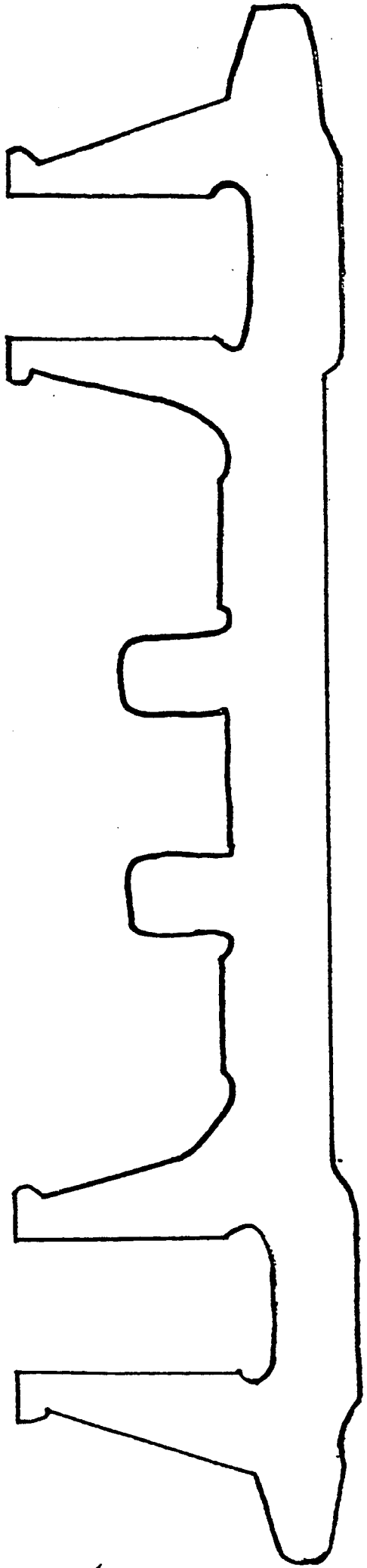
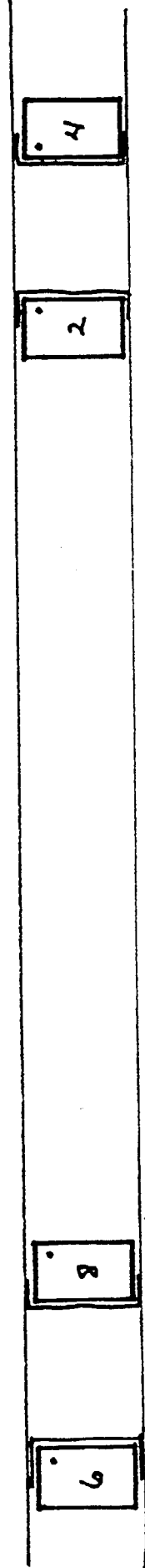
Top View

Pedestal Leg

Step # 5



Liners are to be in longitudinal alignment within 1/16"



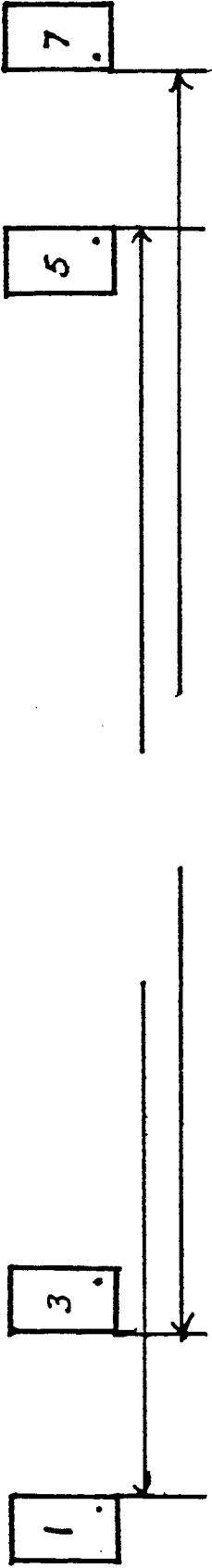
Side View

Truck Frame

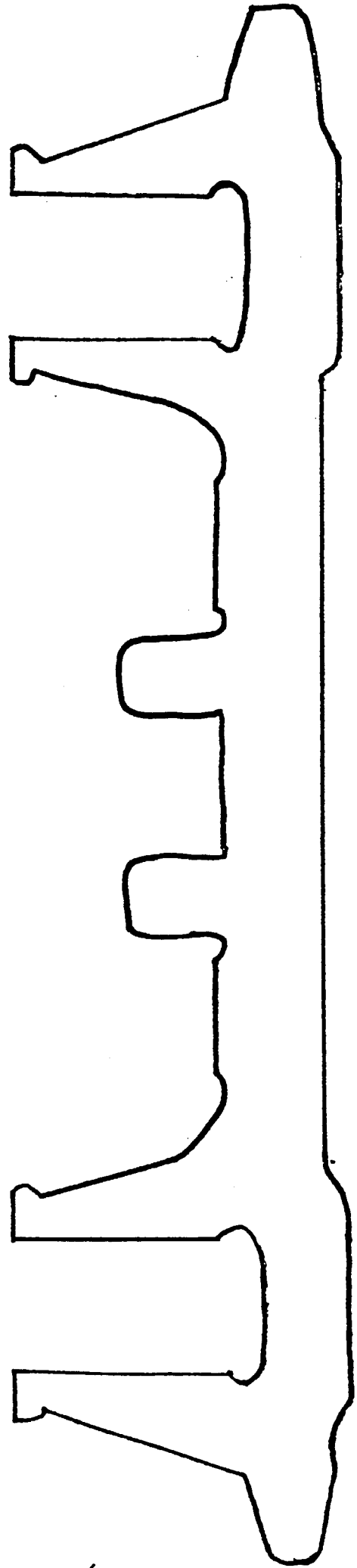
Top View

Pedestal Leg

Step # 6



Tolerance: 1/8" overall and side to side

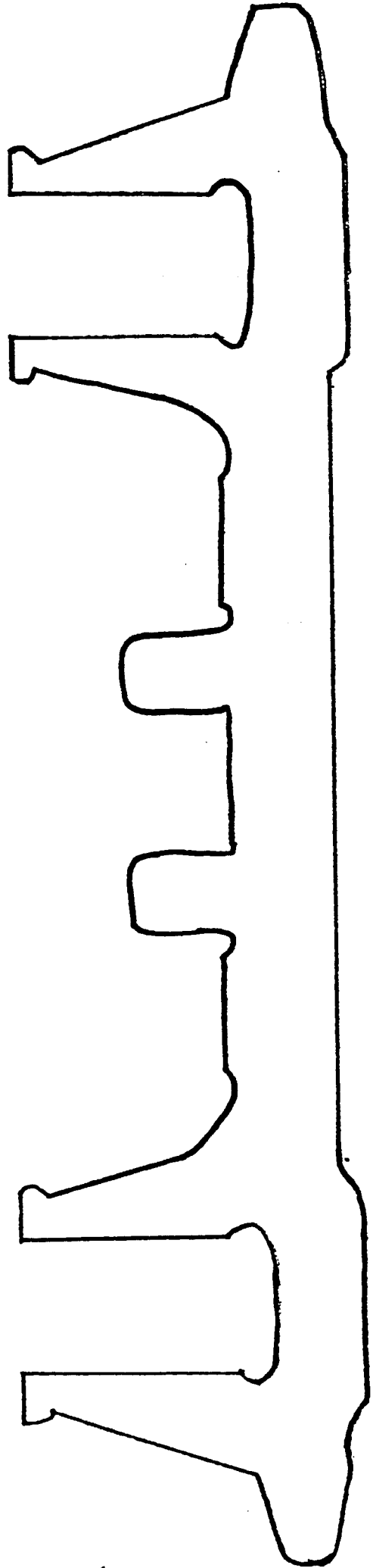
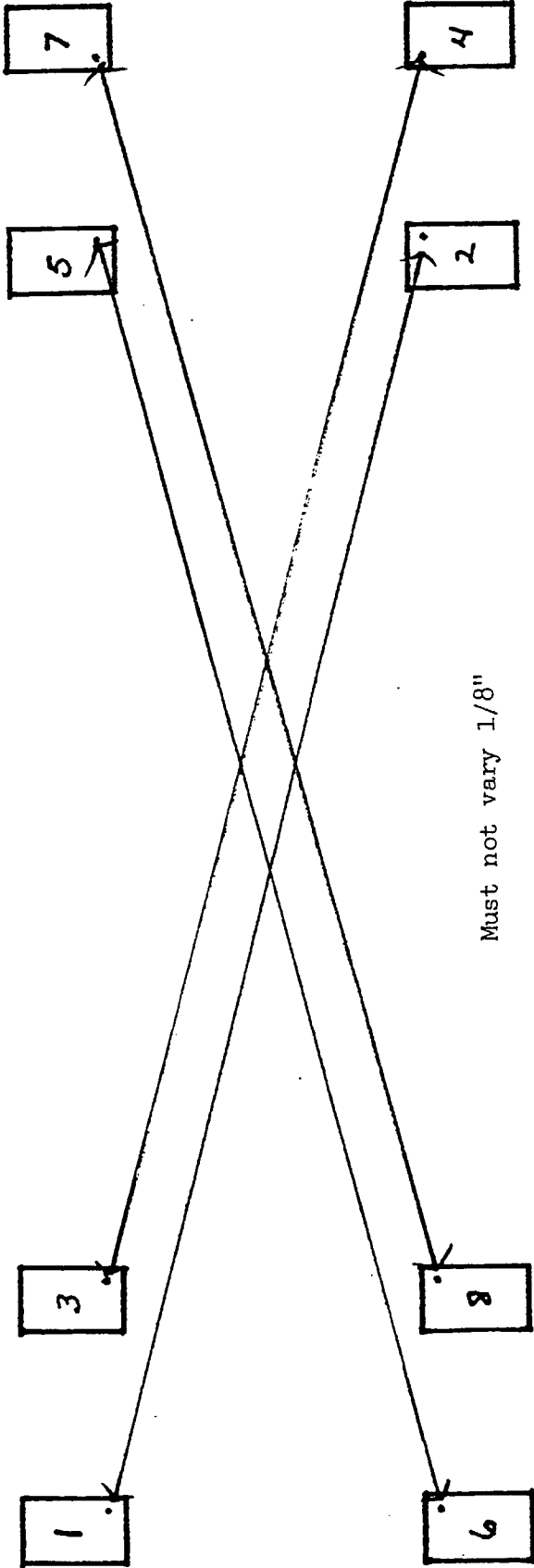


Side View

Truck Frame

Top View
Pedestal Leg

Step # 7



Side View
Truck Frame