

**DIRECTORATE GENERAL BORDER ROADS**

**GENERAL REPAIR INSTRUCTION NO. 149**

**ON**

**REPAIR OF BODY CRACK OF BMRR**

**AIM**

1. To lay down the procedure of minor repairs of Body crack as generally found vertically about 150 mm long left side of front portion near front roll.

**REASON OF DEVELOPING CRACKS**

2. Probably, sudden shock load on front roll.

**PROCEDURE**

3. The following procedure for its minor repair has been suggested by M/s Britannia Ltd :-

(a) Drill a 4mm O hole at the end of the crack.

(b) Cut a 3mm x 3mm Groove along the crack using a Nose Chisel.

(c) Weld along the Groove using Gas or Arc welding.

(d) Weld one 150mm x 50mm x 5mm plate on the crack at the back side leaving the 4mm O hole free.

4. Sketches attached, may be referred for guidance.

**Authority :**

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Dated : 10 Feb 2005

**(Raghubir Singh)**

EE (E&M)

Dy Dir (Tech)

For Dir Gen Border Roads

# REPAIRING PROCESS

