

POINT RAIL MACHINING SEQUENCE

<p>① MACHINE CHANNEL IN STOCK RAIL SIDE REINFORCING BAR GTS-342/Y</p> <p>② DRILL RAIL AND WEB REINFORCING BARS IN PLACE.</p> <p>③ DEBURR ALL HOLES BY REMOVING REINFORCING BARS-REMOVE ALL CUTTINGS-REASSEMBLE WITH 3 BOLTS.</p>	<p>⑧ MACHINE STOCK RAIL SIDE HEAD CUT 1:3 SLOPE</p> <p>TOP VIEW</p>
<p>④ BEND POINT RAIL 1-7/32" IN 9'-5 11/16"</p> <p>TOP VIEW</p>	<p>⑨ ASSEMBLE ALL REINFORCING BAR BOLTS AS PER GTS-374, OMIT CLIPS AND BOLTS</p> <p>⑩ MACHINE FINAL BASE CUT 1:4 SLOPE</p> <p>BOTTOM VIEW</p>
<p>⑤ MACHINE GAUGE SIDE HEAD CUT (DIMENSIONED 6-9/16" ABOVE BASE)</p> <p>TOP VIEW</p>	<p>⑪ GRIND BASE RADIUS</p> <p>FINISH MACHINE BASE 1:4 SLOPE</p>
<p>⑥ MACHINE FIRST TOP CUT FOR 8'-0" LENGTH</p> <p>SIDE VIEW</p>	<p>⑫ GRIND POINT TO 1-1/2" RADIUS</p> <p>⑬ ASSEMBLE BOLTS, CLIPS, STOPS & TAG AS PER GTS-374</p> <p>⑭ REALIGN OR STRAIGHTEN POINT FROM MACHINE WARP-CHECK FOR 1-7/32" BEND</p>
<p>⑦ MACHINE SECOND TOP CUT FOR 1'-0" LENGTH</p> <p>SIDE VIEW</p>	

LEFT HAND POINT

NOTES:

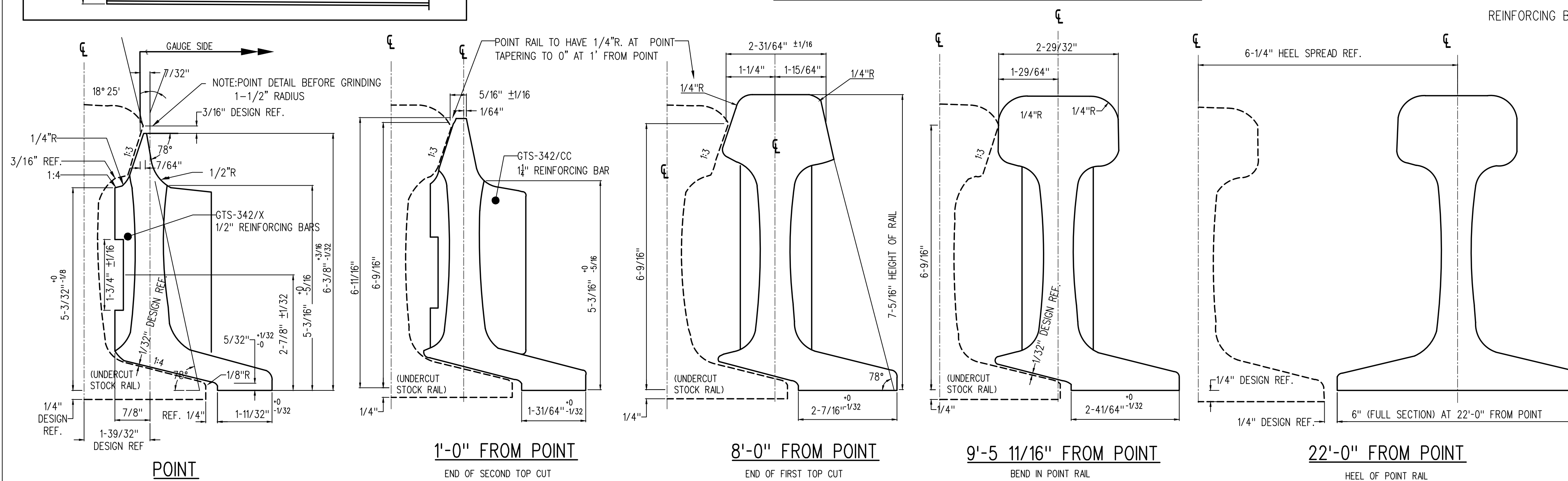
- 1- THE MACHINING DETAILS ON THIS DRAWING ARE FOR LEFT HAND SAMSON POINT RAIL ONLY, RIGHT HAND POINTS ARE MACHINED TO OPPOSITE HAND.
- 2- THIS IS A MACHINING DRAWING FOR SAMSON POINT RAILS-FOR ASSEMBLY SEE GTS-0374 A/B 22'-0" SAMSON POINT RAIL FOR SPRING OPERATION.
- 3- ALL HOLES ARE TO BE DRILLED: THE USE OF ACETYLENE TORCH OR OTHER BURNING METHOD FOR THE MAKING OF HOLES OR CUTTING IN THE MANUFACTURE OF POINTS IS ABSOLUTELY PROHIBITED.

MATERIAL:

RAIL: UNLESS SPECIFIED OTHERWISE POINT RAILS SHALL BE ONLY No1 RAILS (WITH "A" RAILS ELIMINATED) IN ACCORDANCE WITH SPECIFICATION 12.3 LATEST ISSUE. (HEEL OF POINT TO BE HARDENED).

REINFORCING BARS: SEE GTS-0342/CC & GTS-0342/Y

SECTIONS OF MACHINED LEFT HAND POINT



METRIC CONVERSION: 1 inch=25.4mm, 1 foot=304.8mm

1	18/07/27	ADDED IMPERIAL TO METRIC CONVERSION NOTE	
No.	Date	Revision	By Approved
Standard		MACHINING DETAILS-UNIFORM RISER DESIGN 22'-0" SAMSON POINT RAIL SPRING OPERATED - 136LB. R.E. RAIL	
Drawn	MG	Checked	GGG
Approved	VP Engineering & Asset Management		
Date	DEC 15, 2017	Plan Number	GTS-0436
Rev	1		
REFERENCE: TS-436			Sheet 1 OF 1