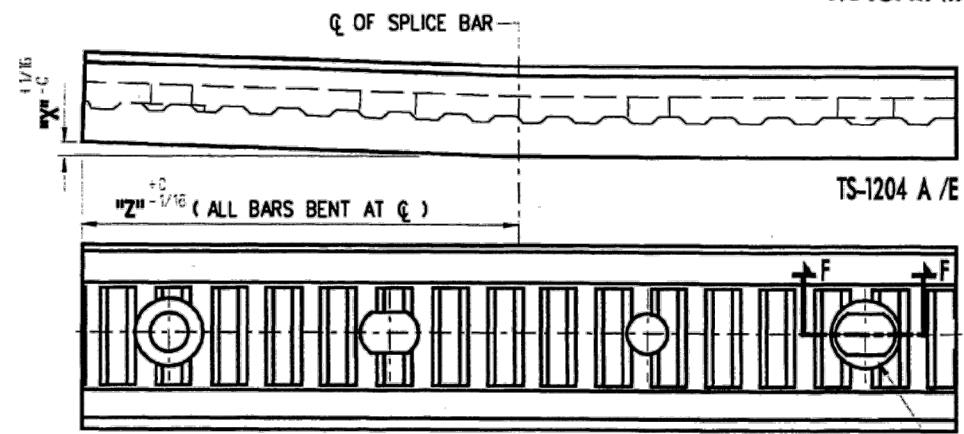


DOTTED LINE INDICATES SHAPE OF OLD STYLE STANDARD SPLICE BAR, IN 1977 A NEW HEAD WAS DESIGNED TO ALLOW ADDITIONAL CLEARANCE FOR INCREASED RAIL WEAR LIMITS.

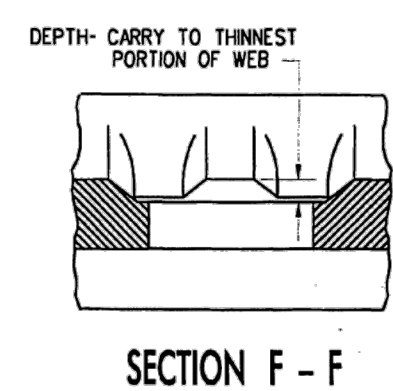
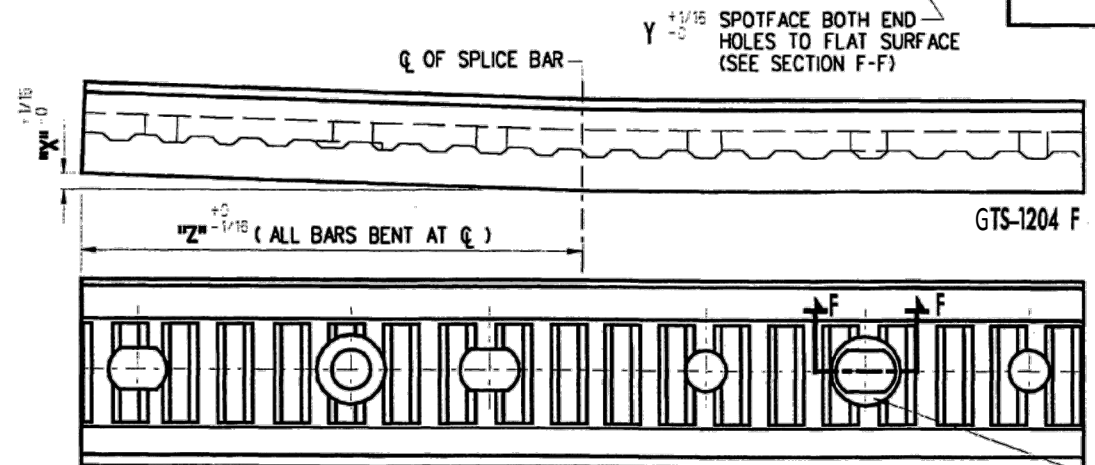
- WHEN OLD STYLE BARS ARE TO BE USED MACHINE HEAD ACCORDING TO PREVIOUS INSTRUCTIONS.
- WHEN NEW STYLE BARS ARE TO BE USED, NO HEAD MACHINING REQUIRED ON BARS 1204E & 1204F AND MINOR MACHINING ON BAR 1204D.

NOTES:

- 1- HEAD MACHINING AND SPOTFACING TO BE COMPLETED BEFORE BENDING BAR.
- 2- CUTTING TOOL SHAPED TO RESEMBLE HEAD SHAPE OF BAR.
- 3- PAINT OUTSIDE FACE WHITE AFTER MACHINING AND BENDING.
- 4- MARK NUMBER 1204A, B, OR C, ETC.... TO BE CLEARLY STAMPED INTO BAR IN 1/2" MINIMUM CHARACTERS.
- 5- FOR DETAILS OF STANDARD RAIL SPLICE BARS, SEE DRAWING:
 - GTS-1201 FOR 100 LB. RAIL
 - GTS-1202 FOR 115 LB. RAIL
 - GTS-1203 FOR 132 & 136 LB. RAIL
- 6- WHEN REFERRING TO BENT SPLICE BARS, DRAWING NUMBER MUST BE STATED AS A, B, C, D, E OR F TO INDICATE SPECIFIC BAR REQUIRED.
- 7- THE USE OF ACETYLENE TORCH OR OTHER BURNING METHOD FOR CUTTING OR MAKING OF HOLES IN THE MANUFACTURE OF SPLICE BARS IS ABSOLUTELY PROHIBITED.
- + 8- PARTLY WORN SPLICE BARS ARE CONSIDERED ACCEPTABLE, PROVIDED THEY HAVE BEEN CLEANED, STRAIGHT EDGE TESTED AND MAGNETIC PARTICLE TESTED.



REFERENCE: STOCK NO. OF STANDARD SPLICE BAR TO BE REWORKED +	BENT SPLICE BAR STOCK NO.		MARK NO.	BEND " X "	SPOTFACE DIA.			WEIGHT OF FINISHED BAR	REFERENCE END USE
	NEW	PARTLY WORN			" Y "	" Z "			
			1204A	1/2"	1-5/8"	1"	26.5 LBS	100 LB. / 11'-0" SWITCH	
			1204B	5/16"	1-5/8"	1"	26.0 LBS	100 LB. / 16'-6" & 22'-0" SWITCH 100 LB. / No. 10 & 12 SPRING FROGS	
			1204C	5/16"	1-5/8"	1'-0 1/2"	34.1 LBS	115 LB./SWITCHES & SPRING FROGS	
			1204D	5/16"	1-7/8"	1'-0"	36.9 LBS	132 & 136LB./16'-6", 22' & 26'- SWITCH 132 LB./ NO 10 & 12 SPRING FROG	
			1204E	1/8"	1-7/8"	1'-0"	37.1 LBS	132 & 136 LB./39'-0" SWITCH	
			1204F	17/32"	1-7/8"	1'-6"	53.27 LBS.	136 LB./ NO. 10 & 12 SPRING FROG	



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 AND BENDING DETAILS OF BENT SPLICE BARS	
FOR 100, 115, 132 & 136LB SWITCHES & SPRING FROGS			
Drawn	MG	Checked	GGS
		Approved	<i>[Signature]</i> VP Engineering & Asset Management



Date DEC 15, 2017 Plan Number GTS-1204 Rev 1