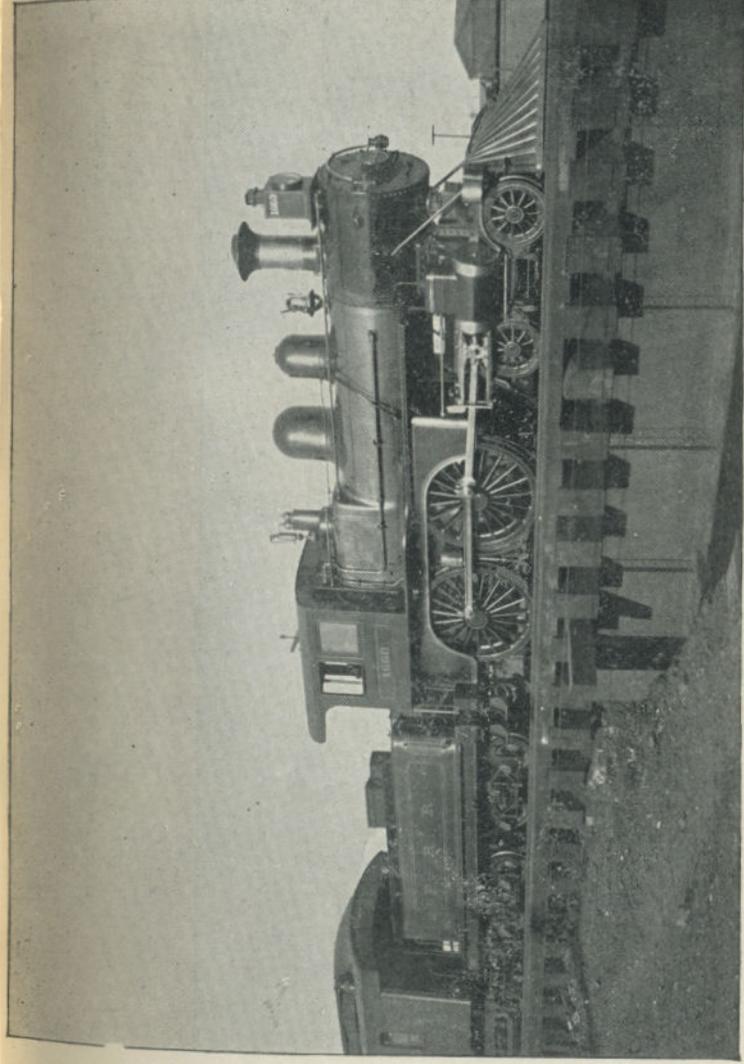


PENNA. R. R. TWO-CYLINDER COMPOUND, LINDNER SYSTEM.

$11\frac{1}{2}$ ft. \times 31" \times 28" stroke.

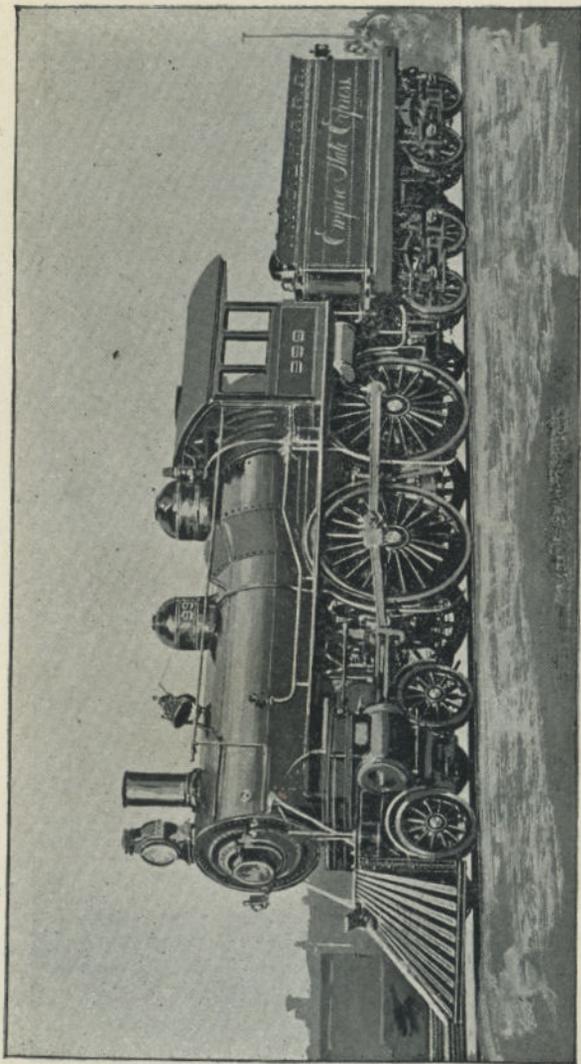
Diameter of Boilers, 60".
Diameter of Drivers, 7 feet.
Steam-pressure, 205 pounds.
Weight on Drivers, 90,000 pounds (about).



ENGINE FOR PENNSYLVANIA RAILROAD.

Diameter of Cylinders, 19 $\frac{1}{2}$ " \times 24" stroke.

Boiler-pressure, 175 pounds.
Diameter of Drivers, 78".
Weight on Drivers, 80,600 lbs.



ENGINE 999, NEW YORK CENTRAL RAILROAD, 1893.

Diameter of Cylinders, 19" X 24" stroke.
Boiler-pressure, 180 pounds.

Diameter of Drivers, 87".
Weight on Drivers, 82,200 pounds.
Speed, 102 miles per hour.

LOCOMOTIVES:

SIMPLE, COMPOUND, AND ELECTRIC.

BY

H. C. REAGAN,

Locomotive Engineer.

FOURTH EDITION, REVISED AND ENLARGED.

FIRST THOUSAND.

NEW YORK:

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BY
JOHN WILEY & SONS

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THIS BOOK

IS RESPECTFULLY DEDICATED TO THOSE

Locomotive Engineers and Firemen

WHO ARE TRYING TO INCREASE THEIR KNOWLEDGE OF THE STEAM
POWER UNDER THEIR CONTROL, DECREASE THE CHANCE
OF ACCIDENT, INCREASE THE SAFETY OF HUMAN
LIVES, AND GIVE GREATER SATISFACTION
TO THEIR EMPLOYERS,

BY

THEIR FRIEND THE AUTHOR,
WHO IS PRACTICALLY
ONE OF THEM.

PREFACE.

THE author, who is a practical engineer, attempts in this book to write a practical treatise on the Locomotive Engine, and has tried to describe the manner in which the locomotive is handled while in service.

There are many excellent books on the locomotive, but there is one portion of the subject which, in the author's opinion, has not yet been covered.

The man who wishes to understand an engine thoroughly will learn more by watching repairs made in the shop, or in case of accident on the road, when the engine is disconnected, than if the method were described to him in so many words; for he thus sees the actual construction, break, and repairs.

The author has illustrated this book with this purpose in view, and has made most of the drawings himself.

Where others are used due credit is given, and therefore it may be truly said the drawings represent actual practice.

The text contains also a full explanation of the drawings, questions are asked and answered on the construction of the locomotive and its performances,

and complete directions are given as to what should be done in case of emergency.

The reasons for first explaining the construction and action and then asking and answering questions are three: first, when a question is asked and answered, and the reader does not thoroughly understand the construction and action of mechanism, the questions and answers will not be clear to him; second, the reader will be more vividly impressed by reviewing the questions and answers; third, the questions and answers are so arranged that the book can be used by Master Mechanics or Travelling Engineers for the examination of candidates for promotion, or by the demonstrator in the Lodge Room.

An effort has been made to present to the reader a full and clear explanation of the Compound Locomotive, showing the construction of different systems in actual use, and giving the method of disconnecting such engines when broken down.

The author has illustrated the principal "break-downs" that happen to a locomotive, so that when one actually occurs on the road the engineer can compare the break with the illustrations in the book, and find out exactly what should be done.

Each part of the mechanism is named in the illustrations as a guide to the engineer in making out work reports.

I am indebted to the proprietors of the works whose Compound Locomotives are shown in this book, for drawings and photographs; to the Westinghouse and New York Air-brake companies, and other manufacturers whose appliances have been illustrated and de-

scribed; and to the *Railroad Gazette* for part of the description of the Brooks Two Cylinder and Schenectady Compounds.

If the book fulfils the mission for which it was written, the author will consider that his labor has been rewarded.

H. C. REAGAN,
Locomotive Engineer.

PHILADELPHIA, January, 1894.

PREFACE TO SECOND EDITION.

AS electricity is developing very rapidly in all directions, and especially in the method of transportation, the Electric Locomotive as a motive power is naturally attracting the attention of the officials of the larger railroad. The development in the street-railroad service has also been phenomenal. There are very large electric locomotives at work daily on some of the trunk lines, and they are doing the work successfully; hence it appears as if they had come to stay, and that more may be expected in the future. The author, having this thought in his mind, believes now is the time for those who are to-day handling our steam locomotives to investigate the working and construction of the electrical locomotive, although he does not believe it is going to displace the steam locomotive immediately. Such a change will be gradual rather than instantaneous. He has tried to make the description and operation of an electric motor as simple as possible,

that it may be readily understood by the average reader, and in the hope that it will be instructive and therefore lead to a further investigation of the subject. Thinking it a good plan, he has therefore incorporated the description of the electric locomotive with the book entitled "Locomotive Mechanism and Engineering," which has been received so kindly by the locomotive enginemen. It was thought proper to give a description of the street-railroad and stationary motor as a stepping-stone to the larger motor used on the electric locomotive, since there is no great difference in their principles, but in their size and method of connecting with the axles the method of control is nearly the same. The locomotives which receive their supply of current from a central station and those which generate their own current, and in fact are a travelling central station, are shown.

I am indebted to the *Electrical World*, the *Electric Engineer*, and the *Railroad Gazette* for some data and cuts relative to the several electric locomotives shown; also to the General Electric Company for cuts of their electric locomotive, and others whose apparatus is shown.

H. C. REAGAN.

PHILADELPHIA, March 1st, 1896.

PREFACE TO THIRD EDITION.

A BOOK written for the purpose of instructing the reader in engineering, of whatever branch, should be up to date. Therefore, while the previous editions of this work have been well received, the author felt that a new issue would be incomplete without some account of the latest types of electric locomotives and of various improvements in air-brakes, etc., which have been introduced since the last edition was published. A description of these has now been embodied, some forty pages having been added, including a number of cuts and diagrams, thus, it is believed, materially enhancing the value of the work.

H. C. REAGAN.

WHITE PLAINS, N. Y.

PREFACE TO FOURTH EDITION.

THIS edition describes and illustrates by means of photographs and detailed drawings the latest improvements in locomotive practice. This includes the latest types of compound and single expansion locomotives, and treats of many improvements in fire-boxes and boiler construction.

The subjects of liquid fuel and oil-burning engines are carefully considered, as well as piston-valve engines and track-sanding apparatus.

The author, also, discusses the different methods of operating valve motion for compound locomotive engines, and takes up the questions of metallic packing and of air-pumps.

The new matter is intended to put the reader in touch with the very latest and highest type of locomotive and its details.

The author desires to make, here, his acknowledgement to the various firms whose apparatus is described, for their courtesy in furnishing cuts and descriptions.

H. C. REAGAN.

PHILADELPHIA, Aug. 1, 1902.

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LOCOMOTIVE MECHANISM AND ENGINEERING.

CHAPTER I.

THE LOCOMOTIVE BOILER.

THE best subject with which to start is the locomotive boiler, of which there are two illustrations. Fig. 1 is a wagon-top boiler. Fig. 2 is a Belpaire boiler, which is now being used on many roads.

The principal difference between them is the shape of boiler over fire-box, and the method of staying. In the Belpaire boiler the back end over fire-box is nearly square, there being a radius on the corner for bending. The Belpaire boiler also uses radial stays, thus obviating the necessity of using crown-bars and sling-stays; which seems an advantage, as it not so complicated, and the mud cannot accumulate on the crown-sheet, as it does when using crown-bars. The sheets can adjust themselves to each other better under different pressures and change of temperature.

The principal parts of a boiler are the fire-box, flues, dome, steam or dry pipe, throttle-valve, the smoke-arch in which are the steam-pipes leading to each steam-chest, the exhaust-nozzles, and the stack.

That portion of boiler which is over the fire-box must be very strongly stayed with either crown-bars or radial stays. The Belpaire boiler is strengthened in the latter manner. This staying is necessary from the large area and the exposure to the hottest part of the fire.

The dome is for the purpose of providing a reservoir for dry steam and in it the throttle-valve is placed

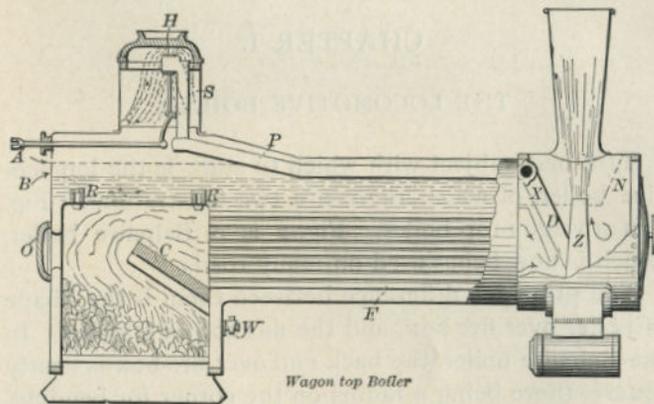


FIG. 1.

as high as possible above the water-line, to prevent entrained water from being carried over into cylinder, which is detrimental to the engine, and might cause a cylinder-head to be knocked out, if in large quantities.

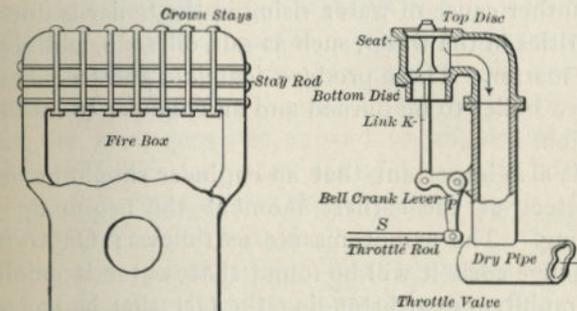
The throttle-valve is a double disk (Fig. 3) having two seats in the steam-pipe. The disks are of nearly the same diameter, in order to balance.

The top disk is the larger, so that the throttle will stay closed, due to the greater pressure on top, hold-

ing valve down to seat. The difference in area, however, is not sufficient to make the throttle open with difficulty.

To the lower disk is attached a link *K*. This link is connected with a bell-crank lever *P*, which has its fulcrum on steam-pipe.

On the lower end of bell-crank lever is the throttle-rod *S*. To this on the outside of the boiler is the



Belpaire Boiler Back End

FIG. 2.

FIG. 3.

throttle-lever, which every ambitious fireman is anxious to control.

The dry pipe is put into a boiler to carry dry steam to the cylinders, the steam entering the pipe at throttle-valve in dome. If this was not provided, the boiler would prime.

One of the most important things that an engineer should understand is the action of water in a boiler, and the effect of heat and impurities in the water. It often causes the student or beginner to wonder at the change of the water-line in a boiler when using and not using steam from it.

It will be found that after the throttle is opened the water in the boiler has raised one gauge or more. This is caused by the release of pressure on water-line on the opening of the throttle. The water being in a state of ebullition, due to the intense heat from the fire, expands. Fig. 1 at letter *B* shows the water-line when the throttle is closed; *A*, or dotted line, shows water when the throttle is open and using steam.

Another cause of water rising in the boiler is due to impurities in the water, such as salt, oil, soap, and vegetable matter. These produce foaming, and frequently cause a boiler to be burned and an engineer to lose his position.

It is also important that an engineer should be able to detect at the earliest moment the beginning of foaming. The symptoms are as follows: On trying the gauge-cock it will be found that water is gaining very rapidly, notwithstanding the fact that he has not readjusted his injector, or changed the point of cut-off in his cylinder *s*. Also, if the engine is foaming very badly, water will appear at the stack, in a light lathery foam. If, then, the throttle is closed, the water will fall probably to the bottom gauge-cock, or below, and this is a dangerous action. Now if the water should fall below the bottom gauge, and the engineer is desirous of finding out where the water is, he should open the throttle suddenly or frequently by blowing the whistle, and if there is water near the bottom gauge-cock it will show. If water shows, the boiler should be filled up to top gauge, and the surface blow opened, keeping the injectors on while it is open, in order to keep the water-line up.

By doing this the water can be changed, and that which contains the impurities blown off.

It should be remembered that there is a difference between foaming and priming. Priming is caused by too much water in the boiler, or by a cracked, dry pipe, or by a dome of too small diameter.

When there is too much water in the boiler and the throttle is opened, the water is carried over with steam into the cylinder, as is shown in Fig. 1, in dome.

This is a very bad practice, and is far from economical. The water which is thus carried over contains heat, which is wasted, because this water which contains the heat does not expand to any considerable degree, and therefore does not give out any effective power, while it reduces the expansive force of the steam with which it mingles.

Remember, also, that dry steam is capable of doing more work than wet steam, and is therefore more economical, while with it there is less danger of breaking the engine down, or cutting valves and seats.

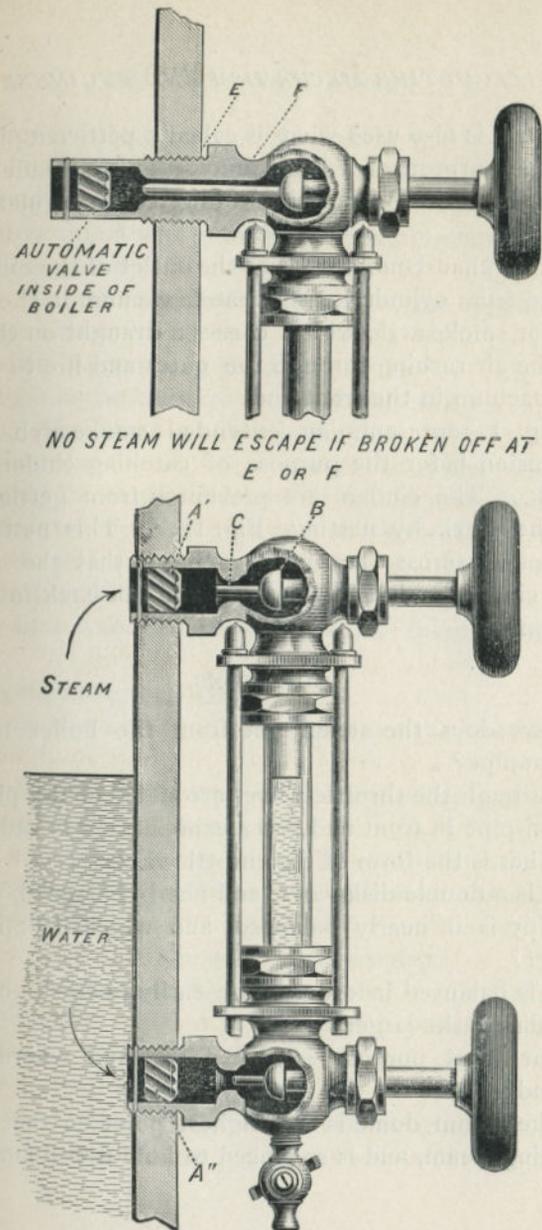
It is very important that all gauge-cocks should be kept open, and especially, under all circumstances, the bottom one.

When water-gauge glasses are used, the glass and valves should be open and free, for it is dangerous for them to be clogged up, as the glass will not then register correctly.

Water-gauge glasses are equipped with automatic-closing valves, so that when from any cause the glass is broken the steam and water will not escape into the cab, scalding the engineer and fireman; also prevent the loss of water and endangering the crown-sheet, if

broken when no one is around. The sketch at *A*, *A'* shows a very simple form of automatic valve. This valve will grind out any sediment that may collect on the seat. The grooves or wings are in the form of a spiral. By screwing the button or main valve towards the seat until the pin *C* extends through far enough to let the automatic valve come up against it, this forms an axis for valve *A*. By opening the pet-cock at bottom of glass, the steam will pass through the wings of automatic valves *A*, *A'*, causing them to revolve rapidly. Grind-seat and passage open the valve *B* wide when done grinding. Most all glasses have ball-valves which close automatically. Water in a gauge-glass should fluctuate freely with the water-line. If it does not do this, but stands motionless in the glass, the valves are clogged up and should be blown out. It is policy to do this before starting out, on each trip.

The fire-box needs very little explanation, as its purpose is evident to all; but most fire-boxes are equipped with brick arches, which improve combustion by maintaining the gases at an igniting temperature. This is due to the brick becoming incandescent, and also to the brick deflecting the cold air as it comes into the fire-door when open, and preventing it from rushing into the flues and chilling the gases. Fig. 1 shows the course of the gases to the smoke-box, and the appliances therein, as will be seen by referring to the drawing. *D* is the diaphragm, which serves the purpose of regulating the draught through flues and in fire-box. If the diaphragm was not used, the draught would be through the top flues, and burn out the back end of fire, especially in a long fire-box.



WATER GAUGE GLASS.

There is also used what is called a petticoat-pipe, to fill the purpose of a diaphragm. This is made separately, and can be raised and lowered to regulate the draught.

The exhaust-nozzles *Z* are the outlet of the exhaust-steam from cylinders, and create a vacuum in the front end or smoke-arch, which causes a draught on the fire by the air rushing through the gates and fire to fill up the vacuum in the front end.

Fig. 1 represents an extended smoke-arch. The extension is for the purpose of catching cinders and sparks. The cinders are prevented from getting out of the stack by netting, Fig. 1, *N*. This netting is extended across the smoke-arch, so that the sparks and cinders strike the netting and fall back into the extension.

QUESTIONS.

How does the steam get from the boiler to the steam-pipe?

Through the throttle-valve into steam or dry pipe, to steam-pipe in front end and steam-passage in saddle.

What is the form of the throttle-valve?

It is a double disk-valve, and nearly balanced.

Why is it nearly balanced, and which disk is the larger?

It is balanced in order to be easily opened, and the top disk is the larger.

For what purpose is the dome, and where is it placed?

The steam dome is the highest point on the boiler holding steam, and is so placed to hold dry steam.

Where is it placed?

In wagon-top boiler, over the fire-box, as in Fig. 1.

For what purpose is the steam-pipe in boiler?

To carry dry steam from dome to steam-chests.

What is a crown-bar?

A bar over the crown-sheet, with its end supported on the side sheet of fire-box.

For what purpose is it used?

To support the crown-sheet, as in Fig. 1.

What is the water-line in a boiler?

The line on the top of the water in boiler which varies with the height and level of water in the boiler.

What is the effect of low water in a boiler?

Low water is dangerous, and it is liable to burn the sheets or flues if the water is too low.

How is it known how much water there is in a boiler?

By trying the gauge-cocks.

What causes the water to rise when the throttle is open?

The pressure is released on the water-line, and the heat causes the water to expand.

What causes a boiler to foam?

Impurities in the water, such as oil, soap, salt, and vegetable matter.

How is it known when a boiler is foaming?

By the sudden increase of the water in the boiler. If it is foaming badly, it is also shown by the appearance of foamy water at stack.

If a boiler had four gauges of water when the throttle was open, how many would be in it when the throttle was closed?

If foaming badly, water would probably be found in the bottom gauge.

How could the water be found in the boiler if water dropped below the bottom gauge-cock?

By opening the throttle suddenly or by blowing the whistle.

Should more water be put in the boiler if water thus appeared?

It should.

What should be done to prevent water from foaming after finding it?

The injectors should be put on and the boiler filled up, then the surface-cock opened and the impure water blown out of the boiler.

What is a water-gauge glass?

A glass tube on the back of the boiler for indicating the level or amount of water in the boiler.

If the water-glass should break, what should be done?

All water-glasses are supposed to have automatic-closing valves, so that when a glass breaks the pressure will close them; but if they should not, it would be best to shut the hand-valves.

If an engineer is running along and he finds that the water in the glass does not fluctuate, what is supposed to be the matter?

That the valves are closed or clogged up.

What should be done to make the glass indicate correctly?

Open blow-off valve and blow the water out of the glass, and see that the steam and water valves are open.

What is priming in a boiler, and what causes it?

Priming is entrained water in the steam, and carried over into the cylinder. It is caused by too great a quantity in boiler, or too small steam space and dome. It may also be caused by working the engine too hard.

What effect has priming on the working of the engine?

It reduces the power of the engine, by reducing the expansive power of the steam with which it mingles; and is wasteful, because it carries off heat that does no work in the cylinder. It is also injurious to the valves and seat by destroying lubrication.

Which is the more powerful, dry or wet steam?

Dry steam.

ACCIDENTS TO BOILER AND ATTACHMENTS.

When a throttle-valve becomes disconnected and remains open, what should be done to get train under control?

The reverse-lever should be put in the centre notch of quadrant, the steam-pressure reduced, and the train controlled by the air-brakes.

When the whistle-valve is broken, what should be done?

The whistle-bell should be filled with waste or any material to prevent the whistle from sounding. The engine can be run in this manner. Calculation must be made for the extra amount of water blown away free in steam.

When the whistle-stem is broken off, what should be done?

In this case the fire must be put out, as the escape of steam would be too great; but care must be taken that the water must not leave the crown-sheet before the fire is out.

Could the injectors be put on to maintain the water in boiler while fire is being knocked out?

Yes, if put on immediately. Good judgment must be used in cases of this kind.

When a wreck occurs and the engine has studs pulled out, or boiler-check broken out, what should be done to prevent burning the boiler?

If possible to get at the engine, and escaping steam would not interfere, the fire should be covered with sand, sod, or anything to dampen the fire, and then water put on if procurable. Do not undertake to put water on first, as it will be liable to burn the person so doing, as the steam and gas will rush out the fire-door.

When a blow-off cock is cracked or broken off, what should be done, and should the injector be put on?

The fire should be gotten out of the box if possible. In regard to the injector being put on, it would depend on the size of opening and the amount of water in boiler, or if the fire could be gotten out before the water left the crown-sheet. If the injectors would put water in the boiler faster than it was escaping, it would be policy to put them on, or if water is on the crown-sheet.

In cases when the fire must be knocked out of fire-box, and the engine is standing where any live coals would set fire to the material underneath the engine, what should be done?

The ash-pan dampers must be closed. (This applies to bridges and trestles also.)

Is it possible to bulge or drop a crown without it being burned?

Yes, it is possible, and is due to poor material in the crown stay-bolts, or a pressure in excess of the strength of material. In a case of this kind the fire is put out on account of the water rushing into the fire-box. The same occurs when a flue bursts. In either case the engineer and fireman are in immediate danger.

When the throttle becomes disconnected and closes how can steam be gotten into the cylinders to move it?

By the tallow-pipe valve.

In case of a dry-pipe bursting, what should be done?

The reverse-lever should be put in the centre notch, and the steam-pressure reduced. Control the engine by the brakes. If wheels should slip, do not use sand, as there is a possibility of making a wreck of the engine.

CHAPTER II.

FRONT END, OR SMOKE-ARCH.

THE steam-pipes in smoke-arch are connected to the end of steam or dry-pipe, which is called bulkhead or tee pipe, and joined to steam-passage in saddle, as in Fig. 5. The pipes have ball-joints, so that they may contract or expand (Fig. 6) as they are subject to varying temperatures.

Some builders use a ball and flat-ring joint, forming a rotating and sliding joint. The steam-pipes are fastened to the saddle or bed-casting, on shoulders or joints on the saddle, by studs.

These studs become corroded in time, and are very difficult to get out, especially when the engine is warm. The reader will keep this in mind for future purpose.

The exhaust-pipes (Fig. 5) are the double exhaust-nozzle, or an exhaust-nozzle for each cylinder. The single exhaust-pipe is used on some roads with good results.

The engineer and fireman will frequently find that the engine, after steaming excellently for a while, will suddenly commence to steam poorly, and it puzzles them to understand it.

The difficulty is often found in the front end or smoke-arch, and is frequently caused by a loose exhaust-pipe, causing back draught and impairing the

vacuum in the front end. Sometimes the steam-pipe joints are leaking, which produces the same effect as a loose exhaust-pipe. Another cause is a loose dia-

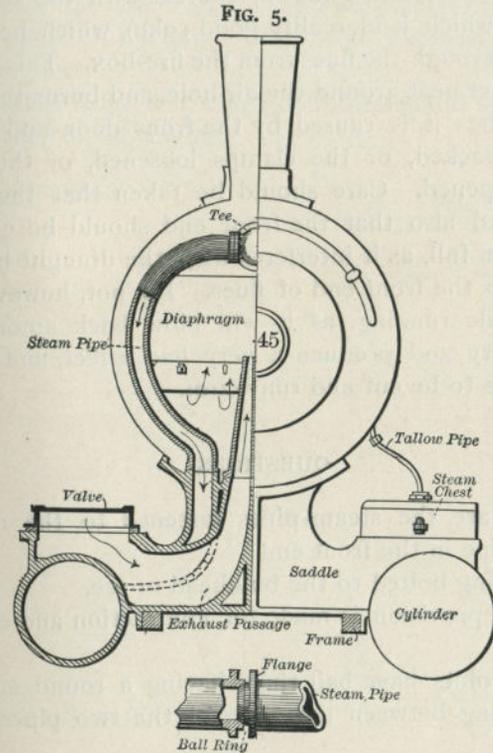


FIG. 6.

phragm, which, having dropped down, spoils the draught on the fire. Other defects are a loose thimble on the end of the exhaust-pipe, and cinder cap off of the hopper or side of the extension. Another great

misfortune is the burning or warping of the extension, which is caused by the extension being filled with live cinders, while there is an air-hole or crack, into which the air rushes and comes in contact with the so-called cinder (which is in reality good coke), which has been drawn through the flues from the fire-box. This causes an intense heat around the air-hole, and burns the iron. Sometimes it is caused by the front door and frame being cracked, or the clamps loosened, or the door partly opened. Care should be taken that these are tight, and also that the front end should be cleaned out when full, as it interferes with the draught by covering up the front end of flues. Do not, however, do this while running, as it will blow back among the machinery and produce a very bad effect, and cause the parts to be cut and run warm.

QUESTIONS.

How are the steam-pipes fastened to the dry or steam pipe in the front end?

By being bolted to the bulkhead or tee.

What provision is made for contraction and expansion?

The joints have ball rings having a round and flat face fitting between the joint of the two pipes, as in Fig. 6.

What is the effect if the steam-pipe or the exhaust-pipe leaks?

It destroys the draught, and causes the engine to steam poorly.

For what is a diaphragm used?

To regulate the draught on fire and through flues.

How is the draught regulated by the diaphragm?

By raising or lowering the movable portion.

What is the effect of an air-hole, cracks, or a door partly open, on an engine having an extension, when full of cinders?

Will burn front end, crack door-frame, and spoil the appearance of the engine.

CHAPTER III.

STEAM-CYLINDERS AND CONNECTION.

LOCOMOTIVE steam-cylinders are made from the best cylinder iron, which should be hard and free from blow-holes, but not too hard to be turned and bored out, and capable of having smooth cylinder walls in contact with the piston-head.

The cylinders are cast separately, in American practice, and bolted together, and are so constructed as to be neither rights nor lefts. There are three parts or names to a cylinder-casting, viz., cylinder, steam-chest, and saddle.

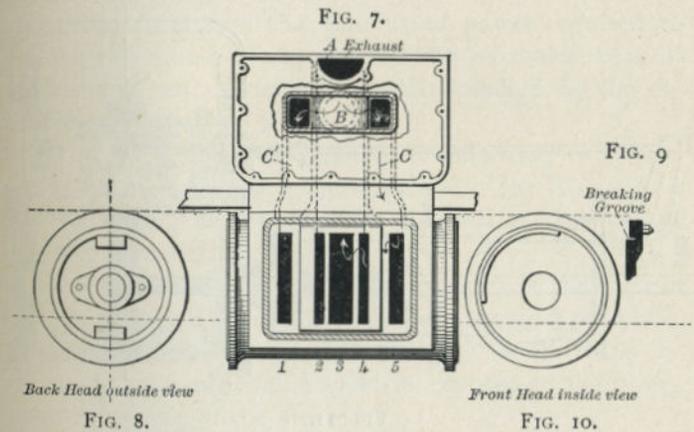
In the steam-chest, which is on the top of the cylinder, is the main steam-valve, which controls the inlet and outlet of the steam from the cylinder; and on the valve-seat proper, in most locomotives, is a loose or adjustable seat, capable of being renewed when worn out, without doing away with the cylinder.

Some engines have the seat cast with the cylinder, and when worn down have the false-seat attached.

In the steam-chest are five steam-ports, as will be seen in Fig. 7. 1 and 5 are the receiving-ports or openings of the steam-passages in the steam-chest. The steam-passage is divided. The passage or core, beginning at *B* in Fig. 7, passes down on the top of exhaust-

passage and branches on each side of the exhaust core or passage, the walls of exhaust passage serving for both.

There seems to be a serious objection to this, from the fact of the difference in temperature of the steam in steam-passage and the exhaust-steam in the exhaust-passage, as it causes an unequal contraction and expansion, which often cracks the saddle, and also robs the steam of some degrees of heat.



Port 3 is the exhaust-port leading to the exhaust passages or core *A*, and leads the exhaust-steam from the cylinder to exhaust-pipe: so there are three passages or cores in the saddle.

Ports 2 and 4 are the steam-ports from steam-chest to cylinder, and through these ports all the steam passes that moves our trains over the roads. The steam passes out the same port after expanding and doing its work in the cylinder, which is governed by the valve.

Fig. 7 is a top view of the cylinder, valve-seat, and ports, also steam-chest and top of saddle. The flange on saddle has the same radius as smoke arch, and is fastened to the same by bolts.

The cylinder is bolted fast to a frame, through a flange which is cast on the cylinder and the centre of frame. Also, there is a key or wedge on the sides of the saddle, to take up any lost motion of the saddles.

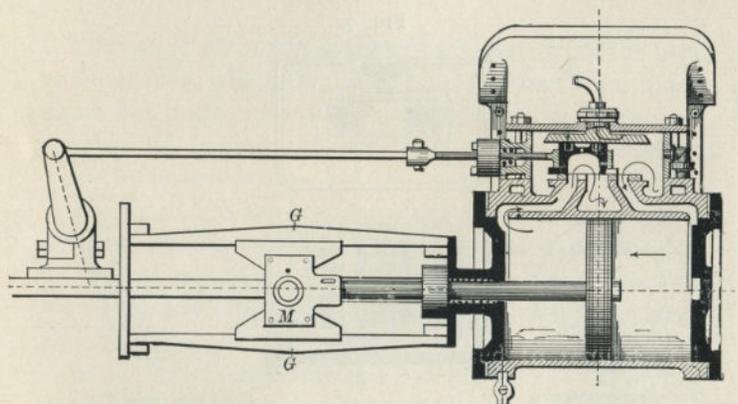


FIG. 11.

Fig. 11 is a longitudinal sectional view of a cylinder, piston-head, steam-ports, steam-chest, and valve. Fig. 7 shows only the top view of the steam-ports. Fig. 11 shows plainly how the steam-ports are. As will be seen, the core or ports are nearly a right and left angle, running from the seat into cylinders at each end. There is a shell or wall left between the bore of cylinder and port, of sufficient thickness for wear and reborring.

The exhaust-port is between the two steam-ports.

That portion of metal between the ports is called a bridge.

On the valve-seat, and working over these ports, is a steam-valve, which is a hollow shell having flanges around it, and is frequently called a D-valve, being of the shape of the letter D.

In most engines of the present day the valves are balanced as nearly as possible. The object is to take as much pressure off the back of the valve as possible, in order to reduce the amount of power required to move valve, and also to prevent the excessive wear of valve and seat, so as to be easily handled by the engineer.

The most common method of balancing is by putting bars on the back of valve, as in the Richardson valve, having a balance-plate fastened to steam-chest cover, as in Fig. 11.

The bars have under them in grooves on the back of valve springs which force the bars up against the plate, making a steam-tight joint, or nearly so, and thus reducing the area of valve which is exposed to the downward pressure of the steam.

There is a small hole in the centre of the valve, which releases the valve from any pressure that might be caused by steam getting past the bars. This hole opens into the exhaust cavity.

By referring to Fig. 11, you will see that the forward steam-port is wide open, and steam is passing into cylinder against the piston-head.

The exhaust-cavity of the valve is over the back of steam-port, and the exhaust-steam is passing out of the port into the cavity of the valve, into exhaust-port.

This action takes place for each end of the cylinder. The valve is encircled by a yoke, which has a stem passing out of steam-chest, through suitable packing.

The valve is free in yoke, so as to adjust itself to the wear.

The piston-head is an important factor in a locomotive, and without it we could not handle our trains as we do, as there is nothing yet constructed that can take the place of a piston-head, and with as little complication. What is essential in a locomotive is a smooth-working, steam-tight piston. The power of the engine principally depends on the area of the piston-head in square inches, as the larger the piston-head the greater the power of the steam-pressure.

The most common method of making a piston-head tight is by cutting grooves in head, and springing cast-iron rings into the grooves, whose diameter is larger than the bore of the cylinder; then when put in the rings are compressed, and fit tightly against the walls of the cylinder. But when the rings become worn, they spread open where they have been cut, and the steam blows through, which creates a loss of heat and power, which is not economical.

There are devices to prevent this, such as dowel-pins and lap-joints. Dowel-pins have a tendency to wear grooves in cylinder and let the steam blow through. Lap-joints or tongues break off and produce the same result. There is also danger of knocking out a cylinder-head and doing other damage by means of broken tongues.

A simple device, which has demonstrated itself to be a perfect remedy for this joint, and which is easily con-

structed, is shown in Fig. 12. It is called a break-joint block, and is in the form of a T, or a block having a tongue. This block is put in a groove back of ring groove of piston, and of the same depth and width. The tongue extends into ring groove, between ends of rings.

This block should be carried on the bottom of the cylinder.

The operation is as follows: The steam-pressure

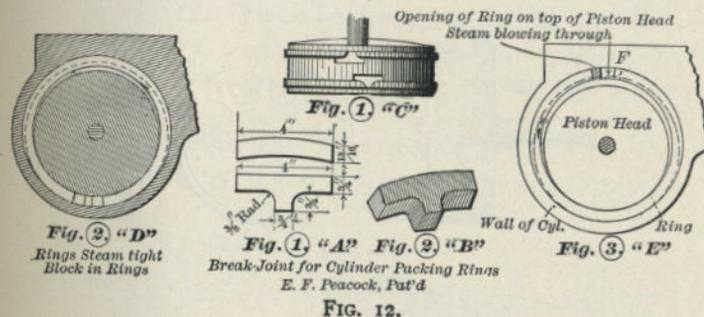


FIG. 12.

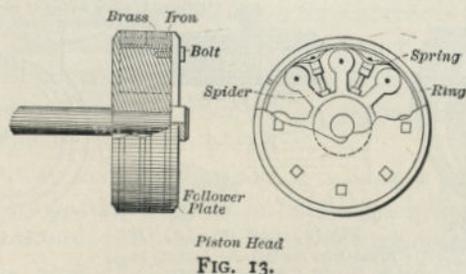
drives the ends of rings against the block, making it the same as a solid ring, and the tongue prevents the ends of ring from turning around on the top. The block wears with the rings, due to gravity. This device recommends itself on account of its simplicity and absence of springs or pins, and the results obtained from it after severe trials in all classes of locomotive service.

We have another method of packing, in which the piston-head is made in sections (Fig. 13). This packing requires to be set out by the engineer when worn.

The forward portion is called the spider. Between the arms are screw-studs, and on these are steel springs,

which bear against the wide or bull ring. On this ring are the two packing-rings, which are cut and bear out against the cylinder walls, due to the pressure of the springs on studs.

The front plate is called the follower-plate, and is bolted fast to the spider. This form of packing is more expensive than the spring ring, and has some defects, namely, that of being set out too tightly, which causes excessive friction and wear of cylinder, and also



that the packing will sometimes fall and become follower-bound. Figs. 8 and 10 show the front and back cylinder-head.

As will be seen, there is a groove cut in head at *B* in order to prevent breaking off the face of the cylinder when a head is broken out. Attached to the piston-head is the piston-rod.

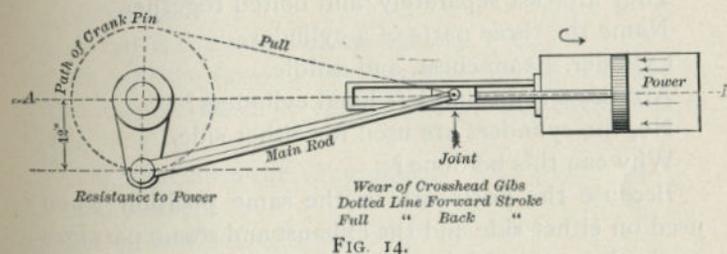
This rod passes through the stuffing-box in cylinder-head, and is fastened in the sleeve of cross-head. Fig. 11 shows the cross-head, which is of the vertical or two-bar type of cross-head, by some called the alligator cross-head.

This cross-head consists of three parts, the main body

(*M*), and the top and bottom shoe. This combination acts as a carrier for the back end of piston-rod. To the centre or wrist pin is attached the main rod, which is not shown in Fig. 11.

The shoes are made separate from the main portion of the cross-head, so that they can be taken off and relined or babbitted; and if a shoe breaks, it can be replaced without throwing away the whole head. This cross-head slides between the two guide-bars, as in *G G* in Fig. 11. These bars are fastened to the disks on stuffing-box, on the front end, and to a yoke at the back end. The most wear occurs on the top guide-bar and shoe.

Some of our students may wonder as to the cause of this wear on the top guide in forward motion, and why



it is more on the bottom guide in the backward motion. It is caused in this manner: In taking the back stroke, the pressure against the piston-head is pushing back the crank-pin, which is on the bottom quarter, the resistance is at pin below the centre-line of motion, through the piston-head, and there being a joint between the power (piston-head) and the resistance (crank-pin) causes the cross-head to be pushed up against the guide-

bar, as in Fig. 14. In the forward stroke (forward motion) the cross-head is pulled up against the guide-bar, as in Fig. 14.

In the backward motion this is reversed, and the wear is greater on the bottom guide-bar. This should be thoroughly understood by an engineer, as it will frequently aid him when he breaks a cross-head or shoe.

There is the four-bar type or horizontal cross-head, to which these remarks also apply.

QUESTIONS.

How are the steam-cylinders made in American practice?

They are cast separately, and bolted together.

Name the three parts of a cylinder.

Cylinder, steam-chest, and saddle.

Are there right and left hand cylinders?

No, the cylinders are used for either side.

Why can this be done?

Because the ports are in the same position when used on either side and the exhaust and steam passages are in the centre of the saddle, and the cylinder heads fit on either end of cylinder.

How does the steam get from the steam-pipe to the steam-chest?

Through the steam passage or core in the saddle, as in Fig. 7, *B*, which shows the passage on each side of the exhaust-passage, and from there through receiving ports, shown by 1, 5.

How many ports in the steam-chest?

Five. Two receiving-ports, two steam-ports, and one exhaust-port.

For what purpose is the exhaust-port?

To let the steam that has expanded in the cylinder pass out into the exhaust-passage, as in Fig. 11.

For what purpose are the steam-ports?

Passages or ports to let the steam into cylinder from the steam-chest.

Does the steam pass out the same port that it goes in?

It does.

What is the metal between the ports called?

Bridges.

What controls the inlet and outlet of the steam from the cylinder?

A valve.

What is the shape of the valve?

It is in the form of the letter *D*, having a cavity in the centre, which is called the exhaust-cavity, as in Fig. 11.

On what does the valve slide?

On a seat.

What is a balanced valve?

A valve having almost all the pressure taken off the back.

How is this done?

The most common method is by putting strips or bars in grooves on the back of the valve, and having a plate above the valve fastened to steam-chest cover, against which the bars slide, making a steam-tight joint, or nearly so, and thus reducing the area of valve which

is subject to the downward pressure of the steam. (See Fig. 11.)

What provision is made for the steam that might leak past the bars?

A hole is bored through the top of the valve into the exhaust-cavity, thus taking off any pressure that might accumulate.

What is the advantage of a balanced valve?

It reduces the friction and wear of valve on seat, and requires less power to move the valve, and makes the reverse-lever easy to handle.

What surrounds the valve?

A yoke having stem passing out through stuffing box (Fig. 11).

What and where is the piston-head?

It is a round disk, against which the steam exerts its pressure. It slides in the cylinder.

How is the power of an engine increased with a given steam-pressure.

By increasing the size of the piston-head.

How is a piston-head made tight?

Most piston-heads have cast-iron spring rings fitted in grooves in head, which spring out against the cylinder walls.

Do they ever leak?

They frequently leak when worn where cut, if nothing has been provided to stop the leak.

What is the result if they leak?

Loss of power and waste of force, as the live steam blows out the stack.

Can they be made steam-tight without complication?

They can. (See Fig. 12.)

What is the use of the cross-head, and what is attached to it?

It acts as a carrier for back end of piston-rod and also for front end of main rod. The piston-rod and main rod are attached to it.

Between what does it slide?

Between the guide-bars.

Which guide is more worn in the forward motion?

The top guide-bar.

Why is this?

When on back stroke the crank-pin is below the centre-line of motion, and the push of the piston drives the cross-head against top guide; on the forward stroke the crank-pin is above the centre-line of motion and the pull of piston draws cross-head against top guide-bar, the joint being at the wrist-pin in both cases, when running backward the wear is greater on bottom guide-bar. (See Fig. 14.)

Explain the course of the steam in Fig. 11 by the arrows.

As shown, the forward port is fully open, and steam is passing in the front end of the cylinder against piston-head. The steam from back end of cylinder is passing out port under valve, into exhaust-port.

Breaking-down will next take our attention; and as it is essential that the engineer or fireman should thoroughly understand the construction and principle of his machine, we have endeavored to make it clear so far as we have gone. He should also understand how to disconnect his engine when broken down, and how to clear the road.

There is one point the reader will do well to re-

member, that whenever a breakdown occurs which requires the cylinder on the broken side to be run without steam in it, the piston-head must be without motion, or disconnected, and the steam-ports to be covered in all cases except in towing, as a dead engine.

The writer will try and illustrate the method of disconnecting, so as to make it plainer to the student; and he holds the theory that an illustration of the break and repair can be remembered for a longer time than if told in so many words.

QUESTIONS ON BREAKDOWN AND DISCONNECTING.

When a cylinder-head is knocked out by a broken piston-rod, what should be done?

If the piston-head went clear of cylinder without breaking anything but the head, the best plan is to place valve in the centre of seat and clamp valve-stem. If there were no clamp at command, tie valve-rod up to hand-railing with a rope. In all cases disconnect valve-rod from upper rocker-arm, but do not take down the main rod. Position of valve is illustrated by Fig. 15.

What must be done if a valve-rod breaks?

Do the same as in the breaking of a cylinder-head, except that in this case the main rod must be disconnected from the cross-head. This is shown in Fig. 15.

Why must the main rod be disconnected in this case, and not in breaking out the head, the piston going out to clear?

Because in that case there was no piston in cylinder to cut, and in the other there is; so the main rod must be taken down to prevent cutting the cylinder.

If you were near a siding, would you disconnect the main rod on broken side?

Not unless the distance were very great. It is better to clear the main line as soon as possible.

In what position should a cross-head be blocked?

In the back end of guides. (See Fig. 15.)

Why should it be blocked in the back end of guides?

Because when blocked in the front end, if the steam

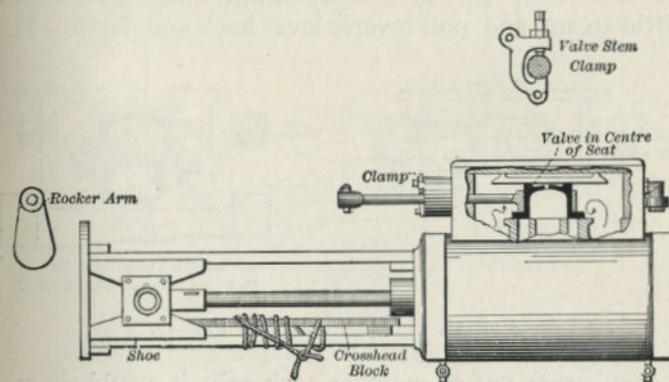


FIG. 15.

should get in front of the piston-head, and blocking should slip or break, it would be likely to knock out backhead, bend the guide-bars and yoke, and also injure the packing. If blocked back, it would knock out front head only.

Why would it not break out backhead?

Because the piston-head would strike the front head, and the force of the blow would be reduced before the cross-head would strike the backhead. This is the case where the main rod breaks.

When a valve-stem breaks, what must be done?

Clamp valve-stem, having the valve covering the ports. Take down main rod, block cross-head, and disconnect valve-rod from rocker-arm, as in Fig. 15. This applies to broken valve-rod.

How can a broken valve-yoke be found without taking off steam-chest cover?

Place the engine on a quarter on the side supposed to be broken, open cylinder-cocks, give the cylinder a little steam, and pull reverse-lever back and forth. If

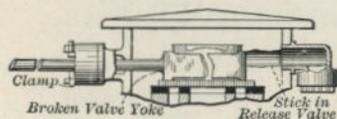


FIG. 16.

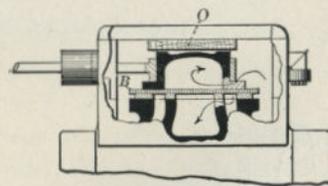


FIG. 17.

steam comes out of cylinder-cock only, it would show that the break was on that side.

Why should the engine be put on a quarter?

In order to have a full travel of valve over seat.

After finding broken yoke, how should the engine be disconnected?

In the same way as in the case of broken valve-rod, except that in this case the release-valve should be taken out. Cut a stick and put in release-valve * nut, with the stick against steam-valve so as to hold valve central over ports, as in illustration, Fig. 16.

* Also called *relief-valve*.

What should be done in the case of a broken valve or bridge?

Put a board over the valve-seat, put valve on it, bolt steam-chest cover down on it. This is in an engine where a balance-valve is not used, as in Fig. 17.*

If both cylinder-heads broke out, would it be possible to run the engine?

Yes, by blocking up the front steam-ports, and running with the back-ports.

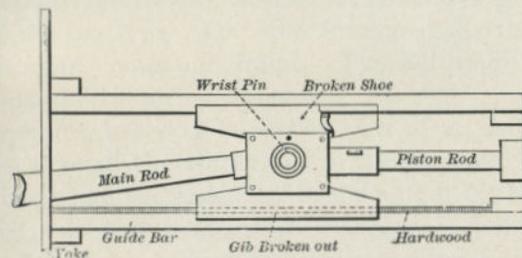


FIG. 19.

When a release-valve blows out, what must be done?

Put a wooden plug in the hole, if thread is not stripped.

If a piece broke out of steam-chest, how could steam be prevented from entering the steam-chest?

By putting a blind-washer in steam-pipe joint.

Could this be done very easily?

It could not, on account of the heat from the fire; and in most cases where the engine has run for any length of time the studs are corroded, and hard to get loosened.

When a cross-head shoe is broken, what should be done?

* A block of wood can be substituted for the valve when balance-plate is used.

If not broken too badly, and especially the bottom one, the engine can be run. If the top one is broken, however, it must not be over half gone. When running forward also in case a gib breaks out entirely, a board of the thickness of the gib should be put on the guide-bar. (See Fig. 19.)

Remember that you should always block the valve in centre of the seat. Cover the ports. Do not shove valve ahead or back, leaving one port open. This is a bad practice.

CHAPTER IV.

LOCOMOTIVE FRAMES, DRIVING-BOXES, AND SPRING RIGGING.

LOCOMOTIVE frames, as used in American practice, are of the bar type. On most foreign roads they use the slab and compound frame. The bar frame seems best adapted to our locomotives.

The frame is a very important part of an engine, as it must take all the thrust due to the push and pull of the piston, and the resistance in the weight of the train behind. It also keeps the driving-wheels in their respective places, carries the boiler, cylinder, and all the machinery connected with the boiler.

This in turn is carried by the driving-axles, so it is plain that the locomotive frame must be well made.

The construction of the bar type is as follows: In an eight-wheel or passenger engine, as shown in Fig. 20, it is composed of two parts—the back portion, which contains the pedestals or jaws for the driving-boxes, and the forward portion, which carries the cylinders and rocker-arms and tumbling-shaft.

As will be seen in Fig. 20, the top rail of back part of frame is dropped behind the front driving-box. This is for the purpose of getting a deep fire-box or slope in the front end. In this form of frame the fire-box is above the frame, thus getting a wider fire-

box than could be done if the fire-box was between the frames.

The pedestal-jaws or frame-legs are forged to the top and bottom rails, thus binding the two rails together. In some engines they are forged only to the top rail, and the bottom rail is bolted to jaws. Fig. 20 shows solid frame.

The forward portion or bar has a T head and the

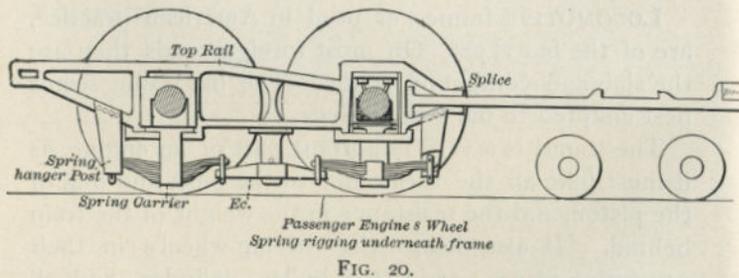


FIG. 20.

bar is between the two rails of the back part, which are drawn together, binding the forward part.

The T head or bar is bolted to jaw, and the whole is called the splice. On the forward part of bar are two shoulders, between which the saddles are bolted.

There is a key at this point to take up any movement of cylinder. At the extreme end comes the breast-beam, to which is bolted the pilot.

Fig. 21 shows a consolidation engine for heavy freight service. As will be seen, there is no splice in this frame, and there are four pedestal-jaws.

In this engine all but a small portion of the entire weight of the engine is carried on the driving-wheels.

The forward end of the frame is brought together in order to clear the pony-wheel.

On the bottom of pedestal-jaws are bars or binders, which are bolted to the bottom of jaws, and are usually called pedestal-caps. These are for the purpose of making it possible to take out the driving-boxes, or dropping out wheels, which could not be done if they were solid, unless the end of axle and wheel were loose. They also serve to bind the jaws together.

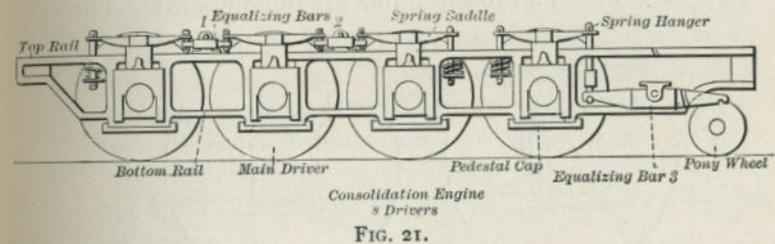


FIG. 21.

The number of jaws and style of frame is governed mostly by the number of driving-wheels.

In order to make an engine ride easily and reduce the shocks and concussion on the running gear, the engine is provided with springs which are called driving-springs and engine-truck springs.

The driving-springs are placed over each driving-box and carried on a saddle which straddles the frame, resting on the top of the driving-box in the most common form of construction, as in Fig. 21, which shows the construction very plainly.

Fig. 20 shows a different method of placing the springs. In this form the spring rigging is underneath the frame. By referring to Fig. 20 you will see that

the springs are supported by carriers whose upper ends have an eye in them, and a pin runs through the flanges of driving-boxes and the eye of carrier, thus making a support for the driving-spring.

The driving-box takes the weight, as in other forms. In order to equalize the weight between the drivers, there are provided bars, which are called equalizing-bars. These are placed between the drivers, on the top of the frame, in the form using springs on top, as in Fig. 22. Fastened to the frame are fulcrum-posts. The

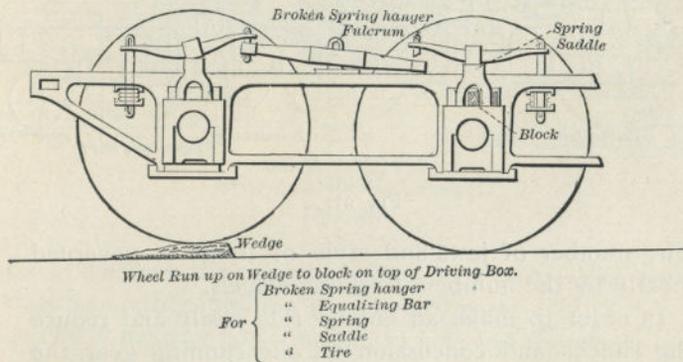


FIG. 22.

bar has an eye in it into which the post fits. Passing through the post is a pin, forming the fulcrum or axis on which the bar rotates.

The ends of the bar are attached to the springs by a spring hanger. If equalizing-bars were not used, the weight would not be distributed evenly on the drivers, for an illustration, if we should place the frames down on the top of the boxes, and run over an uneven piece of track, the weight would be taken one time by one

driving-box and then by the other. This is from the fact that the one in the hollow place would drop away from the frame and leave all the weight on the one on the highest part of the rail, and this action would take place also when the other wheel dropped into the hollow or low place.

This happens when passing over switches; but in using the equalizing-bar, whose ends are fastened to the springs over each driving-box, and having an axis around which it can rotate, the weight being concentrated at that point, either of the drivers can go up or down, but the weight will be carried by both driving-boxes, because the bar can adjust itself to the movement of the boxes on either side of the axis.

In Fig. 20 the equalizing-bar is underneath the frame, for the purpose of getting the fire-box on top of the frame.

In Fig. 21 you will see that three pairs of drivers are equalized together, but the front pair is connected to the pony-truck by equalizing-bar, thus equalizing front driver and truck.

There are coil springs on the end of spring hangers. The forward equalizing-bar is bolted to the under side of the saddles or bed-casting.

Driving-boxes are generally made with a shell of brass, but in most modern locomotives the driving-box is cast solid, of some good composition, such as phosphor bronze.

The advantage of a cast-steel box with a shell over a solid box is that the shell can be renewed without disposing of the whole box, as is done when a solid box wear out.

Driving-boxes are set in the frames or pedestal-jaws, and between them and the jaws are two pieces of metal, front and back. That in the front is called the shoe, and it is perfectly straight. The one back is called the wedge, and is tapered; the jaw is also tapered. This is done for the purpose of taking up the wear due to the push and pull of the piston. The wedge must

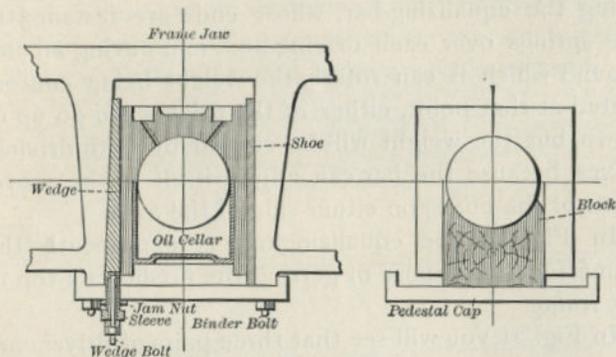


FIG. 23.

FIG. 24.

not be too tight or the frame cannot oscillate up and down; or if the driving-box becomes a little warm, the wedge and frame will stick, which causes the engine to ride very hard on the driving-boxes. As will be seen by Fig. 23, the wedge has an arrangement at the bottom to adjust it, which is called a wedge-bolt. The one shown is the standard on the P. R. R.

There is a hollow bolt having a head on the lower end, and the body threaded its entire length. The pedestal-cap or binder is also threaded. This hollow bolt screws into the cap and abuts against the bottom of the wedge. In the centre of this hollow bolt is the

wedge-bolt proper, the upper end of which has a head which fits into the wedge. On the lower end are two nuts for jamming to hollow bolt. To set the wedge up you first unscrew the nuts on wedge-bolt proper, then screw the hollow bolt up; this carries the wedge with it. When raised far enough, screw the nuts up on the wedge-bolt against the end of hollow bolt. This binds the wedge fast to the hollow bolt, using a jamb-nut on the hollow bolt to bind it to the pedestal-cap.

To lower, do as in raising, except to draw the hollow

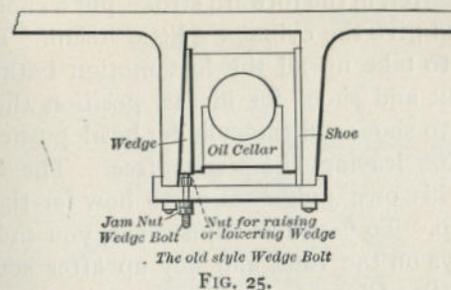


FIG. 25.

bolt down, and screw up nuts against hollow nut, and that will draw the wedge down on the top of hollow bolt.

To keep the driving-boxes thoroughly lubricated, there is an oil-cellar fastened between the flanges of the driving-box, which is hollow, and fits closely to the axle. This is filled full of waste suitable for packing cellars, and well oiled or sponged up.

The tops of driving-boxes have oil cavities with oil-holes leading to journal. Sponging is put into the cavities in the top. The cellar catches the oil that passes around the journal and underneath it. The

sponging must bear against the under side of the journal, or the box will become hot and give trouble. When the sponging becomes hard, due to being burned, it should be taken out and fresh sponging put in, as when hard it drops away from journal, and the capillary action is also stopped.

Setting up wedges is something that should be understood by all engineers. The proper position to place an engine is on a straight, level piece of track; then place the crank pins on the side you are working at on the top quarter, in the forward stroke, put a chock under wheels, and give the cylinder a little steam. The idea of this is to take up all the lost motion between the driving-box and shoe, for in this position the piston pulls box to shoe, and the cylinder-head pushes frame against box, leaving the wedge free. The engineer must use his own judgment as to how far the wedge must go up. To use finer adjustment, you must slack up the keys on the rods, and key up after setting up wedges. (See Fig. 26).

Breaking down any portion of spring rigging sometimes presents a difficult problem, as all engines are supposed to carry jacks, but do not do so. Then the question of how to raise the weight is solved by using a wedge of wood or iron, as in Fig. 22, which shows a broken spring hanger which has let the frame down on the driver, and the end of equalizer down on the frame. The best thing to be done in this case is to put a wedge under the wheel, either back or front of the one with the broken hanger, and run this wheel up on wedge. This will raise the frame off the driver with the broken spring; then put on top of the box a

block or anything that can be put in between frame and box, such as a piece of fish-plate; then run the wheel down off the wedge, and put a block under the low end of equalizer. In order to do this, run the wheel that is blocked up on a wedge, and this will take all the weight off the bar; then take down all loose parts, and proceed.

With the spring rigging underneath you do as in the former case; but to raise equalizing-bar it is best to put a wedge or roller under the low end of equalizing-bar

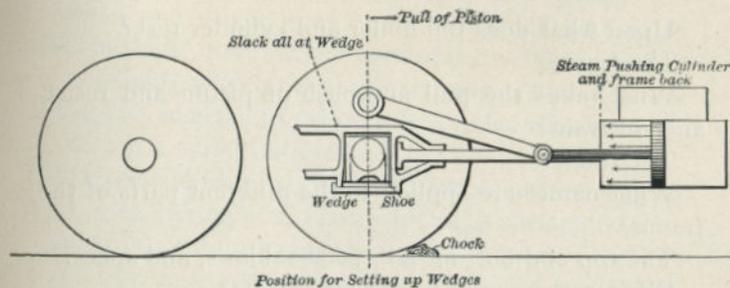


FIG. 26.

and move the engine back. If a front hanger, this will raise the bar, and then chain fast to frame. It is policy, when running a wheel up to raise frame, to put a block on top of that box, to take the strain off the springs, also to move frame more quickly; but leave it small enough to enable it to be taken out, when run down off wedge.

When a spring, spring hanger, equalizing-bar, or spring saddle breaks, do as in Fig. 22 (broken hanger), removing all loose parts. When a tire breaks, the wheel containing the break should be run up on a

wedge as thick as the tire, then the oil-cellar should be taken out and a block of wood substituted, as in Fig. 24. This will carry the weight, and make a bearing for the axle to revolve on. Never let the axle revolve on the oil-cellar, as this will cut the axle and ruin it. When an axle is broken off outside the driving-box this would not be absolutely necessary, for that axle is spoiled but block between pedestal-cap and cellar and top of box and frame.

QUESTIONS.

Upon what does the boiler and cylinder rest?

The frame.

What takes the pull and push of piston and resistance of train?

The frame.

What names are applied to the different parts of the frame?

The top and bottom rail, pedestal-jaws, and splice.

What is the use of the pedestal-jaws?

To hold the drivers in position.

What is the splice?

It is that point in an eight-wheel frame that the forward portion or bar is attached to, the back part of frame in front of front driver.

What governs the number of jaws in a frame?

The number of drivers to be used.

For what is a pedestal-cap or binder used?

To permit wheels and boxes to be dropped out or put in; also to bind jaws together.

Why are springs used?

To make engine ride easily; also to avoid the con-

cussion and jar, which would be hard on machinery and road-bed.

How is the weight on driving-boxes equalized?

By equalizing-bars attached to a frame and springs between driving-boxes, the weight suspended at the centre of bar or at the axis of rotation.

How will it equalize the weight between drivers?

If one driver goes up or down, the end of the equalizing-bar will go up or down with the box, and the weight will still be divided between the two boxes.

What is the result of using independent springs?

When one driver goes up or down, due to uneven track or frogs, it will throw most of the weight of engine on the high wheel, thus reducing the adhesive power of the low wheel, and making the engine ride hard.

What is a spring saddle?

A U-shaped iron spanning the frame and resting on the top of driving-box, upon which the springs rest.

What is a spring hanger?

An iron link connecting the spring and equalizing-bar, or spring and frame.

Of what materials are driving-boxes made?

Of cast steel and phosphor bronze. Cast-steel boxes have brass shells next to journals.

What advantage has this over a solid box?

The shell can be renewed without renewing the whole box.

What are wedges and shoes used for between boxes and jaws?

Shoes are used to prevent the wear of pedestal-jaws or frame-legs; wedges are used to take up the lost motion between boxes and pedestal-jaws.

On what side is the wedge in most locomotives?

On the back of the driving-box.

How is the wedge set up or pulled down and fastened?

By a wedge-bolt, as in Fig. 24.

What is an oil-cellar?

A hollow shell held between the flanges of driving-boxes, which is filled with sponging and oil to lubricate driving-box and journal.

What is the principal cause of driving-boxes getting hot?

The sponging dropping away from journals or getting hard.

In what position should your engine be placed to set up wedges?

On a straight, level piece of track, put crank-pin on top quarter in forward stroke, give a little steam in cylinder, and put a chock under wheels.

Why would you do this?

To get all the lost motion in the wedge side of box.

When a spring, spring hanger, or equalizing-bar or saddle breaks, what should be done?

Run wheel up on a wedge, back or front of wheel having a broken spring or hanger, and put block on top of that box, between box and frame, as in Fig. 22; run wheel down off wedge, and take down all loose parts. If equalizing-bar broke in centre, would put blocks on top of both driving-boxes, and proceed.

When a tire breaks, what should be done?

Wheel should be run up on a wedge the thickness of tire, the oil-cellar taken out, and a block put in as in Fig. 24.

Would you run without taking cellar out?

No, except when the axle breaks off outside of box, and then it is not absolutely necessary.

What is the difference between an engine-truck and a pony-truck?

An engine-truck has four wheels, while a pony-truck has only two. It is used in consolidation and mogul engines.

If an engine-truck wheel or axle breaks, what should be done?

If a forward wheel broke, collars should be set up close to boxes. Box and frame should be chained up to main frame, and a cross-piece put on back of truck frame between that and the main frame. Do the same with the back wheel. Proceed cautiously in all cases of this kind.

What should be done when a back or front driving-wheel or axle breaks on an engine?

The back or front wheels should be blocked to clear rails, and rods disconnected.

What is a blind wheel?

A wheel without a flange.

Which are the blind wheels on a consolidation engine?

The two middle drivers.

Why are these wheels made without flanges?

So that the engine will go around curves of short radius.

What is the blind wheel on a ten-wheel engine?

On a ten-wheel engine it is mostly the forward driver; in a six-wheel engine the blind wheel is the main driver or centre wheel.

CHAPTER V.

RODS AND CONNECTIONS.

THE main or connecting rod is the rod that connects the cross-head with the crank-pin, and transmits the power to the whole number of driving-wheels, and is therefore called the *main-rod*. This is illustrated in Fig. 27.

The main rod has brasses in each end, front and back. The front ends fits around the cross-head, or wrist-pin. The brass is in two pieces, and is set up by a key. Some rods are made solid, while others have straps. The P. R. R. standard for eight-wheel engines is as in Fig. 27. In driving this key (*B*) care must be taken that the set-screw (*S*) is loosened before starting key.

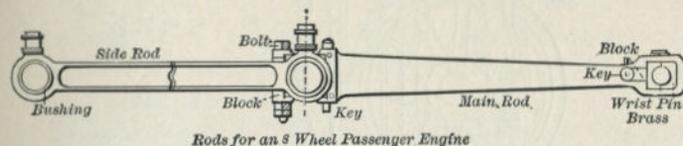
The back end of main-rod is the end that encircles the crank-pin. As with the front end, the rod is made with or without a strap. Fig. 27 shows a rod with a forked end, and the brass is slipped in from the back, while a block fits in between forks, and a large bolt passes through the forks and block, thus holding brasses in their place.

This is a convenient way of making rods, but there is this objection to it: If a strap or fork breaks, the whole rod is useless in that condition, and besides, it cannot be taken down on the forward centre. In other

forms the rod has a strap bolted to the main portion of rod, and leaves what is called the stub end when the strap is taken off; and if the strap breaks, it may be renewed without rendering the rod unserviceable, and can be taken down in any position.

Side-rods or parallel-rods are the rods connecting the driving-wheels together. Many efforts have been made to get a substitute for these rods, **but nothing** has been devised that will do better.

Where only two driving-wheels are used there is only one section of rod on each side, as in Fig. 27.



Rods for an 8 Wheel Passenger Engine

FIG. 27.

This shows a fluted or I section-rod. This form is very desirable on account of its strength and resistance to centrifugal force. This rod has no keys or straps, but has bushings of brass in each end or eye of rod. This makes a very simple form of brass, but when worn badly it must be renewed as a whole, and cannot be reduced to fit the pin, as in brasses which are in two parts, with keys to adjust them to the pin.

To keep the bushing from turning, a stud is screwed down through the eye of rod and bushing, in which is screwed the oil-cup.

On freight engines using three, four, or five driving-wheels, as in Fig. 21, the side-rods are divided into sections, as in Fig. 28, showing a set of rods for a consol-

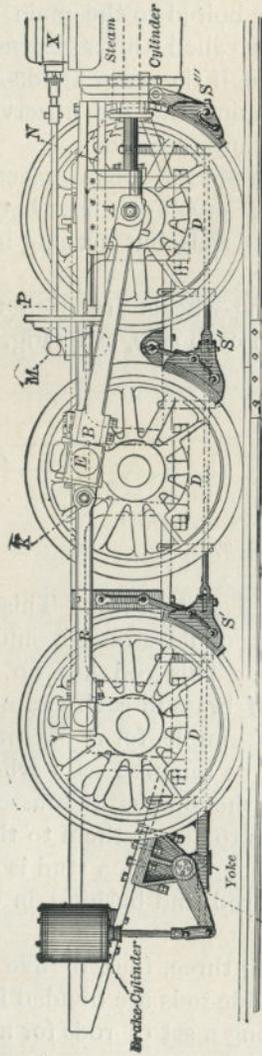


FIG. 27a.—SIX-WHEEL CONNECTED ENGINE.

N, Two-bar Guide.
P, Valve-rod.
D, Counter-balance.
X, Steam-chest.
M, Rocker-arm.
E, Main-pin.

B, Main-rod.
A, Cross-head.
K, Back-section Side-rod.
K, Knuckle-joint.
 Main Driver without a Flange.
S, *S'*, *S''*, Brake-shoe and Clogs.

idation engine. The main pin is on the third wheel from the front end. This set of rods is divided into three sections. The middle section is on pins 3 and 2. The straps on each end have an eye on their back ends. The other sections front and back, or 3 and 1, fit on their respective crank-pins. The ends of sections 1 and 3 have their ends next to pins 3 and 2 forked. These ends span the ends of the straps of the middle section, which have an eye in them. A pin passes through the two, binding them together, and forming what is called a knuckle-joint.

This joint is provided for unevenness of track, frogs, or going on a turntable. If this was not provided, and the rods solid, or if one wheel raised or lowered, it would break the rods.

Six-wheel connected engines have only one knuckle-joint, using two sections of rods. The joint is back of main-pin on most engines. On rods using straps there are keys or wedge-shaped pieces of steel, which pass through the strap, bearing against the brass and strap or strap and stub end of rod.

This is done in order to adjust the brasses to the wear by raising or lowering the keys. Most pin brasses have two keys, the one front and the other back; but some engines have only a single key on the main-pin brasses, on main-rod and side-rod. When made this way the key moves the front brass up to pin, and must pull the whole rod in order to get the back brass up to pin. This causes the rod to be lengthened, unless liners are put in between the brass and the back end of strap. In the back of main-rod brasses babbitt or other similar metal is placed in grooves, which pre-

vents the brasses from heating so quickly as without it.

When a pin gets so warm that it commences to throw the metal out, it begins to give trouble to the runner, and if judgment is not used the pin will get worse and cut. It will be found in most cases that there is some obstruction in the oil-cup which prevents the oil from getting down to pin, and when the metal starts matters become worse, as the metal will fill up oil-way in cup solid.

Oil-cups are made with a regulator or needle in

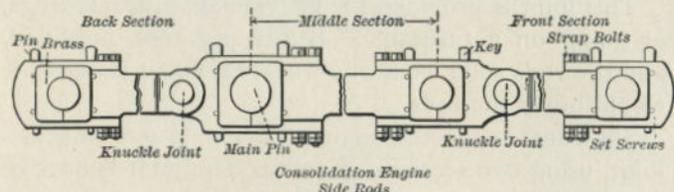


FIG. 28.

them, which can be lowered or raised to regulate oil flowing to pin, and it frequently happens that dirt or waste gets around the point of needle and stops the oil. This will cause heated bearings.

Cups should be kept clean; and in order to make the cup feed regularly, an engineer should take the cup off, fill it with oil, and set regulator by the drop, which he can see issuing from the cup if he holds it up to view.

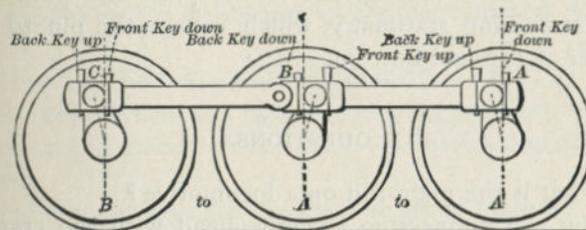
Another cause of the rod-brasses getting warm is too tight keying, which binds the brasses to pin, and causes much friction. In this case keys should be slacked up, according to judgment. Again, the brasses

will not fit the strap correctly, or the key will be driven down too hard, springing the crown of brass.

Every engineer should understand how to key up an engine, as it is one of the important parts of an examination for promotion by a travelling engineer or master mechanic.

When keying up the side-rod always place the crank-pins on the centre, either forward or back. By so doing the length of rod will not be changed, as the pins are in the centre-line of motion through wheels and cylinder, and this is also the extreme point of travel of pin through the centre-line of motion.

Never key rods up with the pins on top or bottom quarter, for the reason that then the rods can be lengthened or shortened, as in Fig. 29; which will be



Showing the effect of Keying Side Rods.
On the C. Quarter (Drawings Exaggerated)
A to A the Rod has been Shortened.
B to A " " " " Lengthened.

FIG. 29.

plain to all, as the pins are above the centre-line of motion, and form a lever with the axis of motion at the centre of the wheel. The pins can be drawn to or spread without moving the engine in a horizontal direction. Driving down the keys A and B would

shorten rods, while driving down *C* and *B* would lengthen them. We see, then, that in either case when the pins come to the centre they would be either too long or too short, which would cause them to buckle or break if their length was changed greatly by keying.

The question with which brass to begin depends on the number of keys to a brass and the rods. On a six-wheel connected engine using a single key in front of pin it is policy to drive that key first, the others being slacked off, as this key must push brass up to pin and pull back brass to pin by moving the whole rod.

When keying up the front end of the main-rod it is a general rule to put crank-pin on either quarter, which brings the brass on the large part of pin, as the wear of wrist-pin is oblong, due to the push and pull, the pin remaining stationary, which causes the pin to be larger at top and bottom.

QUESTIONS.

What is the main-rod on a locomotive?

The rod connecting the cross-head with the crank-pin.

What are the side or parallel rods for?

To connect the drivers.

Are they solid rods throughout?

No; it depends on the class of engine, as those using but four driving-wheels have only a single rod. Six-wheel connected and consolidated engines have their side rods divided into sections.

What is a knuckle-joint, and why is it provided?

A knuckle-joint is the point at which the sections are joined together, as in Fig. 28. This is provided so as to allow for variation in the height of the driving-wheels in passing over rough track, frogs, or turntables.

If there was no knuckle-joint, what would happen on rough or uneven track?

It would bend or break rods.

How are most brasses held on rods?

By straps which are bolted on the end of rods, the brasses fitting in the straps.

Are there any other forms?

Yes; a solid bushing fitted into the end of rods.

What advantage has the divided brass over a solid bushing?

The divided brass can be reduced to fit pin as it wears. The solid bushing must be renewed when worn.

How are the brasses held to pins?

By keys which are tapered or wedge shape, which take up the space between strap and bars when driven down.

How many keys are used to one set of brasses?

Generally two, one on each side of brass, although some use only one, especially on the back end of main-rod.

Are there many main-rods having the back end without straps?

Yes; strap being solid with rod, using a block and bolt to hold brass in. This is called forked or spade handle rod.

Can this rod be taken down in all positions?

No; it cannot be taken off pin on the forward centre.

What causes the pins to become hot?

It is mostly caused by not getting any oil to the pins, due to the oil-way becoming stopped up by dirt or waste, regulator or needle working down, brasses keyed up too tight or out of line, also metal thrown out filling oil-way up, and for the want of oil in cup.

What should be done when pin becomes warm?

Oil-cup should be examined for any of the above defects, and if the pin is very warm would cool it off. Raise regulator if the cup was full of oil, to let it feed more freely. If oil feeds freely and pin still runs warm, would slack up on keys, using judgment in doing so.

Is there any particular position in which to place crank-pins when keying up side-rods?

Yes; the pins should be placed on either forward or back centre.

Why is this done?

So that the pins will be in the centre-line of motion through driving-wheel, or at the extreme point of travel of pins through the centre-line of motion.

If placed on any other point, what would be the result of hard keying?

The rod could be made shorter or longer.

What would be the result if keyed in that way when pin came on the centre?

It would bend or break the rods; or if not keyed that much, would cause pins to run warm.

In what position is the main-rod usually placed?

Mostly on the top quarter, so as to bring the wrist-pin brass on the largest part of pin.

What would be the shape of a wrist-pin much worn?

Oblong; as the pin does not revolve, and the wear is front and back, due to the push and pull of piston-head.

Is there any particular pin to key in keying side-rods?

That depends on the kind of rods and the number of keys to a brass.

CHAPTER VI.

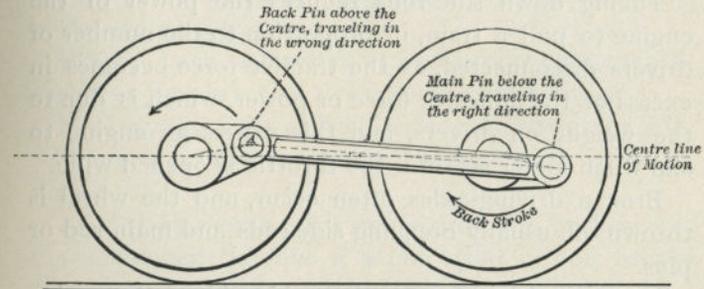
BREAKING OF RODS.

WHEN an engine breaks a side-rod, strap, or pin, the opposite rod must be taken down; also on an engine having four driving-wheels; and it should never be started unless this is done, as it is liable to break the good rod or pin. If the engine should slip when on the centre, it will do this, and it is liable to go either above or below the centre-line of motion, or in the opposite direction to that of the main-pin.

The reason for this is that there is nothing to guide or pull the pin in the proper direction, as when two rods are connected to their respective pins. This rule applies to all classes of engines, but it is not necessary to take all the side-rods down on all engines, as will be explained.

It has been argued that one side-rod could be run without any danger, as the main-pin would pull the back-pin around in the right direction, if it went over the centre. This is all a mistake, as will be seen by Fig. 30, which shows the engine in the forward-motion back-stroke. The back-pin has passed above the centre, due to the backward push of the piston, and having no side-rod on the other side to guide, it was free to go either way if the driving-wheels slipped. Some think that with the engine going forward, with the

pins in this position, the pin would be pulled down below the centre-line of motion; but this cannot occur: as the main pin is travelling backward, it is pushing the other pin away from the centre in the direction of the arrow, and under no circumstances can that pin (*A*) come below the centre, unless it breaks or buckles the rod. Then, due to the forward motion of the engine, the wheel would reverse itself. So the reader will



Showing the action of an Engine which is run with only one Side Rod, The back Pin has passed above the Centre.

FIG. 30.

readily see why side-rods should come down when one is broken; as on the consolidation engines, where the rods are divided into sections, if a back or a forward section breaks it is only necessary to take down the opposite section, but if a middle section breaks, all the side-rods on both sides must come down, for the reason that when a middle section breaks, all the support for the other sections is gone, the knuckle-joint being on each end of the middle section. This must be done in case a pin holding or a middle section, a strap, or bolts breaks.

On six-wheel connected engines the side-rod is in

two sections, the forward section back end having the knuckle-pin.

If a back section breaks, the opposite section must come down. If a forward section breaks, all the side rods must be taken down. When the main-rod breaks, the engine must be disconnected, as when a valve-rod breaks. If both rods break, it is not necessary to take side-rods down for towing.

Taking down side-rods reduces the power of the engine to pull a train, in proportion to the number of drivers disconnected, as the tractive force becomes in excess of the adhesive force or power, which is due to the weight on drivers, and this causes an engine to slip when under steam if the throttle is opened wide.

Broken driving-axles often occur, and the wheel is thrown off, usually breaking side-rods and main rod or pins.

If a main driver breaks off outside of box, the engine should be brought in with the good side, taking down all side-rods. The box on broken side should be blocked up, putting a block between the top of box and top of frame, and also between the bottom of box and pedestal-cap; this prevents the axle from binding, and keeps the box in position.

QUESTIONS.

If a side-rod breaks, what must be done before starting engine?

The side-rod on the other side must be taken down.

Why must this be done?

So that the good rod may not be broken.

Why would the good rod be broken if left up?

If the engine stopped at either centre, the back crank-pin would be liable to go either above or below the centre-line of motion, there being no rod on the other side to pull it over the centre. If it went above the centre, as in Fig. 30, it would break the rod or pin.

If the pin passed above the centre, could the main pin pull it back again?

No, that would be impossible without breaking either rod or pin.

When a back or forward section breaks on a consolidation engine, must all the side-rods come down?

No, only the front or back section, on the other side.

When the middle section breaks, what must be done?

All the side-rods must come down on both sides; the same must be done if a pin, strap, or bolt breaks on a middle section.

Why must all come down?

On account of the knuckle-joints being on each end of the middle section, thus leaving no support for the front and back sections.

When a main pin breaks on a six-wheel connected engine, what must be done?

All the side-rods must be taken down on both sides, and when only a back section, the opposite section is taken down.

What effect does disconnecting side-rods have on an engine?

It reduces the power of the engine to haul a train, in proportion to the weight on each driver disconnected.

How does the engine act when the throttle is open?

The engine will slip, because the tractive force is in excess of the adhesive power.

Can an engine be run when an axle breaks outside of box?

It can be run.

When an axle breaks in the centre, what should be done?

The wheels should be blocked up to clear track, and disconnected.

CHAPTER VII.

VALVE-MOTION.

THIS is a portion of a locomotive which often remains a mystery to many. The writer will endeavor to make it as plain to the reader as possible. Starting with the valve, which (as has been shown in a previous chapter) is a hollow shell in the form of the letter D, this valve slides over the steam-ports, controlling the inlet and outlet of steam; also the exhaust.

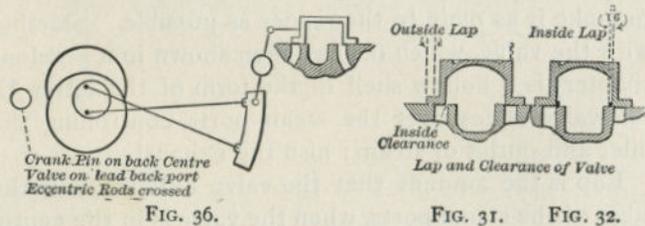
Lap is the amount that the valve extends over the edge of the steam-ports, when the valve is in the centre of its travel, as in Fig. 31. The purpose of lap on a valve is to get an increased amount of expansion from the volume of steam used in the cylinders. Increase of lap is increase or expansion, to a certain extent, as the valve will release the steam earlier in the stroke if the exhaust side of valve is line on line with steam-ports.

Inside lap is the amount that the exhaust side of valve overlaps the port, as in Fig. 32, which causes the valve to exhaust the steam later in the stroke; but then it will close the valve earlier to the exhaust, and cause greater compression.

Inside clearance is the amount that the port is open on the exhaust side of valve, when in the centre of its travel, as in Fig. 31. In this the valve will exhaust

the steam earlier in the stroke of the piston, but will close the exhaust later, thus reducing the compression. With a valve without lap, the steam would follow full stroke without expansion, which would be wasteful.

Lead of a steam-valve is the amount the valve has opened port when the crank-pin is on either centre. The idea of having lead is to provide a cushion and help start the engine off centre. There is a great difference in opinion as to how much lead an engine should have, but generally freight engines are given

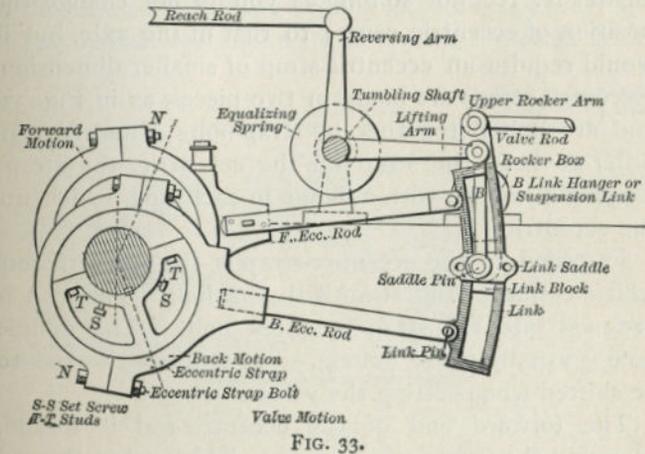


one eighth lead, full stroke, and passenger engines one sixteenth.

Valve-motion is composed of several parts, as Fig 33 shows. We will start with the eccentrics which are fastened onto the main drivers. As a rule, the eccentric encircles the main shaft, and is the only substitute for a crank. There are four on an engine using the Stephenson or link motion, two for a link—the forward-motion eccentric, which controls the motion of the valve when running forward; the backward eccentric, which controls the motion of the valve when running backward.

Eccentric sheaves or wheels are made in two parts, and bolted together by studs, as in Fig. 33. The

method of fastening to the axle is by a key and set-screws. The travel of the valve is controlled by the travel of the centre of eccentric in a horizontal line each side of the centre of axle. Thus if we had a valve whose travel was four inches we would place the centre of the eccentric two inches above the centre of axle or horizontal line *AB* in Fig. 34; then when the axle revolved, the centre of eccentric would travel just four



inches in a horizontal line, which would be the travel of valve.

There is, however, another point with which we must deal, and that is the lap and lead of valve: this, then, will cause the centre of eccentric to be moved beyond the vertical line *CD*, in Fig. 34, just the amount of lap and lead of valve, which in this case may be thirteen sixteenths of an inch,—three-fourths lap plus one-sixteenth lead,—which is called the angular advance of

the eccentric center. If this were not done the piston-head would leave the end of the cylinder before the valve would open, as the valve would have to travel the length of lap and before it would open the port of the cylinder; in that case the piston-head would lead the valve.

It is often asked if reducing the diameter of the eccentric would diminish the travel of valve. The answer is: No, not so long as you do not change the position of eccentric centre to that of the axle, but it would require an eccentric-strap of smaller dimension. Eccentric-straps are made in two pieces, as in Fig. 33, and are bolted together by strap-bolts *N* and *N'*. In order to keep the strap on the eccentric, the straps are made hollow, with a flange in each side, which fits the eccentric.

Fastened to the eccentric-strap is the eccentric-rod, which connects the strap with the link. This rod is fastened into the strap by three bolts. The middle hole is usually made oblong, so as to allow the rod to be shifted when setting the valves.

The forward end of the eccentric-rod is forked, spanning the link, as in Fig. 33. This end of the rod is fastened to link by the link-pin, which runs through the eye in link and fork of rod. This construction is the same for the forward and backward motions.

As usually constructed, the forward eccentric is next the driving-box, and the backward inside. In all indirect motion using a rock-shaft, the forward eccentric-rod is connected to the top of the link. The link is simple in its construction, but is an important feature

in valve-motion, as by its use the motion is reversible, or the engine can be run either forward or backward.

As generally made, it is forged solid; but some builders make the two sides separately, and use a block top and bottom, putting a bolt through them, binding it together as a link.

The link is not straight, but is curved, having a given radius. This radius is measured from the centre of the axle to the centre of link, as in Fig. 33.

The reason for making a link with a radius is on

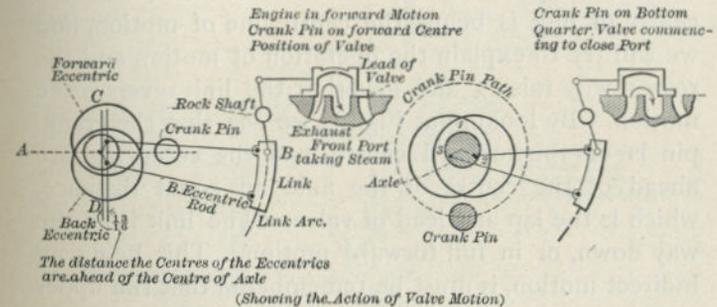


FIG. 34.

FIG. 35.

account of the link being raised and lowered each side of the centre-line of motion, and if straight it would throw the valve out in its travel.

On the back of the link is a cross-piece called the saddle, and spanning the link on this saddle is a pin, which is called the saddle-pin. This is the axis on which the link rotates or swings.

From this saddle-pin to the lifting-arm is the link-lifter or suspension link, which is attached to lifting-arm, which in turn is welded to tumbling-shaft, the

forward from the vertical line *A* to what would be full forward travel of link, the dot *B* would move from *A* to *F*; but with the same movement of link the dot *C*, midway between the dot *B* and fulcrum *S*, would move only half as far as *B*. Thus it is with the link-motion if the link is all the way down in the forward motion. The link-block will be in top of link-slot, and is controlled wholly by the forward-motion eccentric; now if the link is raised the block will be further down in link, or at dot *C* in Fig. 37, and would travel only half as far as when top of link-slot.

When in this or any other point between full stroke or top of link-slot and centre of link, the valve is being short-stroked, and is partly controlled in its movements, by both eccentrics.

The action is the same for backward motion. When the link-block is in the bottom of link-slot the engine is in the backward-motion full stroke and the valve is controlled by the backward motion eccentric; and when the link is lowered toward the centre, the valve is being short-stroked, the same as in the forward motion.

Raising or lowering the links also will reverse the motion of valves and engine. The position of the centre of the eccentrics, in connection with the link, controls this action.

By Fig. 35 it will be seen that the link is in full forward travel and the port is full open. The centre of the eccentrics is at 2 and 3, while the crank pin is not quite at the bottom quarter.

The reason for this is that the centres of the eccentrics are not at right angles with the crank-pin, but are moved forward the length of the lap and lead.

Drawing the vertical line *ON* in Fig. 38, the link-block centre is at 7, or forward of the vertical line *ON*, while the bottom of link is back of the vertical line *ON*.

To reverse the motion, the links are raised, and the link-block will be in the lower part of link-slot. It must not be forgotten, that in the act of raising the link it changes its position very slightly, but slides up over

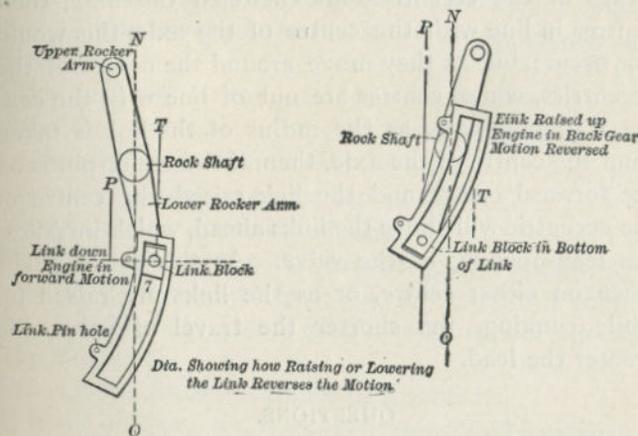


FIG. 38.

FIG. 39.

the link-block, the slot acting as a guide to the link-block, which in turn moves the rocker-shaft and valve. When the link is raised from the full forward motion to the backward motion, the block will then be in the bottom of link-slot, having moved from the line *T* in forward motion to the line *P* back of the vertical line *ON* in Fig. 39, and has moved the valve across the seat and uncovered the back-port, reversing the motion of the engine.

Remember, too, that the link-block must follow the slot in link, and the rocker-arm must move whichever way that the link is inclined, either side of the vertical line *NO*.

The question is often asked: "Does the lead of opening increase as the links are raised up?" I answer that it *does* increase, for the reason that it is due to the position of the centre of the eccentric. If the straps of the eccentric-rods encircled the axle, their centres in line with the centre of the axle, this would not occur; but as they move around the centre of the eccentrics, whose centres are out of line with the centre of the axle, also as the radius of the link is taken from the centre of the axle, then, if the crank-pin is on the forward centre and the link raised, the centre of the eccentric will shove the links ahead, which increases the lead-opening of the valve. As this action takes place on either centre, or as the links are raised up while running, the shorter the travel of valve, the greater the lead.

QUESTIONS.

What is meant by the lap of valve?

The amount that the valve extends over the edge of steam-port when the valve is in the centre of travel.

Why does a valve have lap?

In order to get an increased amount of expansion in the steam-cylinder.

How does a valve without lap act?

Cylinders would take steam throughout the whole stroke, which is not economical when not using a cut-off.

What is meant by the lead of a valve?

Lead is the amount that the port is open when the engine is on either centre.

Why is lead given to a valve?

To form a cushion for the piston-head; and at the same time, if the compression is in excess of the pressure in the chest, it will allow it to equalize.

Why is a cushion required in a cylinder?

To prevent the piston-head from striking the cylinder-head, also to retard the motion of the reciprocating parts.

What is meant by the inside lap of valve?

It is the amount that the valve extends over the edge port on the exhaust side of valve, as in Fig. 32, which shows three-sixteenths lap on inside.

Why is a valve given inside lap?

In order to increase the expansion, by preventing the steam from exhausting as soon as it would if there were no inside lap; but it produces an earlier cut-off of the exhaust.

What is the inside clearance of a valve?

It is the amount that the port is open on the exhaust side when the valve is in the centre of its travel.

Why is it used in a valve?

To produce a later closing of the valve to the exhaust, by reducing the back pressure or compression, but at the same time it reduces the amount of expansion by an earlier exhaust-opening. (See Fig. 31.)

What is the most common form of valve-gear which is used on the American locomotive?

The link-motion. The names of the parts are shown in Fig. 33.

What governs the travel of the valve?

The throw of the eccentric or the distance the centre of eccentric travels in a horizontal line, providing that the rocker-arms are of equal length.

What is the position of the eccentric centres when the engine is on the forward centre?

The centres are in front of the centre of axles, or line *CD*, as in Fig. 34.

What distance are they ahead of the line *CD*?

The length of the lap and lead of valve.

Why must they be in advance of the line *CD*?

If they should be at right angles with the crank-pin, the piston would leave the end of cylinder before the valve opened the steam-port. This is called the angular advance of the centre of the eccentric, and is equal to the lap and lead of valve.

In how many parts are the eccentrics?

They are made in two parts, so that they can be put on an axle.

How are they joined together, and fastened on an axle?

The parts are fastened together by studs, as in Fig. 33, and then fastened to the axle by set-screws *SS* in Fig. 33. A key is also provided.

On what axle are the eccentrics usually attached?

Mostly on the main driving-axle.

What is an eccentric-strap?

An eccentric-strap encircles the eccentric, and has the back end of eccentric-rod attached to it.

How are the parts of the strap fastened together?

By strap-bolts, as in Fig. 33.

In a locomotive valve-motion, how many eccentrics are there?

Four—a forward and a back-up eccentric for each valve.

To what part of the link is the forward-motion eccentric-rod generally attached?

To the top part of the link; the end of the rod is forked, spanning the link.

What is the use of the link in the valve-motion?

By using the link the motion of the engine can be reversed, and the valve can be short-stroked.

What is the radius of the link, and why is the link curved?

The radius is the distance from the centre of the axle to the centre of the link or link arc. The link is curved on account of being raised and lowered, rotating around a centre with the curve in the link. The moving of the link up or down does not make the travel unequal, as it would if it was not curved.

What is the link-block?

The link-block fits in the slot of link, and is attached to the lower rocker-arm pin.

What are the saddle and saddle-pin?

The saddle is a plate spanning the link, to which the saddle-pin is fastened, the saddle-pin forming an axis for the link. To the saddle-pin is attached the link-hanger or suspension-link.

What is the use of the tumbling-shaft?

A tumbling-shaft * runs across the frame, carrying the lifting-arms, and also the reverse-arm, to which the

* Also called lifting-shaft.

reach-rod is attached. To the lifting-arms is attached to the link-hangers.

What is provided to counteract the weight of the links, eccentric-rods, and tumbling-shaft?

An equalizing-spring, which takes the weight and makes the links easy to raise and lower.

Are the rocker-arms used in all valve-motions using a link?

Only in indirect motion.

Are they always of the same length?

They are of different lengths when the travel of the valve is greater than the throw of the eccentric.

Should the steam-ports be covered when the engine is on either centre, with a valve having lead?

No; the valve will be wider open when in the out notch than when full throw, even when on the centre.

Why does this increase of lead occur?

On account of the position of the centres of the eccentrics and the movement of the link.

Why does the raising or dropping the link reverse the motion?

The motion is reversed by the position of the link, or in whatever position the links are. This position is governed by the centres of the eccentrics, and as the link is raised or lowered the link-block must follow the slot of the link, which acts as a guide to the block. (See Figs. 38 and 39.)

BREAKING DOWN OF THE VALVE-MOTION.

When an eccentric-rod breaks, what must be done in the way of disconnecting?

Both eccentric rods and straps must be taken down.

Cover port and disconnect as for a broken valve-rod. (See Fig. 15.)

If the forward-motion eccentric was broken, could the engine be run without taking down both rods?

Yes, by disconnecting the link-hanger, and letting the link carry on top of the link-block.

If the eccentric became loose on the axle and shifted, what could be done to fasten it in place, the key and setscrews of that eccentric being lost?

Take the two setscrews from the other eccentrics and fasten it. There are eight setscrews on the shaft.

Is it possible to break a backward-motion strap, and not take down the eccentric-rods?

This can be done by fastening the back end of rod fast to the forward motion.

Could the engine be reversed on that side when the back-up rod is fast to forward-motion rod?

No, it should be in the forward motion on that side, because there is only one eccentric that controls the motion, that being the forward eccentric.

Would an engine hold if reversed in that condition?

No, as it would not have any braking-power.

When an eccentric slips or is moved away from the proper position, there being no key-way for a guide, how would it be possible to set the eccentric so as to bring the engine in on the road?

The proper way to do this is to place the engine on the forward centre, and set the slipped eccentric by the good one. If it is the back-up eccentric that has slipped, put the reverse-lever in full forward notch, and make a mark on the valve-stem, close to the stuffing-box. After this is done, put the reverse-lever in full

back notch, and move the loose or slipped eccentric around until the mark on valve-stem comes back to stuffing-box; then fasten eccentric, and it will be in proper position. This applies as well to the forward eccentric. If slipped, set it by the good one or back-up eccentric.

Why is it possible to set one by the other?

Because when on either the forward or back centre the eccentric centres are the same distance ahead of the centre of axle, as in Fig. 34.

Are there any other ways of setting a slipped eccentric?

There are other ways, but the one referred to is the best. It can be done by using the cylinder-cocks as a guide. If engine is on the forward centre, move the eccentric until there is but little steam escaping from the front cylinder-cock. This will place the eccentric nearly right.

When a link-hanger, tumbling-shaft, lifting-arm, or reach-rod breaks, what should be done?

When link hanger, saddle-pin, reach-rod, or tumbling-shaft breaks, it would leave the links dropped down on top of the link-block, and the best thing to do is to fit blocks in the links, as in Fig. 40. When a link-hanger or saddle-pin breaks, blocks should be put in that link only; if running in the forward motion, the reverse-lever should be put in the position that the engine will be run, and then measure the distance from the top of link to the link-block, on the good side; that will the length of block to be put on top of link-block on the broken side. This will be a short block. When running in the backward motion, the link-block will be

in the bottom of the link, as in Fig. 41, and then it will require a long block on top of the link-block. A hole should be bored through it to fasten it to link. This rule is applicable to several breakdowns.

If running a fast passenger train, would it be policy to stop and block other lines by doing as directed in the former rule for the breaking of saddle-pin or link-hanger?

No; would leave link carry on link-block, putting

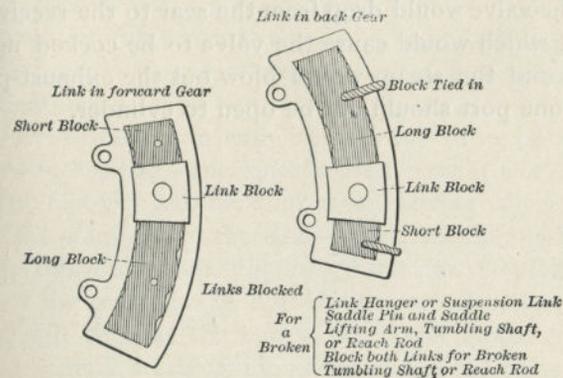


FIG. 40.

FIG. 41.

some waste between block and top of link, and proceed.

When a link-block pin or lower rocker-pin breaks off, what should be done?

Would get the block, if possible; disconnect the valve-rod from the upper rocker-arm cover ports and disconnect main-rod, push the lower rocker ahead to clear the link, and fasten; then proceed with train. This applies the same when a lower rocker-arm is broken.

How can a valve be put in the centre of seat, to cover ports?

By the reverse-lever. If the crank-pin is off the centre, by putting the reverse-lever in centre notch, or by opening the cylinder-cock and moving valve until the steam disappears, then move valve one half an inch or more, and the valve will have ports covered.

Why not shove them all ahead or back, and leave one port open?

The valve would drop from the seat to the receiving-port, which would cause the valve to be cocked up on seat, and the steam would blow out the exhaust-port, and one port should not be open to cylinder.

CHAPTER VIII.

VALVE-SETTING.

LOCOMOTIVE-ENGINEERS, as a rule, do not set valves, but it is nevertheless a subject that should be understood.

Valve-setting is usually done in the shop, by a person who has had experience in that class of work.

The first thing to be done when setting valves is to get the crank-pin in the dead-centre, and the best way to do this is shown in Fig. 42. First put the crank-pin below the centre (as in dotted line) so that the cross-head will be near the end of its travel in the guides. Make a mark on the guide at the end of the cross-head shoe, as in *A*. At the same time take a tram and scratch an arc of a circle on the centre of the tire *EE* in figure; then put a punch-mark in wheel-cover or any convenient point, put a tram point in that punch-mark in cover with the other end of tram, and scratch a line across the arc on wheel, as in *B*. Now with the line on guide-bar and the line at *B* move the driving-wheel around in the direction of the arrow in figure until the cross-head shoe comes back to the mark on guide-bar; then with the tram scratch another line across the arc on tire, as at *C*, the point of tram being in the punch-

mark of wheel-cover, as in the first case. Next, find a point on arc *EE* half-way between the punch-marks *B* and *C*, which is *S*. Now move the driving-wheel back until the point of tram comes in the punch-mark *S*, and the mark on wheel-cover. The crank-pin will then be on the centre, and the end of cross-head be at the line *N*. This method will do for either centre; only the marks on wheel will be on different parts of the tire.

After the crank-pin is on the centre the valve-setting begins. The eccentrics are generally fastened on

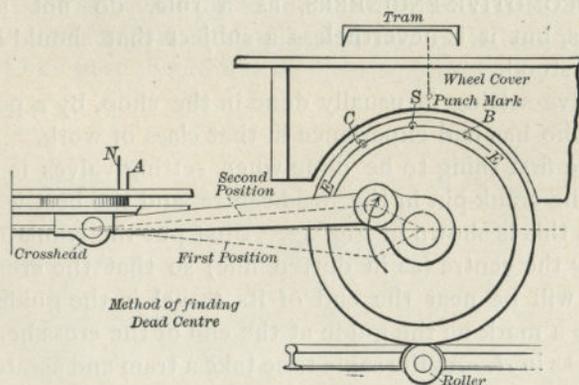


FIG. 42.

in their proper positions by a key. The links being all the way down, the next point is to find the proper length of the eccentric-rods.

The valve in steam-chest is given the proper amount of lead, and a piece of wood or tin the thickness of lead is put between valve and port holding the valve, the valve-rod being connected to valve and rocker-arm.

The eccentric-rod is then fastened to link; and as most rods have oblong holes in them to allow them to be moved, the rod is connected to the strap and the nut tightened up and the wheel moved around to the back centre; and if the lead-opening is the same as for the front port, the rod is of the proper length, and then the two other holes are marked on the eccentric-strap and bored out. But in an engine which has been running the eccentrics must be lengthened or shortened by contracting or expanding in a forge, which is done by a competent smith.

Next find the length of the backward eccentric-rod as in the forward, except that the lever is in full back gear. Try it on both centres, as before.

When an engine has become lame after being run for some time, the valves are found to be opening the ports unequally, that is, one port is open wider than the other, with the same travel on the valve. There is no difference in the travel of the valve over the seat, but the centre of the travel of the valve has been moved either ahead or back of the centre of the valve-seat.

This will cause the valve to cut off unequally, and one end of the cylinder is doing more work than the other. This can be told by the exhaust, and to rectify this the eccentric-rod should be lengthened or shortened, as the case may be; for if the valve opened wider on the front port, then on the *back* one the eccentric-rod must be shortened, which will change the centre of valve-travel, or throw the valve ahead and equalize the port-opening. The amount must be determined by the one setting the valves.

When the back port is open more than the front port; then the eccentric-rod must be lengthened, and the valve will be drawn back to the centre-line of the valve-seat.

When an eccentric is shifted, it can be easily known by the lead-opening. As an example, the writer was on an engine which broke a valve-stem and eccentric-straps, and for some cause the eccentric became shifted, and when the valve-setter put the gear up again, the engine had fully one-quarter lead with the valve that was used before, the lead being almost equal for both ports. The valve-setter was puzzled, when the writer suggested that he examine the eccentric centre, which he did, and found the trouble at once, moved the eccentric back in its place, and the lead was all right.

Valves cannot be made to cut off equally, on account of angularity of rod-motion; but when an engine is running along, and there are two heavy beats and two mild beats or exhaust, the trouble is that one engine is working stronger than the other, and it is caused by the link-blocks being in different positions of the link. A link-hanger that is longer on one side will cause it, and should be shortened, or both made the same length.

Another cause is, that one saddle-pin is worn more than another, or eye in link-hanger, or the tumbling-shaft boxes being of different heights. The cause very often of valve being out is the wear of driving-boxes between shoe and box; the wedge is back of box, and wear is taken up at that point, throwing the axle ahead that moves the eccentric also. In order to find

the position of reverse-lever for different cut-offs, move the piston-head from the end of cylinder the number of inches that is wanted for cut-off, and then raise links up until the valve closes the port, and mark point on quadrant.

TABLE I.

Travel of Valve.	Width of Port-opening.		Point of Cut-off.		Point of Release.		Lead.
	Backward Stroke.	Forward Stroke.	Backward Stroke.	Forward Stroke.	Backward Stroke.	Forward Stroke.	
2½	1½	5/8	8	6¾	17	16½	3/8
2¾	1¾	11/8	9½	9½	18¾	18½	¼
2¾	1¾	½	12	11¾	19¾	19¾	3/8
3¾	1¾	¾	14	14	20½	20½	1/8
3½	¾	¾	16½	16½	21½	21½	5/8
4	1½	1¾	18½	18½	22¾	22½	½
4½	1½	1½	19¾	19½	23½	22¾	5/8
5	1½	1½	20¾	20½	23½	23½	1/8

Travel of valve.....	5
Steam-ports.....	1½
Exhaust-ports.....	2¾
Lap of valve.....	7/8
Inside lap of valve.....	1/8
Lead full stroke.....	1/8

Table II shows the different travel and point of cut-off of two valves, one having 5-inch throw or travel and 7/8 lap, the other 3½ throw and ½ lap, both cutting off at

the same point, showing the difference in port-opening between a long- and short-throw eccentric.*

TABLE II.

Point of Cut-off.	Width of Opening of Steam-ports.	
	Eccentric 5-inch Throw.	Eccentric 3½-inch Throw.
6 inches	$\frac{7}{32}$ inch	$\frac{5}{32}$ inch
8 "	$\frac{9}{32}$ "	$\frac{3}{16}$ "
10 "	$\frac{11}{32}$ "	$\frac{7}{32}$ "
12 "	$\frac{7}{16}$ "	$\frac{9}{32}$ "
15 "	$\frac{5}{8}$ "	$\frac{8}{8}$ "
18 "	$\frac{31}{32}$ "	$1\frac{1}{16}$ "
21 "	$1\frac{1}{4}$ "	$1\frac{1}{32}$ "

* M. N. Forney.

CHAPTER IX.

THE COMPOUND LOCOMOTIVE.

LOCOMOTIVE-BUILDERS, in endeavoring to keep the locomotive ahead as a motive power, have been advocating the compound engine, of which many have been built in this country and are being handled by our engineers and firemen. The idea of a compound engine is the saving of fuel, which means dollars and cents to any railroad company.

The different methods of compounding are the two-cylinder and the four-cylinder, also the three-cylinder, in which two high-pressure and one low-pressure are used.

ELABORATE TEST OF COMPOUND ENGINES.

It is not claimed for compound locomotives that a heavier train can be hauled at a given speed than with a single-expansion engine of similar weight and class. No engine can haul more than its adhesion will allow; but a compound will, at a very low speed on heavy grades, keep a train moving where a single-expansion engine will slip and stall. This is due to the pressure on the crank-pin on the compound being more uniform throughout the stroke than is the case with a single-expansion engine.

The principal object in compounding locomotives is to effect fuel economy, and this economy is obtained—

1. By the consumption of a smaller quantity of steam

in the cylinders than is necessary for a single-expansion engine doing the same work. 2. The amount of water evaporated in doing the same work being less in the compound, a slower rate of combustion combined with a mild exhaust produces a higher efficiency from the coal burned. In a stationary engine, which does not produce its own steam-supply, it is of course proper to measure its efficiency solely by its economical consumption of steam. In an engine of this description the boilers are fired independently, and the draught is formed from causes entirely separate and beyond the control of the escape of steam from the cylinders; hence any economy shown by the boilers must of necessity be separate and distinct from that which may be effected by the engine itself. In a locomotive, however, the amount of work depends entirely upon the weight on the driving-wheels, the cylinder dimensions being proportioned to this weight; and whether the engine is compound-or single-expansion, no larger boiler can be provided, after allowing for the wheels, frames, and other mechanism, than this weight permits.

Therefore the heating-surfaces and grate-area are practically the same in both types, and the evaporative efficiency of both locomotives is determined by the action of the exhaust, which must be of sufficient intensity in both cases to generate the amount of steam necessary for utilizing, to the best advantage, the weight on the driving-wheels.

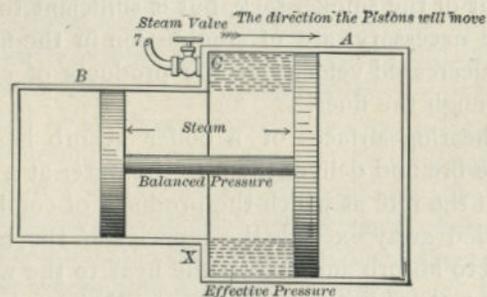
This is a feature that does not appear in a stationary engine, so that a compound locomotive cannot be judged by stationary standard, and the only true comparison to be made is between locomotives of similar

construction and weight, equipped in one case with compound and in the other with single-expansion cylinders. One of the legitimate advantages of the compound system is, that, owing to the better utilization of the steam, less demand is made upon the boiler, which enables sufficient steam-pressure to be maintained with the mild exhaust, due to the low tension of the steam when exhausted from the cylinders. This milder exhaust does not tear the fire, nor carry fuel unconsumed through the flues into the smoke-box and from there out of the smoke-stack, but is sufficient to maintain the necessary rate of combustion in the fire-box, with a decreased velocity of the products of combustion through the flues.

The heating-surfaces of a boiler absorb heat-units from the fire and deliver them to the water at a certain rate. If the rate at which the products of combustion are carried away exceeds the capacity of the heating-surfaces to absorb and deliver the heat to the water in the boiler, there is a continual waste, that can be overcome only by reducing the velocity of the products of combustion passing through the tubes. This is effected by the compound principle. It gives, therefore, not only the economy effected by a smaller consumption of water for the same work, but the additional economy due to slower combustion. It is obvious that these two sources of economy are interdependent. The improved action of the boiler can be obtained only by the use of the compound principle, while the use of the compound principle enables the engine to develop its full efficiency under conditions which in a single-expansion engine would require a boiler of such large capac-

ity as to be out of the question under circumstances usually governing locomotive construction. Also, the compound system prolongs the life of the boiler by decreasing the demand on it for steam.

We will now endeavor to explain the system of compounding, so that it may be understood by the beginner. To many who are handling our present locomotive it seems a difficult question to solve how any effect can be produced by the additional expansion. The back-pressure seems to be the most troublesome point.



Showing the action of two Piston Heads on one rod with Steam between them

FIG. 43.

Those handling engines frequently ask the question: "How can the steam exert any more power after once expanding the high-pressure cylinder? Will not the pressure against the high-pressure piston counteract any power thus derived?"

By referring to Fig. 43 will be seen a simple way of explaining the effect of steam between two pistons on a single piston-rod, as in a tandem compound engine. This applies as well to any other system of condensing or non-condensing compound engine.

Fig. 43, on page 90, shows two piston-heads, *A*, *B*. Piston-head *A* is perhaps three times as large as piston-head *B*. These heads are fastened on one piston-rod. The cylinder is made to suit the diameters of the heads, there being no cylinder-head between these two piston-heads. Having connected the piston-heads and cylinder to suit, the pipe 7 is tapped into the cylinder at *C*. Now when steam is let into the cylinder between the piston-heads *A* and *B*, which way will the pistons move, or will they move at all?

The answer is, that they will move in the direction of the arrow, or with the larger piston-head *A*. This is because of the difference in area of the two piston-heads, they being exposed to the same steam-pressure per square inch. The greater pressure of power is against the larger piston *A*, thus overcoming the pressure against the smaller piston-head *B*. The effective pressure against the piston-head *A* is that represented by the dotted lines, which was resisted in its expansion by the shoulder or head on the cylinder at *X*. Thus it is shown that it is possible to connect two piston-heads on a single rod and get a movement of the piston-heads when the steam is introduced between them, the one piston-head being larger than the other. So it is with the compound engine. The low-pressure cylinders are of a larger diameter than the high-pressure cylinder. Now this figure represents the compound engine exactly. Fig. 44 is a tandem compound or four-cylinder engine. Some builders prefer this principle on account of the power being equal on both sides of the locomotive, and the powers of the high and low pressure in line with the centre-line of motion. One fact should

be particularly understood, that the compound engine is supposed to use the steam that is being exhausted into the atmosphere, directly from the cylinder of a high-pressure simple engine, to a better advantage by expanding it into another cylinder before it escapes into the atmosphere.

To explain this, it will be supposed that a simple engine is being run with a train, and the initial pressure is

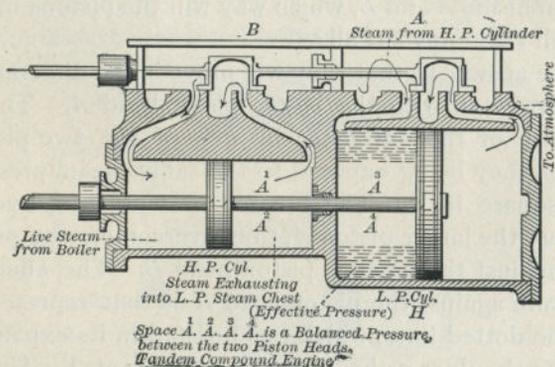


FIG. 44.

one hundred pounds to the square inch in the cylinder. The point of cut-off is one-half stroke: then expansion take place at or near the end of stroke. It is found that the steam has been reduced in its pressure just one half of the initial pressure of one hundred pounds, which makes the terminal pressure fifty pounds per square inch when it escapes into the atmosphere. This terminal pressure varies with the point of cut-off and the initial pressure.

Then it is this high terminal pressure that the compound engine saves by exhausting it into the low-

pressure cylinder, causing it to expand further and to a lower terminal, as in the tandem cylinder.

In Fig. 44 the compounding is clearly shown as follows: *B* is the high-pressure and *A* is the low-pressure cylinder, corresponding to *B* and *A* in Fig. 43; but the two cylinders in this case are separated, or have a head between them, thus making them into two cylinders of different diameters. The two piston-heads are on the same piston-rod, which is connected to the cross-head. A stuffing-box is provided between the two cylinders for the piston-rod. The exhaust-steam from high-pressure cylinder passes to low-pressure chest by the pipe *O*. There are two steam-valves for controlling the inlet and outlet of steam in the cylinders, also the exhaust. As shown, the piston-heads are moving in the direction of the arrow, and the H. P. valves are cutting off steam at half stroke. This is done to illustrate the action of the terminal or exhaust pressure; steam is entering the back end of the high-pressure cylinder from the boiler, the initial pressure is one hundred pounds. The steam that was expanded in the forward end of the high-pressure cylinder whose initial pressure was one hundred pounds, cut-off at one-half stroke, expanded in that end down to fifty pounds, is now being exhausted over into the low-pressure cylinder, as shown by the arrow, and exerting its power against the low-pressure piston-head, thus getting an additional power from the steam that would have been exhausted into the atmosphere, at fifty pounds per square inch.

Then if the volume of the low-pressure cylinder was three times that of the high-pressure, and the steam

was to follow the low-pressure full stroke, the average pressure throughout the whole stroke of the low-pressure cylinder would be one third of fifty pounds, or sixteen pounds.* Thus in this case, instead of a terminal of fifty pounds per square inch, as in the simple engine cutting off at the same point in the high-pressure cylinder of the compound engine, we get a terminal of sixteen. Then by getting this increased expansion in the compound engine it enables the high-pressure cylinder of the compound engine to be reduced in its area below that of the present high-pressure engine, thus reducing the amount of steam used, which represents fuel saved. The total power of the two cylinders in a tandem engine should equal the power of one high-pressure cylinder.

In calculating the power of the compound engine, the average mean effective pressure through the stroke of high-pressure cylinder per square inch is multiplied by the area of that cylinder in square inches; then find the average mean effective pressure in the low-pressure cylinder, multiply that by the area of the low-pressure cylinder, and at the same time deduct from the total power of the low-pressure piston the area of the high-pressure piston-head, multiplied by the average pressure in the low-pressure cylinder. The power remaining after this deduction is the actual power of low-pressure cylinder; this, then, added to the power of the high-pressure piston head, is the total pull or power of the steam pushing the two piston-heads.

Another deduction has to be made from this total

* Omitting fractions.

power, and that is the back-pressure in face of the low-pressure piston-head. This is the total power of the compound engine. Fig. 46 shows the distribution of steam in the cylinders.

Cylinder condensation is a point that is not usually understood,—I mean in the manner in which the term is used in connection with the compound engine. Any change in the temperature of steam causes a change in the pressure of that steam, so that the higher the temperature the more expansive the steam. In compounding, excessive cylinder condensation is thought to be reduced.

Cylinder condensation is caused in the following manner: When a cylinder takes steam, the wall of the cylinder absorbs a certain amount of heat from the entering steam, thus reducing the temperature of that steam and causing a loss in pressure. This action takes place until about the time of exhaust-opening, when re-evaporation takes place, which in a simple engine is exhausted into the atmosphere. The cause of this re-evaporation is, that when the steam has expanded to the point of exhaust it is at the lowest temperature it will reach while in the cylinder at this point, the cylinder walls being hotter than the steam. The steam that was condensed while the walls of cylinder were absorbing the heat from the incoming steam being in the form of water, reabsorbs the heat from the cylinder walls and turns into steam.

Water is a great absorber of heat, and in the compound engine this regenerated steam exerts its pressure against the low-pressure piston-head. In a high-pressure or simple engine, when expansion is long in

the cylinder, it causes a great variation in the temperature of the steam.

If the steam entered the cylinder at one hundred pounds per square inch the temperature would be 338 degrees, and if expanded four times, or twenty-five pounds, the terminal temperature would be 240, leaving the walls at this temperature, so that the incoming steam would again be robbed of some of its heat, to bring the temperature of the cylinder walls up again. In the figures given we find a difference of 98 degrees between the temperature of the steam when it first entered the cylinder and when the exhaust was about to take place; and the amount of heat absorbed by the wall to equalize the temperature is 49 degrees, which causes the condensation spoken of. This condensation is less as the steam follows the piston farther before cut-off takes place, or as the expansion is reduced.

In most compounds the steam is cut off at or near the end of the stroke in the high-pressure and then expanded in low-pressure cylinder.

Keeping the temperature nearly the same in the two cylinders, preventing excessive condensation.

The different systems are being pushed, and there are a great many two-cylinder compound engines running which give satisfaction. In a compound engine simplicity of construction is the main point looked at by some builders. The two-cylinder seems to meet that point. The difference in the two-cylinder compound engine is to be found in the construction of the intercepting-valve. Some work automatically, others work by hand.

The purpose of this valve is, in starting, to introduce live steam into the low-pressure cylinder and cut it off from that cylinder when under way. Some are made so that the engine can be run as a simple engine or compound, at will.

The difference between the four-cylinder engine and the two-cylinder, in handling the exhaust steam from the high to the low-pressure cylinder, is that in the two-cylinder the steam passes into a receiver or steam pipe in the front end or smoke-arch, and there the steam is reheated, as the receiver is exposed to the hot gases coming through the flues. This is a very good feature in a two-cylinder engine.

CHAPTER X.

INDICATOR-CARDS.

THE action of double-expansion in a compound engine is very simply shown by an indicator-card.

An indicator-card is traced on paper by a machine called an indicator, of which the construction is as follows (Fig. 45):

The main part consists of a cylinder, which is attached to the steam-cylinder of which cards are being taken.

In this small cylinder is a piston-head having a piston-rod. To the piston-rod is a pencil-bar, which carries the pencil which traces the card. A spring is on the top of the piston-head to counteract the steam-pressure underneath. The springs are of various tensions, dependent on the steam-pressure used in the cylinder. On the cylinder is attached a revolving barrel, which carries the paper on which the card is traced. This barrel takes its motion from a cord which is fastened to a reducer, the reducer being fastened to the cross-head of the engine. The card then moves the whole stroke of the piston-head in steam-cylinder.

We have given this plain description of the indicator in order to give the reader some idea of how a card is taken. There are some very good books on the indi-

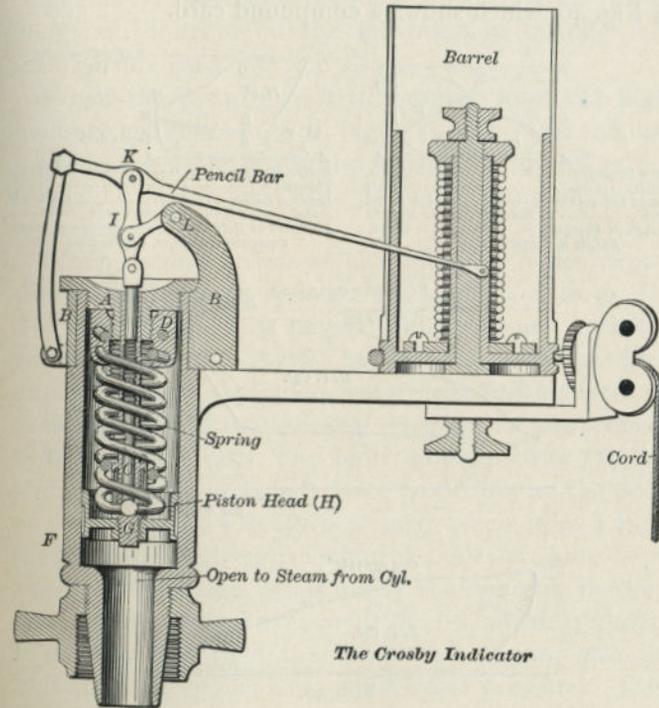


FIG. 45.

cator, such as "Twenty Years with the Indicator," by Thomas Pray, Jr., and others.

The indicator-card shows exactly the distribution and action of the steam in a cylinder, and is traced as in Fig. 46, which shows a compound card.

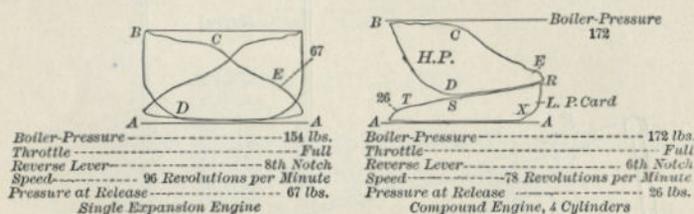


FIG. 46.

The straight line at *AA* is called the atmospheric line. With no steam in the cylinder the pencil would rest on the line *AA*, but when the steam-valve opens the pencil will be moved up to *B*, and as the valve remains open the pencil will trace the line from *B* to *C*, which is called the steam-line. When the valve closes

at *C* then expansion begins, and continues to the point *E*; this is called the point of release. From *E* to *D* is the exhaust and back-pressure line. From *D* to *B* is the compression-line, the valve being closed to the exhaust.

This is the outline of the high-pressure card. There being an indicator on the low-pressure cylinder, the low-pressure card is traced also.

When the steam begins to exhaust from the high-pressure cylinder at *E* on high-pressure card, the low-pressure valve opens and the steam-line from *R* to *S* is traced, while the line from *E* to *D* is traced on the high-pressure card.

When the low-pressure valve closes at *S* the expansion in low-pressure cylinder takes place, as from *S* to *T*; then the exhaust begins, and continues until the valve closes at *X*. As will be seen, the steam has been expanded in two cylinders before exhausting into the atmosphere, and the terminal pressure in low-pressure cylinder is 26 lbs. The boiler-pressure was 172 lbs., and has been expanded down to 26 lbs. at the point of exhaust. In Fig. 46 is a card taken from a high-pressure or single-expansion, the boiler-pressure being 154 lbs., the speed being nearly the same for both engines; the terminal pressure is 67 lbs., which is a much higher terminal than the compound engine; also, the high-pressure engine has a much lower pressure. Then it is this high terminal pressure which the advocates of the compound engine claim is used as an additional power, instead of being exhausted out into the atmosphere as in the single engine, thereby reducing the amount of steam used to do a certain amount of work, and so saving fuel.

CHAPTER XI.

DESCRIPTION OF VARIOUS SYSTEMS OF COMPOUND LOCOMOTIVES.

THE VAUCLAIR OR BALDWIN SYSTEM.

IN designing the "Vauclain" or Baldwin system of compound locomotives, the following results have been sought:

1. To compound an ordinary locomotive with the fewest possible alterations necessary to obtain the greatest efficiency as a compound locomotive.
2. To develop the same amount of power on each side of the locomotive, and avoid the racking of the machinery resulting from uneven distribution of power.
3. To make a locomotive in every respect as efficient as a single-expansion engine of similar weight and type.
4. To insure the least possible difference in the cost of repairs.
5. To attain the utmost simplicity and freedom from complication.
6. To realize the maximum economy of fuel and water.
7. To require the least possible departure from the methods of handling usual with single-expansion locomotives.
8. To permit a train, in case of breakdown, to be brought in without unusual delay, when using but one side of the locomotive.

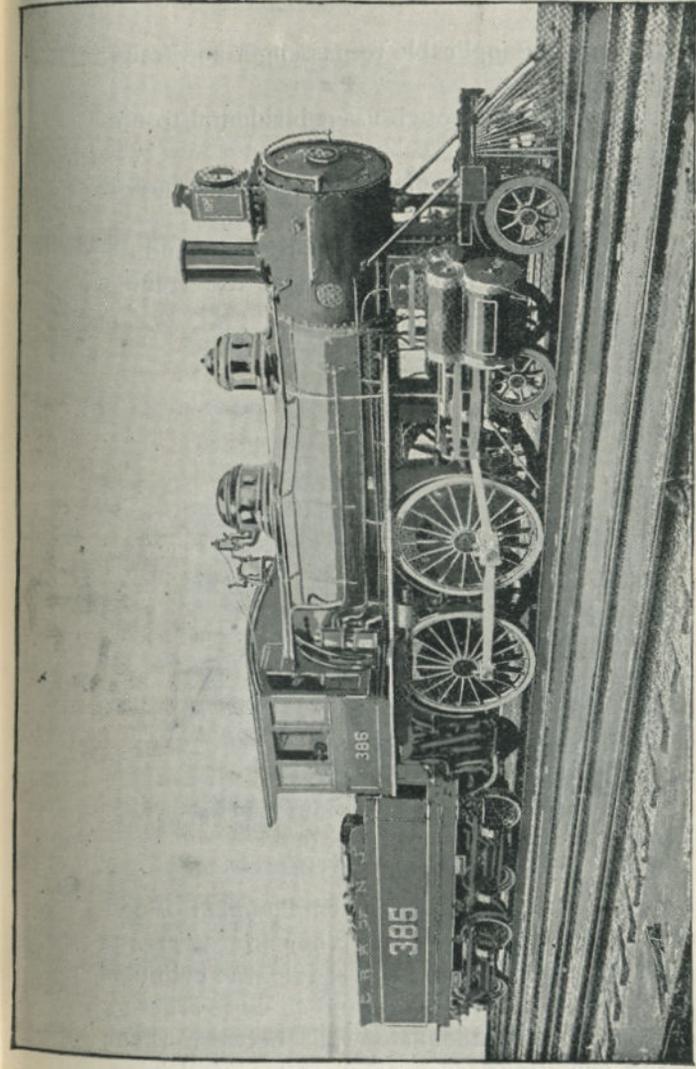


FIG. 47.—EIGHT-WHEELED "COMPOUND" LOCOMOTIVE.

Speed, 1 mile in 37 seconds.

H.-P. Cylinder, 13" Diameter.

L.-P. Cylinder, 22" Diameter.

Stroke, 24".

Driving-wheels, 78" Diameter.

Total Weight, 124,000 Pounds.

Weight on Drivers, 88,000 Pounds.

Total Wheel-base, 22' 3 1/2".
Driving-wheel Base, 7' 6".

9. To be equally applicable to passenger and freight engines.

10. To withstand the rough usage incidental to ordinary railroad service.

The principal features of the construction are as follows:

The cylinders consist of one high-pressure and one low-pressure for each side, the ratio of the volumes

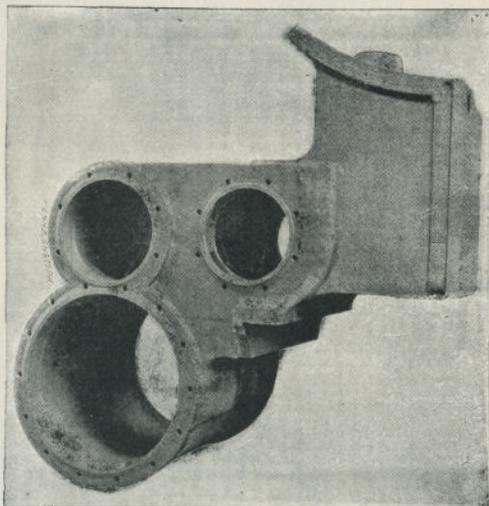


FIG. 48.—CYLINDERS FOR HIGH WHEELS.

being as nearly three to one as the employment of convenient measurement will allow. They are cast in one piece with the valve-chamber and saddle, the cylinders being in the same vertical plane, and as close together as they can be with adequate walls between them. Where the conditions, such as diameter of driving-

wheels and type of engine, will allow, the high-pressure cylinder is put on top, Fig. 48; but where the wheels are low, the position is reversed, Fig. 49. This latter is the practice with consolidation and other engines, where the roadway clearance would interfere should the first position be used. The valve-chamber is placed in the cylinder-saddle between the boiler and cylinders.

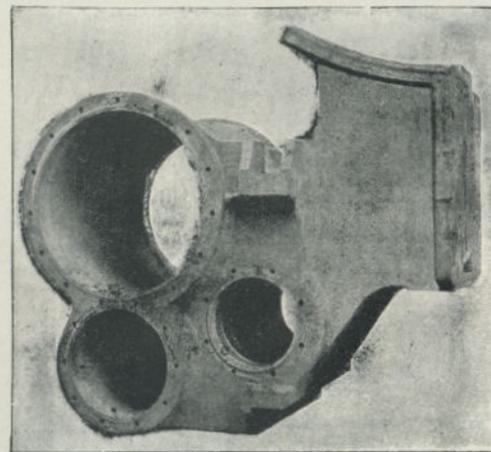


FIG. 49.—CYLINDERS FOR LOW WHEELS.

As the construction of this chamber is such that the steam-passage must be rough-cored, a bushing, in which the ports are accurately slotted, is turned to a neat fit and forced into the valve-chamber. The ports in the bushing are divided at regular intervals by bridges, as shown in Fig. 50. The valve shown by Fig. 51 is of the hollow-piston type, fitted with cast-iron rings sprung into place, after the manner of the ordinary piston-rings.

It is a combination of two D valves in piston form, the two ends of which control the admission and exhaust of steam to and from the high-pressure cylinder, and the inner rings perform the same functions for the low-pressure cylinder.

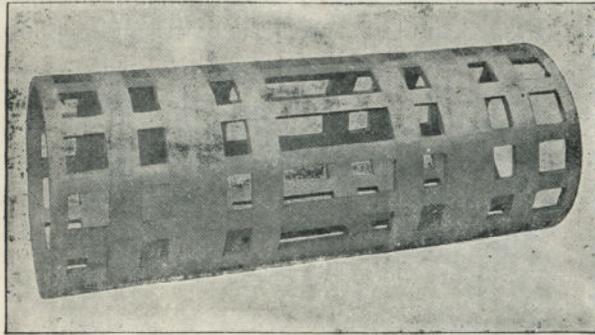


FIG. 50.

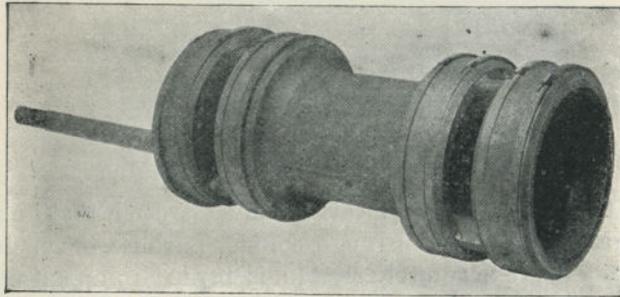


FIG. 51.

Its operation will be clearly understood by Fig. 52. When the low-pressure piston is placed on top, the position of the valve is such as to preclude the use of

the common rocker-box. Case-hardened cross-head and guides are substituted, and operated in direct motion from the links by means of an extension-bar.

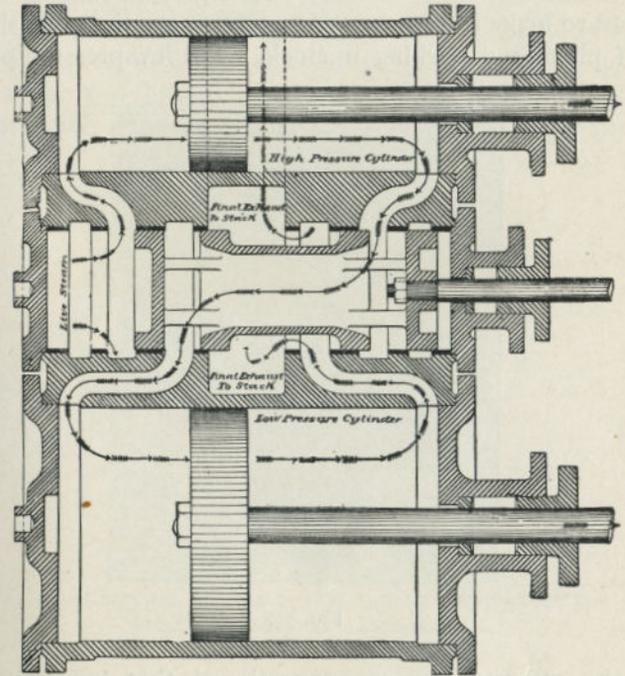


FIG. 52.—DIAGRAM OF THE BALDWIN PATENT COMPOUND CYLINDER AND PISTON SLIDE-VALVE, SHOWING THE COURSE OF THE STEAM.

In this manner the wear is reduced to a minimum, and all parts are made easy of access.

The cross-head, which is shown in Fig. 53, is of cast steel, of a pattern combining great strength with the least possible metal.

The wearing-surfaces are covered with block-tin one-sixteenth inch thick. The piston-rods are of the same size for both high-pressure and low-pressure piston. This is to secure uniformity of parts, ease in fitting up, and to make it unnecessary to carry more than one size of piston-rod packing in stock. The low-pressure pis-

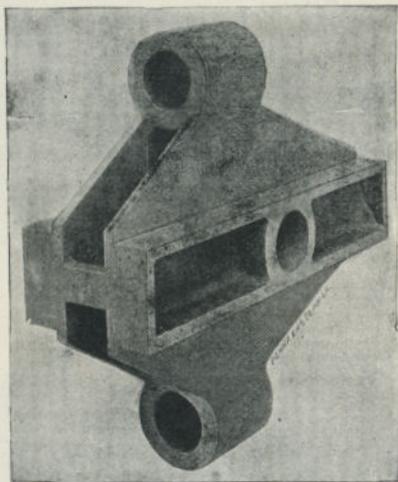


FIG. 53.

tons and rods are so proportioned that in case an excess of pressure is by accident admitted to the low-pressure cylinder they will withstand the strain with an adequate factor of safety.

The starting-valve of the Baldwin Compound is simple in construction, but the action is hardly understood by a great many handling the engine. The operation is as follows:

When the valve is put in position for starting, live steam passes from that end of high-pressure cylinder in which main-valve is admitting live-steam, through the starting-valve to the other end of high-pressure cylinder—bear in mind that the steam-port on this end of high-pressure cylinder is open to the low-pressure steam-port—through the main-valve, which is the course the exhaust-steam would take, Fig. 52. The

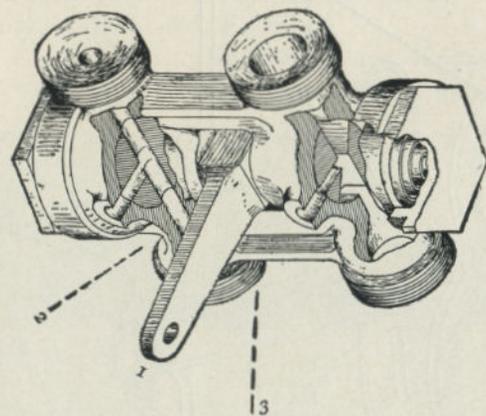


FIG. 54.—COMBINED CYLINDER-COCK AND STARTING-VALVE FOR VAUCLAIN COMPOUND LOCOMOTIVE.

live-steam would follow this same course, exerting its power against the low-pressure piston, and at the same time, at slow speed, put the high-pressure piston-head in nearly an equilibrium.

But the amount of steam that enters the low-pressure cylinder through the starting-valve decreases as the speed increases. The combined starting-valve and cylinder-cock, Fig. 54, consists of a single casting, in

which there are two taper-plugs, one controlling the high-pressure cylinder-cock and the steam for starting, the other controlling the low-pressure cylinder-cock.

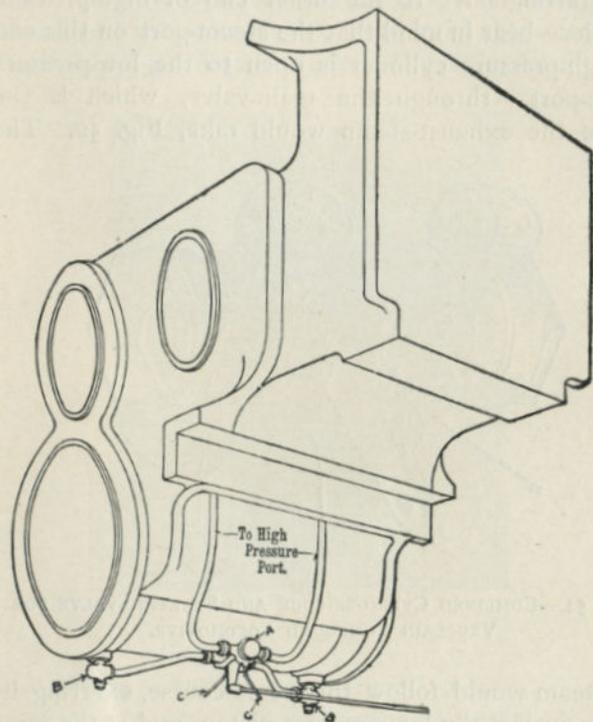


FIG. 55.—COMBINED STARTING-VALVE AND CYLINDER-COCK FOR COMPOUND LOCOMOTIVE.

The two plugs are held in place by springs, and controlled by an arm operated by a lever in cab. The operation is as follows:

In position 1 the starting-valve is open to admit

live steam to the low-pressure cylinder, the cylinder-cocks at the same time being open to the atmosphere.

In position 2 all passages are closed.

In position 3 the starting-valve only is open to admit live steam to low-pressure cylinder. Fig. 55 shows the application. Air-valves to relieve the vacuum in the low-pressure cylinders when the engine is running with steam shut off are placed in each end of the low-pressure cylinders, where cylinder-cocks are ordinarily located. *BB*, Fig. 55.

The combination cylinder-cock and by-pass valve, Fig. 56,* is designed to take the place of independent

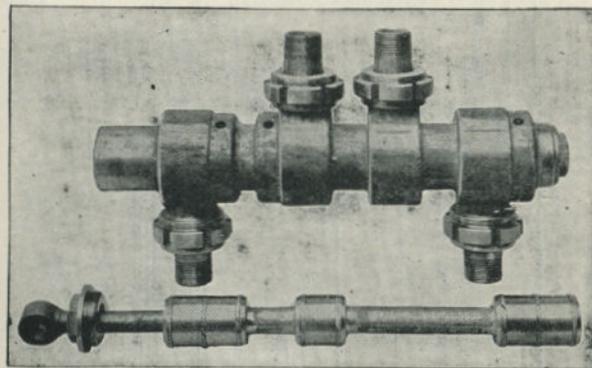


FIG. 56.

cylinder-cocks and by-pass valve for each cylinder, so the whole may be operated by a single lever in the cab.

The construction of this valve is such that by a simple movement of the lever the cylinder-cocks may be opened or closed and at the same time admit live

* Old style.

steam into the low-pressure cylinder, when needed to start a train; or the cylinder-cocks may be closed, the live steam cut off from the low-pressure cylinder, and the engine will be compounding in the most economi-

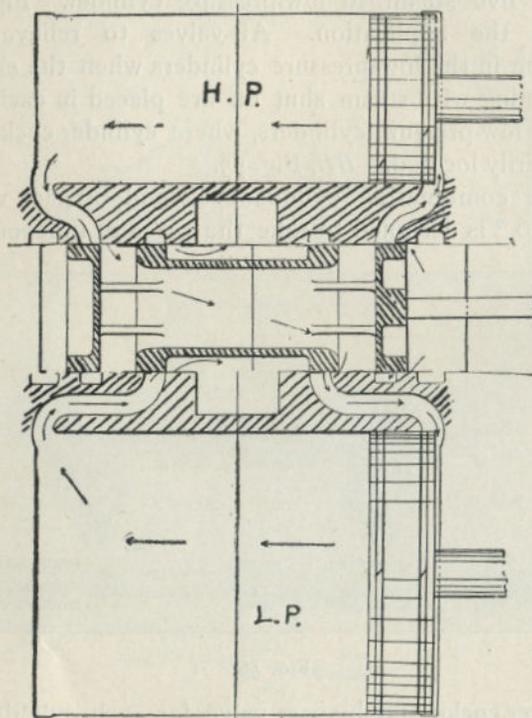


FIG. 57.

cal manner. The valve consists of a cylinder having a connection to each end of the high- and low-pressure cylinders, in which works a plunger with three piston-heads fitted with packing-rings. These piston-heads

are so spaced that by a change of their position in the cylinders the desired results described above are obtained. These are the only points of difference between a Vaucrain compound and a single-expansion locomotive. The compound is operated the same as an ordinary engine, with the exception of the by-pass or intercepting valve, which is used only in starting to admit high-pressure steam to the low-pressure cylinders.

ACCIDENTS WITH THE BALDWIN COMPOUND.

When a main steam valve-rod on a Baldwin Compound is broken or disconnected, what must be done in order to bring the engine in?

The valve must be put in the centre of the seat, covering all the ports on that side. Take down main-rod and block cross-head as for a simple engine. (See Fig. 57 for position of valve.) This rule applies for both engines, as they are the same in construction.

Can a Baldwin Compound be run with both sides if a low-pressure cylinder-head is broken out?

The engine can be run with a low-pressure cylinder-head broken out with both sides without disconnecting.

What would be the course of the steam on the broken side?

The steam from one end of the high-pressure cylinder would pass into low-pressure cylinder, and from there into the stack; but from that on which head is broken out the steam would pass out into the atmosphere through open end of cylinder.

Would it be policy to disconnect in a case of this kind?

It would, on account of the escaping steam interrupting the view of the engineer, if far to go, when broken on his side. But when the piston-head breaks from the cross-head, goes out of the cylinder, the steam escapes from both ends of high-pressure cylinder into atmosphere through open ends of low-pressure cylinder.

Has a Baldwin compound ever been run with both low-pressure cylinder-heads broken out?

They have been run for some distance this way.

How many exhausts is there on the fire running with both low-pressure cylinder-heads broken out?

Only two per revolution.

Can a Baldwin Compound be run with the high-pressure piston-heads taken out of cylinders?

The engine can be run in this manner by putting a board or washer across the stuffing-box, bolting it fast. This will make it steam-tight. The steam-valve will supply steam to the low-pressure cylinder.

What would be the course of the steam?

The steam would enter the high-pressure cylinders, pass from there through the main steam-valves into the low-pressure cylinders, these cylinders acting as a high-pressure engine.

When a main-rod breaks or is disconnected, what should be done?

The valve put in centre of seat on that side covering all ports blocking cross-head; run with the other side.

On engines using the direct motion for the valves, the end of valve steam is carried on cross-head, sliding between guides.

What is a good way to fasten the valve?

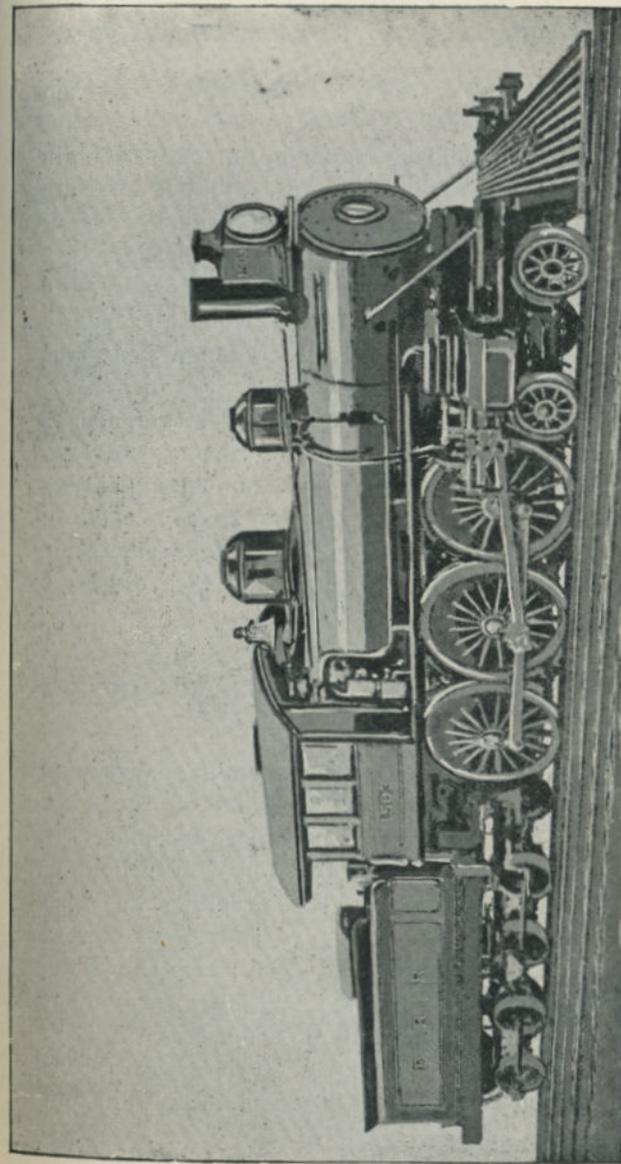


FIG. 58.—TWO-CYLINDER COMPOUND PASSENGER LOCOMOTIVE FOR THE PENNSYLVANIA RAILROAD,
BUILT BY THE SCHENECTADY LOCOMOTIVE WORKS, SCHENECTADY N. Y.

Cylinders H.P., 20" x 24"
Cylinders L.P., 31" x 24"
Driving-wheels 74"

Total Weight, 138,000 pounds.

On Drivers, 102,000 pounds.

Boiler Diameter, 58'.

Fire-box 96 $\frac{1}{8}$ " long.

" " 39 $\frac{1}{2}$ " wide.

Pressure, 180 pounds.

Put the valve in centre of seat, and put blocks each side of small cross-head.

If the small equalizing-valve in the end of main steam-valve is broken or taken out, would it interfere with the working of the engine on that side?

It would convert that side into a high-pressure engine. The work would be done by the low-pressure cylinder, the high-pressure piston would be nearly balanced; this would occur also when a head was broken out of the main steam-valve.

When running along and not using steam, always open the cylinder-cocks; this will prevent the low-pressure piston from creating a vacuum in high-pressure cylinder, and causing the packing to be picked up by the high-pressure piston-rod; this is injurious to the packings, when the engine is equipped with old style of starting-valve. (See Fig. 56.)

IMPROVEMENTS IN BALDWIN COMPOUND LOCOMOTIVE, VAUCLAIN SYSTEM.

Fig. 59 shows a means for preventing a vacuum being formed in the steam-passages of the L.P. cylinders. In some engines air-valves are placed in these passages; these valves are wing-valves held to the seat by the steam-pressure while running, but open when steam is shut off. Fig. 59 is a cross-section through main piston-valve and ports; also shows the starting or by-pass valve-piping and lever attachment and the position of the water-relief valves on L.P. cylinder. Instead of the usual air-valves the piston-valve rod is made hollow and bored full of holes in that

portion. In the interior of valve on the outer end of this hollow valve-stem is placed an air-valve which closes with the pressure of steam, but opens when there is no pressure. This valve is carried back and forth by the main valve-stem and this necessitates a stuffing-box at

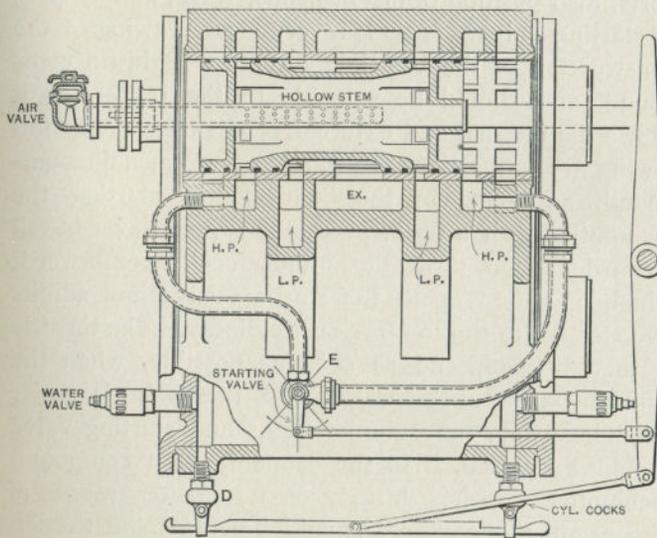


FIG. 59.

each end of the main valve-chest. The action is as follows: When the engine is drifting, using no steam, the air-valve drops away from its seat against a stop-pin provided in casing; the air can then pass into hollow stem and through holes into low-pressure passages, preventing a vacuum therein. The purpose of the by-pass valve is to equalize the pressure on each side of the high-pressure piston-head and admit live steam into the low-pressure cylinder when starting

away. This valve is attached to the cylinder-cock lever, as shown, but is often supplied with a lever to operate independent of the cylinder-cock lever.

Fig. 60 is a view showing general arrangements of cylinders, with section through steam-chest valve and ports, also position of piston-heads, valve, and by-pass or starting-valve. This is a very clear drawing of the construction of the Vaucrain system or Baldwin compound, and should be valuable to the reader, as it shows the internal and external mechanism. The following are suggestions for running the Vaucrain compound, as issued by the builders. In starting the locomotive with a train, place the reverse-lever in full forward position, throw the cylinder-cock lever forward, which operation opens the starting-valve and admits live steam into the low-pressure cylinder. The throttle is then opened, and as soon as possible, when the cylinders are free of water, and the train is under good headway, the cylinder-cocks and starting-valve should be closed. As the economy of a compound locomotive depends largely on its greater range of expansion, the engineer should bear in mind that in order to get the best results, he must use his reverse-lever. After starting-valve is closed, and as the speed of the train increases, the reverse-lever should be hooked back a few notches at a time until the full power of the locomotive is developed. If after moving the reverse-lever to the last notch, which cuts off the steam at about half stroke in the high-pressure cylinder, it is found that the locomotive develops more power than is required, the throttle must be partially closed and flow of steam to cylinders reduced. On slightly

descending grades the steam may be throttled very close, allowing just enough steam in the cylinders to

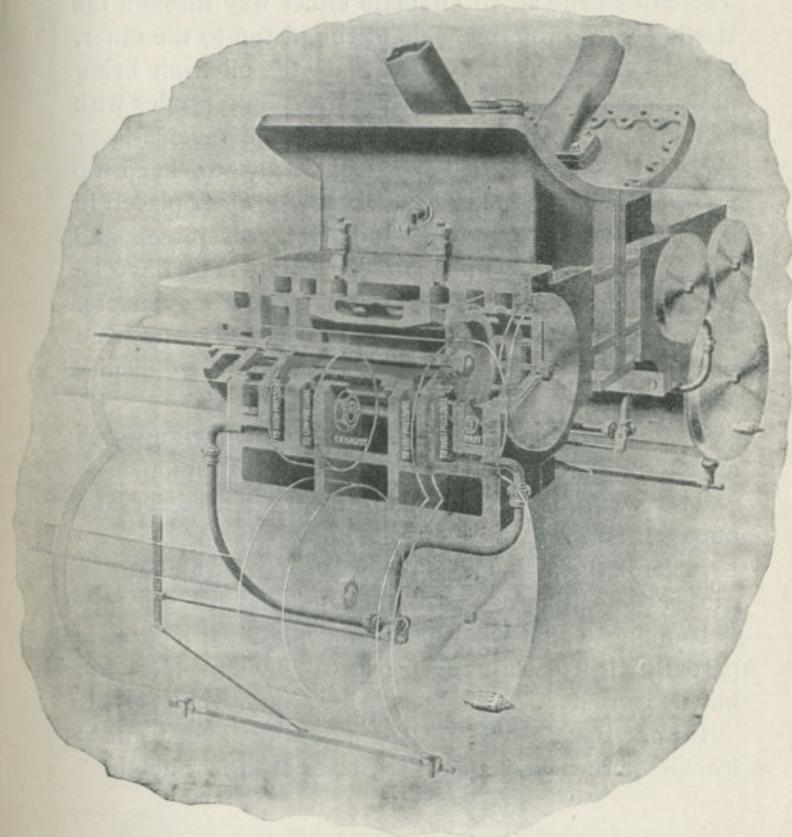


FIG 60.—VIEW SHOWING GENERAL ARRANGEMENT OF CYLINDERS, WITH SECTION THROUGH STEAM-CHEST VALVE AND PORTS.

keep the air-valves closed. If the descent is such as to prevent the use of steam, close the throttle and move

reverse-lever gradually to the full forward notch and move the starting-lever to its full backward position. This allows the air to circulate either way through the starting-valve from one side of the piston to the other, relieves the vacuum, and prevents the oil from being blown out of the cylinder. On ascending grades with heavy trains, as the speed decreases the reverse-lever should be moved forward sufficiently to keep up required speed. If after the reverse-lever is placed in the full forward notch the speed still decreases and there is danger of stalling, the starting-valve may be used, admitting steam to the low-pressure cylinders. This should be done only in cases of emergency and the valve closed as soon as possible after the difficulty is overcome.

The reverse-lever should never be hooked up until after the cylinder-cock lever is in central position.

The starting device should never be used for any purpose than starting the train.

Placing the cylinder-cock lever in central position causes the engine to work compound.

Running with starting-valve open and with throttle partially closed, with reverse-lever hooked up in top notch, is wasteful, using an excessive amount of coal.

Do not open by-pass valve admitting live steam to low-pressure cylinder until the lever is in last notch.

TWO-CYLINDER OR CROSS COMPOUND FOR NORFOLK AND WESTERN RAILWAY.

In designing this type of compound locomotive, the essential feature sought was to provide an intercepting

and reducing mechanism which would permit the engine to work as a single-expansion engine until such

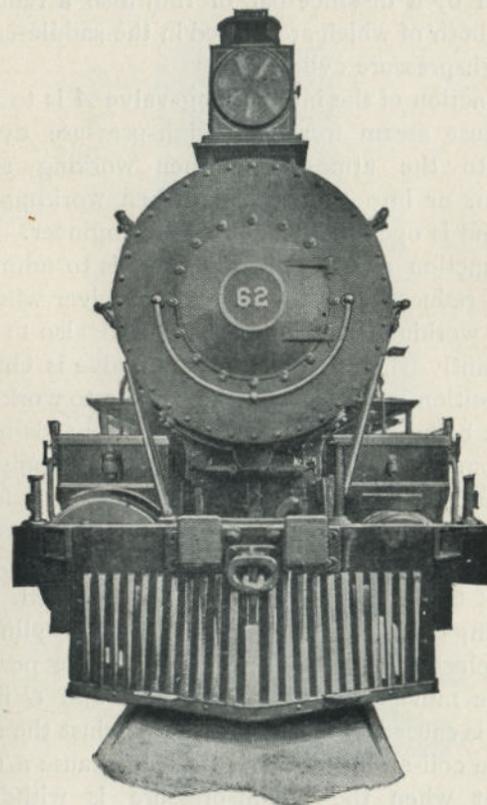


FIG. 61.—FRONT ELEVATION, TWO-CYLINDER COMPOUND.

time as the engineer desired to change it to a compound. To obtain this result, the normal condition of the parts employed is such that the engine will start at any point of the stroke and any position of the cranks.

To accomplish this, an intercepting-valve *A* (Figs. 63 and 64) is employed, consisting of two pistons connected by a distance-bar or rod, also a reducing-valve *C*, both of which are placed in the saddle-casting of the high-pressure cylinder.

The function of the intercepting-valve *A* is to divert the exhaust steam from the high-pressure cylinder either into the atmosphere when working single-expansion, or into the receiver when working compound, and is operated at will by the engineer.

The function of the reducing-valve is to admit live steam at reduced pressure into the receiver when the engine is working single-expansion, and also to close itself instantly when the intercepting-valve is changed to the position which causes the engine to work compound; it being evident that the receiver needs no live steam from the boiler when receiving its supply from the exhaust of the high-pressure cylinder. A further function of the reducing-valve is to regulate the pressure in the receiver so that the total pressure upon the pistons of the two cylinders will be equalized. The intercepting- and reducing-valves are both cylindrical in form, placed in bushings in which suitable ports are cut. The movement of the valves *A* and *C* in one direction is caused by steam-pressure against the action of suitable coil-springs. These springs cause a return movement when the steam-pressure is withdrawn. These valves are controlled by steam supplied through pipes *D* from the operating-valve in the cab.

The reducing-valve *C* is operated automatically by the pressure in the receiver when not closed permanently by the steam in the operating-pipe *D*. For

this purpose the port *E* is provided, connecting the receiver with the large end of the reducing-valve piston, under the poppet-valve *F*, which remains open

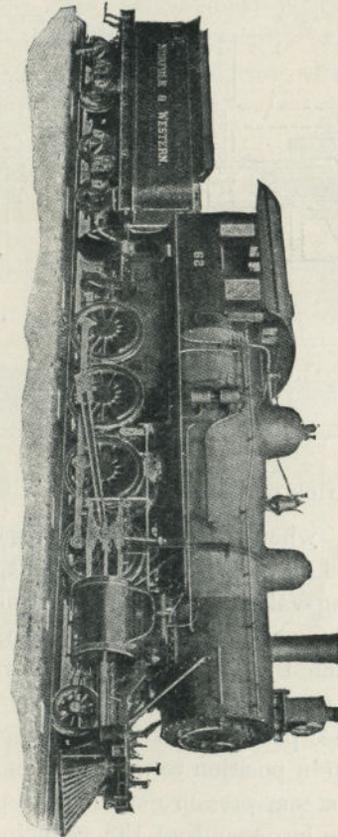


FIG. 63.—TWO-CYLINDER COMPOUND, NORFOLK AND WESTERN RAILWAY.

as long as the engine is working compound, the poppet-valve *G* being held closed by the same pressure, thus preventing its escape to the atmosphere. This

pressure, acting on the large end of the reducing-valve, causes it to close the steam-passage *H* between the live-steam passage of the high-pressure cylinder and

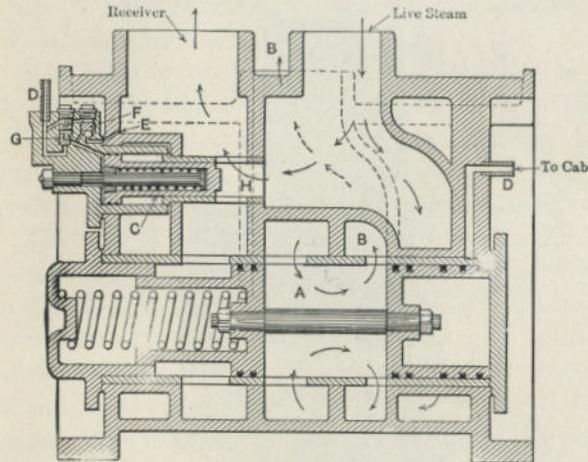


FIG. 63.—POSITION OF VALVE RUNNING AS A SIMPLE ENGINE.

the receiver, when the receiver pressure becomes excessive, and *vice versa* when deficient, the two ends of the reducing-valve being so proportioned that equal cylinder power will be given to both sides of the engine. When the engine is in its normal condition the lever of the small operating-valve in the cab is placed at the position marked "simple," and the engine is then in position to work as a single-expansion engine, the steam-pressure against the intercepting-valve and the large end of the reducing-valve being relieved, permitting the valves to assume (by the action of the springs) the position shown in Fig. 63. The ports of the intercepting-valve *A* stand open to receive

the exhaust-steam from the high-pressure cylinder and deliver it to the auxiliary exhaust-passage *B*, and through it to the atmosphere. At the same time the reducing-valve is wide open, connecting the live-steam passage *H* with the receiver, through which live steam enters and charges the receiver from which the low-

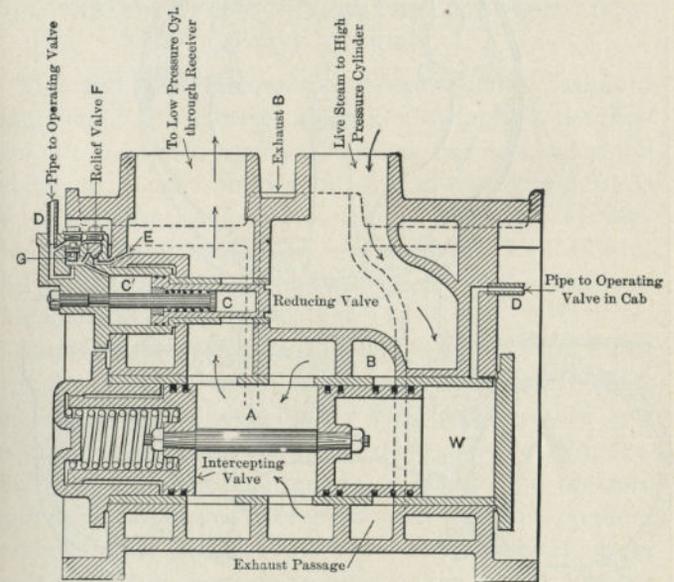


FIG. 64.—POSITION OF VALVE WHEN ENGINE IS OPERATING AS A COMPOUND.

pressure cylinder derives its supply. The receiver-pressure is governed by the automatic action of the reducing-valve, previously explained.

Thus the engine can be used as a single-expansion engine to make up trains and start them, and at the will of the engineer the operating-valve in the cab can

be moved to position marked "compound," which will admit steam to the supply-pipes *D*, thence to the cylinder *W*, and cylinder *C*, changing the intercepting-

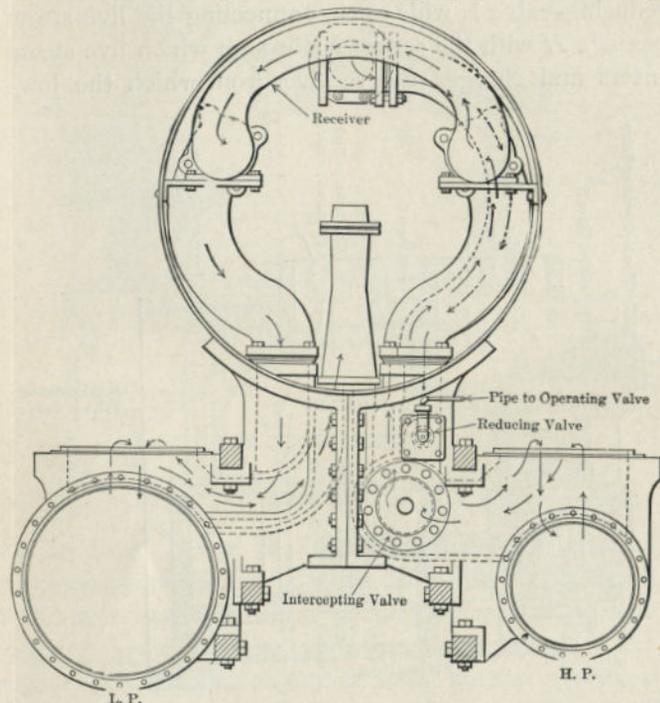


FIG. 65.—VIEW SHOWING RECEIVER AND STEAM-PIPE IN FRONT END.

The arrows show the course of the steam from H.P. to L.P. cylinder and to exhaust.

and reducing-valves instantly and noiselessly to position, as shown in Fig. 64, diverting the exhaust from the high-pressure cylinder to the receiver, instead of to the atmosphere, and closing the passage *H* between the live-steam passage and the receiver at the reduc-

ing-valve. All the parts liable to wear are made of the piston type, depending on packing-rings instead of ground-joints for prevention of leakage, and at the same time prevent the hammering action so common with valves of the poppet type automatically arranged.

THE TANDEM COMPOUND OF THE BALDWIN LOCOMOTIVE WORKS.

The Baldwin Locomotive Works build "tandem compound" locomotives. The following is a description of a decapod engine which has been built for the Atchison, Topeka and Santa Fé Railway from designs of John Player, Consulting Superintendent of Machinery of the Atchison, Topeka and Santa Fé Railway, and S. M. Vaucrain, Superintendent of the Baldwin Locomotive Works.

In this locomotive there are four cylinders, a high- and low-pressure cylinder and cylindrical valve-chest on each side of the engine. The high-pressure cylinder is placed in front of the low-pressure cylinder, their axes being concentric. The high-pressure cylinder with its valve-chest and the low-pressure cylinder with its valve-chest are cast separately from each other and from the saddle. The steam-connection is made by a pipe from the saddle to the high-pressure valve-chest, and the final exhaust is made by a connection with the saddle from the low-pressure cylinder through a stuffing-box. The juncture of the cylinders and valve-chests to the saddle is therefore perfectly solid, as there is nothing to prevent the parts coming into solid contact. The connection between the two steam-chests is made in a similar manner, but

with bolts placed in such a way that they serve to fasten the stuffing-box gland and at the same time hold the valve-chambers together. The cylinders are fastened together with ground-joints and held in correct alignment by having the flanges counterbored so that the intermediate head enters each casting. A glance at Figs. 66 and 67 will make clear this construction.

The valve is of the balanced-piston type. It is formed practically of two valves joined together on a rod. The high-pressure valve admits live steam to the high-pressure cylinder, exhausts it through the centre of the valve to the low-pressure valve, which admits it to the low-pressure cylinder and finally exhausts it by means of the valve through the stuffing-box connection to the saddle and out the stack. The valve-motion is connected indirectly with the links by a rock-shaft as in ordinary locomotive practice.

The pistons in the high- and low-pressure cylinders are on a continuous rod passing through the intermediate head between the cylinders, and work simultaneously.*

This form of compound is advantageous for extraordinarily large engines intended to haul heavy loads on steep grades. The guides, cross-heads, and rods can be made quite light, and so maximum power can be produced with minimum weight of reciprocating parts.

An important feature of this type of compound is that the packing between the high-pressure and low-

* See Fig. 108, page 201, for similar construction.

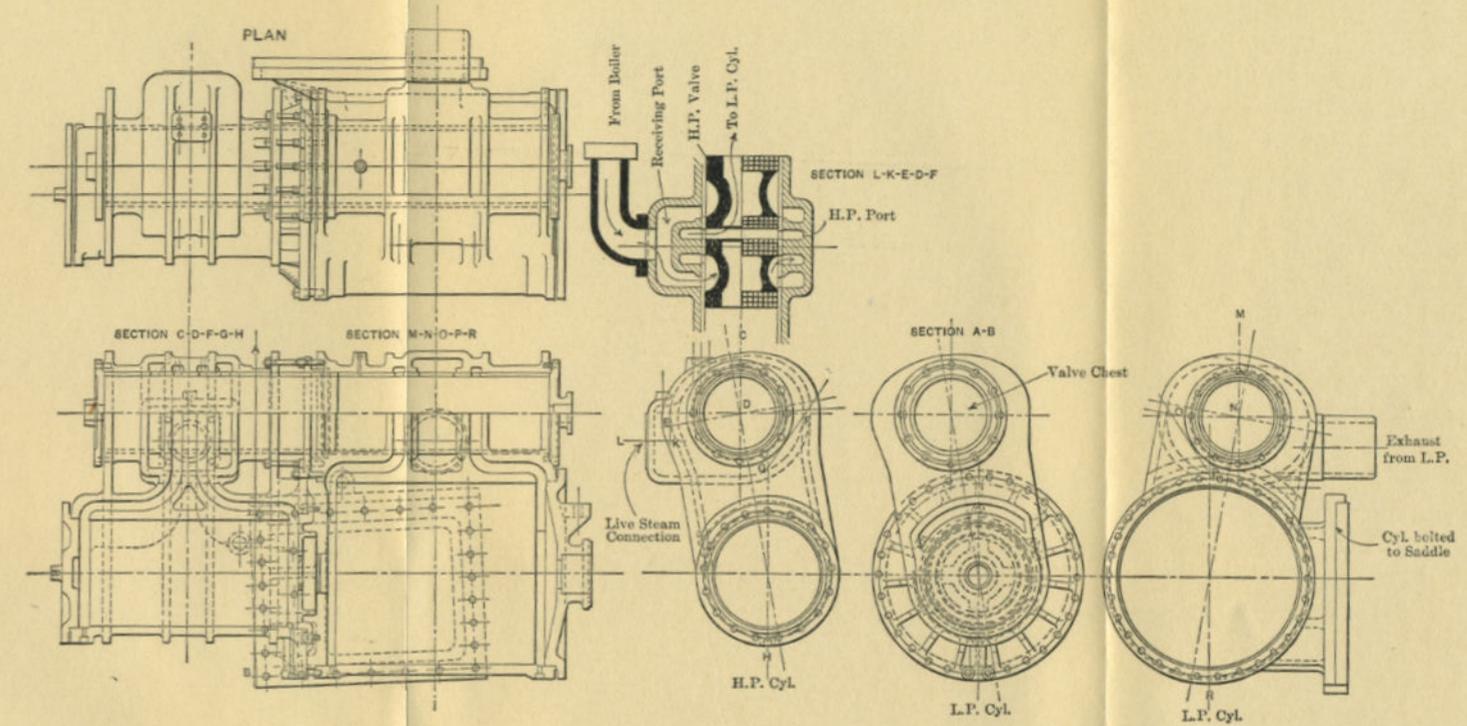


FIG. 66.—LONGITUDINAL SECTION THROUGH CYLINDERS AND VALVE-CHEST.

[To face page 128.]

pressure cylinders, which is of a type that will wear well, is in a position where it is protected from dirt and rust and will last for a long time.

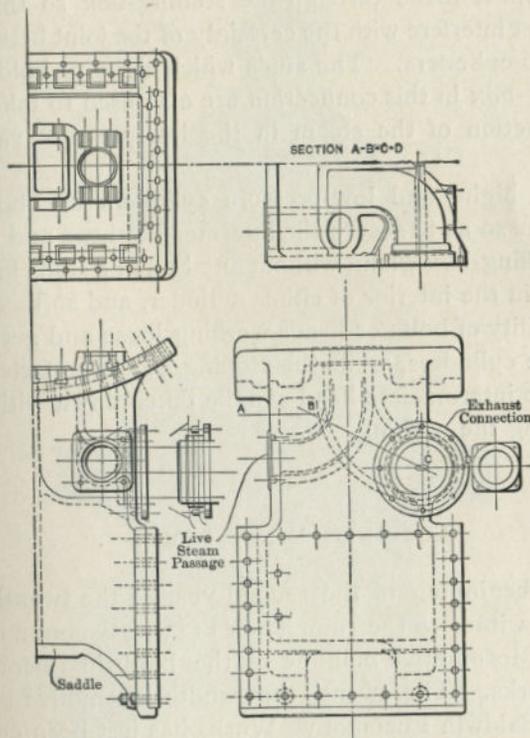


FIG. 67.—SHOWING LIVE STEAM AND EXHAUST PASSAGE THROUGH SADDLE.

The connection of the cylinders with the saddle and with each other is also a special advantage. The connection for the supply-pipe and for the exhaust from the cylinders to the saddle is made in such a way as

not to interfere in any way with the secure fastening of the cylinders with the frame. The connection between the valve-chambers of the high- and low-pressure cylinders is made through the stuffing-box so that it does not interfere with the certainty of the joint between the two cylinders. The studs which serve to hold the stuffing-box in this connection are also used to take up the reaction of the steam in the low-pressure valve-chest.

The high- and low-pressure cylinders are bolted together so as to secure the intermediate head and also the stuffing-box gland without any bolts or studs being placed in the interior of either cylinder, and so there is no liability of bolts or heads working loose and getting into the cylinders, while the stuffing-box is so fastened that the intermediate head can be taken down without removing the packing.

LOCOMOTIVE NO. 20000.

The beginning of the second year of the twentieth century witnesses the completion of seventy continuous years of locomotive building by the Baldwin Locomotive Works. The twenty-thousandth locomotive built by the Baldwin Locomotive Works has just been completed, and a contrast between the pioneer steam locomotive engine of this country and the twenty-thousandth is interesting and a departure from American practice. Locomotive No. 20000 is a compound ten-wheeled passenger engine, built for the Plant system of railroads, and completed in February, 1902.

The special features of construction are the Vaucain four-cylinder balanced system of compounding, the

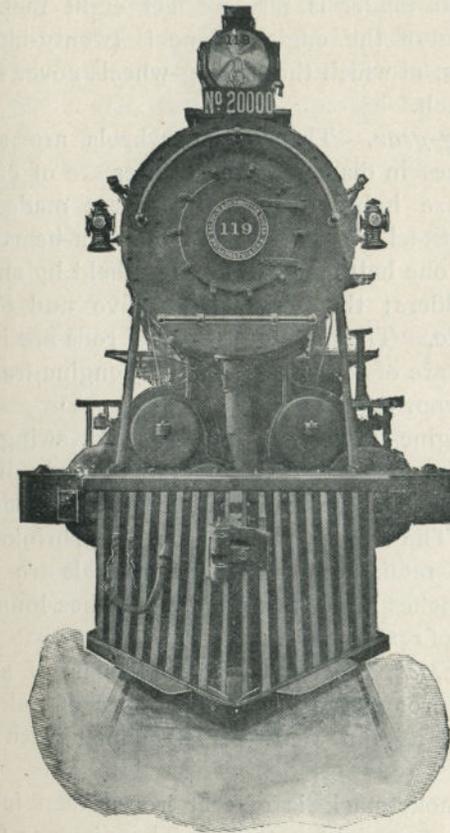


FIG. 68.

Vanderbilt boiler and tender, and the Symons boltless cast-steel tender-truck. The locomotive weighs, in working order, 176,510 pounds, 127,010 pounds of

which are on the driving-wheels; the tender weighs, loaded, 99,000 pounds. The total wheel-base of engine and tender is fifty-six feet eight inches; the wheel-base of the engine alone is twenty-eight feet four inches, of which the driving-wheels cover fourteen feet one inch.

Running-gear.—The driving-wheels are seventy-three inches in diameter; the centres are of cast steel with bronze hub-plates; the tires are made by the Standard Steel Works and are of open-hearth steel, three and one half inches thick, and held by shrinkage and shoulders; they are flanged five and one half inches wide. The main and parallel rods are in I sections and are of forged steel. The engine-frame is of wrought iron.

The engine-truck is a four-wheeled swing-bolster truck. The wheels are thirty-three inches in diameter, spoke-centres of cast steel, made by the Standard Steel Works. The tires are of steel held by shrinkage and double-lip retaining-rings. The journals are five and one half inches in diameter and ten inches long. The axles are of open-hearth steel.

Pilot, Stack, and Cab.—The pilot is of seasoned oak, well ironed, and with a bumper of oak. It is fitted with a Janney M. C. B. coupler with hinged head.

The smoke-stack is of cast iron fifteen inches in diameter, of straight pattern. The distance from the top of the rail to the top of the stack is fifteen feet six inches.

The cab is made of southern yellow pine well seasoned. It is fitted inside, besides the engineer's

and fireman's seats, with time-table pockets, torch rest, pockets for flags and torpedoes, Golmar automatic bell-ringer, one Hancock composite injector Nos. 9 and 10, Nathan triple-sight feed-lubricator, Crosby vertical reading-gauge, six-and-three-quarter-inch face, having black dial with one large pointer to indicate steam-pressure boiler is carrying and one smaller pointer to indicate varying pressures; also with glass water-gauge and lamp.

Boiler and Fire-box.—The boiler and fire-box, Figs. 69 and 72, embody the invention of Cornelius Vanderbilt, M.E. The boiler-sheets are of steel, seventeen thirty-seconds and eleven sixteenths inches thick, having longitudinal butt-seams, sextuple riveted, and with welded ends. The lagging is of sectional magnesia and the jacket is of American planished iron. The boiler is sixty-two inches in diameter at the smoke-box end and is designed for a working steam-pressure of 200 pounds. It is subjected to a steam test of 250 pounds and a water test to one third above the working-pressure. The boiler carries one helmet-shaped dome thirty inches in diameter, placed centrally, and an auxiliary dome, near the cab, furnished with two Coale three and one half inch muffled safety-valves, encased with one relief-valve set to 200 pounds, and a chime whistle. The smoke-box is extended, with spark-hopper, netting, and deflecting plate, and has a cinder valve-spout extending below the truck-axle. The boiler contains 341 tubes of No. 11 wire gauge, two inches in diameter and fifteen feet long, made of solid drawn high-carbon steel. The tubes are swaged for copper ferrules at one end. They are

prossered at the fire-box end, rolled at front end, and beaded on both ends.

The total heating surface of the boiler is 2793 square feet, of which 128 square feet are in the fire-box and 2665 square feet are in the tubes.

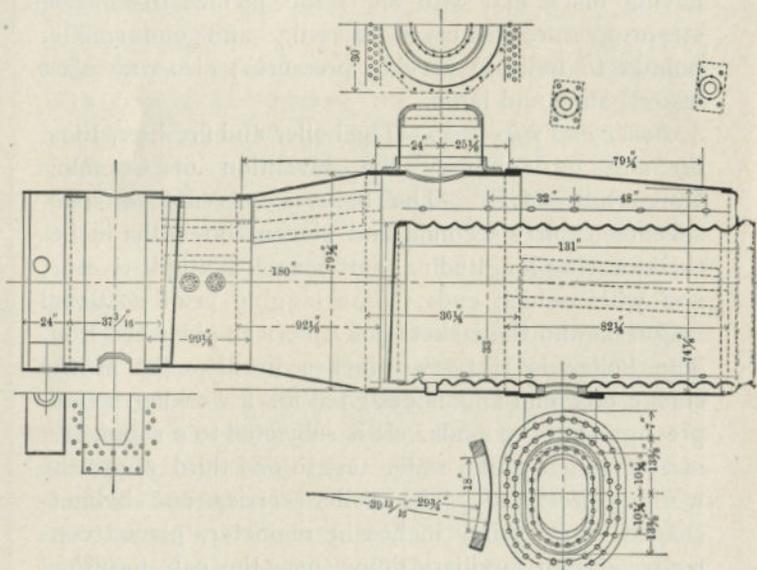


FIG. 69.

The fire-box, which is cylindrical in form with annular corrugations, is the special feature of the Vanderbilt boiler. It is of carbon steel, 131 inches long and fifty-five inches diameter inside, welded and corrugated by The Continental Iron Works of Brooklyn. It is suspended within the cylindrical shell of the boiler with its axis eccentric to that of the boiler, in order to allow suitable steam-space above the crown. The principal

point of suspension is at the rear, where it is riveted to the back head of the boiler; it is also supported at the bottom by the reinforcing-rings around the openings provided for cleaning the furnace, otherwise the fire-box is entirely disconnected from the boiler-shell.

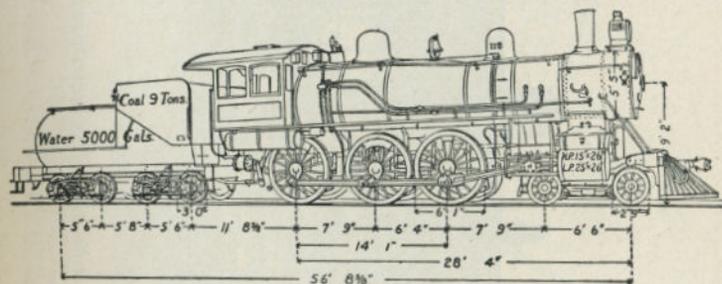


FIG. 70.

By this construction all the flat surfaces ordinarily encountered in a locomotive boiler are eliminated, and the use of stay-bolts is entirely avoided. By doing away with the stay-bolts a saving is made not only in the stay-bolts themselves, but the weakening of the plate, by reason of corrosion around the stay-bolts, especially where bad water is encountered, is avoided. By disconnecting the fire-box from the outer shell, as is done in the Vanderbilt boiler, the destructive effects of contraction and expansion are reduced and the need of stay-bolts is entirely avoided.

The grate is designed for burning soft coal and contains 27.27 square feet. The fire-box contains a fire-brick bridge-wall against which the flames and products of combustion impinge and which prevents the flues from becoming choked by coal and cinders. The

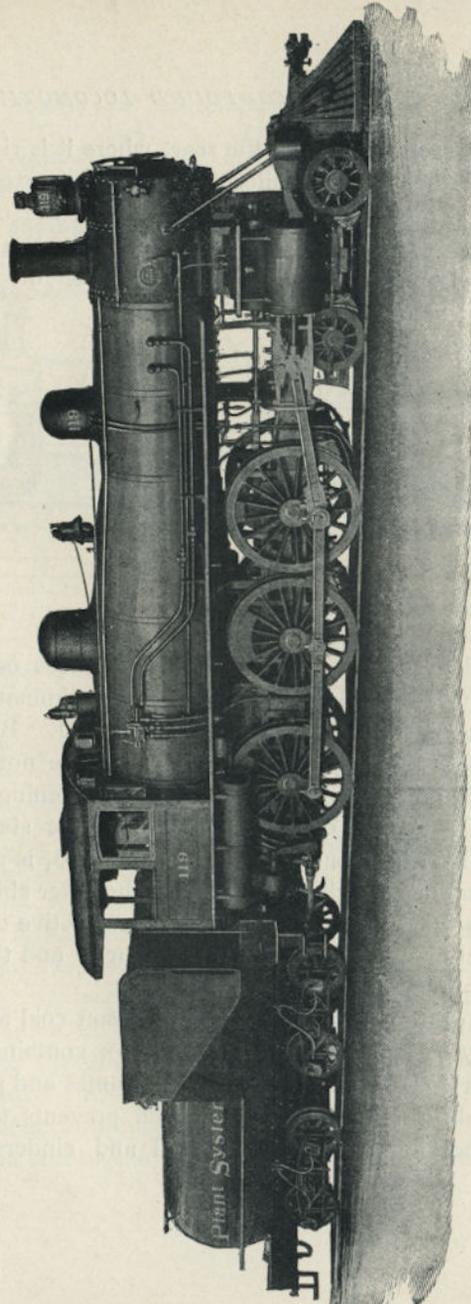


FIG. 71.—VAUCLAIN FOUR-CYLINDER COMPOUND LOCOMOTIVE, BALANCED SYSTEM.

grate is made to rock in two sections and the ash-pan has dampers front and back.

Tender.—The tender is also constructed from designs

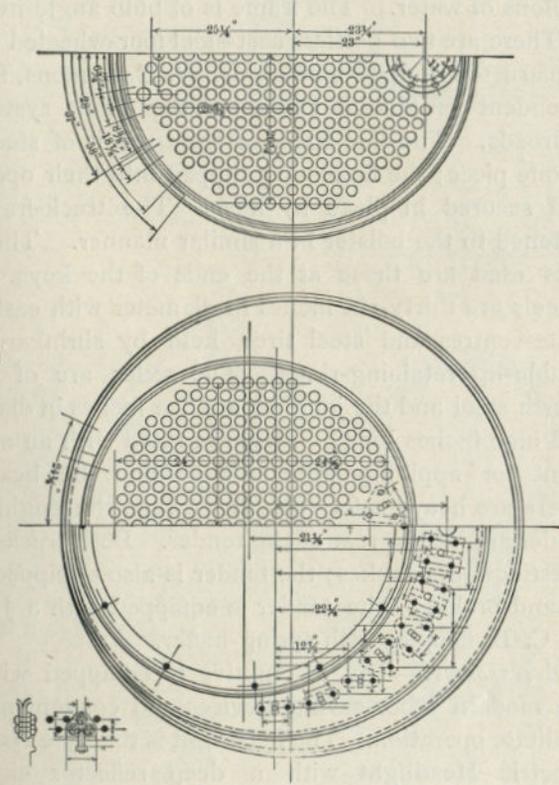


FIG. 72.

of Mr. Vanderbilt. The circular form of tank is introduced principally on account of the economy of construction. Besides this advantage, however, it is found that the strength is greater in proportion to the weight, and that the capacity for fuel in proportion to the

amount of water is larger than in the ordinary type, and the disposition of the fuel is more convenient. The tender carries nine net tons of coal and 5000 gallons of water. The frame is of bulb angle iron.

There are two boltless cast-steel four-wheeled trucks constructed from designs of Mr. W. E. Symons, Superintendent of Motive Power of the Plant system of railroads. The side frame of the truck is of steel cast in one piece; the boxes are slipped into their openings and secured in place by keys. The truck-frame is fastened to the bolster in a similar manner. The only nuts used are those at the ends of the keys. The wheels are thirty-six inches in diameter with cast-steel plate-centres and steel tires, held by shrinkage and double-lip retaining-rings. The axles are of open-hearth steel and the journals are five inches in diameter and nine inches long. They are fitted with an attachment for applying water for cooling the bearings. There are heavy safety chains between the engine and tender and at the rear of the tender. Both trucks have Westinghouse brakes; the tender is also equipped with a hand-brake. The tender is equipped with a Janney M. C. B. coupler with spring-buffer.

Accessories.—The locomotive is equipped with all the modern labor-saving devices and conveniences to facilitate operation. The headlight is the Pyle National Electric Headlight with a deep reflector eighteen inches in diameter. The dynamos for the headlight are located on top of the boiler, near the front of the cab. These dynamos also supply power for lights in the cab and under the foot-board to facilitate oiling at night.

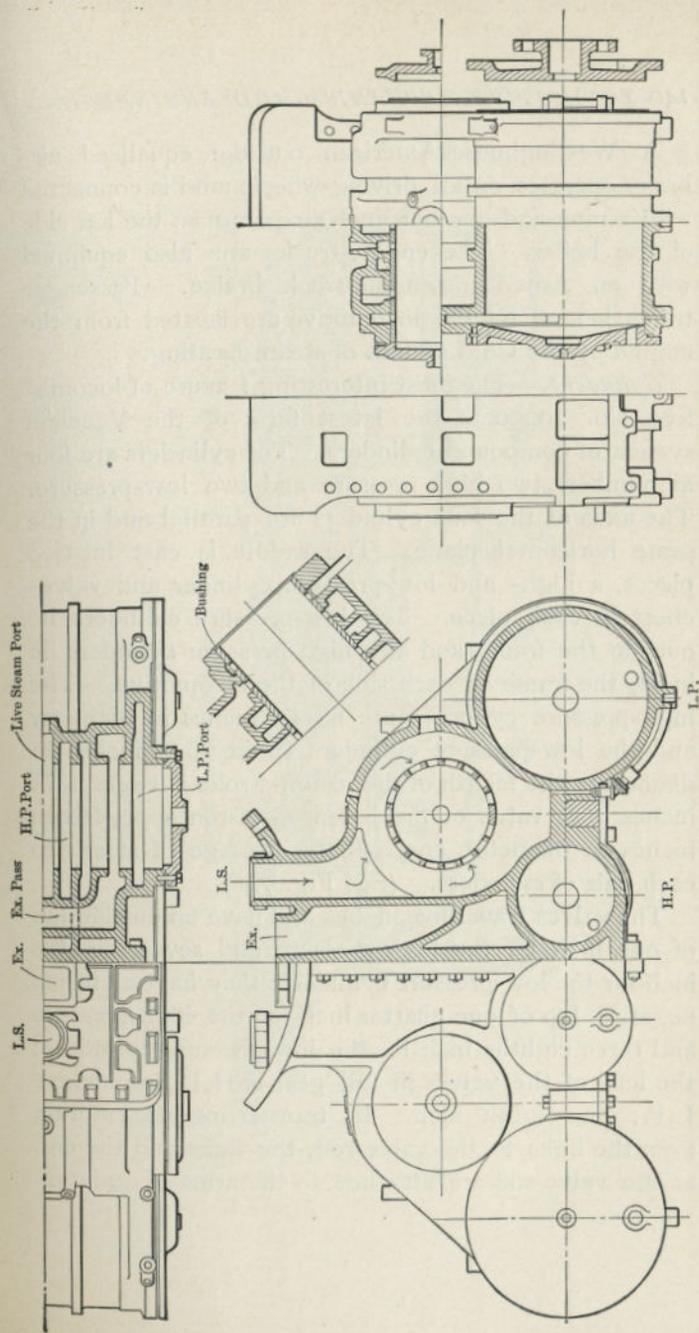


FIG. 73.—CYLINDERS AND SADDLE, FOUR-CYLINDER BALANCED COMPOUND.

A Westinghouse-American outside equalized air-brake operates on all driving-wheels and is connected with a nine-and-one-half-inch air-pump on the left side of the boiler. The engine-trucks are also equipped with an American engine-truck brake. Passenger trains hauled by the locomotive are heated from the engine by the Gold system of steam-heating.

Cylinders.—The most interesting feature of locomotive No. 20000 is the latest form of the Vauclain system of compound cylinders. The cylinders are four in number, two high-pressure and two low-pressure. The axes of the four cylinders are parallel and in the same horizontal plane. The saddle is cast in two pieces, a high- and low-pressure cylinder and valve-chest in each piece. The low-pressure cylinders lie outside the frame and the high-pressure cylinders lie inside the frame on each side of the locomotive. The high-pressure cylinders are fifteen inches in diameter and the low-pressure cylinders twenty-five inches in diameter; the length of the piston-stroke is twenty-six inches. A valve of the balanced-piston type, fifteen inches in diameter, controls the passage of steam to each pair of cylinders. (See Fig. 74.)

The valves travel five inches and have an outside lap of one inch for the high-pressure and seven eighths inch for the low-pressure cylinders; they have an inside negative lap of one quarter inch for the high-pressure and three eighths inch for the low-pressure cylinders; the lead of the valves in full gear is H.P., no inches, L.P., one-eighth inch. In transferring the motion from the links to the valve-rod, the links and the end of the valve-rod are attached to the arms of an inter-

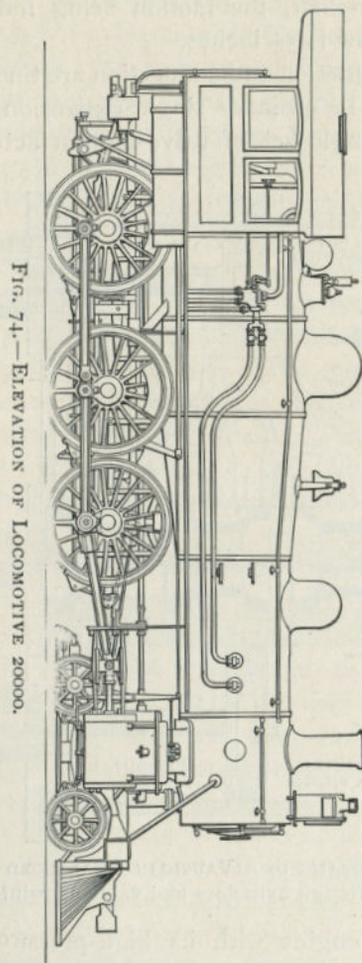


FIG. 74.—ELEVATION OF LOCOMOTIVE 20000.

mediate rock-shaft, the motion being indirect. The eccentric throw is $5\frac{1}{2}$ inches.

The valve-motion and connection are thus practically the same as in ordinary single-expansion locomotive practice, a single set of valve-motion actuating each

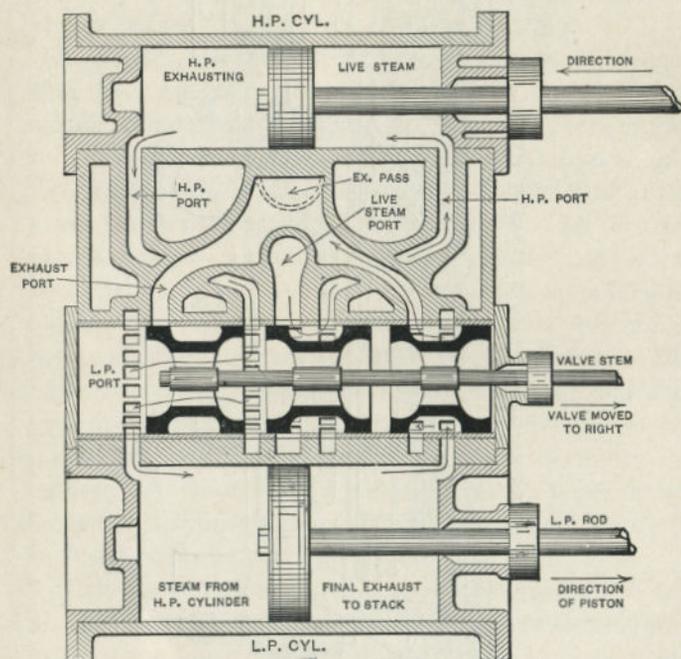


FIG. 75. — DIAGRAM OF VACLAİN BALANCED COMPOUND. Section through cylinders and valve showing ports.

side of the engine with its high-pressure and low-pressure cylinders.

Fig. 75 is a diagram of the cylinders, valve, valve-chest, and ports, showing the valve in full port-open

position, and the piston-heads in the centre of cylinders. The diagram is not made as a working-drawing, but is designed to show the two cylinders and the ports leading to and from each cylinder, with the cylinders placed each side of valve-chamber (for working-drawing see Fig. 73). The valve-chamber has seven ports therein, as shown. The two end ports lead to the low-pressure cylinder. The two ports, one at each end of chest; next to low-pressure ports are the final exhaust-ports leading to exhaust-passage in saddle. The central port is the receiving-port or live-steam port. The ports on each side of the centre port are the high-pressure ports leading to the high-pressure cylinder. These ports are very clearly shown in the diagram. As will be understood, the piston-heads in these cylinders move in opposite directions. The valve is made up of three parts or pistons, with a depression between each end; these three parts are fastened to a valve-stem, as the drawing shows; between each section a space is left open. The sections have four spring-rings, two at each end, to make them steam-tight. This valve works in a bushing fitted into the valve-chamber in saddle, and the ports are bridged as usual with piston-valves, to prevent the rings from dropping into port when travelling over. In the position shown in Fig. 75 the action is as follows: The middle section of valve has uncovered the high-pressure port to the right and opened it to the central port, and live steam is flowing into the high-pressure cylinder, driving the piston-head to the right. That section of valve to the extreme right has uncovered the low-pressure port and put it in communication with the

final exhaust-port, and exhausted the steam from the right-hand end of low-pressure cylinder. The section of valve to the left has opened the low-pressure port to left-hand end of low-pressure cylinder, and at the same time the middle section has opened the high-pressure port to the centre of valve. This then permits the exhaust steam from the left-hand end of high-pressure cylinder to flow through the centre of valve and into the low-pressure port at left-hand end of low-pressure cylinder, moving that piston-head to the right and in opposite direction to the high-pressure piston-head. The arrows and lettering show very clearly the operation. This action is the same for both ends of cylinders. Fig. 76 is a full view of the valve and rings.

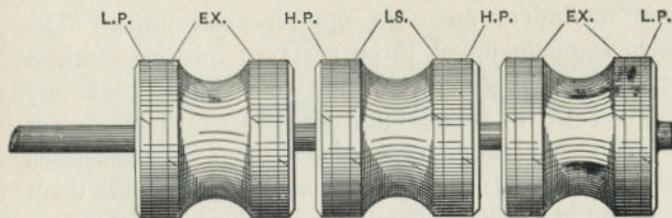


FIG. 76.—PISTON-VALVE OF FOUR-CYLINDER BALANCED COMPOUND.

The four piston-rods are of the same size, as small as possible, made of solid steel, and the pistons are fitted with snap-rings and Peacock packing-ring joints. Each of the four pistons is connected with a separate cross-head, of the alligator type, working in separate parallel guides. The piston-rods and valve-stems are all fitted with United States metallic packing.

The valve admits steam to the high- and low-pres-

sure cylinders in such a manner that the high- and low-pressure cross-heads work in opposite directions, starting their stroke at opposite ends of the guides.

The cross-heads are of open-hearth cast steel, with bronze shoes. The guides are of steel. The low-pressure cross-head and guides on each side of the locomotive are located outside the frames, and the cross-head is coupled with the main driving-wheel, which in this locomotive is the front wheel, by a connecting-rod, as in ordinary practice. In addition the main axle has two cranks, set at right angles to each other, one on each side of the centre of the locomotive; and each crank is coupled to a cross-head of one of the high-pressure pistons. The crank on the axle and the crank-pin in the wheel for the corresponding high- and low-pressure cylinders are set at an angle of 180 degrees; the two axle-cranks being set at 90 degrees, brings the action of each high- and low-pressure cylinder on one side of the locomotive quartering with the equivalent cylinder on the opposite side.

Fig. 77 is a diagram of the valve-motion, as has been stated; this is an indirect motion, using the rocker-arms. The peculiar feature is that the eccentrics are not on the same axle as the cranks, as in usual construction. This engine has three pairs of driving-wheels, as 1, 2, 3 in diagram. The axle marked number 1 is the main driving-axle and is the crank-axle for the high-pressure rods. As there is no room for eccentrics on this axle, the eccentrics are placed on the axle marked number 2 or middle drivers, the links being immediately back of the main driving-axle. The distance from link to valve being long,

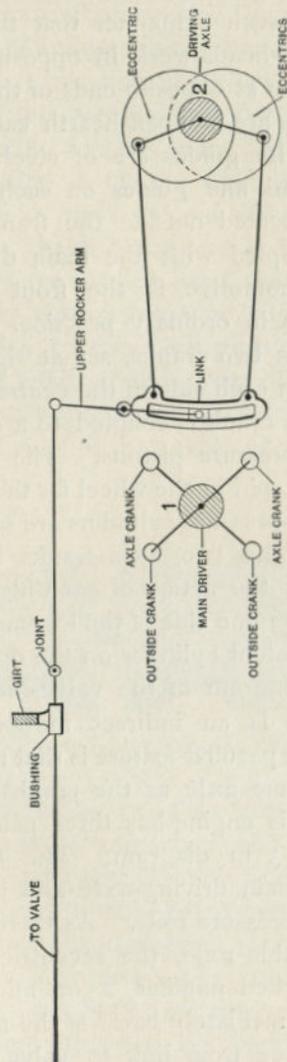


FIG. 77.—DIAGRAM OF VALVE-MOTION OF FOUR-CYLINDER COMPOUND.

the valve-rod is in two sections, and is jointed as shown. Immediately ahead of the joint, the rod is carried in a bushing in the yoke. Fig. 78 shows the

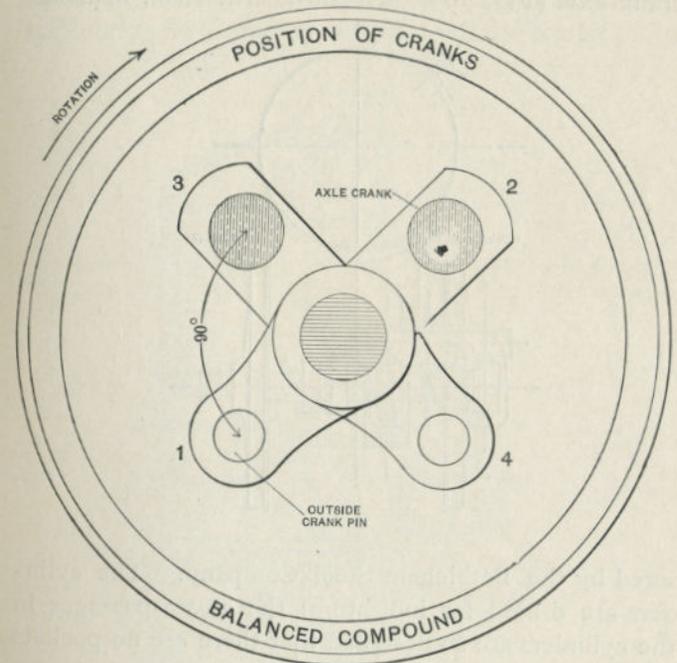


FIG. 78.

position of cranks to one another. Number 1 is the crank-pin on driving-wheel of right side of engine, looking to the right. Number 2 is the axle-crank of right side. Number 4 is the crank-pin on driving-wheel, left side. Number 3 is the axle-crank on the left side. Numbers 2 and 3 are connected to high-pressure cylinders; numbers 1 and 4 to the

pressure cylinders. In this case the leading engines are on the right-hand side.

The axles of all driving-wheels are of steel. The crank-axle (Fig. 79 is of open-hearth steel, manufac-

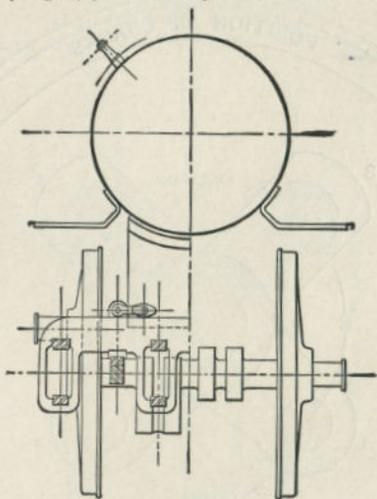


FIG. 79.

tured by the Bethlehem Steel Company. The cylinders are drilled for indicators; the steam-passages in the cylinders are so designed that there are no pockets where water can collect.

Certain advantages are expected of this system of compounding, besides the recognized ones of economy of fuel and steam. The most important one is the fact that by a crank-axle connected with pistons travelling in opposite directions from each other an almost perfectly balanced engine is secured. The main driving-wheels are practically self-counterbalanced by the positions of the inside cranks with relation to the out-

side wrist-pins and their respective connections. It is only necessary to counterbalance such portions of the main wheels as are not sufficiently balanced by the cranks. The other driving-wheels are counterbalanced each for its own rotating weight. As the reciprocating

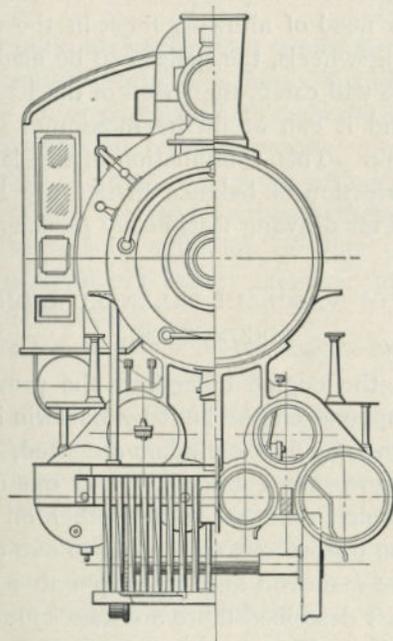


FIG. 80.—CROSS SECTION OF LOCOMOTIVE 20000.

weights of the high- and low-pressure pistons and their connections move in opposite directions at the same time, they are within a few pounds of each other and the locomotive is only out of balance to that small extent. Thus we have a machine that will allow the maximum load on the driving-wheels without detriment

to the track, there being no unbalanced rotating weight in the wheels to either tend to lift the wheel or exert additional weight on the rail. As an offset to the objections pertaining to a crank-axle, and the duplication of guides, cross-heads, and main rods, there is no variation in the vertical stress upon the rails, and consequently no need of allowing for it in the weight put on the driving-wheels, the boiler can be made as large as the engine will carry, the speed of the locomotive is increased, and it can attain its maximum speed with minimum risk. This combination of the large boiler with the perfection of balance makes the locomotive well adapted for drawing fast, heavy passenger trains.

REVIEW OF VAUCLAIN BALANCED COMPOUND LOCOMOTIVE.

How does the engine differ from the previous four-cylinder compound engine built by Baldwin?

In both engines four cylinders are used, two high- and two low-pressure cylinders. The one engine has the two cylinders one above the other on the same side, with the piston-rods connected to one cross-head and using one main rod and crank-pin to a side. In the engine just described there are two cylinders to a side, one high- and one low-pressure, which are placed on a horizontal line with each other, each side of the frame, with a valve common to both cylinders, as in the former case.

Are there more than two connecting-rods?

There are four connecting-rods to this engine, two inside and two outside rods, four cross-heads, and four pairs of guide-bars.

Why are four connecting-rods used?

Each piston-rod is connected to its own main rod and crank-pin and not as in the previous engine, where the two piston-rods are connected to one cross-head and main rod.

What is the form of the main driving-axle in this engine?

It is a crank-axle having two cranks formed therein, and these cranks form part of the axle, and the portion forming the pin or part on which main rod bears is very large in diameter to prevent weakening of the axle. These cranks are set at 90 degrees with each other.

What cylinders are connected with these cranks?

The high-pressure cylinders in this engine; the low-pressure cylinders being connected to crank-pins on outside of wheels.

What are the positions of the cranks in relation to each other?

The crank-pins on driving-wheels have an axle-crank directly opposite, and the crank-pins are set at 90 degrees with each other, as in usual construction (see Fig. 79). When crank-pin marked 1 is on the quarter the axle-crank marked 2 is also on the quarter, while crank-pin and axle-crank marked 3 and 4 are on centre. (See Fig. 78 for numbers.)

How do the piston-heads travel in relation to each other in the cylinders?

By this construction they move in opposite directions.

Does it require a complicated valve-motion to operate these piston-heads?

It does not require any extra motion other than the usual link-motion. The valve is so constructed that a single movement operates both cylinders.

What is the position of the valve-chest ?

It lies above and between the high- and low-pressure cylinders.

How many ports are in this chest ?

There are seven ports: two high-, two low-pressure ports, two exhaust, and one receiving or live-steam port.

In what position are these ports in the chest ?

The two end ports are the low-pressure ports to low-pressure cylinder. The ports next to the low-pressure ports are the final exhaust-ports to stack. The central port is the live-steam or receiving port; and the ports on each side of central port are the high-pressure ports to high-pressure cylinder.

Describe the valve.

This valve is what is called a piston-valve and is composed of three sections fastened to one stem. These sections have a central depression with packing-rings at each end (see Fig. 76). The central section controls the steam to and from the high-pressure cylinder and live-steam port. The two end sections control the steam to and from the low-pressure cylinder and the exhaust to stack.

In this locomotive the main driving-axle is the forward one; on which axle are placed the eccentrics ?

The eccentrics are placed on the second axle in this engine, due to the cranks on axle of main driver. This feature differs from the usual construction, where the eccentrics are on the main driving-axle.

How is the power of this engine increased to start away or on grades ?

The high-pressure cylinder piston-head is balanced

by starting-valve admitting steam to each end of high-pressure cylinders and live steam flowing to the low-pressure cylinders.

Would the breaking of a main rod prevent running of this engine with the three main rods up ?

This engine can be run by removing the broken parts and taking piston-head out of cylinder, putting a board over the stuffing-box to prevent steam from escaping. The engine would be out of balance and should be run carefully.

If the high-pressure main rod were broken, what would be the action in the cylinders when parts were taken down as described ?

The engine would be run as a simple engine with the low-pressure cylinders, with the piston-head balanced in high-pressure cylinder on good side.

If it were a low-pressure rod, what would be the effect in cylinders, and what should be done ?

The low-pressure head would be taken out, proceeding as in former case; the engine would then be a compound on one side and high-pressure on the disabled side; or it could be used as a high-pressure engine on both sides by balancing the high-pressure cylinder on good side, using the low-pressure with live steam. In this case the one side would be stronger than the other. This illustrates the flexibility of this engine.

With a broken valve-stem or rod the valve should be placed in centre of travel, closing all ports, as with the usual D valve; disconnect both main rods on that side, block piston-heads in back end of cylinders, and go in with one side.

With the two end sections of valve taken out could the engine be run?

Yes; in this case the middle section of valve will control the high-pressure cylinders; only the low-pressure pistons would be travelling in the cylinders without power, as the exhaust from the high-pressure would escape into stack. Care would have to be taken to see that there was sufficient lubrication of low-pressure cylinder to prevent cutting.

What would be the effect on engine with the forward section of side rods broken?

The engine would have to be pulled in.

Why?

Because the eccentrics are on the second pair of driving-wheel axles, and they receive their power from main drivers through the side rods.

Could the engine run with one forward section of side rod taken down?

No; because if the other side were left on, the second and third pair of drivers would have to be driven by the good side, and, not having the other forward section on the second and third pair of drivers, they would be liable to revolve in either direction from the centre.

With an end section of valve broken or taken out, what would be the effect on that side?

The engine would work as a high- and low-pressure on that side; one end of low-pressure cylinder would have power, while the other would have no power, because the exhaust-steam from the high-pressure cylinder would escape to stack.

What effect would this have on the exhaust?

There would be three mild beats with one sharp beat

to one revolution. The sharp beat being the exhaust from high-pressure cylinder, and from that end from which the section of valve was taken or broken. This would cause the engine to work irregularly.

Why is it necessary to take out the piston-heads of disabled engines when main rod is taken down in order to run with the remaining rods up?

If it is the L.P., the piston-head would prevent the steam from one end of H.P. to escape to exhaust-pipe. If it were the H.P., steam would flow from one end of H.P. cylinder to the L.P. cylinder only, except when starting-valve was opened. The best way is to take down both main rods on disabled side when one is broken, running in with good side.

The above questions and answers are given to show what might happen, and what could be done to meet emergencies.

THE SCHENECTADY COMPOUND LOCOMOTIVE.

Probably the most interesting feature of this engine is the new starting gear and intercepting-valve apparatus, invented by Mr. A. J. Pitkin, Superintendent of the Schenectady Locomotive Works. This we show in considerable detail. Figs. 81 and 83 show the intercepting-valve open; that is, in the position before the engine starts. Fig. 82 shows the intercepting-valve closed, or in the position at the time of the initial movement.

The construction of this valve is as follows (see Figs. 81, 82, and 83).

There are two pistons *AA* at one end of the single

stem *B*, which moves to and fro in a cylindrical chamber having three openings. Two of these openings,

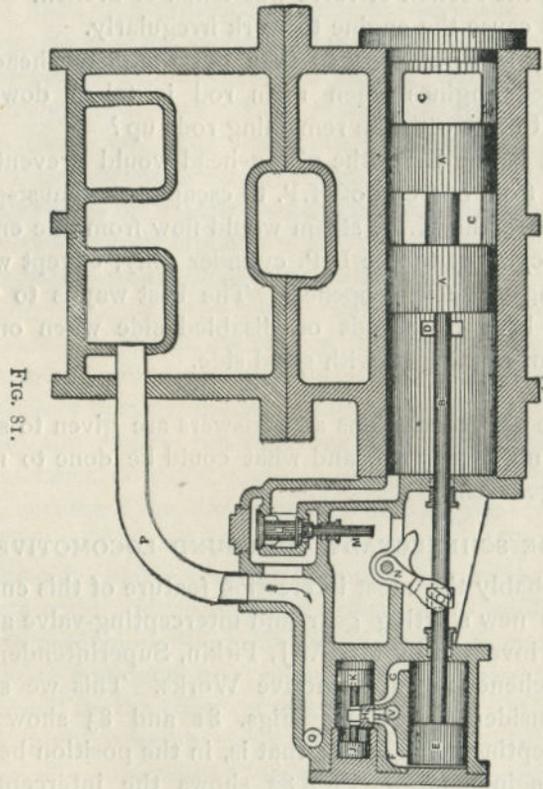


FIG. 81.

C C, lead to the receiver and to the low-pressure steam-chest, as shown in Fig. 81, and it is the office of the pistons *A A* to open and close these large openings and prevent the steam in the low-pressure steam-chest

from entering the receiver when it is not wanted there. The other opening, *D*, in this cylinder (see Figs. 81 and

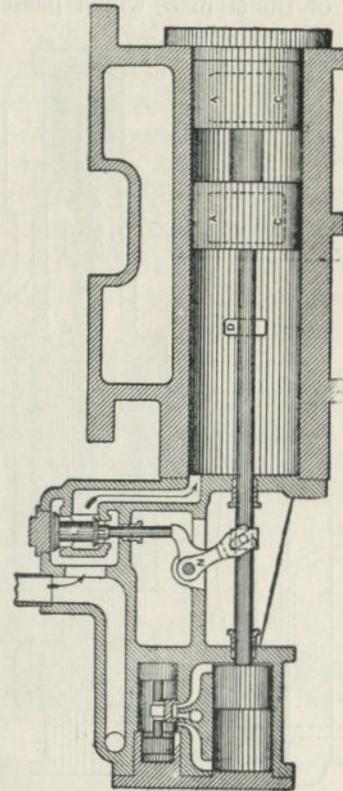


FIG. 82.

82) connects the intercepting-valve cylinder with the low-pressure steam-chest.

So far we have described the intercepting-valve proper. The remaining portion of the mechanism is

the apparatus for driving and connecting the intercepting-valve. It is constructed as follows:

On the end of the stem *B*, which passes through a

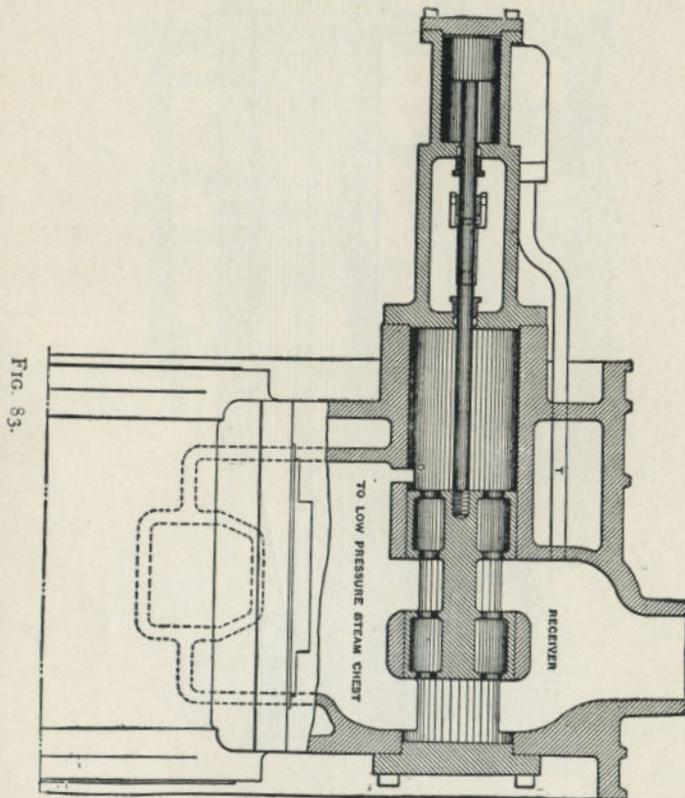


FIG. 83.

stuffing-box in the end of the intercepting-valve chamber, there is a piston *E*, which moves in a small cylinder having ports *F* and *G*, one at each end. These ports lead to a valve-seat, on which is a plain *D* valve

not unlike the ordinary locomotive slide-valve. This slide-valve is moved to and fro by means of a double piston with a stem between, shown at *J* and *K*. These pistons are of different diameter, *K* being larger than *J*, and as they move to and fro they carry with them the slide-valve. The office of this portion of the mechanism is to move the intercepting-valve *AA* to and fro, as desired.

The third part of the device consists of a balance poppet-valve *L*, which is placed in the path of steam coming direct from the boiler to the low-pressure cylinder to assist in starting. This valve has an extended spindle *M* on the lower side, and is lifted by means of a bell-crank *N*, which is driven by means of a trunnion on the intercepting-valve stem *B*. As the stem *B* passes to the right the valve *L* is lifted, and as it passes to the left the valve *L* is allowed to fall. Fig. 62 is a detail of the pipe connections and passages leading to the pistons *JK*, the office of which will be de-

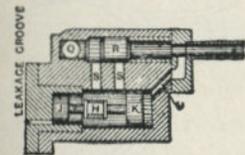


FIG. 84.

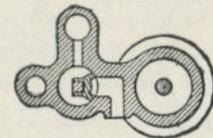


FIG. 86.

scribed in what follows. Fig. 85 shows the location of the intercepting-valve and its parts in relation to the cylinders and steam-pipes. Fig. 86 is a section through the side-valve *H*, showing that it has a cylindrical seat. The operation of this valve is as follows:

The engineer opens the throttle as usual. Steam passes into the high-pressure steam-pipe *O*, Fig. 85, and passes through the pipe *P*, which is tapped into the

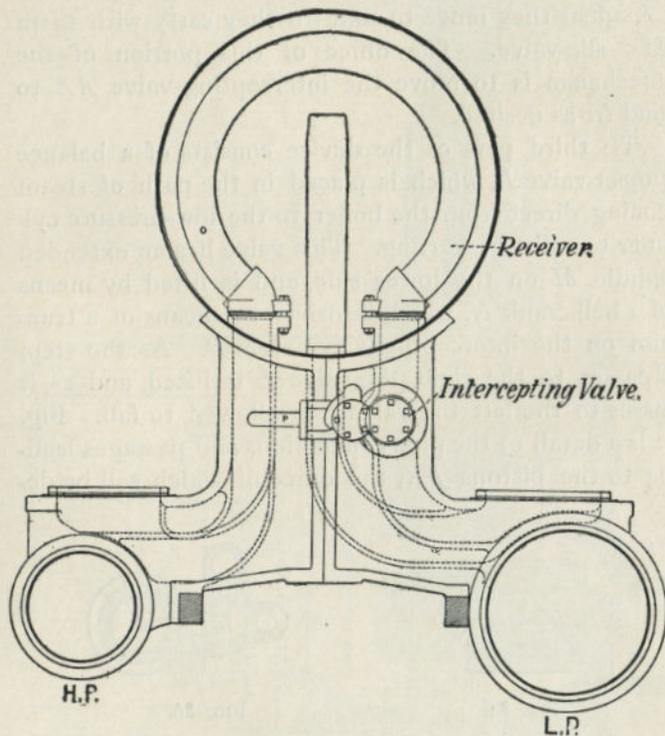


FIG. 85.

side of the saddle to the apparatus which actuates the intercepting-valve, as shown in Figs. 81 and 84. It passes down through the passage *Q*, through the small ports *S S*, between the pistons *J* and *K*. *K* being larger

than *J*, it has a greater total pressure; hence the pistons move to the right and carry the slide-valve with them. This opens the port *F*, and allows the steam to pass on the left side of the piston *E*, and forces it, together with the intercepting-valve *A A*, to the right until it is in the position shown in Fig. 82 with the *CC* passages closed. The position of the pistons *J K* and the slide-valve *H* at this time are shown in Fig. 82.

During the foregoing operation, as the intercepting-valve stem *B* moves to the right it carries with it the bell-crank to the position shown in Fig. 82, thus lifting the balance poppet-valve *L*, and admitting steam, as shown by the arrows, Fig. 82, into the intercepting-valve cylinder, from whence it passes out through the opening *D* into the low-pressure cylinder steam-chest, and in this way steam is admitted direct from the boiler to the low-pressure steam-chest always just before the engine starts.

As soon as the engine has started, and there is an exhaust into the receiver from the high-pressure cylinder, steam passes from the receiver through the pipe *T*, shown in Fig. 83, to the passages leading to the small slide-valve *H*, as shown in Fig. 84. This pressure acting on the right-hand side of the larger piston *K*, through the smaller passage *U*, overcomes the pressure on the other side of this piston *K*, and the pistons *J* and *K* move to the left, carrying the slide-valve *H* with them. This movement opens the steam-passage *G*, Fig. 81, and the exhaust-passage *V*, and admits steam to the right side of the piston *E*, and drives it to the left, and with it the intercepting-valves *A*, thus opening the passages *C* and the receiver to the low-pressure

steam-chest. At the same time the bell-crank *N* is moved to the left, and the valve *L* is allowed to drop into the position shown in Fig. 81, thus cutting off the connection between the boiler and the low-pressure steam-chest.

After this the engine works in the well-known way of the two-cylinder compound, that is, by taking steam into the high-pressure cylinder, discharging it into the receiver, taking it out of the receiver into the low-pressure cylinder, and discharging it into the atmosphere.

ACCIDENTS WITH THE SCHENECTADY COMPOUND LOCOMOTIVE AND INTERCEPTING-VALVE.

When a main rod of the high-pressure engine is broken or disconnected, what should be done to bring the engine in or continue the trip?

The high-pressure valve should be moved ahead to clear exhaust-port, and the piston pushed in the forward end of cylinder and blocked. The live steam would pass through the exhaust-port on the high-pressure side into the receiver, from there into the low-pressure steam-chest. The low-pressure cylinder would then be acting as a high-pressure engine. Care must be taken not to open the throttle-valve suddenly, on account of the large area of low-pressure cylinder.

When the low-pressure main-rod is broken or disconnected, what should be done?

The piston-head must be blocked in the back end of the cylinder, and the low-pressure valve moved back to clear the exhaust-port on that side, the valve cover-

ing the back-port when a head is not broken out. Opening the exhaust-port on the low-pressure side provides an outlet for the exhaust-steam from high-pressure engine.

Why must the high-pressure valve be pushed ahead?

In order to clear the receiving-port, or the port by which the live steam enters the high-pressure steam-chest, this port being in the back end of the steam-chest.

When a valve-rod breaks on either side, what should be done?

Do the same as for a broken main-rod on that side; also, take down the main-rod and block cross-head.

If the back-head of intercepting-valve steam-cylinder broke out, could the engine be run as a compound engine?

The engine would be as a compound engine, from the fact that the intercepting-valve would not be moved to the position as when starting as a non-compound because of the steam in the intercepting-valve cylinder not being able to move the valve to the proper position on account of the head being broken out; also, the exhaust from the high-pressure cylinder into receiver would hold the intercepting-valve in the compounding position.

Would steam escape from the steam-cylinder of intercepting-valve in this case when in the compounding position?

Steam would not escape when in this position. The engineer should see that the lever in cab is in the proper position for compounding. When the lever is put in the position for starting, then steam would es-

cape from the back end of steam-cylinder of intercepting-valve with the head broken out.

Has this ever happened?

It has.

How would it be possible to use live steam in both cylinders when starting with the intercepting-valve disabled in the manner spoken of?

Live steam could be used in both cylinders to start with by lifting the poppet-valve and blocking it from the seat. This would let live steam into the low-pressure steam-chest.

When should this be done?

Before the throttle is opened.

Would it be possible to run with low-pressure cylinder having the high-pressure valve covering all the ports on H. P. side?

The engine can be run in this manner. With the intercepting poppet-valves steam will pass through the poppet-valve into the low-pressure steam-chest. The engineer must put the lever in cab in the position for starting. This will admit steam into back end of intercepting-valve steam-cylinder, closing the receiver and holding poppet-valve open. As there is no steam in the receiver, the intercepting-valve will not open and close the poppet-valve.

Is there any other way in which the poppet-valve could be held open to admit live steam into the low-pressure steam-chest?

The poppet-valve could be held open by taking the back head off the intercepting-valve steam-cylinder and pushing the piston-head in forward end of cylinder and putting a block in, and putting on the head.

This would prevent the steam in receiver from closing the poppet-valve. The same can be done with the small piston moving the valve admitting steam to the intercepting-valve steam-cylinder. This will also prevent the movement of the intercepting-valve mechanism and closing the poppet-valve.

What form of breakdown would cause the high-pressure valve to be put in the position to cover all the ports on that side?

When both cylinder-heads are broken out or a front head broken out, and a piece broken out of the bridge between exhaust-port and front steam-port; also, it is policy when running with low-pressure cylinder alone, and do not want any steam to get into the high-pressure cylinder, to cover all the ports on the high-pressure side.

How can the engine be used as a high-pressure engine for some distance when starting?

By shifting the lever in and out of compound position repeatedly. Remember that there is no steam in the intercepting-valve when the throttle is closed and the dry-pipe empty. Disconnect as for a simple engine for other breaks.

COMPOUND PASSENGER LOCOMOTIVE, NEW YORK, NEW HAVEN & HARTFORD R. R.*

The line and photo engravings on the opposite page show the general appearance and some details of construction of a new eight-wheeled compound loco-

* Nat. Car and Loco. Builder.

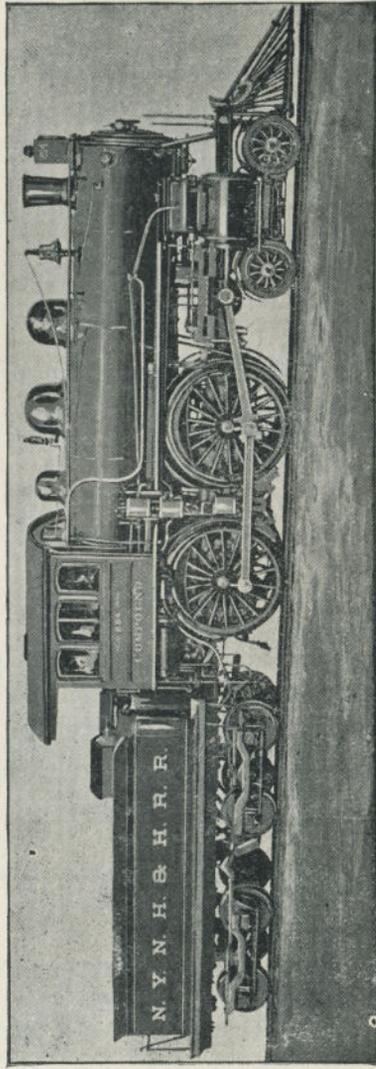


FIG. 87.—COMPOUND PASSENGER LOCOMOTIVE.

Cylinders, 21" X 31" X 26".	Boiler, 60" Diameter.
Driving-wheels, 78" Diameter.	Flues, 250.
Truck-wheels, 33" Diameter.	Fire-box, 120 X 41½.
Total Wheel-base, 92' 9".	Steam-pressure, 200 pounds.
Total Weight Working Order.	
125,000 Pounds.	
Total Weight on Drivers, 84,000 pounds.	

tive built for the New York, New Haven & Hartford Railroad, according to designs furnished by Mr. John Henney, Jr., Superintendent of Motive Power, by the Rhode Island Locomotive Works.

The intercepting-valve is the Rhode Island Locomotive Works patent.

Figs. 88 and 89 illustrate the construction and show the operation of the intercepting-valve. Fig. 88 shows a front section of the intercepting-valve at ports *d* and *e*; also a view of a portion of receiver with the exhaust-valve. Fig. 89 shows a side section of intercepting-valve while running compound, and Fig. 90 shows same while running simple. *A* (in Figs. 87, 88, and 89) is the intercepting-valve casing. *B* is the reducing-valve. *C* (in Fig. 89) is the oil dashpot. *D* (in Figs. 87 and 88) is a pipe from main steam-pipe to intercepting-valve. *E* is the receiver, and *F* is the exhaust-valve; *a*, *b*, and *c* (in Figs. 89 and 90) show the intercepting-valve pistons; *d*, port from *D*, through *A*; *e*, port from *A* into the reducing-valve *B*; *f* (in Figs. 89 and 90), port from *A* into passage to low-pressure steam-chest; *m*, exhaust-valve lever; and *o*, ports through exhaust-valve and seat.

This device operates as follows, the intercepting-valve being in any position (as in Fig. 89), and the exhaust valve closed (as in Fig. 89) and the throttle open:

Boiler-steam will pass to the high-pressure cylinder, in the usual manner, and also through pipe *D* into the intercepting-valve *A*, causing the piston to move into the position shown in Fig. 90. In this position the receiver is closed to the low-pressure cylinder by the piston *C*, and steam from *D* passes through ports *d* and

e and reducing-valve *B* into the low-pressure steam-chest, the pressure being reduced from boiler-pressure, in the ratio of the cylinder areas. The piston *a*, *b*, *c* is so proportioned that it will automatically change to the compound position shown in Fig. 89, when a pre-determined pressure in the receiver *E* has been reached by exhausts from the high-pressure cylinder. The engine thus starts with steam in both cylinders, and automatically changes to compound at a desired receiver-pressure.

The engine may be changed from the compound system to the simple at any time, at the will of the engineer, by opening the valve *F* connecting the receiver to the exhaust-pipe, allowing the exhausts from the high-pressure cylinder to escape through the nozzle in the usual manner.

The exhaust-valve *F* is operated as follows: The lever *m*, which rotates the exhaust-valve *F*, is connected by a rod to a handle in cab. To run compound, place lever *m*, as shown in Fig. 89, which closes port *o*. To run simple, place lever *m*, as shown in Fig. 90, the ports *o* opening *E* to exhaust.

It is obvious that, in case of bad conditions of starting, the engine may be operated as a simple one at the will of the engineer by opening the exhaust-valve before starting, and that upon its closure the piston *a*, *b*, *c* will automatically take the compound position shown in Fig. 89.

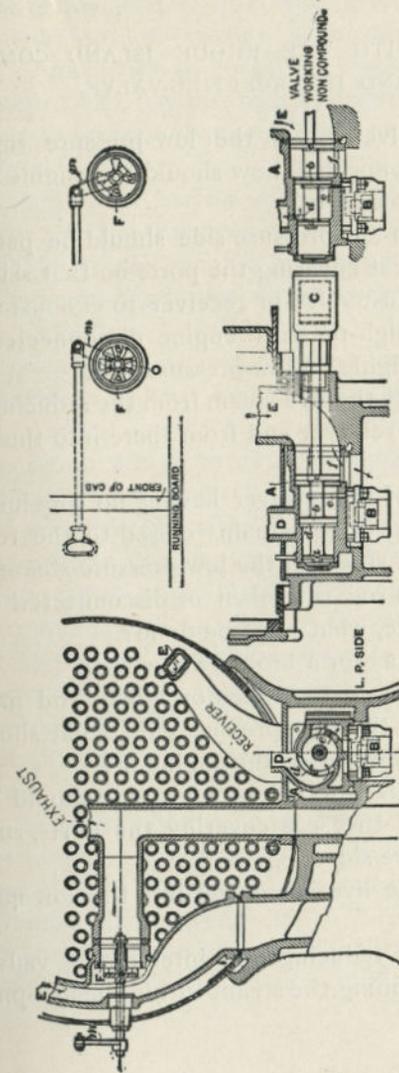


FIG. 90.

FIG. 89.
COMPOUND
INTERCEPTING-VALVE FOR COMPOUND ENGINES.

FIG. 88.

ACCIDENTS WITH THE RHODE ISLAND COMPOUND
AND INTERCEPTING-VALVE.

When a valve-rod of the low-pressure engine is broken or disconnected, how should the engine be prepared to be brought in?

The valve on low-pressure side should be put in the centre of the seat covering the ports on that side, then open the exhaust-valve in receiver to exhaust-nozzle; run with the high-pressure engine disconnected main as for simple engine on low-pressure side.

Why does not the live steam from the reducing-valve escape into the receiver and from there into the atmosphere?

On account of the receiver having no pressure in it, the intercepting-valve remains closed to the receiver, holding the live steam in the low-pressure steam-chest.

When a main-rod is broken or disconnected on the low-pressure side, what must be done?

Do the same as for a broken valve-rod.

When a valve-rod is broken or a main-rod must be taken down on the high-pressure side, what should be done in this case to bring the engine in?

The steam-valve on high-pressure side should be put in the centre of the seat covering the ports, and run with low-pressure side.

How does the live steam get into the low-pressure steam-chest?

Through the reducing and intercepting valve, the latter valve confining the steam within the low-pressure steam-chest.

If the piston-head of intercepting-valve that closes the receiver to low-pressure steam-chest should be broken or cracked, how could the engine be run without using in the low-pressure cylinder live steam, or having an excessive back-pressure on high-pressure piston-head?

By taking off the back-head of the intercepting-valve oil-cylinder, and putting a block in, pushing the intercepting-valve to the position for compounding, putting on the cylinder-head, and screwing tight against the block.

Why cannot the exhaust-valve in receiver be opened and the engine run as a high-pressure engine?

On account of the hole in intercepting-valve letting the live steam escape into the atmosphere from the low-pressure steam-chest.

What would be the effect if the middle piston-head of intercepting-valve was cracked or broken out?

The live steam would move intercepting-valve to the non-compound position, closing the receiver, and admitting live steam to the low-pressure cylinder. This would form a heavy back-pressure against the high-pressure piston-head.

What should be done then to overcome this back-pressure?

Open the exhaust-valve in receiver and run as a high-pressure engine. The intercepting-valve must be closed in this case, or live steam will pass out into the exhaust-pipe through the receiver.

How should the engine be run with a broken or cracked receiver?

By opening the exhaust in receiver and running as a high-pressure engine.

Disconnect for other breaks as for a simple engine.

A COMPOUND PASSENGER LOCOMOTIVE.

The accompanying illustration is from a photograph of an 8-wheel compound engine recently built by the Pittsburgh Locomotive Works. It is of the two-cylinder type, and has the starting-valve patented by Mr. Henry F. Colvin of Philadelphia. With this the engine can be worked as a compound, or steam can be admitted directly into the low-pressure cylinder at the will of the engineer. In the latter case the valve admitting steam from the boiler acts as a reducing-valve, in order to equalize the force exerted in the two cylinders.

Figs. 92 and 93 show the general construction of the starting gear and intercepting-valve of the Pittsburgh compound locomotives. This gear is generally placed on the cylinder saddle, and is so arranged that the engineer, by moving the lever in the cab, can open an independent exhaust for the high-pressure cylinder through the passage, Fig. 93, to the stack. When it is desired to run compound the lever is again moved and the intercepting-valve is open. In Fig. 92 the intercepting and reducing valves are shown when in the position to work compound.

In this system steam from the steam-pipe in the high-pressure cylinder saddle passes to the reducing-valve through a small passage shown in Figs. 92 and 93. When the reducing-valve is permitted to open, as it is

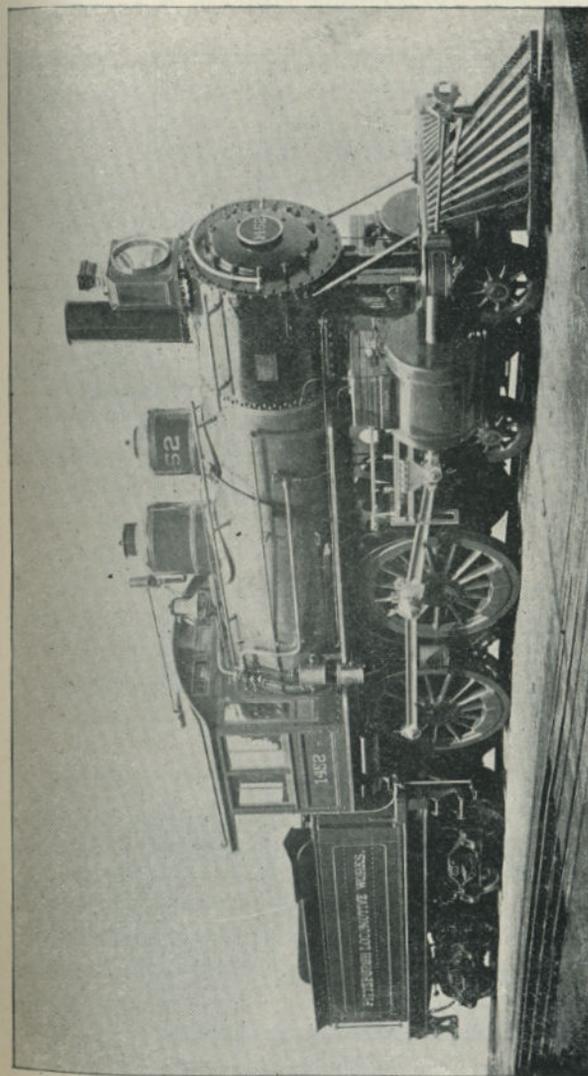


FIG. 91.—EIGHT-WHEEL COMPOUND PASSENGER ENGINE, BUILT BY THE PITTSBURGH LOCOMOTIVE WORKS.
 Gauge of Road, 4 feet 8½ inches. Driving-wheel Base, 8 feet.
 Cylinders, 19 and 29 X 26 inches. Diameter of Driving-wheels, 72 inches.
 Total Wheel-base, 22 feet 6 inches.
 Total Weight, 112,550 pounds.
 Weight on Driving-wheels, 72,000 pounds.

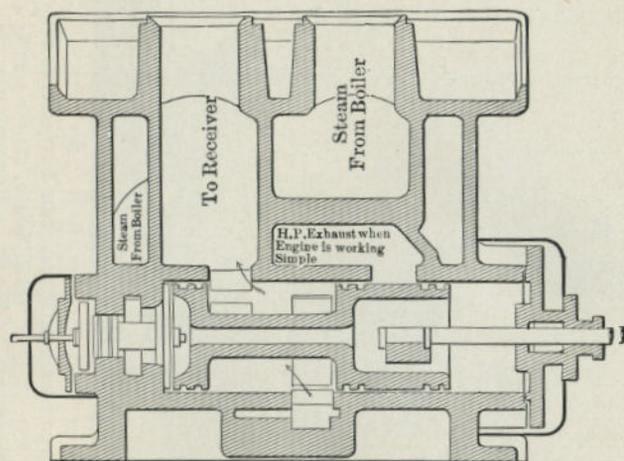


FIG. 92.

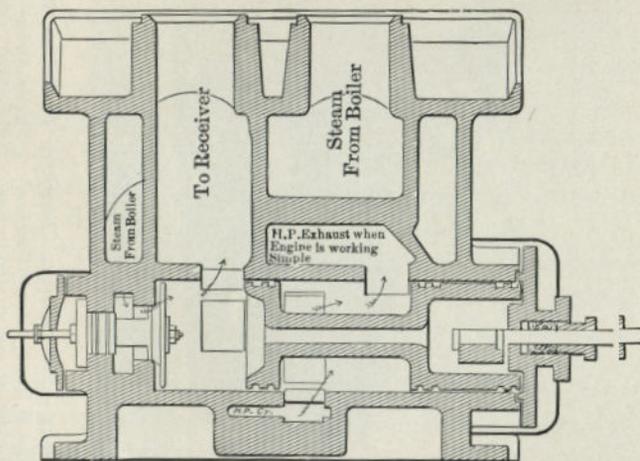


FIG. 93.

in Fig. 93 by the removal of the intercepting-valve to the right, steam passes directly through the reducing-valve, as shown by the arrows from the high-pressure steam-pipe to the receiver, thence to the low-pressure cylinder. The amount of reduction of pressure by the reducing-valve depends upon the ratio of the areas of the piston of the reducing-valve and the area of the valve itself.

When the engine is to be run compound the engineer forces the intercepting-valve back to the position shown in Fig. 92 by means of the rod which is connected to a lever in the cab. The movement of the intercepting-valve to the left forces the reducing-valve to its seat, as shown in Fig. 92, and permits the high-pressure cylinder to exhaust into the receiver. When in the non-compound position, shown in Fig. 93, the high-pressure cylinder exhausts directly to the atmosphere, as indicated.

ACCIDENTS TO PITTSBURGH COMPOUND LOCOMOTIVE AND INTERCEPTING VALVE.

When a main-rod is broken or disconnected on the low-pressure side, what should be done to run engine to end of trip?

The low-pressure steam-valve must be put in centre of seat covering the ports on that side, the intercepting-valve pulled back-opening the exhaust from high-pressure cylinder to the stack; run in with high-pressure side.

When a valve-rod is broken or taken down on low-pressure side, what should be done in this case?

Do same as for a broken main-rod, also blocking cross-head and taking down main-rod, and run in with high-pressure side.

When the intercepting-valve is pulled back, opening the high-pressure to stack, does live steam get into the low-pressure steam-chest?

Steam passes through the reducing-valve into receiver and low-pressure steam-chest.

When a main-valve stem or rod is broken or taken down on the high pressure side, what should be done in order to bring the engine in?

The steam-valve on that side should be put in centre of seat covering the ports, the intercepting-valve pulled back, which opens the reducing-valve, admitting live steam into receiver and low-pressure steam-chest, do the same for a broken main-rod, and run in with low-pressure side.

If the reducing-valve was broken or a piece broken out, would it interfere with the working of the engine?

No. The engine can be run as a high-pressure engine, putting the intercepting-valve in the position as a non-compound, but the engine can be run as a compound by putting the intercepting-valve in the compounding position. The end or head of intercepting-valve has rings sprung in it; this will prevent the live steam from getting into receiver or low-pressure steam-chest.

If the front head of intercepting-valve was broken or cracked, what would be the effect on the engine when starting?

If the intercepting-valve was put in the non-compound position, as when starting or running as a high-

pressure engine, the live steam escapes into the atmosphere, causing the engine to be weak on that side.

Can the engine be used as a high-pressure engine to start with in this condition?

If the break or crack is large enough, the intercepting-valve can be pushed ahead until the back-head covers the exhaust-port to stack. This will permit the live steam from reducing-valve to pass over into low-pressure steam-chest through the receiver. The intercepting-valve after a couple of revolutions of driver can be put in the compounding position closing the reducing-valve, and the engine run as a compound.

When a piece is broken out of front end of back-head of intercepting-valve, can the engine be run with both sides?

The engine can be run by putting intercepting-valve in the compound position, although the power of low-pressure cylinder would be reduced in proportion to the amount of steam escaping into stack through broken head.

How can the engine be run as a high-pressure engine when a piece is broken out of back-head of intercepting-valve?

By putting the valve in the non-compound position, and, driving a plug in the port leading from end of valve to the other. (The purpose of the port is to equalize the pressure on valve, so that it can be moved by hand.)

If the receiver was broken or cracked very badly, what should be done in this case?

The reducing-valve bound to its seat, the intercepting-valve put in the non-compound position, the low-

pressure side disconnected as for a broken main-rod, run with the high-pressure side.

How can the reducing-valve be held to the seat when the intercepting-valve is away from it?

By taking off the collar on the end of reducing-valve and putting thick washers on; then put collar on and screw up tight-binding reducing-valve to seat.

What effect has a receiver which is very badly cracked or broken on the engine?

It destroys the draught, preventing the engine from steaming, and is liable to cause a back draught and burn the fireman.

This applies to any engine using a receiver in front end.

Disconnect as for a simple engine for other breaks.

THE BROOKS TWO-CYLINDER COMPOUND LOCOMOTIVE,

built by the Brooks Locomotive Works, under patents issued to Mr. John Player, Mechanical Engineer of the Brooks Locomotive Works. The notable features of Mr. Player's patents are shown in the accompanying illustrations.

Referring to Fig. 94, it will be seen that a novel form of receiver has been adopted, and that the combined intercepting and reducing valve is placed in the smoke-box on the right-hand side of the engine. The course of the steam is so clearly indicated in Fig. 94 that further description of the general arrangement of the engine is unnecessary. The intercepting and reducing valve is shown in greater detail and in two positions in Figs. 97 and 98. The position shown in

Fig. 97 is that which the valve occupies when the engine is working as a compound. Suppose that the

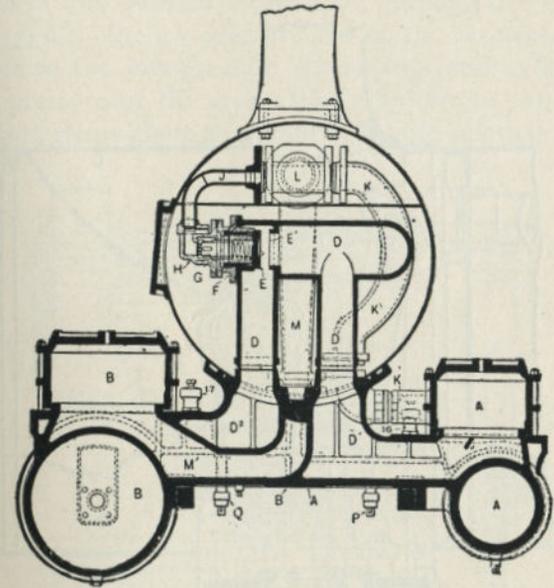


FIG. 94.—THE BROOKS TWO-CYLINDER COMPOUND LOCOMOTIVE.
(Cross-section.)

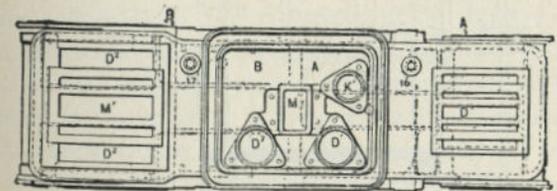


FIG. 95.—THE BROOKS TWO-CYLINDER COMPOUND LOCOMOTIVE.
(Plan.)

throttle is opened when the valve is in this position:

live steam enters by the pipe *J*, and pressing on the end of the reducing-valve *G*, opens it, and passes thence

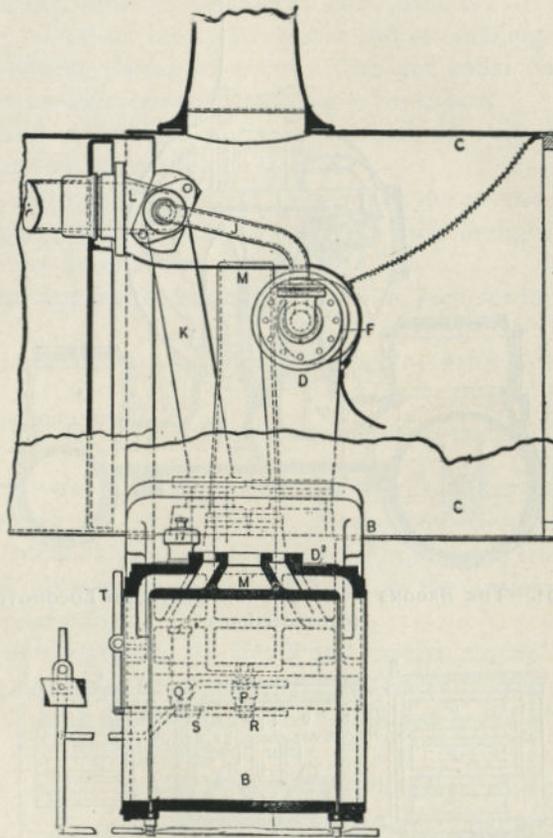


FIG. 96.—THE BROOKS TWO-CYLINDER COMPOUND LOCOMOTIVE.
(Longitudinal Section through Low-pressure Cylinder.)

through the opening (6) and the cored space in the reducing-valve, and acts upon the back of the inter-

cepting-valve *E*, closing it against its seat *E'*. The valve would then occupy the position shown in Fig. 98. When in this position steam flows through the openings (3) into the low-pressure end of the receiver, and thence to the low-pressure steam-chest and cylinder. The pressure of the steam thus admitted to the low-pressure steam-chest is regulated by the relative areas

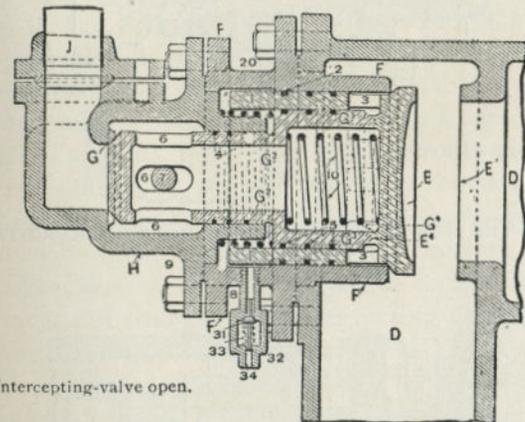
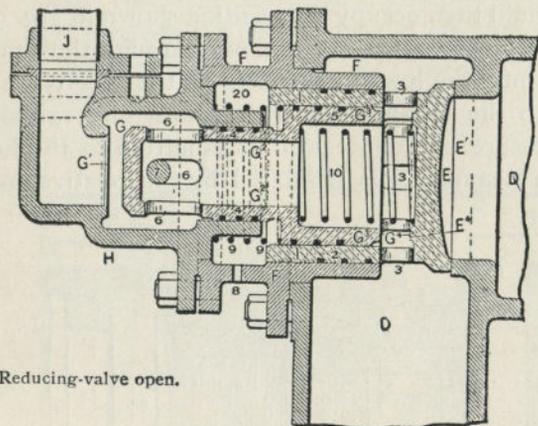


FIG. 97.—THE BROOKS TWO-CYLINDER COMPOUND LOCOMOTIVE.
Intercepting-valve open.

of the two ends of the reducing-valve. Under these circumstances steam from the high-pressure cylinder is exhausted into the closed receiver until the back-pressure in the receiver is approximately equal to that of the steam being admitted directly to the low-pressure side. When the pressure on the high-pressure side reaches this point approximately, the intercepting valve *E* is forced open, and by its first movement closes the outlet of the reducing-valve at *G*, thus



Reducing-valve open.

FIG. 98.—THE BROOKS TWO-CYLINDER COMPOUND LOCOMOTIVE INTERCEPTING-VALVE.

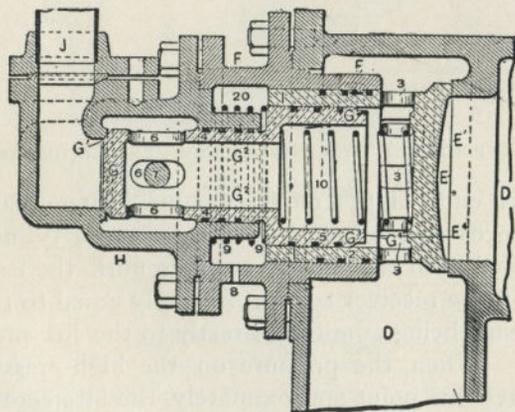


FIG. 99.—THE BROOKS TWO-CYLINDER COMPOUND LOCOMOTIVE INTERCEPTING-VALVE.

closing off the direct supply of steam to the low-pressure side. The difference in area between the large end of the intercepting-valve and the small end of the reducing-valve is then sufficient to enable the receiver-pressure to remove both valves further to the left, as shown in the illustrations, and to close the reducing-valve, thus shutting off the direct supply of boiler steam to the low-pressure cylinder. It will be seen that this valve is, as has been mentioned, a combined reducing and intercepting valve. Mr. Player has patented several other forms of this valve, one of them provided with springs for regulating the action in opening and closing, and also providing for placing the valve in the cylinder saddle. Fig. 99 shows the position of valves with throttle closed and receiver empty.

Another feature of this system of compound locomotives is the arrangement of regulating valves, which is shown by Fig. 96, and at *P* and *Q* in Fig. 94. The object of these valves, which, it will be seen, are operated similarly to the ordinary cylinder-cocks, is, in the first place, to provide an outlet for the exhaust-steam from the high-pressure cylinder when it is desired to move the engine a short distance, as in switching, etc., and, secondly, to provide a means of freeing the receiver and steam, and so taking all pressure off the low-pressure piston, when it is desired to stop the engine within a short distance, as in coupling to trains, etc.

ACCIDENTS TO THE BROOKS COMPOUND ENGINE AND INTERCEPTING-VALVE.

When a main-rod is broken or disconnected on the high-pressure side, how can the engine be run to end of trip?

By running with the low-pressure side.

What should be done in the way of disconnecting in this case?

Cover the ports on the high-pressure side with the valve (and using live steam in the low-pressure cylinder to run with).

How does the steam get into the low-pressure steam-chest?

Through the reducing-valve and intercepting-valve.

Why does not the steam get into the high-pressure steam-chest and receiver?

On account of the live steam in intercepting-valve holding that valve to the seat closing the receiver.

For a broken valve-rod or when disconnected do the same as for a main-rod taken down on that side (disconnecting main-rod).

When a main-rod or valve-rod is broken or disconnected on the low-pressure side, what should be done to run the engine?

The low-pressure valve must be moved back to clear exhaust-port on that side, the piston-head blocked securely in the back end of cylinder.

How can the intercepting-valve be kept open in this case. There must be pressure enough in the receiver to keep the intercepting-valve open.

The way to have a pressure in receiver would be to have the exhaust-port opening very small on the low-pressure side.

Is there any other way of providing an outlet for the exhaust-steam from high-pressure cylinder?

There are regulating-valves tapped in the receiver-passages in cylinder-saddles, but these are not large enough to provide an outlet when pulling cars for any distance; also, the exhaust will be lost on the fire.

How can the intercepting-valve be made inoperative?

By putting a blind-washer in the steam-pipe that joins the reducing-valve chamber. This will prevent any steam from getting into the intercepting-valve to operate it.

When the low-pressure steam-valve is moved all the way back in steam-chest, will it open all the ports?

The valve is liable to drop off its seat in any engine whose seat is higher than the face of receiving-ports, and this will open all ports; but if this should happen, the pressure would be on each side of piston-head. When the intercepting valve is made inoperative, the low-pressure exhaust-port should be opened full.

When from any cause the intercepting-valve is broken so as to leave an opening into the receiver, how could the engine be run as a compound?

Put a blind-washer at joint where the small steam-pipe joins intercepting-valve; this will prevent live steam from getting into receiver.

Do the same for a broken reducing-valve.

When a receiver is broken or badly cracked, what should be done?

The proper way would be to disconnect the high-pressure side and run in with low-pressure side, using steam through the reducing-valve.

Disconnect for other broken parts as for a simple engine.

BROOKS TANDEM COMPOUND LOCOMOTIVE.

The Tandem Compound Locomotive is now in actual use in this country, and the system which is described contains the patents of J. Player, Mechanical Engineer of the Brooks Locomotive Works. The longitudinal section, Fig. 101, shows the cylinder valves and receiver, also piston-heads, ports, and method of packing between the two cylinders. The valves are of two types. The low-pressure valve is a slide-valve having the usual balance-plate, but in this case the plate is made as shown in Fig. 102, this being on account of the rod that is pivoted on top of the low-pressure valve-yoke. The high-pressure valve is a piston-valve, being hollow. The live steam is confined between the two heads of valve, packing-rings are sprung in heads to make it tight. As will be understood, this valve acts directly opposite to that of a common slide-valve in this way, that the lap of the valve is in the inside of heads, or what would be the exhaust side of slide-valve, and exhausts the steam from each end instead of into the centre of valve, as with the slide-valve.

The object of having the valve hollow is to allow the exhaust-steam to pass through valve into receiver. By referring to Fig. 101 it will be seen that the valves are in open communication with each other, the valve-cham-

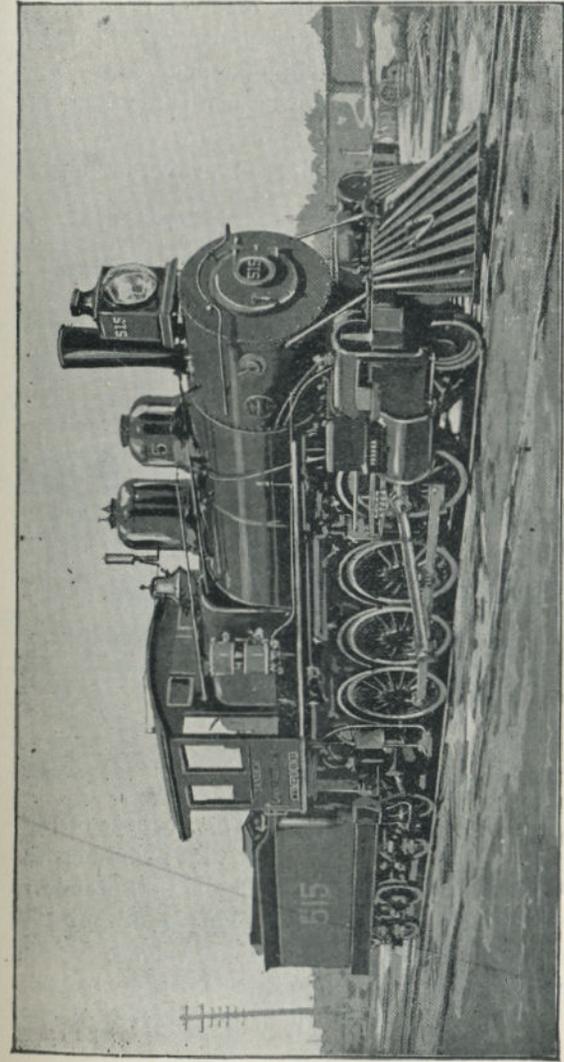


FIG. 100.—BROOKS TANDEM COMPOUND CONSOLIDATION FREIGHT LOCOMOTIVE.

bers acting as a receiver. In the receiver proper is a cross-shaft, on which rotates a rocker-arm; to the upper arm is connected the rod, which is fastened to the low-pressure valve-yoke. To the lower arm is fastened the rod, which is attached to high-pressure valve. The usual yoke surrounds the low-pressure, valve having its

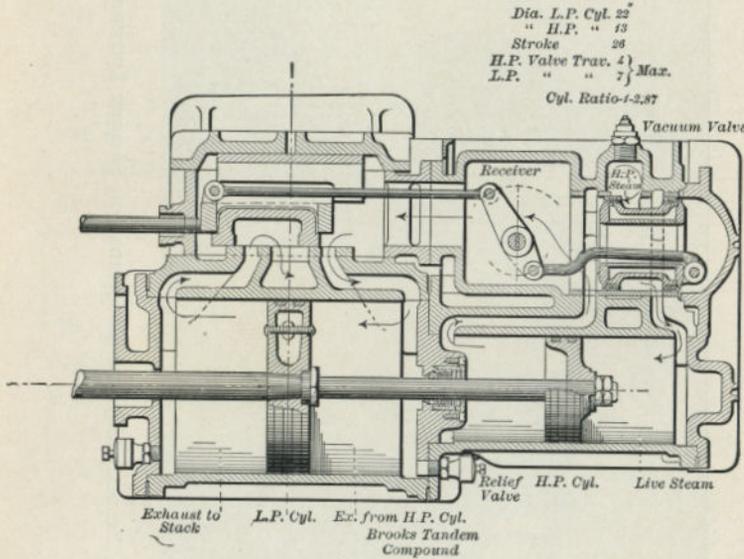
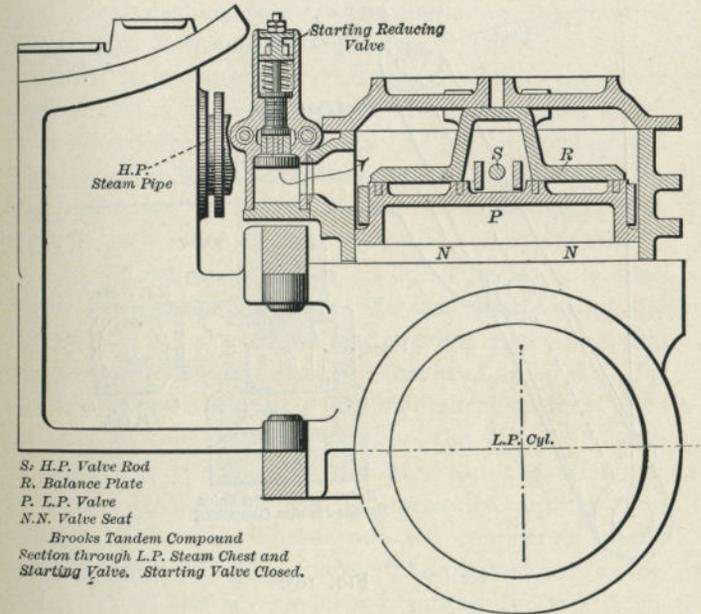


FIG. 101.

stem connected to the valve-rod. The purpose of having the rocker-arm is twofold: First, that by having the arms of different lengths there will be a difference in the travel of the valves, which is a very good point in compounding. When the low-pressure valve travelling 7 inches maximum, the high-pressure valve-travel is 4 inches maximum, so that when using a short cut-off

in the high-pressure cylinder you have a wide opening in the low-pressure ports. Second, the valves must travel in opposite directions on account of the high-pressure steam being confined between the heads of high-pressure valve, and by using the rocker-arm * this



S. H.P. Valve Rod
R. Balance Plate
P. L.P. Valve
N.N. Valve Seat
Brooks Tandem Compound
Section through L.P. Steam Chest and Starting Valve. Starting Valve Closed.

FIG. 102.

is accomplished. The action of valves would be as follows: When the low-pressure valve moves to left of Fig. 101 to uncover the front port of the low-pressure cylinder, the high-pressure valve would move to the

* Builders term, *reversing-arm*.

right and uncover the front of steam-port, and at the same time open back-port of high-pressure cylinder to receiver.

The course of the steam would be as follows: when high-pressure valve opens, the steam enters cylinder, exerting its power against the high-pressure piston-

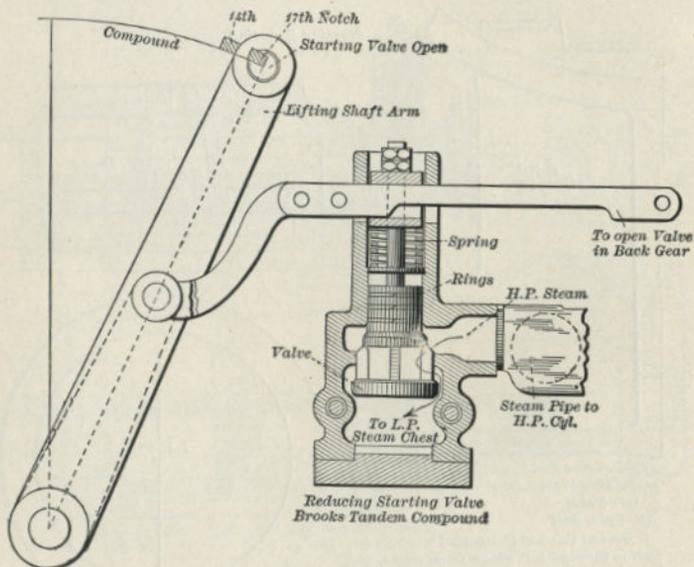


FIG. 103.

head. The steam that has expanded in the other end of high-pressure cylinder would pass out the back-port into the receiver, from there into the low-pressure steam-chest proper, and into the low-pressure cylinder through the front steam-port, which would be open. The steam in the other end of low-pressure cylinder would pass

out the back-port under the valve into the stack, as with the simple engine.

There is provided a starting-valve on this as on all compounds. This valve is attached to the side of low-pressure steam-chest, and steam-pipe that leads to the high-pressure steam-chest. This valve is simple in construction. Fig. 102 shows the construction and position of valve when closed. Fig 103 shows the position when open at the time of starting. The valve-casing is bolted to low-pressure steam-chest, and in the lower end of casing is a seat against which the valve, which is a wing-valve, closes. Attached to this valve is a stem which extends up to the top of casing; this valve has two seats, as will be seen: the upper seat is in contact with valve when it is closed; rings are sprung in the extension of valve to keep it from leaking when valve proper is open. To the upper end of the valve-stem is fastened a head having two horizontal openings through it. Between this head and a shoulder in the casing is placed a strong helical spring. The purpose of this spring is to close the valve. Passing through the openings in the head on the stem are two rods of different widths vertically, similar to a cylinder-cock rod. These rods are connected to the reversing-arm of lifting-shaft. The operation is as follows: When the reverse-lever is put all the way down on the quadrant, as when starting a train, the rods are pushed forward in the head on starting-valve stem, the wider part of rod enters the opening, and forces the head and spring down. The live steam then opens the valve and admits steam into the low-pressure steam-chest, at the same time reducing the steam-pressure due to the

difference in area of the two sides of the valve proper. When the reverse-lever is put back to the 14th notch, the wide part of rod is withdrawn from the head on valve-stem, the spring will close valve and compounding begins. This action takes place in forward or back gear.

ACCIDENTS TO THE BROOKS TANDEM COMPOUND.

When a main-rod is broken or taken down, what should be done in way of preparing the engine to be run in?

The valves on the side disconnected should be put in the centre of their seats covering all steam-ports, and run with the good side.

When a valve-rod breaks, do the same as for main-rod disconnected.

If a front-head of high pressure cylinder is broken out, what should be done?

The valves on that side put in centre of the seats covering the ports, main-rod taken down, cross-head blocked, and run in with the other side.

Could the engine be run without taking down the main-rod?

By taking off the front head of valve-chamber and disconnecting the high-pressure valve-rod, putting the valve in centre of seat covering the ports, putting a block in the centre of valve so as to carry the rod to clear valve, the reverse-lever put in full forward notch, this will open the starting-valve. Disconnect the rod from the reverse-arm: this will prevent the starting-valve from being closed when the reverse-lever is pulled up. The engine will be running as a compound on one side, and the low-pressure cylinder will act as high-

pressure engine on the broken side; this shows what can be done in an extreme case. Care must be taken to keep the high-pressure cylinder oiled; this may be done through the cylinder-cocks or open end of cylinder.

What could be done in case of a broken receiver?

If badly broken, a blind-washer could be put in joint where the steam-pipe joins the high-pressure steam-chest, disconnecting main-rod and blocking cross-head.

If the rocker or high-pressure valve reversing-arm should break off, what should be done?

Put valve in centre of seat covering all ports, take down main-rod, block cross-head, and run in with other side.

How could you cover all ports in this case?

Cover the low-pressure ports by the reverse-lever, then take off the front head of high-pressure valve-chamber, put that valve over ports, and put on head.

How can the high-pressure valve be held in position when disconnected from the rocker-arm?

By cutting a block which should have a section cut out of it the length of the valve, putting it through the valve, and letting it drop down over the ends of valve, the one end abutting against the rock-shaft in receiver, and the other end held by the head being screwed up against it.

In any break in which the valves can be made to cover the ports, the quickest way is to disconnect on that side and run with good side. As both sides of an engine are constructed alike, these questions apply to both.

In a case where the valves could not be made to cover all ports, a blind-washer put in steam-pipe joint will prevent steam from getting into valves or cylinders.

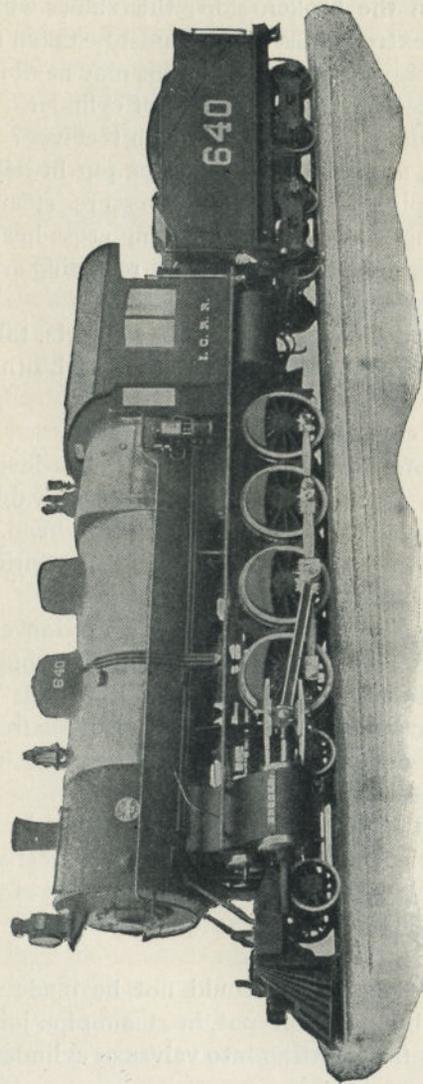


FIG. 104.—ONE OF THE HEAVIEST FREIGHT LOCOMOTIVES IN THE WORLD.

This locomotive is one of the heaviest ever built, and is designed to haul a train weighing 2045 tons, exclusive of engine, tender, and caboose, up a grade of 38 feet per mile, combined with 3-degree curves, at a speed of 15 miles per hour.

The boiler is of the Player-Belpaire type, and the thickness of the plates, $\frac{1}{8}$ inch and 1 inch, is thought to be the greatest ever used upon locomotive boilers. The diameter at front end is 82 inches, connection 88 inches, and throat 97 $\frac{1}{2}$ inches.

Nearly all parts of this locomotive, usually made of cast iron, are, with the exception of the cylinders, made of cast or pressed steel or malleable iron. The Brooks piston-valve is used and the valve-chest in saddle is clearly shown.

BROOKS PISTON-VALVE LOCOMOTIVE.

Cylinders: Simple piston-valve, diameter 23 inches, stroke 30 inches.

Boiler: Improved Belpaire, diameter 82 inches.

Fire-box: Long, wide, length 132 inches, width 42 inches.

Wheels: Coupled drivers, No. 8, diameter 57 inches.

Leading Wheels: No. 4, diameter 30 inches.

Flues: No. 424, diameter 2 inches, length 14 feet 8 $\frac{3}{8}$ inches.

Boiler-pressure: Pounds per square inch above atmosphere, 210.

Average Weight: In working order—tender 132,700 pounds, drivers 193,200 pounds, leading wheels 39,000 pounds.

Total Engine Weight: 232,200 pounds.

Heating Surface: Flues 3237 square feet, fire-box 263 square feet, total 3500 square feet.

Grate Area: 37.5 square feet.

Wheel Base: Drivers 15 feet 9 inches, rigid 15 feet 9 inches, engine 26 feet 6 inches.

Engine and Tender: 55 feet 2 $\frac{3}{4}$ inches.

Fuel: Bituminous.

Hauling Capacity: 2045 tons, fifteen miles per hour, up a grade 38 feet per mile.

Illinois Central Railroad, owners.

BROOKS SINGLE-EXPANSION LOCOMOTIVE USING PISTON-VALVES.

There are a number of locomotives in operation using piston-valves instead of slide-valves. The purpose

of using these valves is as follows: The shortest possible passage between piston-head and valve is secured. The port can be of large area with a very small surface exposed to cooling effect. The large sectional area of port reduces the frictional resistance to a minimum; this reduces the loss in pressure of steam. The piston-valve being perfectly balanced reduces the wear and tear on the valve mechanism, and less power is absorbed to move them. It being possible to use a larger port, a longer lap on the valve can be used than with slide-valves, giving the same power at maximum cut-off as with a shorter lap with a slide-valve. This gives a free opening on the exhaust side, reducing the back-pressure in cylinder to as low a point as desirable. The shortest passage for the steam is secured from the top of saddle to the edge of valve. From the foregoing the following results must occur:

An increase of pressure on the admission-line or positive side of the diagram, due to large port-opening. A decrease of back-pressure on the negative side of diagram or exhaust-line. A decrease of power required to move valves.

Fig. 105 is a cross-section through the valve, valve-chest, and a portion of steam-cylinder of a Brooks engine using piston-valves. The valve-chest is cast integral with the steam-cylinder, and between the steam-cylinder and the upper portion of saddle. The steam-passage between edge of valve and the end of passage to which the steam-pipes are bolted in front is of the shortest possible length. This portion is jacketed over, preventing condensation. The valve is hollow, with a depression between the ends; in the two

heads are placed the packing-rings, made of cast iron. There are two rings at each end, as shown in Fig. 106, which is a detail drawing; these rings are turned with a flange at the side on the inner diameter; these flanges fit in a groove in a bull-ring, one ring on each side of bull-ring. The bull-ring and packing-rings are slipped

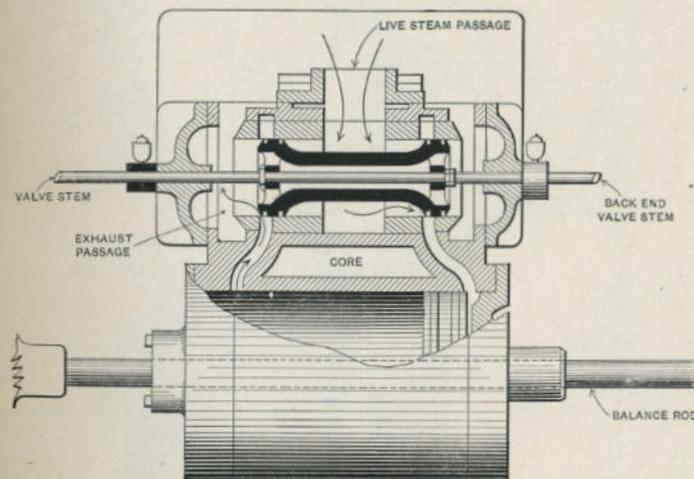


FIG. 105.—SECTION THROUGH VALVE-PORTS AND VALVE-CHEST.

over a follower, which extends the width of bull-ring. To this follower are spiders through which the valve-rod passes. In order to bind the rings and follower to main portion of valve, the nuts on back end of valve-rod are drawn up tight, thus drawing the rings and follower to the main body rigidly. It is understood in fitting these rings the packing-rings are fit so as to be able to expand as they wear, and are compressed when slipped in bushing. The bushing is in two pieces in

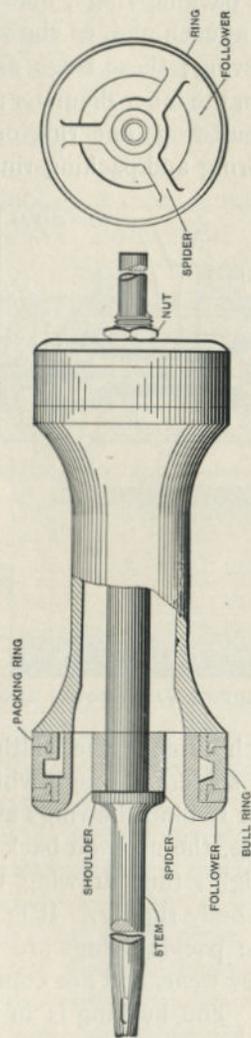


FIG. 106.—BROOKS PISTON-VALVE.

the valve-chest, with the live-steam ports in each end. This valve is what is termed an internal-admission

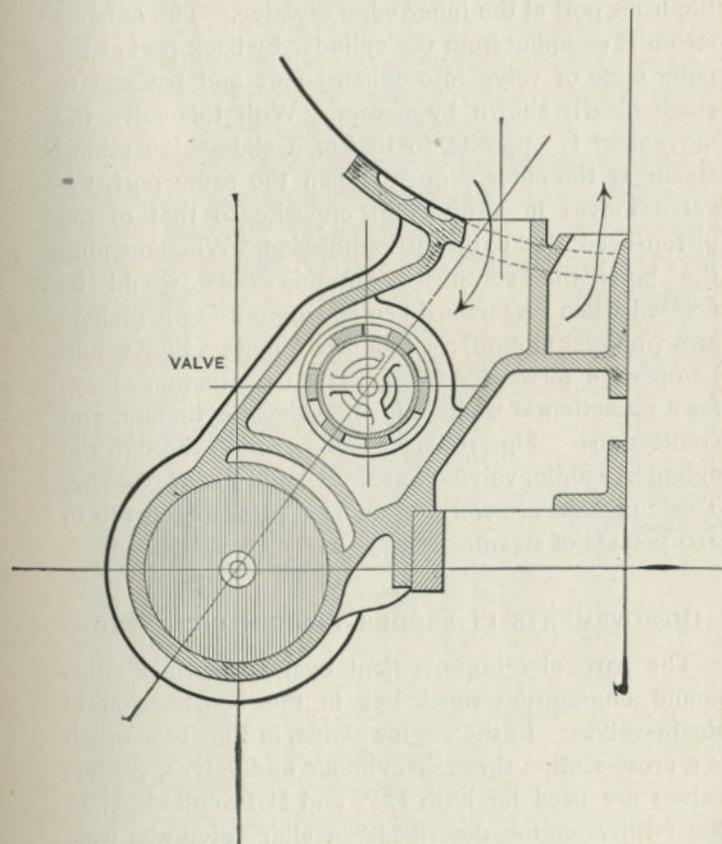


FIG. 107.—SECTION THROUGH SADDLE-VALVE AND CYLINDER, BROOKS LOCOMOTIVE.

valve, as shown by the arrows in Fig. 105; the live steam surrounds the valve between the heads, while the exhaust takes place at each end of valve. An

exhaust-port and passage is provided at each end of valve-chest, as shown. The valve is taking steam in the front port at the inner edge of valve. The exhaust steam is escaping from the cylinder by back port at the outer edge of valve into exhaust-port and passage to stack clearly shown by arrows. With this valve the movement is opposite to that of a slide-valve taking steam at the outer edge; to open the same port, the valve moves in a direction opposite to that of the piston-head, due to internal admission. When opening the port, the eccentrics for this valve would be crossed when on forward centre where using a rocker-arm (indirect motion); with a direct motion they would be open on forward centre. This construction allows for a reduction of weights in the valves, cylinders, and connections. Fig. 107 is a cross-section through the cylinder, saddle, valve-chest, ports, and steam-passage. These engines are working under a pressure of 180 to 210 pounds of steam.

IMPROVEMENTS IN BROOKS TANDEM COMPOUND.

The particular improvement over the former compound engine described lies in the construction of steam-valves. In the engine shown in Fig. 108, which is a cross-section through cylinder and valves, piston-valves are used for both L.P. and H.P. cylinders; in the former engine described,* a slide-valve was used for L.P. cylinder, with valves moving in opposite directions. In Fig. 108 the H.P. and L.P. valves are connected to one valve-stem and both valves move in

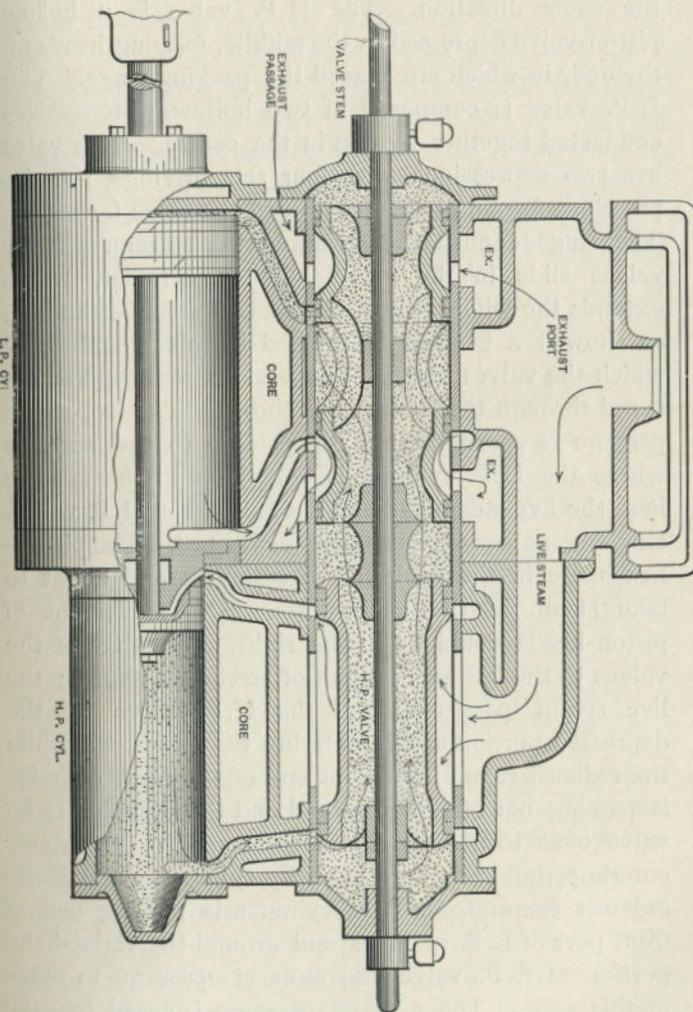


FIG. 108.—BROOKS TANDEM COMPOUND.

* Page 149.

the same direction. The H.P. valve is a hollow piston-valve depressed in the middle, forming heads on the end, in which are placed the packing-rings. The L.P. valve is composed of two hollow piston-valves connected together by ribs in the centre. This valve has two depressions, with four sets of rings, the depressions forming passages around the valve for steam. The rings confine the steam between them. These valves slide in the valve-chest or cylinder, which extends the whole length of the two steam-cylinders, as shown; a bushing is pressed in this chamber, in which the valves slide. The various steam-ports are cored through the bushing, as shown. The live-steam passage is cored through the saddle to the rear, to where the H.P. cylinder is bolted on to the saddle; here the live-steam passage extends to the H.P. valve-chamber, as arrows, as shown in Fig. 108. The piston-heads are in the back end of cylinders and about to take steam in the back ports. The movement of piston-heads would be to the right, while that of the valves to the left for first half of stroke, as shown; the live steam passes around the H.P. valve in the depressed portion and is entering the back port, while the exhaust steam from front end of the H.P. cylinder is passing out of the front end and through the H.P. valve over to the L.P. valves, through them, and entering the back port of L.P. cylinder. The final exhaust steam from L.P. cylinder is passing out of front port of L.P. cylinder and around the right-hand portion of L.P. valve and exhaust passage to stack in this case. The exhaust passage is cored to each side of the steam-ports and then unites in a single

passage, thus making two exhaust ports. [The slide-valve requires the exhaust port to be in the centre and between the steam-ports.] The same action takes place for each end of cylinder. The hollow valves and valve-chamber act as a receiver for the exhaust steam from H.P. cylinder, and the outside of H.P. valve is always surrounded by live steam while running. In order to show the course of exhaust steam from the

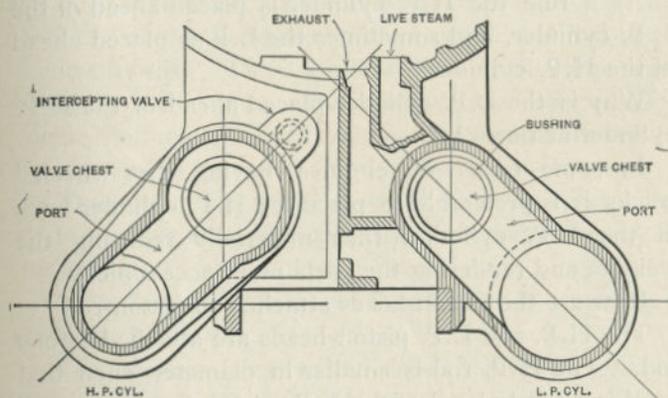


FIG. 109.—SECTION THROUGH CYLINDERS AND VALVE-CHESTS, EXHAUST AND STEAM PASSAGES, BROOKS TANDEM COMPOUND.

H.P. cylinder, the whole area is dotted in to represent steam between the H.P. piston-head and L.P. piston-head. The arrows also show clearly the course taken. The arrows in L.P. port show clearly the passage of exhaust from cylinder to exhaust-port and passage. In this engine the intercepting-valve is placed in the saddle and not in the smoke-arch, as in former engine described, using two cylinders. For description see page 140. Fig. 109 is a cross-section through cylinders

valve-chests, and saddle of tandem compound, showing position of intercepting-valve.

QUESTIONS AND ANSWERS RELATIVE TO BROOKS
TANDEM COMPOUND.

In what position are the cylinders of a Brooks tandem compound?

As a rule the H.P. cylinder is placed ahead of the L.P. cylinder, and sometimes the L.P. is placed ahead of the H.P. cylinder.

Why is the L.P. cylinder placed ahead of the H.P. cylinder at times?

In some types of engines having four-wheeled trucks it is preferable to place the H.P. cylinder back of the L.P. cylinder, thus materially reducing the weights and rendering the parts more accessible.

How are the piston-heads attached to piston-rod?

The H.P. and L.P. piston-heads are attached to one rod. The H.P. rod is smaller in diameter when that head is placed ahead of the L.P. piston-head.

How is the steam prevented from passing into L.P. cylinder from H.P. cylinder around piston-rod?

The intermediate head contains a metallic packing.

How many main steam-valves to a side in a Brooks tandem compound?

There are two piston-valves in some and a piston- and a slide-valve in others.

What is the form of these valves when using the piston type?

They are what is called the internal-admission type. By this term is meant the steam is admitted to the

cylinders from between the heads of piston-valves at the inner edge instead of the outer edge, with the exhaust passing through the valve.

How is the piston-valve kept tight?

By using cast-iron packing-rings, which are fitted into grooves in the piston-valve heads. These rings are turned of a larger diameter than the bore of valve-chamber in order to give them the necessary spring.

How is the L.P. valve constructed?

The valve is composed of two portions joined in the centre by ribs. There are four heads with a depression between each pair, using four sets of rings. The depression makes the exhaust passage around the valve.

How many ports are there in the valve-chamber?

There are six ports: two H.P. steam-ports, two L.P. steam-ports, and two exhaust ports from L.P. cylinder.

How does the steam get from the H.P. to the L.P. cylinder?

The steam is exhausted from the H.P. cylinder through the H.P. valve into the L.P. valve and ports into the L.P. cylinder.

How does the exhaust steam from L.P. cylinder pass to the atmosphere?

It passes out the steam-port and around L.P. valve into the two exhaust-ports into stack *via* exhaust-passage and nozzles.

How are the rings in valves carried over the ports?

By ribs or bridges cast across the ports, which prevent the rings from dropping into ports.

Why does it require less power to move a piston-valve than a slide-valve?

Because a piston-valve being a cylinder it is surrounded by steam, the pressure being equal on all sides.

What prevents live steam from passing over to L.P. cylinder from the live-steam passage and H.P. valve?

The rings in H.P. valve.

If the rings of L.P. valve were broken what would happen?

Some of the exhaust steam from H.P. cylinder would escape directly into the stack, causing a loss of power in L.P. cylinder.

How would such a condition be noted?

There would be a continuous blow from that side of engine.

If the rings on H.P. valve leak from any cause, what effect would it have on that side of engine?

It would cause the L.P. cylinder to operate with H.P. steam, and to work non-compound by balancing the H.P. piston-head. This would cause that side of engine to be much stronger than the other side and the exhaust would be much louder.

Can the usual indirect valve-motion be applied to this engine?

Yes, but the eccentric-rods must be crossed when the engine is standing on forward centre.

How are the piston-heads taken out of the cylinders?

The piston-heads are pushed to front end of cylinders, H.P. piston-head taken off; then the L.P. piston-head is pushed to back head of L.P. cylinder, head taken off, and piston-head taken out; this necessitates the taking down of the guides. Another way would be to disconnect the H.P. cylinder from L.P. cylinder where joined and take out piston-heads.

If from any cause the packing should blow out in intermediate head, what would be the effect?

The live steam from back end of H.P. cylinder would blow out to stack through L.P. cylinder and exhaust-ports at each stroke.

If the H.P. piston-valve should become disabled so as to be taken out, could the engine be run as a simple engine?

Yes, by taking out the H.P. valves on both sides and throttling close, with lever well up in quadrant. In this case the H.P. piston-heads would be balanced by live steam and the cylinders would be lubricated by the entering steam, by which the lubricant is carried. Care should be exercised in running in this manner.

With a broken main rod, or valve-rod broken outside of chest, what should be done?

The ports should be covered by placing the valves in centre of travel, fastened in position by the usual means, and that side of engine disconnected.

With the H.P. piston-heads balanced, which piston-heads would be doing the work?

The low-pressure heads would be doing the work, the engine operating as a simple engine.

With the L.P. valves taken out how would the engine operate?

The engine would run as a high-pressure engine with the low-pressure cylinders doing no work, because the exhaust steam from the H.P. would escape direct to stack. Care would have to be taken to lubricate the L.P. cylinders to prevent cutting.

THE WEBB COMPOUND LOCOMOTIVE.

The accompanying illustration, Fig. 110, from *Industries*, shows the latest compound engine built by the London & Northwestern Company at its shops at Crewe. This engine is of the Webb three-cylinder type, having two high-pressure cylinders outside, connected to one pair of drivers, and a single low-pressure cylinder inside, connected to the other pair. There is no connection between the two pairs of drivers. As shown by the engraving, the driving-wheels are all forward of the fire-box, and there are two pairs of bearing-wheels, one behind the fire-box carried rigidly in the frames, and one pair forward having Mr. Webb's radial axle-boxes, which give a degree of flexibility approaching that of a two-wheeled truck.

The general plan of the engine made necessary the adoption of a very long boiler, and one of a peculiar type has been used.

As shown by the drawing, Fig. 111, a combustion-chamber is arranged in the barrel of the boiler between the fire-box and smoke-box tube-plates so as to divide the boiler into two lengths. The general arrangement will be clearly understood from the illustration, which shows a boiler so constructed in longitudinal section. *A* is the main fire-box, and *B* its tube-plate, from which tubes *C* extend to a tube-plate at one end of the combustion-chamber *D*, and at the other end of which another tube-plate has further tubes *C* leading to the smoke-box tube-plate *E*. The combustion-chamber

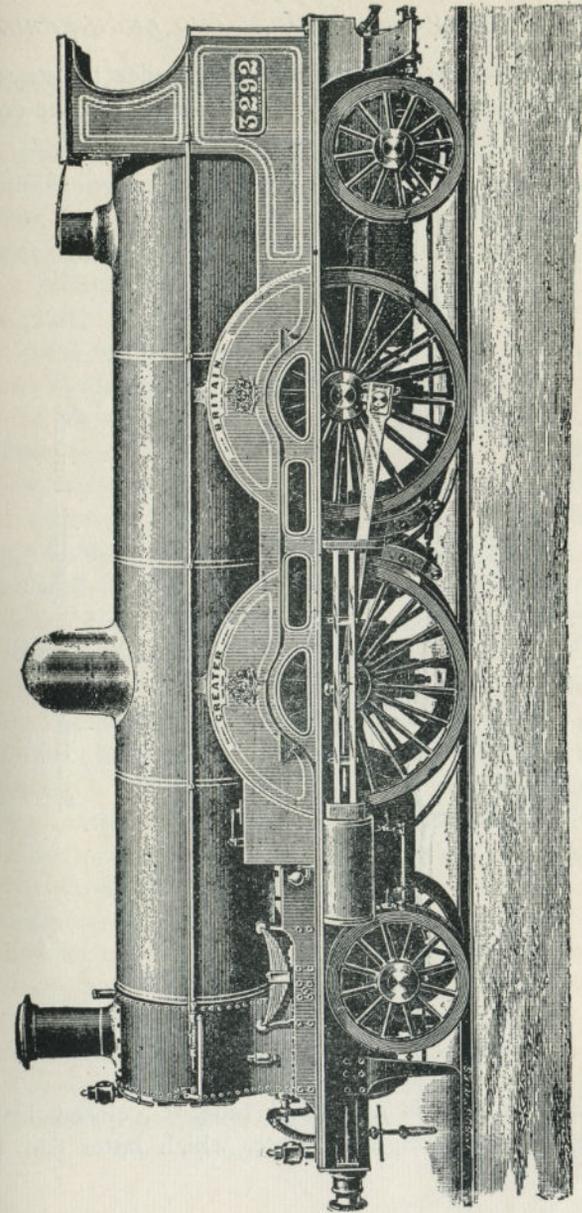


FIG. 110.—WEBB THREE-CYLINDER COMPOUND.

D is secured to the barrel of the boiler by stays *F* riveted to angle-irons. At the lower part of the com-

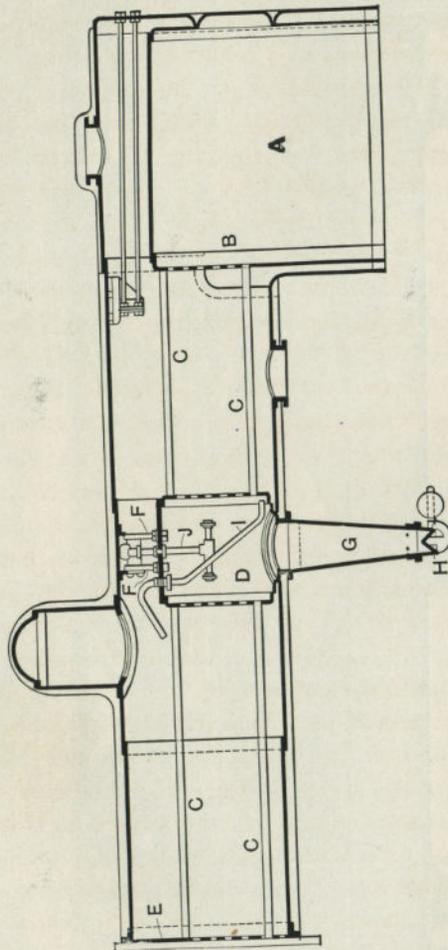


FIG. III.—WEBB LOCOMOTIVE BOILER.

bustion-chamber is a conical tube, *G*, closed by a valve, *H*, and weighted lever, which latter can be

operated from the foot-plate of the engine, so that any ashes collected in the tube *G* may be allowed to fall out when required. *I* represents a circulating tube, of which any number may be arranged, either as represented in the illustration or in any other suitable manner. A pipe, *J*, is also arranged to be controlled by a suitable valve, which may be worked from the foot-plate, and which pipe is provided with two branches, each terminating in a rose, so that when steam is allowed to escape from them any soot or ashes will be blown from the open ends of the tubes *C*.

The described locomotive represents the latest English design of a modern locomotive as applied to that country, and somewhat resembles the Atlantic type of engine of the United States in general use, illustrated in Fig. 277. The data given show very clearly the work done by the engine in actual service.

The barrel of the boiler is 51 inches in diameter and 18 feet 6 inches long. The combustion-chamber is 2 feet 8½ inches long, and there are two sets of tubes, each set being 156 in number and 2½ inches in diameter. The rear tubes, extending from the fire-box to the combustion-chamber, are 5 feet 10 inches long, and the forward tubes, from the combustion-chamber to the smoke-box, are 10 feet 1 inch in length. The outside fire-box casting is 6 feet 10 inches long. The grate-area is 20.5 square feet. The heating surface is: fire-box, 120.6; combustion-chamber, 39.1; rear tubes, 493.0; forward tubes, 853.0; total, 1505.7 square feet. The working pressure is 175 pounds in ordinary service.

The leading- and trailing-wheels are of the same diameter, 49½ inches; the driving-wheels are 7 feet 1 inch. The distance between leading-axle and

forward, or high-pressure, driving-axle is 8 feet 5 inches; the distance between driving-axles is 8 feet 3 inches, and from rear, or low-pressure, driving-axle to the trailing-axle, 7 feet; thus making the total wheel-base 23 feet 8 inches, and the rigid wheel-base 15 feet 3 inches. The driving-axles have $8\frac{1}{2} \times 13\frac{1}{2}$ -inch journals, and the leading- and trailing-axles $6\frac{1}{2} \times 12$ -inch journals.

The weight of the engine in working order is 116,700 pounds, of which 28,670 pounds are carried on the leading-wheels, 34,720 pounds on the forward drivers, 34,720 pounds on the rear drivers, and 18,590 pounds on the trailing-wheels.

The frames are of the ordinary English plate type, the main frame being of 1-inch steel plate. The total length of frame is 32 feet $5\frac{1}{4}$ inches over all.

The two H.P. cylinders are each 15 inches in diameter and 24 inches stroke. The steam-ports are $11 \times 1\frac{1}{2}$ inches, and the exhaust-ports 11×5 inches. The valve-motion is of the ordinary curved-link type; the valves are of the piston type, and have 4 inches maximum travel, $\frac{1}{16}$ inch outside lap, and $\frac{3}{16}$ inch lead in full gear. There are four guides, with a cross-head of corresponding pattern, and the connecting-rods are 8 feet 3 inches long. The crank-pins have 4×5 -inch bearings.

The single L.P. cylinder is 30 inches in diameter and 24 inches stroke. The steam-ports are $20 \times 2\frac{3}{4}$ inches, and the exhaust-port $20 \times 5\frac{1}{4}$ inches. The valve is worked by Mr. Webb's single-eccentric motion; it has $5\frac{1}{2}$ inches travel and $1\frac{3}{16}$ inches outside lap. The connecting-rod is 6 feet 3 inches long; the bearing on the crank-axle is $7\frac{3}{4} \times 5\frac{1}{2}$ inches.

On its first trip after completion the *Greater Britain*, as this engine is named, was sent from Crewe to London, 157 $\frac{1}{2}$ miles, with an experimental train, consisting of twenty-three six-wheeled passenger coaches. The weight of the train at starting was: Locomotive, 116,480 pounds; tender, 56,000 pounds; cars, 684,260 pounds; total, 856,840 pounds, carried on 82 axles. The ratio of the weight of train to that of engine and tender was 3.96 : 1. The length of the train was: Engine and tender, 54 feet; cars, 880 feet; total, 934 feet.

The time occupied in the trip was 4 hours 2 minutes, including a stop of 21 minutes at Rugby. The average speed between Crewe and Rugby was 41.18 miles an hour; between Rugby and Euston Station, in London, 44.59 miles an hour. The particulars of the run are given as follows:

Stations.	Running Times.	Distance in Miles.	Speeds in Miles per Hour.	Weather.
Crewe.....dep.	11:04 A.M.			Fine.
Whitmore.....pass.	11:25 "	10 $\frac{1}{2}$	30	"
Stafford....."	11:42 "	14	49.41	"
Rugeley....."	11:55 "	9 $\frac{1}{2}$	42.69	Strong
Lichfield....."	12:06 P.M.	8	43.63	Side wind
Tamworth....."	12:14 "	6 $\frac{1}{2}$	46.87	"
Nuneaton....."	12:33 "	13	41.05	"
Rugby.....arr.	12:54 "	14 $\frac{1}{2}$	41.42	"
".....dep.	1:15 "			
Blisworth.....pass.	1:46 "	19 $\frac{1}{2}$	38.22	"
Wolverton....."	2:00 "	10 $\frac{1}{2}$	45	"
Bletchley....."	2:07 "	5 $\frac{3}{8}$	49.28	"
Leighton....."	2:15 "	6 $\frac{1}{2}$	48.75	Rain.
Tring....."	2:28 "	8 $\frac{1}{2}$	39.23	"
Watford....."	2:45 "	14 $\frac{1}{2}$	50.29	"
Willesden....."	2:58 "	12	55.38	"
Euston.....arr.	3:06 "	5 $\frac{1}{2}$	39.37	"

The results are computed by Mr. Webb as follows: The coal consumed on the journey was 34 pounds per mile, or 0.089 pound per ton of train per mile; the coal consumed, including 10 cwt. used for raising steam before starting, for the single journey from Crewe to Euston, was 41.1 pounds per mile, or 0.107 pound per ton of train per mile; if the usual double journey from Crewe to Euston and Euston to Crewe were run, the 10 cwt. for raising steam would be divided over the double trip, or 5 cwt. for raising steam, which would give a consumption of coal of 37.5 pounds per mile, or 0.098 pound per ton of train per mile. The tons here are, of course, the English ton of 2240 pounds.

The total quantity of water evaporated on the journey was 5896 gallons, giving the high average of 10.96 pounds of water evaporated per pound of coal consumed.

DESCRIPTION OF INTERCEPTING-VALVE, RICHMOND LOCOMOTIVE AND MACHINE WORKS COMPOUND.

The various drawings show sections through the low-pressure cylinder-saddle, with the valves in their four relative positions.

Fig. 114 shows the position of valves in starting automatically, just after the throttle is opened;

Fig. 115 shows the same at maximum pressure in low pressure steam-chest;

Fig. 116 shows the position when working compound; and

Fig. 117 shows position when working simple.

The high-pressure cylinder exhausts into a receiver, which is placed inside the smoke-box and opens into the chamber *F*. The intercepting-valve, as shown at *V* in the several views, has a piston on its outer end which acts as an air dash-pot, preventing any slamming of the valve. Around the stem of this valve is a sleeve *L*, which has an axial movement on the stem, and acts as an admission- and reducing-valve to the low-pressure steam-chest when starting and when working simple. Valve *H* is a plain bevel-seated winged valve, and is called the emergency-valve, as by its use the engineer can, at will, operate as a simple engine.

When starting, steam from the boiler goes to the high-pressure cylinder in the ordinary way, and also to the port *C* through a two-inch steam-pipe connected to the dry pipe. When the throttle is opened, no matter in what position the valves stand, there is no

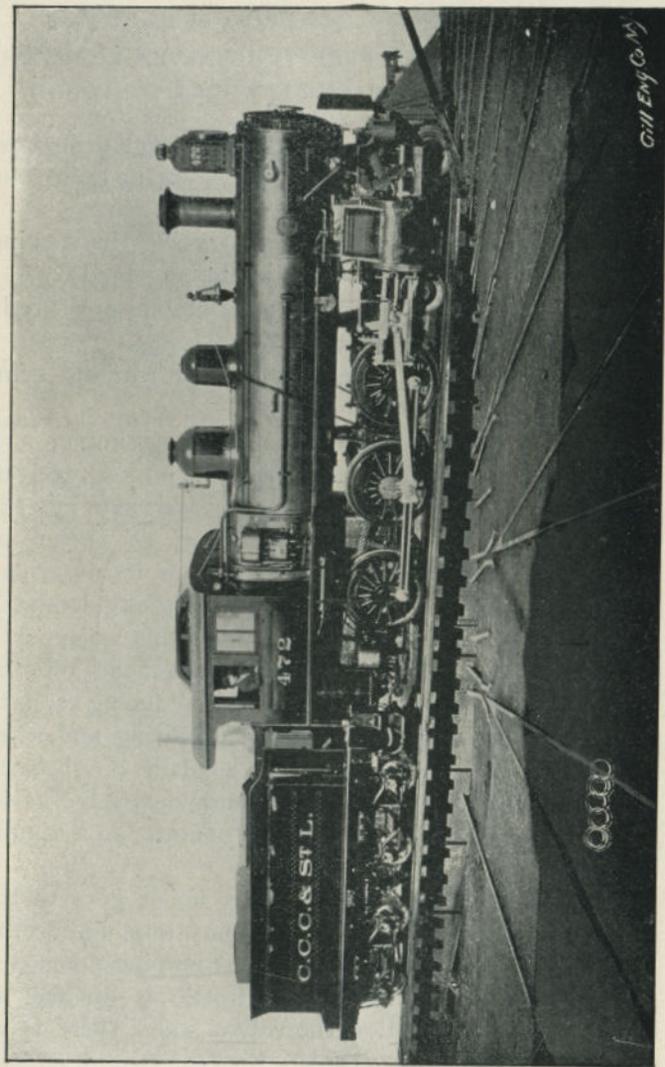


FIG. 112.—RICHMOND COMPOUND FOR C., C. & ST. L. R. R.

Diameter of Drivers, 56".

Weight on Drivers, 107,100 lbs.

Diameter of Boiler, 60".

Total Weight, 136,000 lbs.

Diameter of Cylinders, 19" \times 30" \times 24" stroke

Gill Eng. Co. N.Y.

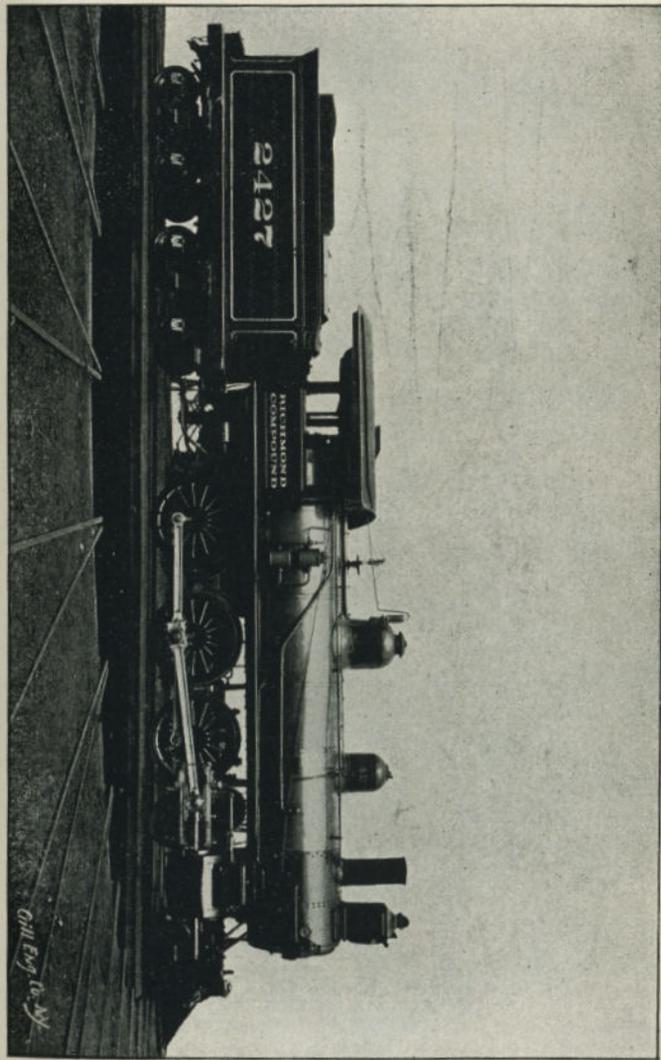
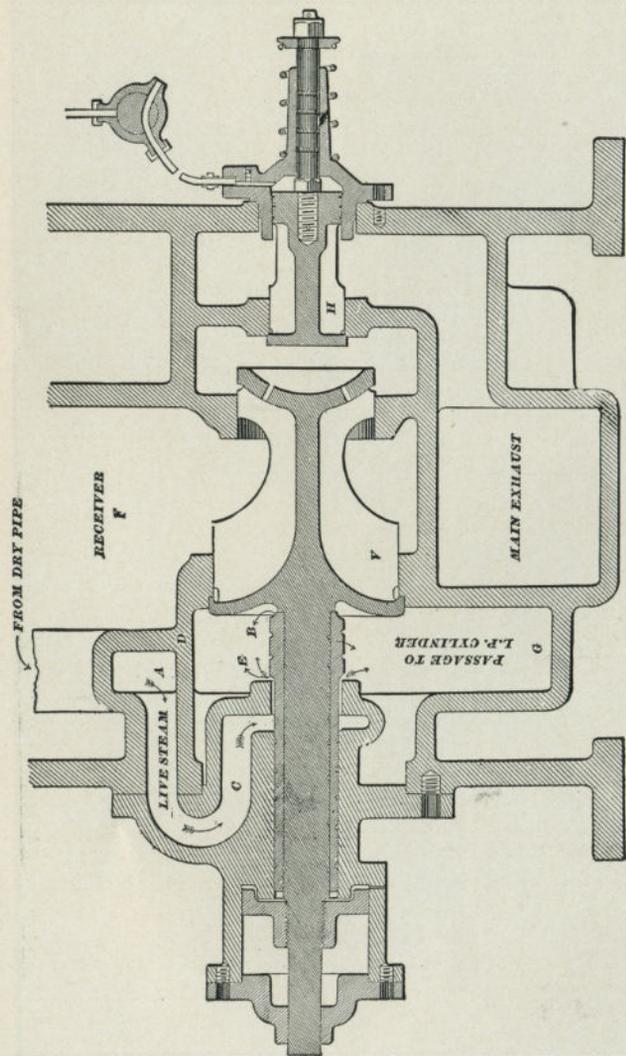
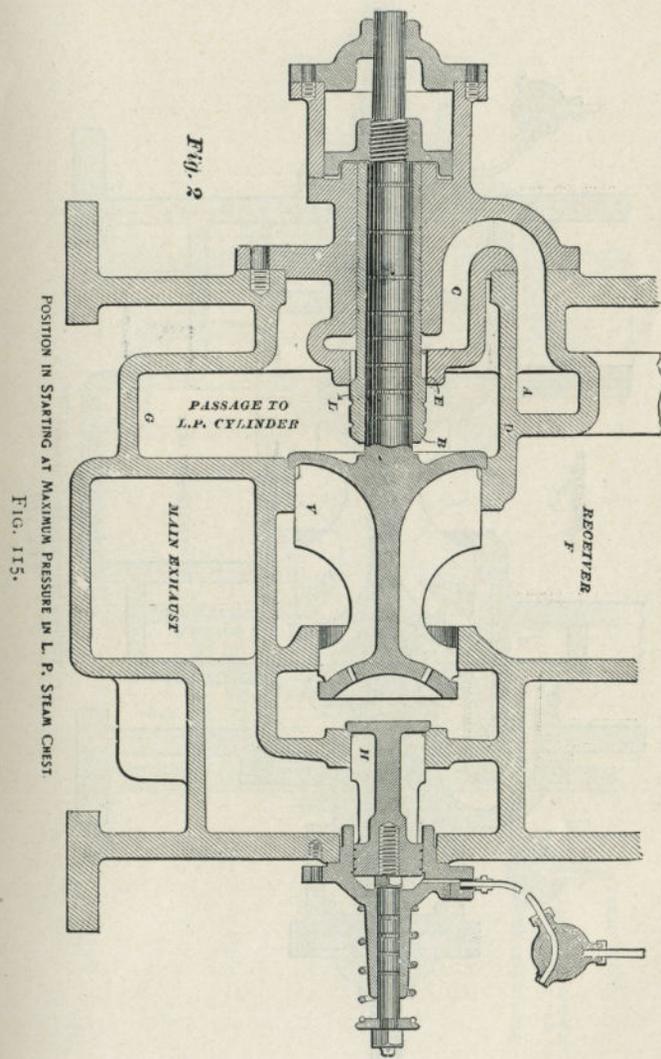


FIG. 113.—RICHMOND LOCOMOTIVE AND MACHINE WORKS COMPOUND.

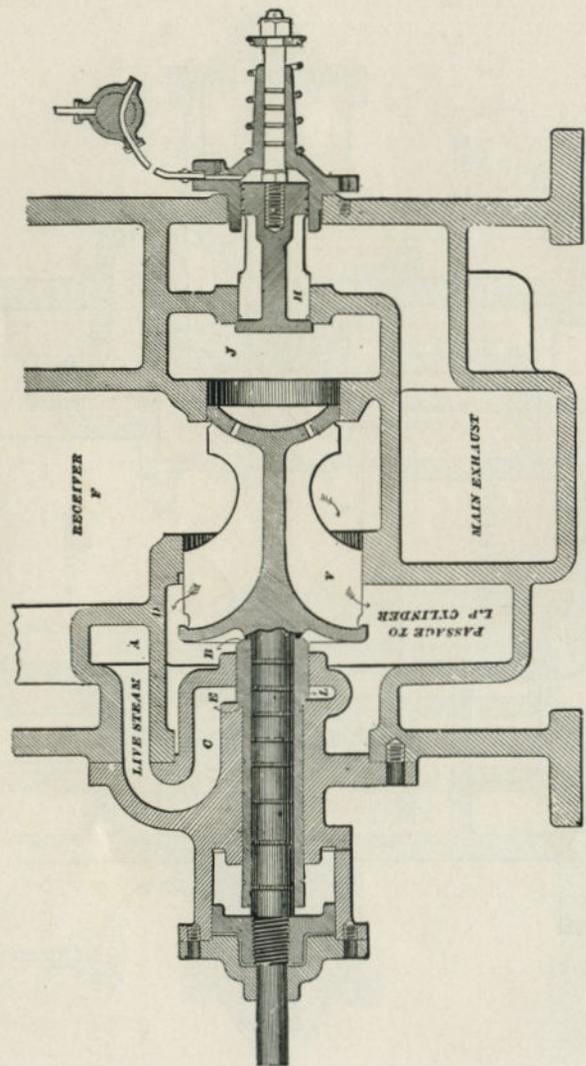
Gill Eng. Co. N.Y.



POSITION IN STARTING AUTOMATICALLY.
FIG. 114.

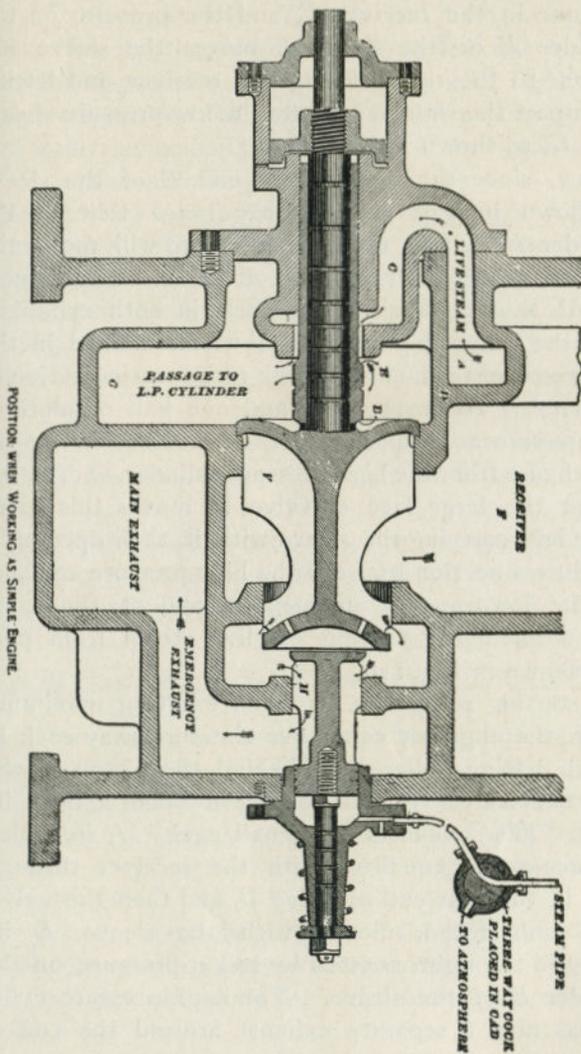


POSITION IN STARTING AT MAXIMUM PRESSURE IN L. P. STEAM CHEST.
FIG. 115.



POSITION WHEN WORKING COMPOUND.

FIG. 116.



POSITION WHEN WORKING AS SIMPLE ENGINE.
FIG. 117.

pressure in the receiver *F*, and the pressure on the shoulder *E* of the sleeve *L* moves the sleeve and valve *V* to the right, closing the receiver, and letting steam past the shoulder *E* into the low-pressure steam-chest *G*, as shown in Fig. 114.

Now, since the area of the end *B* of the sleeve *L*, shown in Fig. 115, is say twice that of the shoulder *E*, half of the boiler-pressure will move the sleeve *L* to the left, cutting off steam through port *C*, and thus equalizing the work in both cylinders, since the reduced pressure is thus maintained in the low-pressure steam-chest by the reciprocating action of the sleeve. After say one and one half revolutions the pressure accumulates in the receiver *F*, due to the exhaust from the high-pressure cylinder, and, acting against the large face of valve *V*, moves this valve to the left, carrying the sleeve with it, thus opening a straight connection between the high-pressure exhaust and the low-pressure steam-chest, and at the same time permanently cutting off live steam from port *C*, as shown in Fig. 116.

In starting on grades, or when exerting maximum power, the engineer can move the three-way cock in the cab, letting boiler-steam behind the piston on the emergency-valve *H*, and holding it open against its spring. This exhausts the small cavity *J*, in which the pressure is equalized with the receiver through holes in the rear end of valve *V*, and then the valve, being unbalanced, moves with the sleeve *L* instantly to the right, assisted by steam-pressure on the shoulder *E* of the sleeve. The high-pressure cylinder has now a separate exhaust around the end of

valve *V*, through valve *H*, into the main exhaust, since the intercepting-valve remains closed, due to no accumulated pressure in the receiver *F*. The low-pressure steam-chest then gets reduced-pressure steam direct from the boiler through port *C* and reducing-valve *L*, as shown in Fig. 117.

Except when working simple, the valves act entirely automatically. The lubricator to the low-pressure cylinder enters port *A* and thus ensures constant lubrication to the intercepting- and reducing-valve.

Owing to the small area of port *C*, and the contracted exhaust through valve *H* the engine develops less power as a simple engine than as a compound, at a speed of over say eight or ten miles an hour, and thus the runner is compelled to work compound.

Should either side break down, the emergency-valve can be opened, and the engine brought in on one side like an ordinary simple engine.

BREAKING DOWN OF RICHMOND COMPOUND.

Q. What should be done when a main-rod is broken or taken down on H. P. side?

A. The valve should be put in centre of seat on broken side and clamped fast; piston-head blocked in back end of cylinder by cross-head in guides; run in with L. P. side.

Q. How can steam be gotten into the L. P. cylinder?

A. By the starting- and reducing-valves on L. P. side, which will act the same as when running a simple engine.

Q. Would there be any pressure in receiver when running in this manner?

A. No; not as long as steam did not leak past the H. P. valve or the intercepting-valve; the emergency-valve could be opened occasionally to exhaust any pressure that might accumulate in receiver, so as not to cause the intercepting-valve to open, thus preventing live steam from entering the receiver from the boiler.

Q. What should be done in case of a broken valve-stem on H. P. side?

A. Do the same as for broken or taken down main-rod; come in with L. P. side.

Q. What should be done in case the main-rod on the L. P. side was taken down from any cause?

A. Block valves in centre of seat on that side; put piston head in back-end of cylinder; block cross-head; open emergency-valve of intercepting-valve.

Q. Why should this be done?

A. In order to let the exhaust steam from H. P. side escape into main exhaust-passage; otherwise the exhaust would back up in the receiver.

Q. What would be the effect if this happened?

A. This would cause back pressure on the H. P. piston-head, reduce the power, and if pressure became great enough would open the intercepting-valve on the L. P. side.

Q. What should be done in case of broken valve-stem on L. P. side?

A. Same as for main-rod taken down; run in with H. P. side.

Q. When broken down on L. P. side, how is it pos-

sible to prevent live steam from getting into L. P. steam-chest?

A. By blocking the intercepting-valve open, thus holding the starting- and reducing-valves closed.

Q. How can the intercepting-valve be kept open?

A. By putting a block behind the air or dash-pot piston-head.

Q. If the intercepting-valve remained open, due to sticking from any cause, and would not act automatically, what would be the proper way to try to close it?

A. Open the emergency-valve; if this would not close it, tap on end of stem projecting through dash-pot cylinder.

Q. What else would cause the intercepting-valve to fail to close?

A. The starting- and reducing-valves might stick, thus preventing live steam getting between that valve and seat to cause it to open and close intercepting valve.

Q. What should be done?

A. Same as for intercepting-valve not working.

Q. If a piece were broken out of intercepting-valve between the L. P. cylinder and receiver, would it open?

A. Yes.

Q. Why, and what would be the effect?

A. The pressure would act on each side of valve having the largest area; also live steam from reducing-valve would flow into the receiver until the intercepting-valve closed the reducing-valve.

Q. Would the engine operate as a compound engine?

A. Not until the reducing-valve was closed.

Q. What should be done to make the engine operate

as a compound in case the intercepting-valve did not close the reducing-valve?

A. Pull the intercepting-valve open, thus closing the reducing- and starting-valves.

Q. How could this valve be held open, if necessary?

A. By putting clamp on stem projecting through dash-pot cylinder close to the head.

Q. Could the L. P. side be operated as a simple engine if the H. P. side were broken down, when a piece was broken out of intercepting-valve?

A. Yes; but the receiver would be filled with live steam.

Q. Would it be possible to operate this engine compound with the emergency-valve broken out?

A. Yes, by taking out broken valve and putting in wooden plug in the valve-seat, and putting on the gland as when valve was in position, letting the end of plug bear against gland.

Q. If the receiver was cracked so as to cause an excessive back draught, what should be done?

A. Would open emergency valve and run as a simple engine.

Q. Why would you do this?

A. To see if relieving the pressure in receiver would lessen the effect of back draught.

Q. If not, what could be done?

A. Disconnect H. P. side and run in with L. P. side.

Q. How long will this engine operate as a simple engine?

A. As long as the emergency valve is kept open.

THE READING'S SINGLE-DRIVER LOCOMOTIVE—FOR THE ROYAL BLUE TRAINS.*

This engine's drivers are equalized with the trailing-wheels by a nice system of underhung springs. This makes her, in service, something similar to an eight-wheeler, so far as the track is concerned.

Ample journal-bearings make the engine run cool; the driving-box and that on the trailing-wheel are each 12 inches long.

The dome is placed over the fire-box and behind the cab; this is unusual, but gives room in the cab, allows the men to see, and prevents the surge of water ahead at stops from entering the dry pipe to injectors, etc. Three 4-inch pops are used—two on the left side of the dome and one on the right; one of these is set to pop at 195 pounds pressure, one at 198, and the third at 200; when steam is suddenly shut off, that $8\frac{1}{2} \times 9$ foot fire makes all three pops sing at once.

The cab is wonderfully comfortable; being in the centre of the boiler, there is little vibration, and each side is roomy. The throttle is an innovation; the stem coming, as it does, from the dome in the rear of the cab, shoves in instead of pulling out, and has a long stem running in brackets on top of the boiler. The lever is the regulation Baldwin ratchet, but on the stem, between the brackets, there is a stiff-coiled spring, which is adjusted by a hand-nut; the tension of this spring tends to open the throttle, and can be so adjusted that the engineer can handle his valve easily without jerking. On the stem outside of the first

* Photo from Locomotive Engineering.

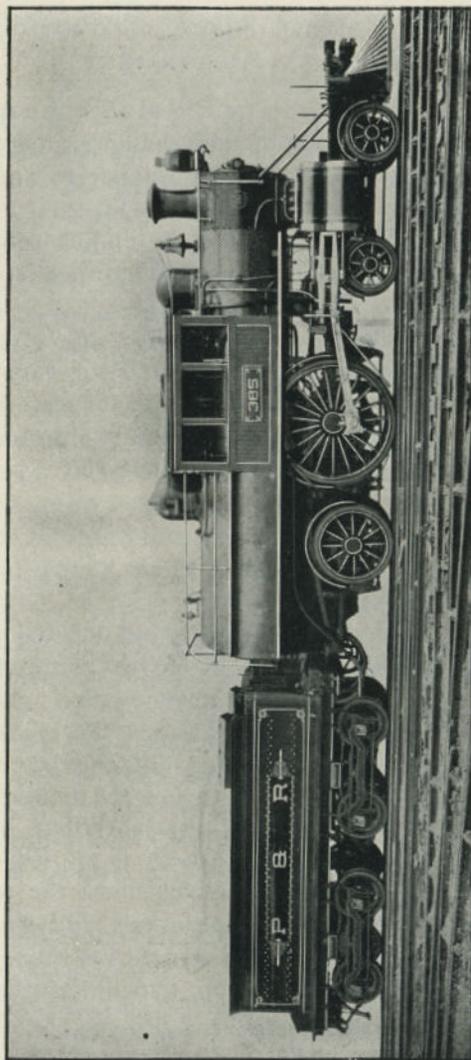


Photo Furnished by B. L. Wks.

FIG. 118. — PHILADELPHIA & READING R. R. CO.'S SINGLE-DRIVER LOCOMOTIVE.

Baldwin Locomotive Works Builders.

bracket a coarse-pitch thread is cut, and a heavy, knurled brass nut is placed; when the engineer leaves his engine, he can quickly run this nut up to the bracket and lock the throttle shut. There are sand-boxes in the back of the cab to use for backing up, provided, as the regular box is, with Leach air sand-jets.

The tires are secured on the drivers by retaining-rings; but an improvement over the Mansell pattern is that they are lipped into the wheel centre as well as the tire, the rivets merely holding the ring in place.

The engine and tender are painted royal blue and gold-leafed to match the trains hauled, and look very handsome.

Gould couplers and passenger platform-buffers are used on the engine both forward and back.

Both injectors are on the right side; the blower can be worked from either side of the cab or from the fire-box deck, and there is a steam-gauge and light on the rear of fire-box for the benefit of the fireman.

The driver and trailing-wheel brake-shoes are on the rear of the wheel, which plan gives a splendid chance to get all the brake apparatus in nice shape; the push-cylinders are located just back of the guides; the levers are straight, stand vertical, and are fulcrummed in the plate-bracket shown just ahead of the driver.

There is no reach-rod on engines with cab located as this one is; the tumbling-shaft arm is simply extended up to form a reverse-lever.

She is a Vaucrain compound, and when working the hardest at speed makes less noise at the exhaust than the injectors do.

She has a short smoke-arch, with a vertical netting and a variable exhaust-nozzle. The Wootten fire-box has a brick bridge-wall at the combustion-chamber.

The following are the general dimensions of this locomotive :

Gauge of track, 4 ft. $8\frac{1}{2}$ in.

Cylinders, 13 in. H. P., 22 in. L. P., by 26-in. stroke.

Driver, $84\frac{1}{4}$ in. diameter, cast steel.

Total wheel-base, 22 ft. 9 in.

Rigid wheel-base, 7 ft.

Wheel-base, engine and tender, 50 ft.

Weight, in working order, 115,000 lbs.

Weight on drivers, 48,000 lbs.

Weight on trailer, 28,000 lbs.

Weight on truck, 39,000 lbs.

Limit of height, 14 ft. 3 in.

Limit of width, 9 ft. $3\frac{1}{2}$ in.

Boiler, Wootten; shell, 56 in. diameter at arch, straight, made of $\frac{5}{8}$ -in. steel; longitudinal seams butt-jointed; circumferential seams, double-riveted; working pressure, 200 lbs. per square inch; dome over fire-box.

Three hundred and twenty-four tubes, $1\frac{1}{2}$ in. diameter, 13 W. G., and 10 ft. 3 in. long.

Fire-box, 114 in. long by 96 in. wide; side, back, and crown sheets, $\frac{3}{8}$ in.; flue-sheet, $\frac{1}{2}$ in. thick; water-space, $3\frac{1}{2}$ in.

Crown supported by crown-bars of inverted T irons, set $2\frac{1}{2}$ in. above sheet; stay-bolts, $1\frac{1}{8}$ in. diameter spaced 4 in. between centres.

Water-tube grates and bars.

Engine-truck, rigid, centre-bearing; 36-in. wrought-

iron Vauclain wheels, steel-tired; journals, $5\frac{1}{2} \times 10$ in.; trailing-wheels, $54\frac{1}{4}$ in., cast steel; journals, 7×12 in.

The valves are $11\frac{1}{2}$ in. diameter, piston pattern; drivers (2), $84\frac{1}{4}$ in. diameter outside tires; centres, 78 in.; tires, $3\frac{1}{8}$ in. thick, 6 in. wide; journals, $8\frac{1}{2} \times 12$ in.; Sellers' " '87 " injectors, No. 10 $\frac{1}{2}$; Westinghouse brake on drivers, trailer, tender, and train; $9\frac{1}{2}$ -in. pump, air-signal, Leach sanders, and U. S. metallic packing.

The boiler is lagged with magnesia blocks, and all the trim is bright iron.

The tender has a water capacity of 3500 gallons, frame of 8-in. channel iron; fitted with water-scoop; Boies wrought-iron centre steel-tired wheels; journals, $4\frac{1}{2} \times 8$ in.

THE 1895 CLASS "L" EXPRESS ENGINES FOR THE PENNSYLVANIA R. R.

The engraving shows the general appearance of these engines. They are fine-looking and fine-working locomotives.

Particular attention has been paid to getting them handy and comfortable to the men in the cab. The steam- and air-gauges are on a bracket on the corner of the Belpaire fire-box, and facing the engineer, who is seated at the corner; the engineer's valve is just below them, and the reverse-lever ahead of the runner, on the side of the boiler. The throttle-stem enters the head and a lever is carried up to top of boiler, which is actuated by a crank on a shaft; this shaft runs to the engineer's side of the boiler, and the throttle-lever is

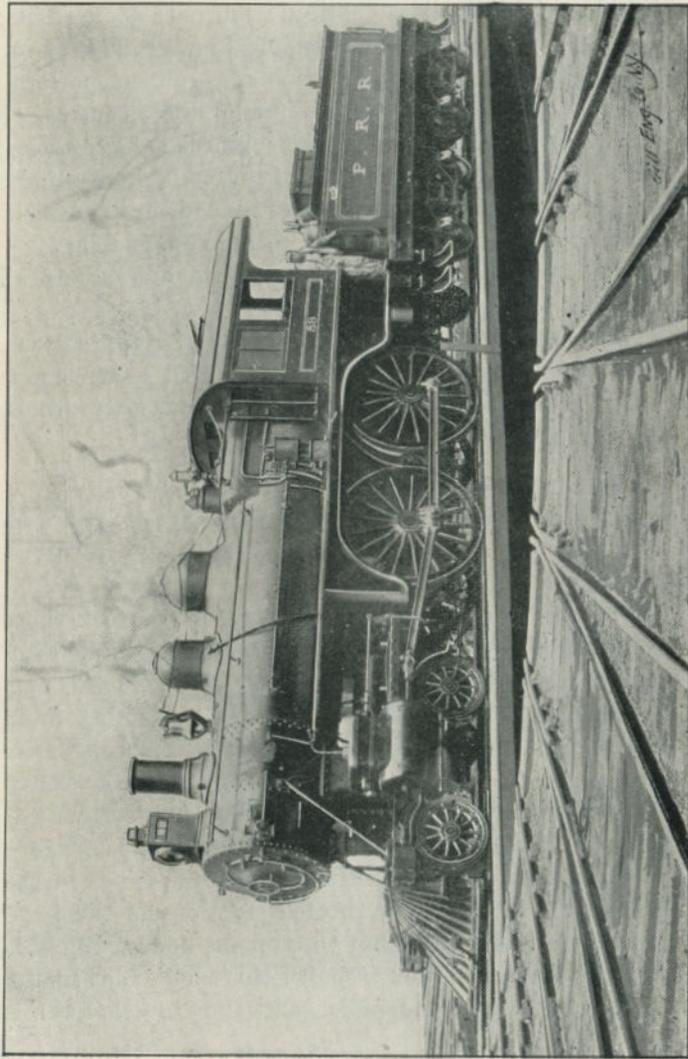


FIG. 119.—CLASS "L" EXPRESS LOCOMOTIVE, PENNSYLVANIA R. R., 1895.

keyed to it; this lever hangs straight down along the boiler side, and the end is turned out for a handle, having a ratchet-latch. Everything is within easy reach of the runner. The lubricator is on the left side, and the feed must be looked after by the fireman.

The boiler has a 62-inch ring at the smoke-box, then a course that is a frustum of a cone, enlarging to 68 inches; back of that there is a straight 68-inch course, carrying the dome, and behind that a Belpaire fire-box. This is 60 inches wide at the rear and across the entire top, the sides being rounded out in front to the size of the shell, and this bulge runs out to the flat at the rear; this gives more room at the rear in the cab.

The fire-box is 120 inches long and $41\frac{1}{2}$ inches wide, fitted for anthracite coal. There are 210 flues $1\frac{3}{8}$ inches diameter.

The cylinders are $18\frac{1}{2} \times 26$ inches; the valves have a 6-inch travel, $1\frac{1}{8}$ -inch lap outside, and $\frac{1}{4}$ -inch clearance inside. The ports are 20 inches long, $1\frac{3}{8}$ inches wide. The drivers are 80 inches diameter, of cast steel.

A Dean cross-head is used, but made of two pieces instead of three.

The links, hangers, etc., have forged cups where ordinary oil-holes are generally used.

The jacket is steel, painted black, and adds much to the "business" appearance of the engines.

They have sand-boxes on top of the boiler.

The smoke-box door has inside hinges on a swinging link, and is bolted up tight all around outside.

The pistons are fastened into cross-head by a split nut, the end of piston being shaped like an axle, the nut surrounding it and forcing it into cross-head.

There are no back-boards in the cab; it is open, like an eight-wheeler, and the men can see and converse with each other.

Good steps and hand-holds are used; inside checks and branch pipes fastened against the boiler.

These engines carry 180 pounds of steam-pressure.

To the bottom of the piston-heads of these engines is attached a carrier or shoe. These piston-heads are very light, being of the single-web dish type of steel. In order to have a perfect-fitting, steam-tight, smooth-working piston-head, the snap-ring packing is used; and to break the joint and prevent any leakage of steam through the opening of the rings the Peacock break-joint is used, which has been tested under severe usage. The reciprocating parts of these engines were reduced to the lightest weight possible. As shown, the main and side rods are channeled, making them very light and strong. Brakes are provided on the engine-trucks. A very good feature is that good steps are on the engine and tender. The outlines of these engines are very pleasing to the eye, and the centre of gravity is high. Taking all into consideration, these engines are a leading example of the modern steam locomotive in appearance, construction, and operation.*

* Single-expansion type.

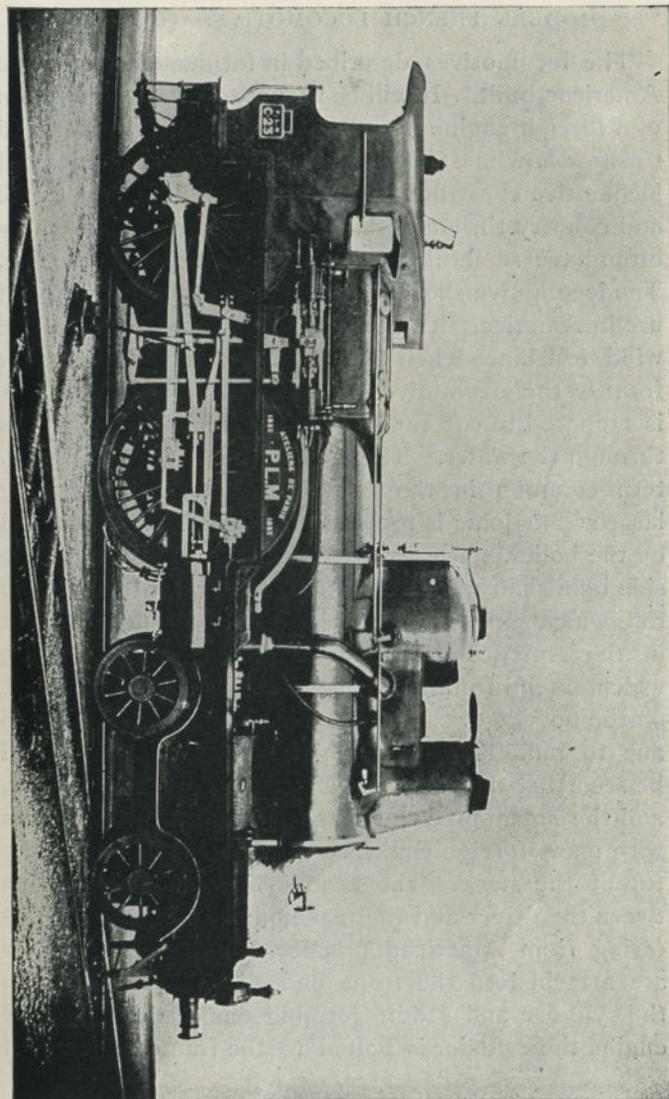


FIG. 120.—MODERN FRENCH LOCOMOTIVE.

MODERN FRENCH LOCOMOTIVE. (Fig. 120).

The locomotives described in former chapters were American-built. It will be proper to give a description of a foreign engine in order to have a comparison and to show how master mechanics differ in their ideas of locomotive construction, although conditions of traffic and country through which the engine operates may often have something to do with the type and outline. The locomotive shown involves ideas which are not in use in America. The purpose has been to reduce the wind resistance when running by placing deflectors in front of the locomotive; even the cab is pointed. This is supposed to cut through air the same as a ship cuts through the water. The boiler is of the Belpaire pattern common in the United States. An unusually large steam-dome is provided, and placed well forward on the boiler. The throttle-valve is worked from the side by a shaft and lever; to the lever is attached the rod, which extends into the cab. A feature not seen in the American locomotive is outside steam-pipes, which extend from the dome down to the steam-chest on the outside of the boiler. This is open to objections due to radiation and change of temperature. It will be seen that the sand-box is between dome and stack, and the steam-pipe ends and tee are in this box, as with many foreign engines a damper is hinged to the top of the stack. The steam-cylinders are placed between the driver and the rear engine-truck wheel,—differing from American practice, where the cylinders are attached to the front end of boiler smoke-arch, the cylinder and saddle forming one casting. In this engine the cylinder is bolted to the frame, which is of

the slab type. By placing the cylinders as shown, the tendency to nose around is not as great. The absence of a pilot looks odd to the average American. Life-guards are provided instead, which project downwards towards the track. Sand is placed on the track by a jet. The valve-motion is a point of interest, as it is entirely on the outside and not under the boiler. It is the Walschart motion. The usual eccentric is missing; instead a small crank is attached to the main crank-pin, which in this engine is on the rear driver. This crank extends from the centre of main crank towards the centre of axle, giving the required throw to cause the valve to travel the proper distance. A rod extending from this crank connects to a stationary link at the bottom. This link is pivoted at the centre, which allows it to swing back and forward each side of the axis. This link does not raise or lower, but the radius-rod is raised and lowered in the link. This link is curved towards the steam-chest, and the radius depends on the length of radius- or valve-rod, which is from the centre of link to the pin at valve-stem cross-head. A block slides in the link to which end of the radius-rod is attached. The radius-rod has attached to it a small cross-head which carries a fulcrum-pin; to this pin is affixed a lever whose lower end is connected to the main cross-head by a link. To the upper end of this lever, which is called the lap-and-lead lever, is connected the valve-stem. The valve will be moved by the crank and link at one time; and when coming to the centre will be under the control of the lap-and-lead lever, and the motion given the valve by the lap-lever will be the width of lap and the lead opening. The position

of the block in the link determines the direction in which the engine will run: when block is above the centre of link it will move forward; when below, it will move backwards. There is no angular advance given to the centre of small crank which drives the motion; consequently the lap-and-lead lever has to be used. In order to reverse the motion a rock-shaft is put below the frame as shown, and a link extends up to the radius-rod, which is moved up and down. The mechanism used to operate the reverse-shaft is somewhat complicated. It is a steam-reverser, having two pistons and cylinders with a yoke attached to the piston-rods; between the two cylinders a bell-crank lever is attached to this yoke. A rack has a toothed wheel meshing with it; this wheel is also attached to the yoke. The purpose of this is to hold the piston in any position. The other end of bell-crank has attached to it the lifting-link to reverse-shaft.

Locomotives having outside connections are not seen very often in the United States, although some of the older ones were built that way. The last one the writer saw was on the Camden and Amboy Railroad, now part of the Pennsylvania Railroad system.

INTERCEPTING-VALVE FOR COMPOUND ENGINES.*

The intercepting-valve for compound engines here illustrated was designed by F. W. Dean of 53 State Street, Boston, Mass. It is in use on engines on the Old Colony Railroad and on the Lehigh Valley. To the upper side of the casing *A* is firmly bolted the secondary casing *B*, provided with the inner pendent tubular hub *B'*, which extends into the chamber of the lower casing and is bored out to form a cylinder having two different diameters, the upper portion being the larger. The upper end of the cylinder is closed by a cap, connected with which is the pipe *D*, the upper part of which is curved and threaded to receive the end of a pipe leading from the interior of the converting valve *D'*, as shown in Fig. 121.

The interior of the casing *A* is formed with a valve-seat for the valve *E*, which is provided with a tubular stem whose outer surface closely fits the smaller bore of the hub *B'*. The bore of the stem is fitted to form a steam-tight bearing on the tube *D*, and it extends through the valve, but of somewhat enlarged diameter, and is threaded to receive a plug the upper end of which is somewhat removed from the lower end of the tube *D* when the valve is raised to its highest position, as shown in Fig. 121. On the upper end of the tubular valve-stem is screwed a sleeve-like piston, formed with two grooves to receive metal packing-rings; the stem is also provided with a pair of packing-rings to work in the lower portion of the cylinder *B'*, and has cut

* Iron Age.

through it just below the packing-rings several rectangular or flat-bottomed radial openings, so located relative to the seating face of the valve and the lower end of the pendent tube *D* that the openings will not begin to be uncovered by passing below the lower end of the tube until the valve has descended nearly to its seat and its outer periphery is partially inclosed by the annular raised rib. Surrounding the valve-seat suitable packing-rings make a steam-tight joint between the tube *D* and the valve-stem.

Live steam direct from the boiler is admitted through the pipe *F*, the upper end of which communicates through the tube-sheet with the steam-space of the boiler, as shown in Fig. 122; but instead of the steam having free access to the chamber through an opening of the size of the pipe, the steam is wire-drawn through a very small hole in a plug or bushing, as shown in Fig. 122.

The tube *D* has drilled through it, just below its junction with the cap, a small hole, through which steam may pass from the interior of the tube to the chamber above the piston, to aid in forcing the valve to its seat.

The casing *B* has formed in its upper part a small vent-hole, the lower end of which opens into a groove in the piston when in its highest position, and its upper end communicates with the annular chamber formed in the upper packing-face of the casing *B*. The cap is also provided with a vent-hole extending from the under side of its flange or its packing-face to the interior of the steam passage through the cap and tube, as shown in Fig. 121, whereby any steam leaking from the

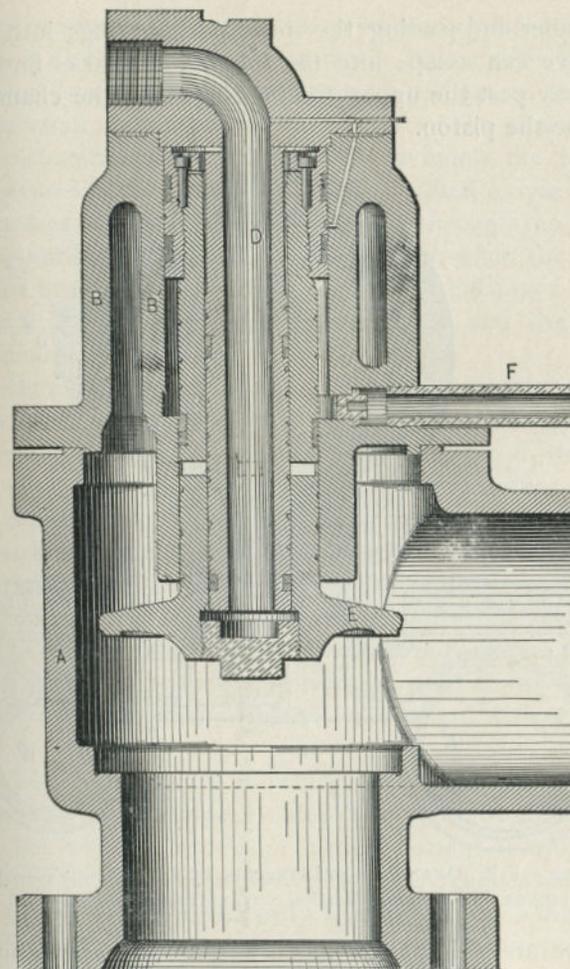


FIG. 121.—F. W. DEAN PATENT INTERCEPTING-VALVE FOR COMPOUND ENGINES. (Central Vertical Section, enlarged.)

chamber and passing the lower packing-rings into the groove can escape into the tube *D*, instead of finding its way past the upper packing-rings into the chamber above the piston.

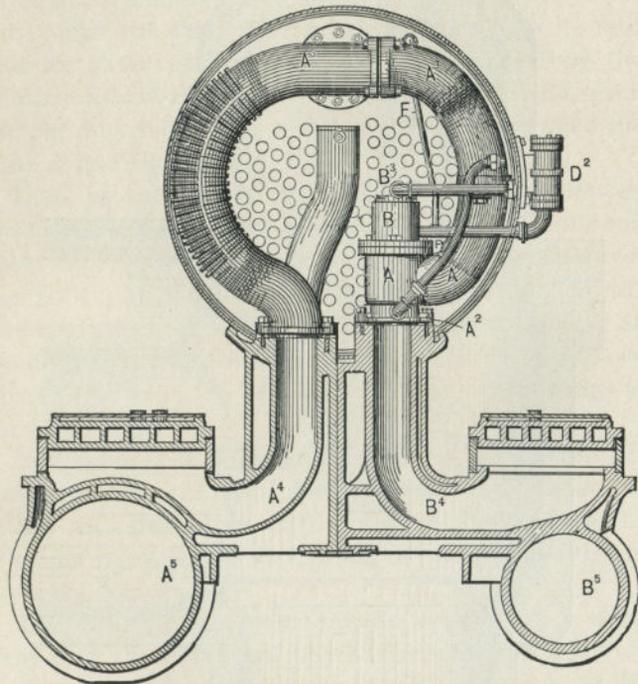


FIG. 122 —F. W. DEAN PATENT INTERCEPTING-VALVE FOR COMPOUND ENGINES. (Transverse Vertical Section through Smoke-box.)

The area of the annular lower end of the piston in the upper chamber *B'* is approximately equal to the area of the lower end of the pipe *D*, so that the pressure of steam in the chamber will nearly counterbalance

the pressure of steam in the pipe tending to move the valve downward, and so maintain the valve in its elevated position until steam enough has passed through the small opening in the upper part of the pipe *D* into the chamber above the piston to overcome the upward pressure in the chamber. The valve then moves downward as fast as the steam can pass through the opening until it has nearly reached its seat, when the openings in the valve-stem will permit the escape of steam from the pipe *D* into the chamber *A*, and the valve will seat without jar.

By admitting the live steam from the boiler to the chamber through the small orifice in the bushing of the pipe *F*, the upward movement of the valve *E*, which is started promptly by the steam in the chamber, which is substantially at boiler-pressure in its continued upward movement, will be somewhat retarded by the restricted supply of steam which can pass through the orifice, and as some steam will remain in the chamber above the piston, which can escape only as fast as it is forced through the orifice into the pipe *D*, the upward movement of the valve will be arrested without slam or jar.

The construction shown and described insures the opening of the valve *E* before the pressure of exhaust-steam in the high-pressure exhaust passage accumulates above the receiver-pressure, and thus relieves the high-pressure piston of the early back-pressure, as the valve being acted upon by the steam in the chamber at substantially boiler-pressure is made to open promptly, when the converting valve is closed and a passage is opened from the interior of the tube *D* to the atmos-

phere, and is also opened in advance of an accumulated back-pressure on the high-pressure piston.

The cap is connected by a pipe with the converting-valve, and as a consequence it follows that when the converting-valve is closed the steam in the tube *D* is free to escape into the open air, and as the converting-valve is closed as soon as the high-pressure cylinder begins to exhaust, it follows that before the pressure of the exhaust can accumulate above receiver-pressure the pressure above the valve *E* will have been relieved and the pressure in the chamber will have commenced to raise the valve *E* to open communication to the receiver.

CHAPTER XII.

INJECTORS, SAFETY-VALVES, STEAM-GAUGES, ETC.

THE INJECTOR.

THE injector is a part of the locomotive machine that must always be in perfect condition. Any defect in it will prevent it from working, and place an engineer in a very bad position, as on it he must depend to get water into the boiler, for the day of pump-using is past.

There are usually two injectors on a locomotive, so that if one fails the other may be used. The action of the injector seems a mystery to many, in regard to the manner in which the water is forced into the boiler, at or above the steam-pressure which is working it.

The operation is as follows :

Steam under pressure acquires a very high velocity in escaping through a tube. Then the steam passing from the boiler in the steam-nozzle *N*, and having a high velocity, comes in contact with the water in combining-tube *O*, condenses, and also imparts to the water its own velocity. Water being a heavier body and acquiring the velocity of the steam, passes from the combining-tube into the delivery, from there it strikes the check with sufficient force to raise it against the boiler-pressure.

If the steam is not perfectly condensed, the injector will not work, but will spray and cause it to fly off, in most automatic-regulating injectors. In answer to the

question, "Why does it force water against a higher pressure than that which is working it?" we answer: A pressure in motion is working against a pressure at rest, or without motion. The pressure in motion is the steam escaping from steam-nozzle combining with the water imparting to it its velocity. The pressure at rest or without motion is the steam in the boiler into which the water is being forced. The pressure in motion having the greater power (due to the velocity and weight acquired), overcomes the pressure without motion.

The most simple form of the injector is shown in Fig. 123. *N* is a steam-nozzle, which extends into the

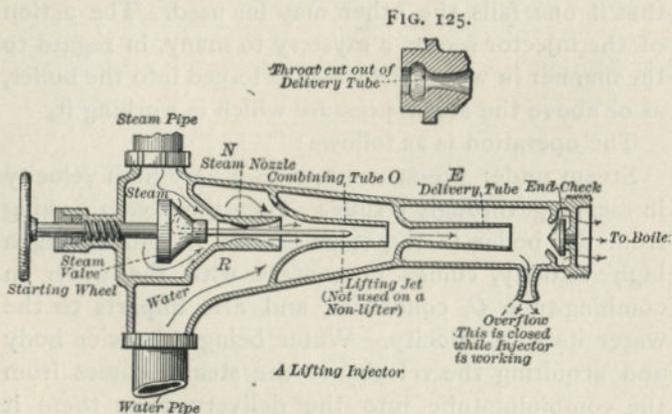


FIG. 123.

tube *O*, which is called the combining-tube. In this tube the steam and water combine, the mouth of the combining-tube being open to the water-chamber *R*. In front of the combining-tube is the delivery-tube *E*. Beyond this is the overflow and end check.

The capacity of an injector is known by the diameter of the smallest tube, which is the delivery-tube. The purpose of the overflow is to allow the steam, which is creating a vacuum, to escape. Also, for the water to acquire a velocity before being forced into the boiler.

A very simple illustration of how an injector operates is shown in Fig. 124. The man is blowing into the

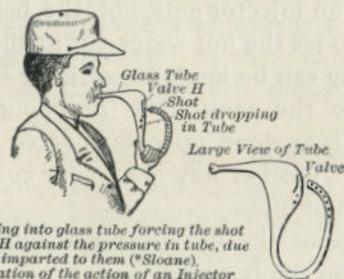


FIG. 124.

tube, which has a valve at *H*, which opens inward. The neck of the tube is bent around and the end is in line with the valve *H*, and the diameter about the size of shot. The tube has some shot in it, and when the man blows into the tube the shot will acquire a velocity, issue from the tube, and strike the valve *H* and open it against the pressure that gives to it its velocity.*

When an injector fails to work, the tank-valve should be examined, and if that is found to be open, the next point is to take down the screen and see if there is any dirt in it. Blow the injector out with a

* Professor Sloane.

little steam. After this, if it does not work correctly, examine the joints in water or suction pipe and see if any air enters: if there is, tighten them up; and if all these necessary matters have been attended to, the injector will now probably work correctly.

Do not start out on the road until you are assured that both injectors are working correctly, for the right-hand one may fail at any time.

When an injector gets hot, the best way to make it work is to let the hot water out at the screen. Sometimes they can be made to work by blowing the water back into the tank, first dropping the tank-valve. When this is done, open tank-valve quickly and start suction. Another way is to pour cold water over the injector and pipes.

At present the lifting and non-lifting injectors are in use, also the restarting.

A lifting-injector is one that will lift the water to combining-tube. The non-lifting will not lift the water, but the water must flow to it. The restarting injector is one that, should the water-supply be stopped and then return, the injector would start to work again, as there is a continuous suction.

The difference between a lifting and restarting injector is, that in a lifting-injector there is generally a closed overflow, and when from any cause the flow of water or steam is stopped, the injector breaks and cannot go to work, because, there being no outlet for the steam except back into the tank through water-pipes, this forces the water away from the injector and makes it hot.

In a restarting injector (which is a lifting-injector

also) there is a free overflow, which is opened by the steam, and the tubes are provided with suitable openings. When the water breaks, the steam, instead of passing back into the water chamber and pipe, escapes beyond the combining-tube into the atmosphere, forming a continuous suction in the water-chambers, and when water returns it will go to work again; but if the overflow is fastened shut, it will not restart, but be as a closed overflow. A closed overflow seems to be preferred, as it will not let the water overflow into the waste-pipe when there is much variation in the pressure.

In fitting up an injector, all the tubes should be in line and free from obstruction inside; the joints on water-pipe must be tight, or the injector will not lift on account of the vacuum being impaired.

Another cause of the failure of an injector to work is dirt in the tube—usually the delivery-tube. This will generally be known by the steam being driven back in the tank, also by dirt, such as fine coal or waste, in the tank valve or screen. These obstruct the flow of water and prevent the injector from working. The screen should be taken down before going out on each trip.

Another cause of the failure of the injector to work is when the delivery-tube becomes worn or cut out at the throat. (See Fig. 125.) This is caused by the tube being struck by the water after leaving the combining-tube, due to the velocity with which the water strikes it. This tube is the one that wears out most quickly.

Many trials have been made to get an injector to force very hot water, but the failure to do so in the

past has been caused by the temperature of the water being too high to condense the steam, which it must do before it will work. It is known that hotter water can be forced with steam of a low pressure than with

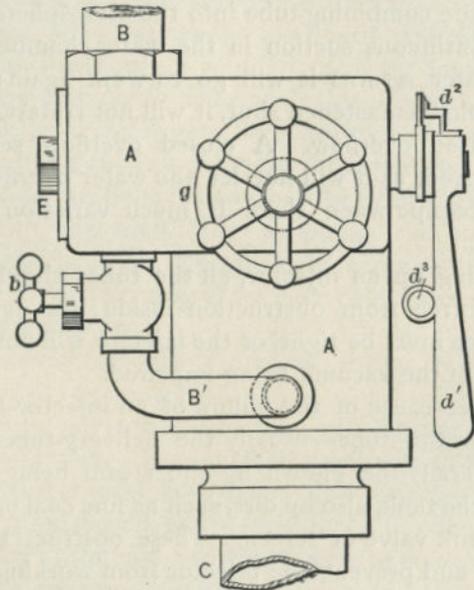


FIG. 126.—THE REAGAN INJECTOR. (Rear Elevation.)

that of a high temperature, for the reason that steam of a low temperature has less degrees of heat to be absorbed by the water, and can be condensed by water of a higher temperature.

The author has taken advantage of this point in injector of Fig. 126, where he converts the steam of a high temperature to a low temperature, before it combines with the water in the combining-tube.

The object sought for in the Reagan Injector was the construction of an injector that would force water

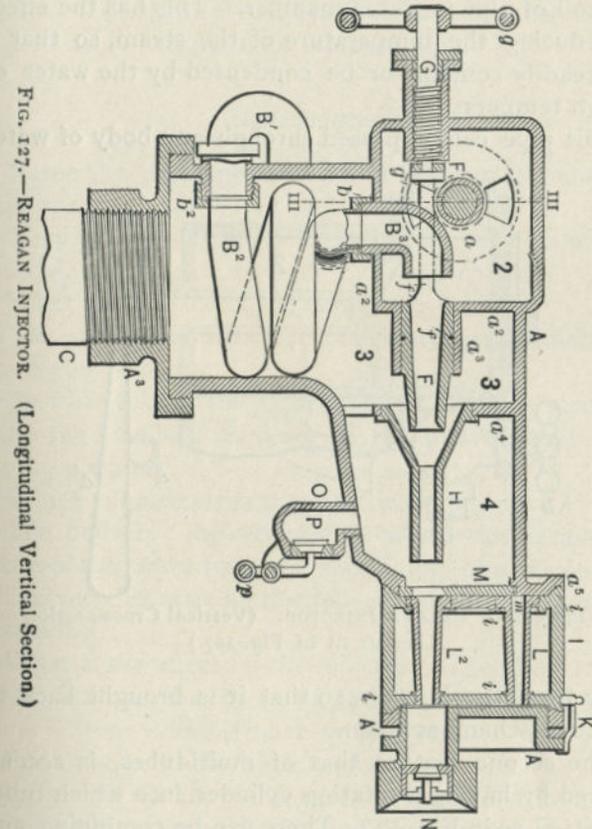


FIG. 127.—REAGAN INJECTOR. (Longitudinal Vertical Section.)

of a high temperature, to be a multi-tube injector, and to reduce the complication of the construction as much as possible.

The first point, that of forcing hot water, is accom-

plished by cooling the steam before it reaches the combining-tube, as in Fig. 123. The steam passes through the coil of pipe in water-chamber. This has the effect of reducing the temperature of the steam, so that it will readily combine or be condensed by the water of a high temperature.

This pipe can be passed through any body of water

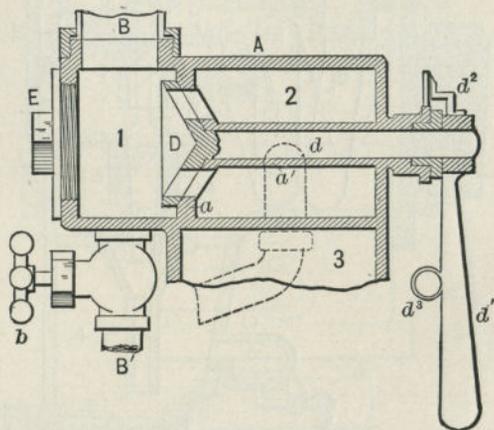


FIG. 128.—THE REAGAN INJECTOR. (Vertical Cross-section on Line III III of Fig. 127.)

away from the injector, so that it is brought back to the steam-chamber again.

The second feature, that of multi-tubes, is accomplished by having a rotating cylinder, into which tubes are fitted as in Fig. 127. There can be combining and delivery tubes in line, thus making a multi-capacity injector, by rotating the cylinder in front of the steam-nozzle.

Another feature is that of making the steam-nozzle

act as a water-regulating valve, thus doing away with an extra valve.

Also, the steam-valve is fitted without packing, which is a valuable feature in an injector.

QUESTIONS.

Name the different parts of an injector as shown in Fig. 121.

They are the steam-valve and tube, the combining- and delivery-tube, the overflow and the check.

What takes place in the combining-tube?

The steam combines with the water and imparts to it a higher velocity.

By what tube is the capacity of an injector rated?

By the smallest diameter of the delivery-tube, and by the pressure.

Which tube receives the most wear, and why?

The delivery-tube receives the most wear, because it receives the water from the combining-tube, which has a high velocity, striking the delivery where the diameter is smallest.

What is the effect on the injector? (See Fig. 123).

Its cuts out the throat of the delivery, which prevents it from working when much worn.

For what is the overflow used?

It is used to allow the water to acquire a high velocity before closing it out and forcing the water in boiler; also, to have an outlet for the steam, which forms the suction to lift the water to the combining-tube.

What causes an injector to fail to work?

There are several causes: small supply of water caused by dirt in screen, dirt in tubes, tubes out of line, loose pipe-joints which impair the vacuum, and injector getting hot.

When an injector fails, what should be done?

Would look for any or all the causes stated.

When an injector gets hot, what is the best way of getting it to work?

By letting the hot water out at the screen, or by cooling the injector with cold water.

What is the difference between a lifting and a non-lifting injector?

In a lifting-injector the water is raised by the steam forming a vacuum; in a non-lifting, the water must flow to it.

What is a restarting injector?

An injector which will recommence work without the attention of the engineer, when from any cause the steam or water should have been stopped.

Why does it operate in this way?

The overflow is free or open, and the steam can escape into the atmosphere, forming a continuous vacuum.

Why is it that an injector with a closed overflow cannot restart?

Because the steam can only escape back into the water-pipe, which forces the water into the tank.

How can a restarting injector be changed to a non-restarter?

By closing the overflow-valve tight; this would make a heater out of it.

When running an engine, and it should become snow-

bound, what should be done to prevent freezing of injectors and pipes?

The frost-cocks should be opened and the water drained out of pipes and injector.

Are non-lifting injectors much used on locomotives, and are there any points in favor of the non-lifter?

There are not many used, but they have the advantage that the tubes do not become coated with sediment as does a lifting-injector, because the water surrounds the tubes and keeps them cool; in a lifting-injector the water falls away and the tubes become dry.

Is it policy to start out on the road without examining both injectors, or if the right-hand one should fail just before starting?

No, it is best to know that both are in working condition.

What should be done in cold weather with the left injector?

A heater should be made out of it to prevent it from freezing up.

Why does the right-hand injector not freeze also?

Because it is being used, and water in the pipes being kept in motion prevents it from freezing.

The injectors that are shown are of three types—single tube, non-restarting; double tube; and a restarting. All are lifting-injectors.

WILLIAM SELLERS & CO., INCORPORATED.

The cuts (Figs. 129, 130) show the new restarting injector of 1887. As will be seen, the principal difference between this injector and others is, that if from any

cause the flow of water or steam is interrupted and then returns, the injector starts to work without atten-

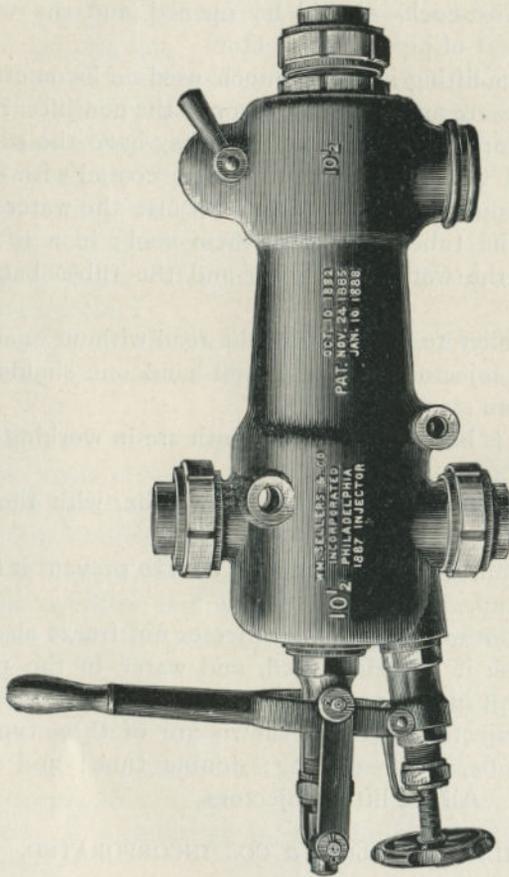


FIG. 129.—WILLIAM SELLERS & CO.'S RESTARTING INJECTOR.
(Perspective View.)

tion, as long as the overflow-valve is open. To make a heater the overflow-valve is closed.

Its construction is such that small particles of dirt,

etc., are not liable to interfere with its working; and as its tubes are in a straight line, a wire can readily

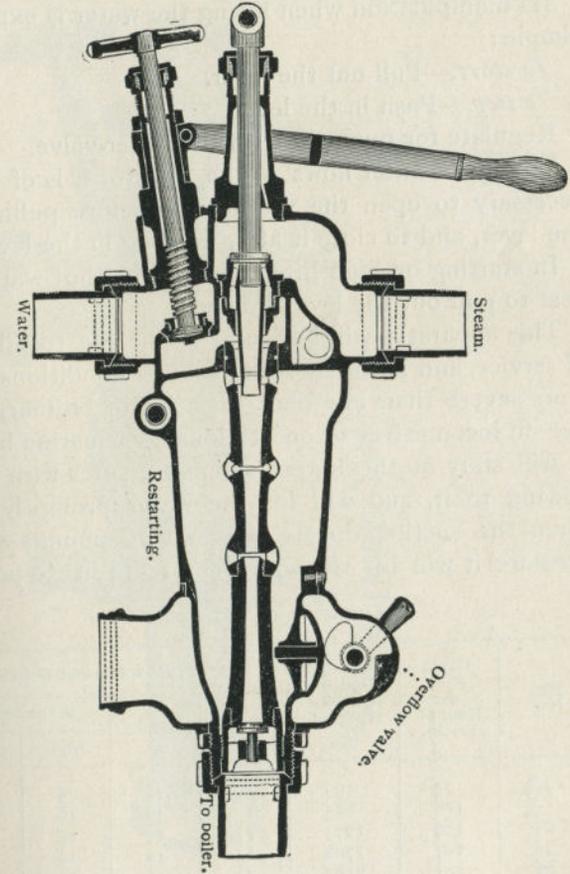


FIG. 130.—WILLIAM SELLERS & CO.'S RESTARTING INJECTOR.
(Sectional View.)

be passed through them to dislodge an obstruction if necessary. By simply disconnecting the pipe union at

the delivery end of the injector the combining and delivery tubes may be taken entirely out.

Its manipulation when lifting the water is extremely simple:

To start.—Pull out the lever.

To stop.—Push in the lever.

Regulate for quantity with the water-valve.

When the water flows to the injector it is of course necessary to open the water-valve before pulling out the lever, and to close it after pushing in the lever.

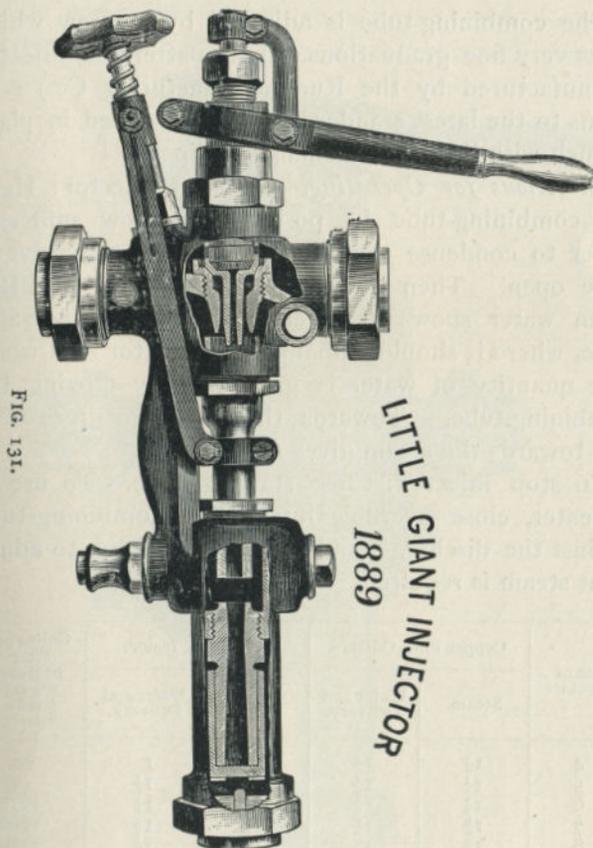
In starting on high lifts and in lifting hot water it is best to pull out the lever slowly.

This apparatus will be found applicable to all kinds of service, and perfectly reliable under conditions much more severe than any likely to arise in ordinary practice on locomotives or on stationary or marine boilers. It will start at the lowest steam-pressures with water flowing to it, and will lift the water promptly, even when the suction-pipe is hot. At 10 pounds steam-pressure it will lift the water two feet; at 30 pounds,

CAPACITY OF INJECTOR.

Size No.	Cubic Feet per Hour at 120 lbs.	Gallons per Hour at 120 lbs.	Size of Pipe-steam and Delivery.			
			Iron.	Copper.	Water-Supply	
					Iron.	Copper.
4 $\frac{3}{10}$	75	562	$\frac{3}{4}$	1	$\frac{3}{4}$	1
5 $\frac{1}{10}$	118	885	1	1 $\frac{1}{8}$	1 $\frac{1}{2}$	1 $\frac{1}{2}$
6 $\frac{1}{2}$	170	1275	1 $\frac{1}{4}$	1 $\frac{1}{2}$	1 $\frac{1}{2}$	1 $\frac{3}{4}$
7 $\frac{1}{2}$	227	1702	1 $\frac{3}{8}$	1 $\frac{3}{4}$	1 $\frac{3}{4}$	1 $\frac{3}{4}$
8 $\frac{1}{2}$	291	2182	1 $\frac{1}{2}$	1 $\frac{3}{4}$	1 $\frac{3}{4}$	1 $\frac{3}{4}$
9 $\frac{1}{2}$	364	2730	2	2	2	2 $\frac{1}{4}$
10 $\frac{1}{2}$	444	3330	2	2	2	2 $\frac{1}{4}$
11 $\frac{1}{2}$	530	3975	2	2 $\frac{1}{4}$	2	2 $\frac{1}{4}$

five feet; and at all ordinary pressures, say 60 pounds and over, it will lift from twelve to eighteen feet.



It requires no regulation to work without waste of water for any variation of steam-pressure above 40 pounds.

RUE INJECTORS.

The combining-tube is adjusted by a screw which gives very fine graduations. This pattern of injector (manufactured by the Rue Manufacturing Co.) conforms to the latest standard, and can be used in place of such with little if any change in pipes.

Directions for Operating.—To start injector: Have the combining-tube in position to allow sufficient water to condense the steam when starting-valve is wide open. Then open the starting-valve slightly; when water shows at overflow, open starting-valve wide, where it should remain while injector is at work. The quantity of water is graduated by moving the combining-tube. Towards the discharge gives *more* and towards the steam gives *less* water.

To stop injector: Close starting-valve. To use as a heater, close overflow by moving combining-tube against the discharge, and open steam-valve to admit what steam is required.

Size of Injector.	Copper Pipe, Outside.		Iron Pipe, Inside.		Gallons of Water per Hour with 125 Pounds Steam.
	Steam.	Water and Delivery.	Steam.	Water and Delivery.	
4	1½	1½	1	1	600
5	1½	1½	1½	1½	950
6	1½	1½	1½	1½	1275
7	1¾	1¾	1½	1½	1800
8	1¾	1¾	1½	1½	2250
9	1¾	2½	1½	2	2800
10	1¾	2½	1½	2	3500

THE METROPOLITAN DOUBLE-TUBE INJECTOR.

The locomotive injector shown in the engravings, in perspective and in section, is an improved form by

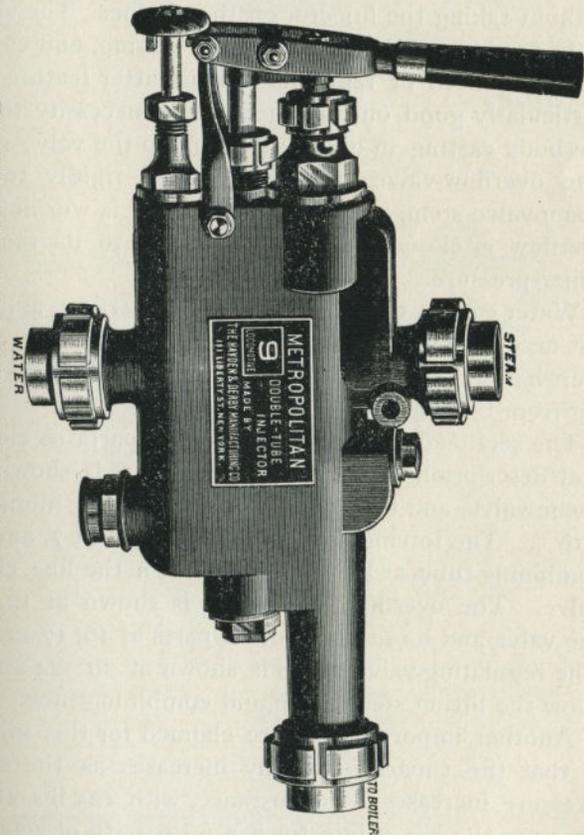


FIG. 132.—METROPOLITAN DOUBLE-TUBE LOCOMOTIVE INJECTOR.

the Hayden & Derby Manufacturing Co. of New York. The construction of the apparatus is simple.

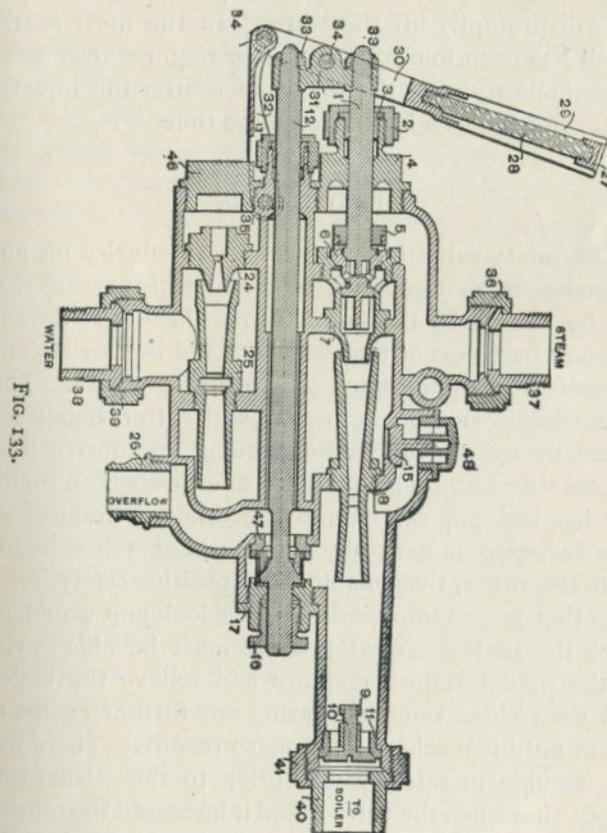
There are no outside attachments to become broken or interfere with placing the numerous attachments necessary in a cab. The tubes are all removed from the back end of the injector, and can be taken out without taking the injector off the engine. The valve-seats are independent of the body casting, and can be easily replaced or reground. This latter feature is a particularly good one, as there is no necessity to put the body casting in a lathe to turn up the valve-seats. The overflow-valve stem is attached rigidly to the steam-valve stem, and when the injector is working the overflow is closed and the valve held to its seat by boiler-pressure.

Water cannot then run out of the overflow, and it is not necessary for an engineman to look out of a cab to see whether the injector is feeding or the water escaping from the overflow.

The sectional view shows all of the parts so clearly, that description is not necessary. At 6 is shown the steam-valve, and the parts relating to it are numbered 1 to 5. The forcing steam-tube is shown at 7, and the combining-tube at 8. At 10 is shown the line check-valve. The overflow-valve stem is shown at 12, and the valve and its seat and other parts at 16, 17, and 47. The regulating-valve wheel is shown at 20; 24 and 25 show the lifting steam-tube and combining-tube.

Another important feature claimed for this injector is that the capacity steadily increases as the steam pressure increases. For instance, with 125 lbs. steam-pressure the No. 9 injector has a capacity of 2900 gallons of water per hour; with 150 lbs. steam-pressure this capacity is about 3000 gallons of water per hour;

and with 180 lbs. of steam-pressure it is about 3075 gallons of water per hour. These injectors will start with 25 lbs. steam-pressure, and without any regulation



the steam or water supply will work at all steam-pressures up to 250 lbs. It is found that the independent lifting and forcing apparatus permits easy and close

regulation of the capacity, and owing to this apparatus these injectors are strong lifters, and no matter how hot the injector or suction-pipe may become, the injector will promptly lift the water. In the most severe test it has been found that it never requires over 30 to 40 seconds to bring the water, even after the injector has been used as a heater for some time.

SAFETY-VALVES.

The safety-valve is a very important device on any steam-boiler, as it governs the amount of pressure that can be carried by the boiler, forms the outlet for any pressure in excess of that which should be carried, and prevents boiler explosions due to high-pressure. This valve should not be tampered with after being set, especially by one not understanding its construction. Locomotives, as a rule, have two safety-valves on them: one is a lock-pop safety, and the other is not locked. The lock-pop is generally set at about 5 lbs. higher than the other, thus making it a positive safety, for if the other were tampered with, the lock-pop would relieve the boiler. A safety-valve must be able to rise at the predetermined pressure and relieve the boiler, and then close, thus preventing any further escape of steam until it reaches the proper pressure. There was this trouble in safety-valves prior to the Richardson safety, that when the valve raised it increased the tension of the spring, and caused the valve to close before the boiler was relieved of the proper amount of pressure, and then if the area of the valve were increased with a spring of the same tension, the valve would stay open

too long and reduce the pressure 15 or 20 lbs.,—not only an uneconomical but a very bad feature on a locomotive hauling heavy trains or on heavy grades. The first successful safety-valve was brought out by a locomotive-engineer named Geo. Richardson, who ran on the Troy and Boston Railroad. The construction is shown in Fig. 134. As will be seen, the valve on the outer edge has an adjustable lip $C'C'$, which can be raised or lowered, and is locked in position by the set-screws LL , which fit in the indents K ; this prevents the lip from turning around. The body of valve behind the lip is hollow, as CC ; the seat has a cavity around it, as aa , into which lip $C'C'$ projects. The action of this valve, then, is to get an increased pressure to hold the valve up without increasing the area of the valve proper, which is accomplished in this manner: When the valve rises the steam fills in the cavity CC , and is then diverted by the lip $C'C'$ down into the cavity aa , this produces a reaction or gain of pressure against the valve, and helps to hold it up. To increase the time that the valve will stay up and the amount of pressure reduced, the adjustable lip should be screwed down, which will reduce the opening between the lip $C'C'$ and the cavity aa . To cause the valve to close quickly and not reduce the pressure too much, the lip should be raised. The proper position at which the valve-lip should be set is when the valve will close at a pressure of 3 to 5 lbs. less than that at which it raised. Bear in mind that it takes but a very little movement of the lip to make a great difference in the action of the valve. To increase the tension of the spring m , Fig. 136, the nut R is screwed down. The valve in Fig. 136 is a

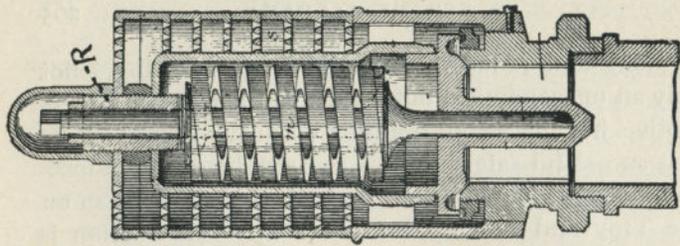


FIG. 136. 266

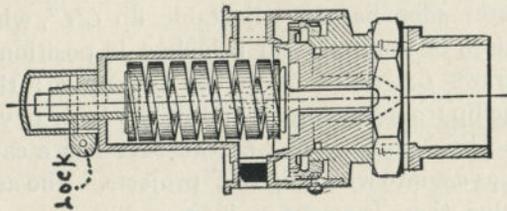


FIG. 135.

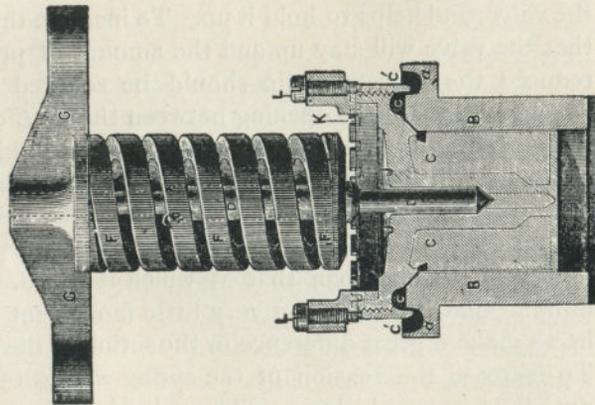
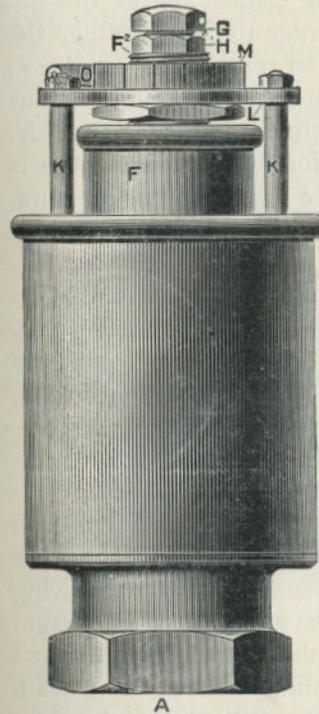


FIG. 134.



OUTSIDE VIEW WITHOUT MUFFLER.

INSIDE VIEW WITH MUFFLER.

FIG. 137.—THE KINNEY LOCOMOTIVE SAFETY-VALVE.

A, base; *A'*, valve-seat; *B*, valve; *C*, spindle; *D*, spring; *F*, follower; *FF*, main casting; *F'*, thread-hub; *G*, compression-screw; *H*, check-nut; *I*, muffer; *J*, regulating ring; *J'*, lugs of ring; *K*, parallel rods; *L*, cross-head; *M*, adjusting nut; *O*, locking-latch.

this has a tendency to break the force of the steam before it reaches the atmosphere, thus reducing the

noise, which was a great nuisance to the public in the older form of valves.

Another design of safety-valve which is coming into use is that of Fig. 137. The claims are in the adjustment of the valve. In order to adjust either the pressure or the blow-down, first remove the muffler *I*; this exposes the compression-screw *G*, adjustable nut *M*, cross-head *L*, locking-latch *O*, and check-nut *H*. Screwing down the compression-nut *G*, the pressure is increased, and the reverse for lessening the pressure. As a rule, from $\frac{1}{8}$ to $\frac{1}{4}$ turn will change the pressure of the valve 5 lbs. either way. By raising the locking-latch *O* screw down on the adjusting-nut *M*, the blow-down is reduced 1 lb., and the reverse increases it 1 lb. This valve can be adjusted without being taken off the dome, made by American Steam Gauge Co., Boston, Mass.

STEAM-GAUGES.

Two forms of steam-gauges are in general use on locomotives, one using a diaphragm, and the other using a hollow tube in the shape of a letter C, having an elliptical section. In the gauge having a diaphragm the pressure is behind the diaphragm, which is fastened on a round chamber, the diaphragm acting as a head, which is steam-tight. The face of diaphragm is corrugated. The pressure bearing against the diaphragm causes it to bulge out in the middle, and the amount that the middle rises depends on the pressure behind it. Bearing against the diaphragm in the centre is a bell-crank lever; attached to the other arm of lever is a link, which is connected to a segment having teeth; this

segment is pivoted on the lower end. In contact with teeth is a small toothed pinion; to the shaft of this pinion is attached the hand or pointer. Any movement of diaphragm will move the hand through the mechanism just described.

In the other form, Fig. 138, the pressure acts on the

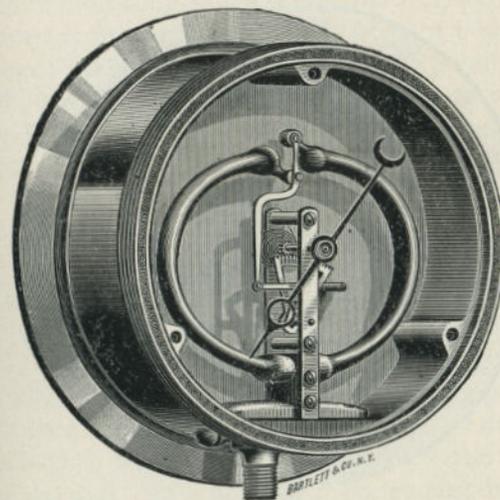


FIG. 138.--IMPROVED STEAM-GAUGE.

inside of tube *cc*; this pressure causes the end of tubes to straighten out, thus spreading the ends, to which is attached the bent lever *CFLM*. This is connected to the toothed segment *e* by rod *R*; the segment *e* rotates the small pinion and shaft *S*, which carries the index or hand *PP* of gauge. By having the lever *CFLM* attached to the ends of tubes *a, c*, as in Fig. 138, the distance the lower end of lever *CFLM* moves is double that

which it would be if only attached to one end of tube, and having the fulcrum rigidly connected. The tubes are made of brass, and are seamless,—which is a great improvement, and required some time and money to accomplish it. The great trouble with the brazed tubes was, that they would leak, this would destroy the

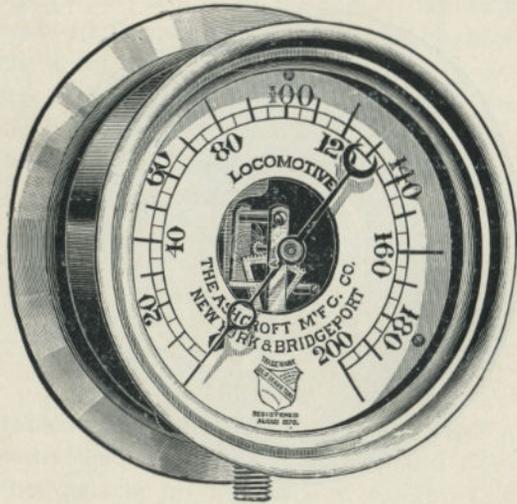


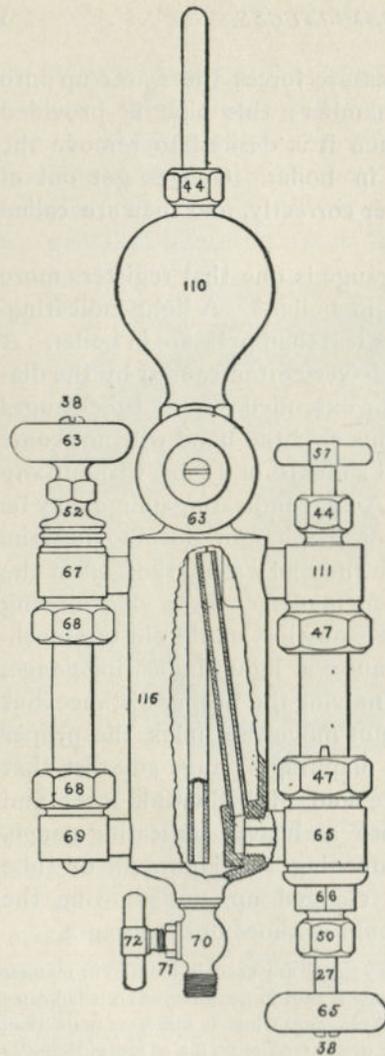
FIG. 139.—IMPROVED STEAM-GAUGE.

accuracy, and steam escaping inside the gauge would make it hard to see the dial. The tubes are attached to boiler by a pipe attached at *H*. The seamless-tube gauges are made by the Ashcroft Manufacturing Company of New York. On all gauges the pipe connecting gauge with boiler is bent in the shape of the letter *S*. The idea of this is to prevent the steam from coming in contact with the diaphragm or tubes, as this would affect their elasticity. The steam is condensed in the

pipe, and the steam-pressure forces the water up into tubes or diaphragm-chamber; this pipe is provided with a cock to close when it is desired to remove the gauge when steam is in boiler. Gauges get out of order, or do not register correctly, and then are called heavy or light gauge.

A heavy indicating-gauge is one that registers more than there is pressure in boiler.* A light indicating-gauge, one that registers less than pressure in boiler. A heavy indicating-gauge is very often caused by the diaphragm becoming set or extended; some tube-gauges will do the same. In this case the hand will not come back to the pin, but will show 10 or 15 lbs. without any pressure in the boiler. A light indicating-gauge may be caused by the tubes or diaphragm not moving the proper distance at which the dial was marked off at the time it was tested when made, or by a dial moving around. Another cause is any lost motion in the mechanism which would cause a light indicating-gauge, for the tubes might be moving the proper distance, but the mechanism would not move the index the proper distance on dial. In a diaphragm-gauge any dirt that would get between the end of bell-crank lever and diaphragm would cause a heavy indicating-gauge. Another cause is the opening to diaphragm or tube becoming corroded or clogged up, not allowing the pressure to act as it should in tubes or diaphragm.

* The terms *light* and *heavy gauge* are used in a different manner when testing a gauge. A gauge is said to be *heavy* when it indicates less than test gauge, and a *light gauge* when it indicates more than test gauge. In the first case it would require 90 lbs. of steam in boiler to make it indicate 80 lbs. of steam. Second case it would require 70 lbs. to make it indicate 80 lbs. of steam.



FRONT. VIEW.

FIG. 140.—THE "DETROIT" NO. 1 IMPROVED AIR-PUMP LUBRICATOR.
(New Style.)

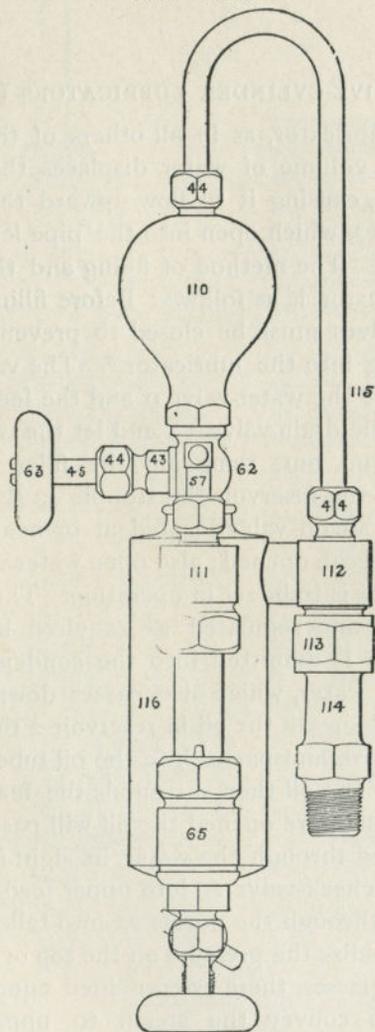
- 27. Feed-valve Stem.
- 38. Handle-button.
- 43. Globe-valve Centre-piece.
- 44. Globe-valve-stem Nut.
- 44. Equalizing-tube Nut.
- 44. Pulsating-stem Nut.
- 45. Globe-valve Stem.
- 47. $\frac{3}{4}$ Nut.
- 50. Feed-stem Nut.
- 52. Filler-plug.
- 57. Pulsating-valve Stem.
- 62. Globe-valve.
- 63. Wood-handle.
- 65. Lower Feed-arm.
- 66. Feed-valve.
- 67. Upper Gauge-arm.
- 68. $\frac{3}{4}$ Nut.
- 69. Lower Gauge-arm.
- 70. Drain-valve.
- 71. Drain-valve Centre-piece.
- 72. Drain-valve Stem.
- 110. Condenser.
- 111. Upper Feed-arm.
- 112. Support-arm.
- 113. Right and Left Coupling-nut.
- 114. Support-post.
- 115. Equalizing-tube.
- 116. Body.

LOCOMOTIVE-CYLINDER LUBRICATORS (DETROIT).

In this lubricator, as in all others of this class, the weight of a volume of water displaces the oil in the oil-reservoir, causing it to flow upward through water in glass tubes, which open into the pipe leading to the steam-chest. The method of filling and the operation of the lubricator is as follows: **Before** filling the reservoir the valves must be closed to prevent any steam from getting into the lubricator.* The valves first to be closed are the water-valve 9 and the feed-valves 26; then open the drain-valve 33, and let the water of condensation run out, removing the filler stopple 42. After filling the reservoir the stopple 42 should be put in, and the steam-valve located at or near the steam-bridge in the cab opened; also open water-valve 9 when the lubricator is to be set in operation. The feed-valves are opened and regulated as required by engineer. When steam is admitted into the condenser 110, this fills up with water, which also passes down the water-tube 36 underneath the oil in reservoir 2 the oil is then forced upward, and passes into the oil-tubes 37, one to each side. The oil then surrounds the feed-valves 26, and when these are opened the oil will pass through in drops, raising through the water in sight-feed glasses, and by the check-valve 20 into upper feed-arm 15, and from there through the nozzle 22 into tallow-pipe. In order to equalize the pressure on the top of water in the sight-feed glasses, there are provided equalizing-tubes 7, 7, which convey the steam to upper feed-arm

* Figs. 142. 143. 147.

NEW STYLE.



SIDE VIEW

FIG. 141.—THE "DETROIT" NO. 1 IMPROVED AIR-PUMP LUBRICATOR.

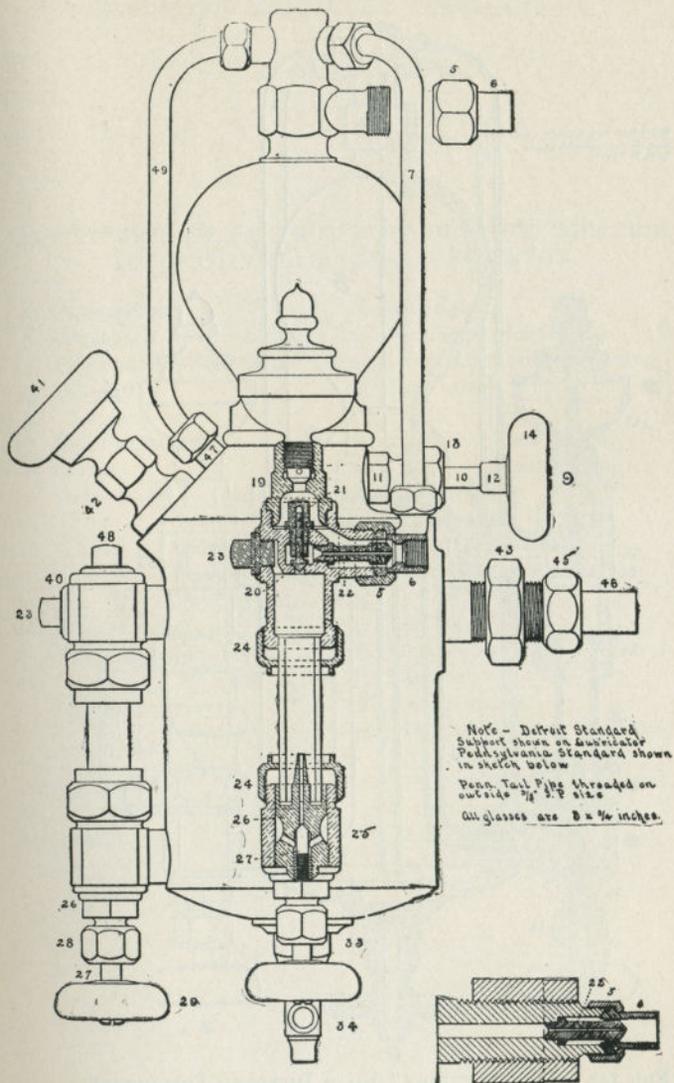
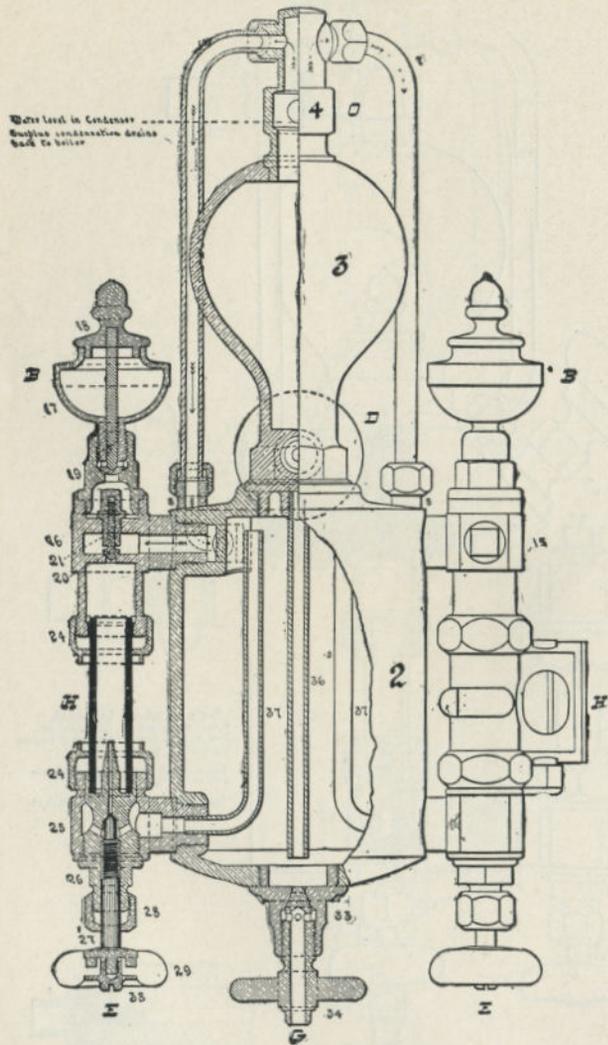


FIG. 142.



DESCRIPTION OF PARTS OF THE DETROIT IMPROVED
LOCOMOTIVE-CYLINDER LUBRICATOR.

- | | |
|-----------------------------|---------------------------------------|
| 2. Oil-reservoir. | 23. Water-plug. |
| 3. Condenser. | 24. Packing-nut for Glass. |
| 4. Extension-top, complete. | 25. Lower Feed-arm, complete. |
| 5. Tail-nut. | 26. Feed-valve. |
| 6. " -pipe. | 27. " Stem. |
| 7. Equalizing-tubes. | 28. " Packing-nut. |
| 8. Elbow. | 29. " Stem-handle. |
| 9. Water-valve, complete. | 30. Filler-arm. |
| 10. " Stem. | 31. " -plug. |
| 11. " Centre-piece. | 32. Lower Gauge-arm. |
| 12. " Follower-plate. | 33. Drain-valve. |
| 13. " Packing-nut. | 34. " Stem. |
| 14. Wood-handle. | 35. Jam-nut. |
| 15. Upper Feed-arm, right. | 36. Water-tube. |
| 16. " " left. | 37. Oil-tube. |
| 17. Hand-oiler. | 38. Handle-button. |
| 18. " Cover. | 15a. Upper Feed-arm, complete, right. |
| 19. " Plug. | 16a. Upper Feed-arm, complete, left. |
| 20. Check-valve. | |
| 21. " Guide. | |
| 22. Nozzle. | All Glasses, 3 × ½. |

FIG. 143.—THE "DETROIT" No. 2 IMPROVED LOCOMOTIVE-CYLINDER LUBRICATOR. (Front View.)

through a cored passage, and at the same time the steam escaping through the nozzle 22 draws the oil out and forces it into the tallow-pipe, this being the action

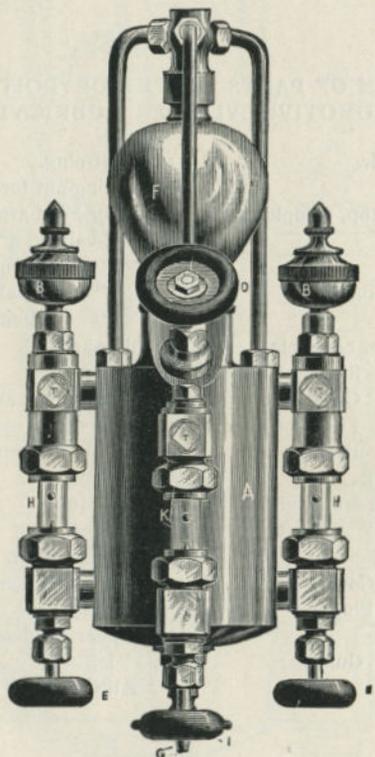


FIG. 144.

complete.* The idea in illustrating this lubricator in full and detail, with each part numbered and named, is to try to make it beneficial to the engineer and fireman. In making out work reports the engineer is often at

* Figs. 142, 143, 147.

loss for a proper name to give the broken parts, but by referring to the cuts and number as shown, the engineer has a guide which the writer hopes will meet all requirements.

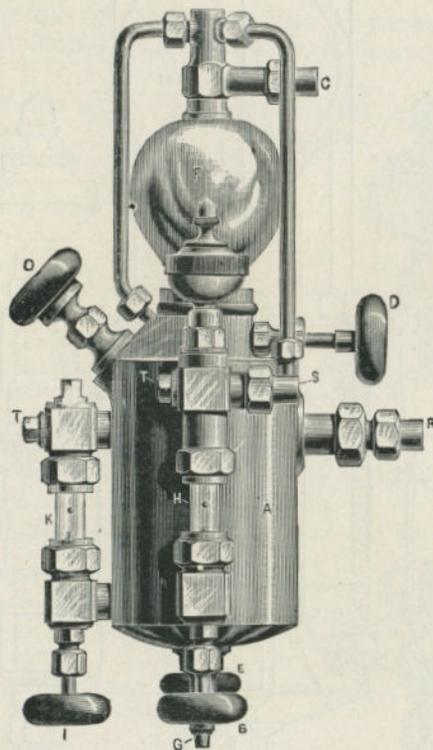


FIG. 145.—THE "DETROIT" No. 3 TRIPLE LOCOMOTIVE-CYLINDER LUBRICATOR. (Side View.)

The principal points of merit in the Detroit lubricator are as follows: The equalizing-pipes start from a point higher than the steam inlet at C, and owing to

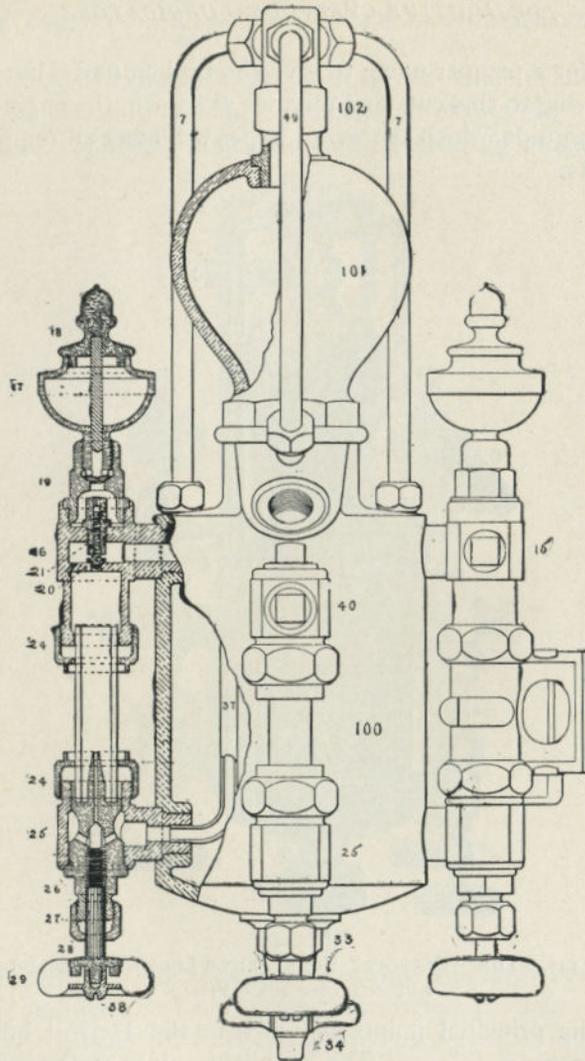


FIG. 146.—THE "DETROIT" No. 3 TRIPLE LOCOMOTIVE-CYLINDER LUBRICATOR. (Front View.)

DESCRIPTION OF PARTS OF THE DETROIT TRIPLE LOCOMOTIVE-CYLINDER LUBRICATOR.

- | | |
|----------------------------|--|
| 100. Oil-reservoir. | 25. Lower Feed-arm. |
| 101. Condenser. | 26. Feed-valve. |
| 102. Extension-top. | 27. " Stem. |
| 6. Tail-nut. | 28. " Nut. |
| 7. Equalizing-tubes. | 29. " Handle. |
| 8. Elbows. | 33. Drain-valve. |
| 6. Tail-pipe. | 34. " Stem. |
| 9. Water-valve, complete. | 37. Oil-tube. |
| 10. " Stem. | 38. Handle-button. |
| 11. " Centre-piece. | 40. Upper Feed-arm to Air. |
| 12. " Follower. | 41. Filler Stopple-handle. Brake-attachment. |
| 13. " Packing-nut. | 42. Filler Stopple. |
| 14. Wood-handle. | 43. Jamb-nut. |
| 15. Upper Feed-arm, right. | 45. Tail-nut to Air-brake Attachment. |
| 16. " " left. | 46. Tail-pipe to Air-brake Attachment. |
| 17. Hand-oiler. | 48. Check-guide to Air-brake Attachment. |
| 18. " Cover. | 49. Equalizing-tube to Air-brake Attachment. |
| 19. " Plug. | All Glasses, 3 × $\frac{1}{4}$. |
| 20. Check-valve. | |
| 21. " Guide. | |
| 22. Nozzle. | |
| 23. Water-plug. | |
| 24. Packing-nut for Glass. | |

this fact all surplus condensation must drain back into the boiler, and oil and steam only (which are both lubricants) pass through the tallow-pipes to the valves and cylinders. This is of the utmost importance, because better lubrication is secured with a minimum amount of oil, and absolute regularity of feed is obtained.

The equalizing-pipes being on outside of lubricator, leakage or defects in same are readily detected and remedied, all overheating of lubricator is avoided, and a full supply of condensation is always to be depended on.

In case of breakage of sight-feed glass, no steam can escape, as ports are instantly closed automatically by check-valve over sight-feed glass.

The disabling of one side of the lubricator will not affect the satisfactory working of the opposite side.

There is no possibility of cross-feed to one cylinder or into boiler. No movement of throttle-lever will cause any variation of feed. It is as simple in operation as those in use on stationary engines, and effects an enormous saving in oil and wear of machinery. The lubricator is made as a combined air-pump and cylinder-lubricator.

PRESSURE-REGULATORS FOR STEAM-HEATING.

As most all trunk lines have adopted the use of steam-heat for passenger trains, the locomotives are equipped with pressure-reducing valves. The construction and action of these valves should be understood by the engineer and fireman. The valves shown are examples of good reducing-valves, giving good service on standard railroads in the country. A reducing-valve which will shut off steam in case of a failure in opera-

tion due to a broken spring. Such a valve is found in the Foster "pressure-regulator," Fig. 148, the action of which is as follows: Steam enters at *A*, and passing through the valve is delivered at *B*. As will be seen, the delivery-pressure entering chamber *K* tends to raise

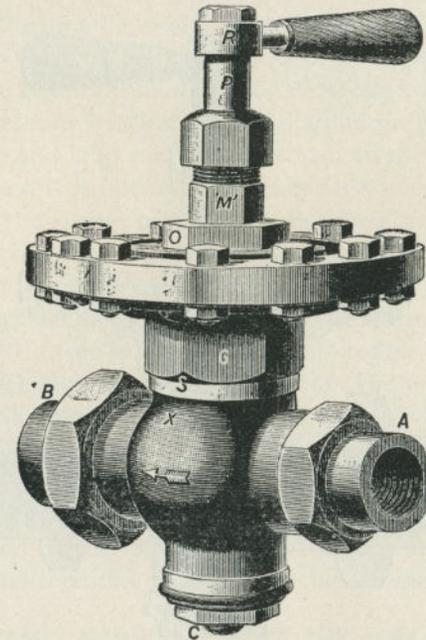


FIG. 147.—FOSTER PRESSURE-REGULATOR.

the diaphragm and to close the valve. In opposition to this the compressed spring *H* tends to open the valve. When the valve is in operation there is an equilibrium between these two forces. If the delivery-pressure falls, the pressure on the diaphragm is diminished, and the spring, overcoming the lighter resistance, opens the

valve until the equilibrium is again established and the pressure restored; on the other hand, any increased delivery-pressure bearing on the diaphragm overcomes the resistance of the spring and draws the valve toward its seat in proportion to the increased pressure. When

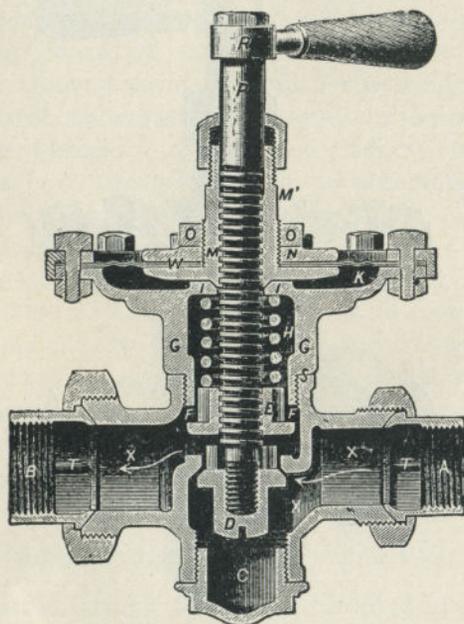


FIG. 148.—FOSTER PRESSURE-REGULATOR.

the tension of the spring is proportioned to the pressure bearing on the diaphragm, a constant and uniform discharge is insured.

The spring-nut *E* is threaded on to the spindle, and, having wings which extend into the hexagon-spring

chamber *H*, it is prevented from turning with the spindle, but is free to move up and down with it. The flange on the lower side of the spring-nut *E* is a stop to prevent an excessive lift and rupture of the diaphragm. The opening of the valve *D* is regulated by turning the spindle, which is threaded into *M*.

It will be seen from this that if the spring should break the equilibrium would be destroyed, and the delivery-pressure bearing on the diaphragm would close the valve and stop the flow of steam to the train-pipe. In this case it is not only a regulating-valve, but in the event of the spring breaking it becomes an automatic check-valve.

This valve, being an automatic regulator, can control to a nicety the steam admitted to each car, making it possible to carry in the train-pipe enough pressure to get a quick and adequate circulation the whole length of the train, and at the same time to carry a low-pressure in each car. This is the ideal condition. The parts are named so clearly in the descriptions, that in case the engineer has a report to make on the work slip, he will not be at a loss for a name for the different parts to be repaired on either of these regulators.

THE MASON REDUCING-VALVE FOR LOCOMOTIVES.

This valve is designed to automatically reduce and maintain an even steam-pressure for heating cars from the locomotives. It is placed in the steam-supply pipe leading from the boiler to the heating system, and regulates the amount of steam passing to the system, allowing only sufficient steam to maintain the desired pressure. These reducing-valves are fitted with union

connections or tapped ends, in any size preferred. They are thoroughly reliable, and are the standard used on over one hundred railroads. [A good reason for showing this valve.—AUTHOR.]

Description. (See Sectional View.)—The principle on which the Mason Reducing-valve works is that of an auxiliary-valve 11 controlled by the low-pressure in the heating system, through the medium of a metal diaphragm, and admits steam from the initial side of the valve through a port to operate a piston 17,

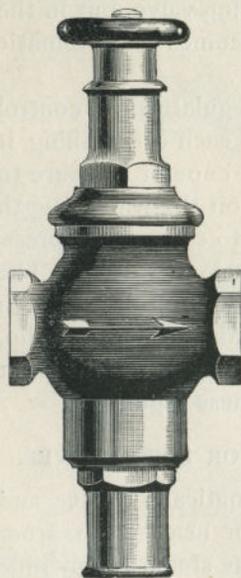


FIG. 149.—MASON REDUCING-VALVE.

which in turn opens the main-valve 16, and admits steam to the system. By referring to sectional view it will be seen that the steam enters the valve at the side marked "inlet," a small portion of it passing up through the auxiliary-valve 11. This valve 11 is forced open by the compression of the large spiral spring 8, acting on the button 10 through the diaphragm, so that in opening the valve 11 the diaphragm is also forced down. As soon as the valve 11 is opened steam passes through and into port *N* under piston 17. By raising this piston 17 the main-valve 16 is opened against the initial pressure, since the area of valve 16 is only one half of that of piston 17. Steam is thus admitted to the system. When the pressure in the system has reached the required point,

which is determined by the spring 8, the diaphragm is forced upward by the low pressure, which passes up through port *XX*, to chamber *OO*, under the diaphragm, allowing valve 11 to close, shutting off the steam from piston 17. The main-valve 16 is now forced to its seat by the initial pressure shutting off steam from the system, and pushing the piston 17 down to the bottom of its stroke. The steam beneath this piston 17 exhausts freely around it (the piston being fitted loosely for this purpose), and passes off into the system. It will be seen from this that when the pressure in the heating system has reached a predetermined point the flow of steam will be automatically checked, and when the pressure is slightly reduced the valve will again open and supply the required amount of steam. The piston 17 is fitted with a dash-pot 18, which prevents chattering or pounding when the pressure is suddenly reduced.

Directions.—Place the valve vertically in the steam-supply pipe. The steam should flow through the valve in the direction indicated by the arrow cast in the side. Before connecting the valve the pipes should be thoroughly blown out, in order to expel all dirt and chips. If the piping is new, steam should be allowed to flow through for some little time, so as to burn off all the oil or grease which may be in it.

When ready to let on steam, turn the wheel at top of the valve in the same direction as you would to open a globe-valve. Time must be allowed for the system to fill, before the required pressure is obtained.

If the valve should not maintain a low pressure, it will probably be due to the fact that some dirt or

chips from the piping have lodged in the seat of the valve 16.

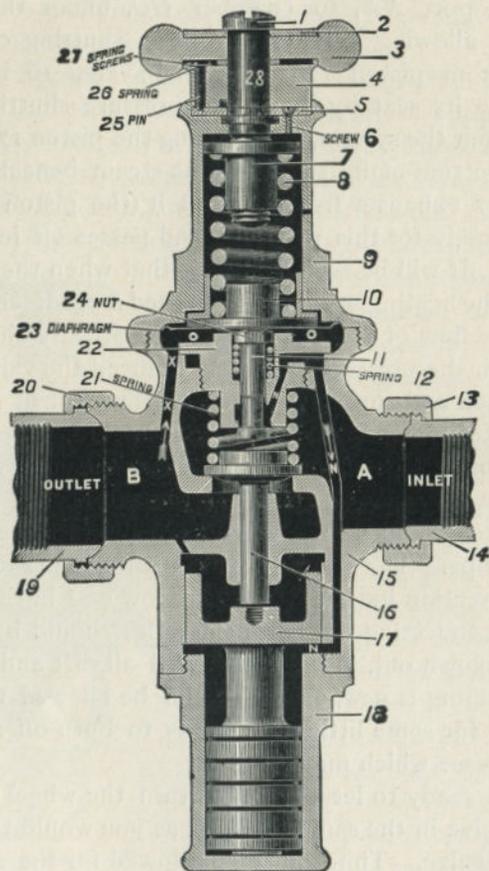


FIG. 150.—MASON REDUCING-VALVE. (Sectional View.)

To take the valve apart, the tension on the diaphragm spring 8 must first be removed by turning the wheel as

far as it will go in the direction taken by the hands of a watch. Then unscrew the spring-case 9, and remove the button 10 and the diaphragm; also remove the cap 22, which contains the auxiliary-valve. The threaded rod which accompanies each valve can then be screwed into the valve-disk 16, which should work easily. Pull out this valve and clean the seat. Then insert the rod through the valve-stem hole, screw it into the piston 17, and see if it works up and down easily. It will not be found possible to raise and lower the piston 17 suddenly, as the dash-pot 18 will restrain it. If the piston 17 is found to be stuck fast, remove the dash-pot 18 at the bottom of the valve, pull out the piston and clean it with fine emery-cloth, being careful to wipe off all emery before replacing. Before replacing the cap 22, examine the small auxiliary-valve 11, and see that it is tight, and free from dirt. Be sure that the diaphragm 23 is perfectly clean, also that there is no dirt where it makes its seat.

The wheel is made self-locking in any position by means of a steel locking-pin 25, which is forced by a spring into any one of twelve recesses in a hardened steel plate 5. We advise removing the valve during the summer. Before replacing, thoroughly clean and oil all the parts.

CHAPTER XIII.*

BRAKES, AIR-PUMPS, VALVES, PUMP-GOVERNORS,
AND WESTINGHOUSE BRAKES.

THE Westinghouse Improved Quick-action Automatic Brake consists of the following essential parts:

1. THE STEAM ENGINE AND PUMP, which furnishes the compressed air.
2. THE MAIN RESERVOIR, in which the compressed air is stored.
3. THE ENGINEER'S BRAKE AND EQUALIZING-DISCHARGE VALVE, which regulates the flow of air from the main reservoir into the brake-pipe for releasing the brakes, and from the main train or brake pipe to the atmosphere for applying the brakes.
4. THE MAIN TRAIN OR BRAKE PIPE, which leads from the main reservoir, to the engineer's brake and equalizing-discharge valve, and thence along the train, supplying the apparatus on each vehicle with air.
5. THE AUXILIARY RESERVOIR, which takes a supply of air from the main reservoir, through the brake-pipe, and stores it for use on its own vehicle.
6. THE BRAKE-CYLINDER, which has its piston-rod attached to the brake-levers in such a manner that

* This chapter is taken from the Instruction-book of the Westinghouse Air-brake Company.

when the piston is forced out by air-pressure, the brakes are applied.

7. THE IMPROVED QUICK-ACTION AUTOMATIC TRIPLE-VALVE, which is suitably connected to the main train-pipe, auxiliary reservoir, and brake-cylinder, and is operated by the variation of pressure in the brake-pipe (1) so as to admit air from the auxiliary reservoir (and under certain desirable conditions, as will be explained hereafter, from the train-pipe) to the brake-cylinder which applies the brakes, at the same time cutting off communication from the brake-pipe to the auxiliary reservoir, or (2) to restore the supply from the train-pipe to the auxiliary reservoir, at the same time letting the air in the brake-cylinder escape, which releases the brakes.

8. THE COUPLINGS, which are attached to flexible hose and connect the train-pipe from one vehicle to another.

9. THE AIR-GAUGE, which, being of the duplex pattern, shows simultaneously the pressures in the main reservoir and the train-pipe.

10. THE PUMP-GOVERNOR, which regulates the supply of steam to the pump, stopping it when the maximum air-pressure desired has been accumulated in the train brake-pipe and reservoirs.

The automatic action of the brake is due to the construction of the triple-valve, the primary parts of which are a piston and slide-valve. A moderate reduction of air-pressure in the train-pipe causes the greater pressure remaining stored in the auxiliary reservoir to force the piston of the triple-valve and its slide-valve to a position which will allow the air in the auxiliary reservoir

to pass directly into the brake-cylinder and apply the brake.

A sudden or violent reduction of the air in the train-pipe produces the same effect, and in addition to this causes supplemental valves in the triple-valve to be opened, permitting the pressure in the train-pipe to also enter the brake-cylinder, augmenting the pressure derived from the auxiliary reservoir about 20 per cent, producing practically instantaneous action of the brakes to their highest efficiency throughout the entire train.

When the pressure in the brake-pipe is again restored to an amount in excess of that remaining in the auxiliary reservoir, the piston and slide-valve are forced in the opposite direction to their normal position, opening communication from the train-pipe to the auxiliary reservoir, and permitting the air in the brake-cylinder to escape to the atmosphere, thus releasing the brakes.

If the engineer wishes to apply the brakes, he moves the handle of the engineer's brake-valve to the right, which first closes the port, retaining the pressure in the main reservoir, and then permits a portion of the air in the train-pipe to escape.

To release the brakes, he moves the handle to the extreme left, which allows the air in the main reservoir to flow freely into the brake-pipe, restoring the pressure and releasing the brakes.

A valve called the Conductor's Valve is placed in each car, with a cord running throughout the length of the car, and any of the trainmen, by pulling this cord,

can open the valve, which allows the air to escape from the train-pipe, applying the brake.

When the train has been brought to a full stop in this manner the valve should be closed.

Should the train break in two, the air in the brake-pipe escapes, and the brakes are applied instantaneously to both sections of the train. The brakes are also automatically applied should a hose or pipe burst. It will therefore be seen that *any reduction of pressure in the train-pipes applies the brakes*—which is the essential feature of the automatic brake.

An angle-cock is placed on each end of the train-pipe, and is closed before separating the couplings, thus preventing the application of the brakes when cars are uncoupled.

A stop-cock is placed in the branch-pipe leading from the main train-pipe to the quick-action triple-valve, and one in main train-pipe near the engineer's brake-valve, and within convenient reach of the engineer. The former is for the purpose of cutting out or rendering inoperative the brake on any particular car which may have become disabled through damage, and the latter for cutting out the engineer's brake-valve upon all but the leading engine, where two or more engines are coupled in the same train.

It is desirable to use the old-style plain automatic triple-valve for locomotive driver and tender brakes, and its illustration in this connection will be noted in Plate I, Fig. 1, and in greater detail in Figs. 3, 4, and 4a.

Mechanically, the engineer's brake and equalizing-discharge valve provides for a lack of skill in so far as

such devices can be made automatic; but it is essential that the engineer should be possessed of a degree of skill and judgment which will enable him to operate the brakes of his train in a judicious manner, by using them with care and moderation in making ordinary stops, and only in cases of actual emergency to make a quick application.

The attention of the engineer is therefore especially directed to the description of the new engineer's brake and equalizing-discharge valve, and the instructions relating to the proper method of operating the quick-action automatic brakes.

THE AIR-PUMP.

The construction of the air-pump is clearly shown in cross-section in plate 2, Fig. 151. A steam-cylinder 3 and air-cylinder 5 are joined together by a centre-piece 4, which forms the bottom head of the steam-cylinder and the top head of the air-cylinder, while suitable stuffing-boxes 56 therein encircle the piston-rod 10, the lower end of which is attached to air-piston 11, and the upper end to the steam-piston, each of which is provided with suitable packing-rings.

Suitably arranged valves in the walls of the steam-cylinder 3 and its upper head 2, to which further reference will be made, admit steam alternately above and below the steam-piston 10, forcing it upward and downward, giving a similar movement to the air-piston; while air from the outside atmosphere is drawn alternately through the air-inlets and receiving-valves 31 and 33 and forced under pressure through the dis-

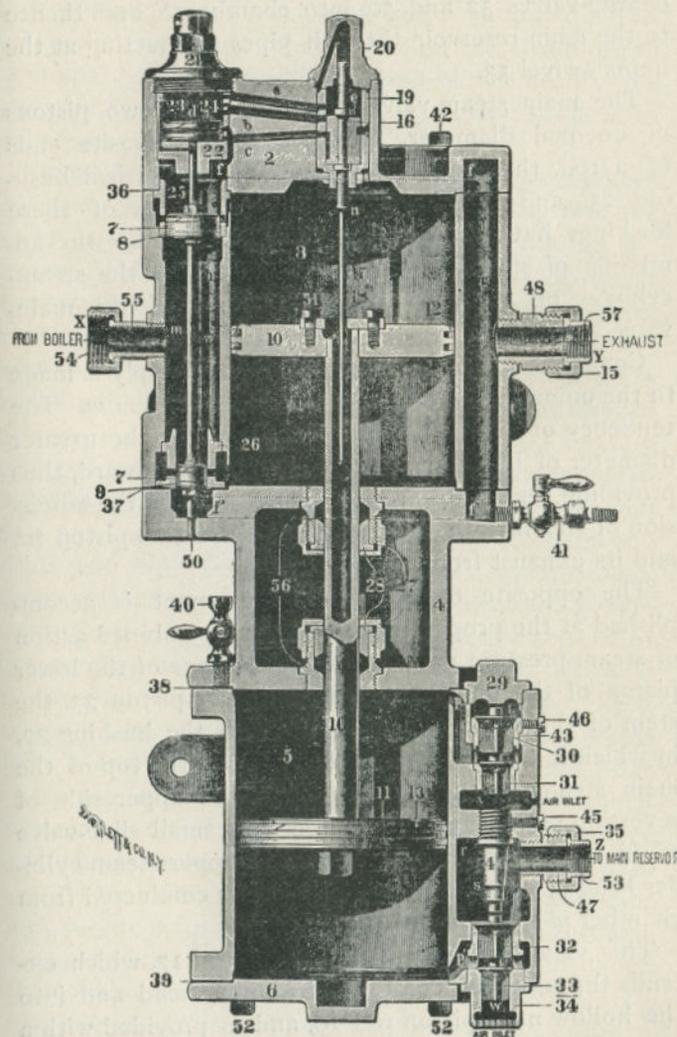


FIG. 151.

charge-valves 32 and 30, into chamber *S*, and thence to the main reservoir through pipes connecting at the union swivel 53.

The main steam-valve 7 is formed of two pistons of unequal diameter, mounted upon opposite ends of a rod, the upper one occupying cylindrical bushing 25, and the lower bushing 26, each of these bushings having two series of port-holes for the admission of steam to and its exhaust from the steam-cylinder by a reciprocating movement of the main-valve.

Connection with the source of steam-supply is made to the union-nut 54, and with steam in chamber *m*. The tendency of the main-valve, on account of the greater diameter of its upper piston, is to move upward, thus providing for its upward movement and for the admission of steam to the upper side of the steam-piston 10, and its exhaust from the lower side.

The opposite or downward movement is accomplished at the proper moment by the combined action of steam-pressure upon the upper surface of the lower piston of the main-valve and reversing-piston 23, the stem of the latter extending through the bushing 22, in which it operates, and bearing upon the top of the main steam-valve. Pressure upon the upper side of reversing-piston 23 is regulated by a small slide-valve 16 in the central chamber *e*, of the upper steam-cylinder head 2, to which steam-pressure is conducted from chamber *m* through port *h*.

This valve is given motion by a rod 17, which extends through bushing 19 in the upper head and into the hollow main-piston rod 10, and is provided with a

button-head on its lower end, and a shoulder *n* just below the top head; the plate 18 on the steam-piston alternately strikes this shoulder and button-head as the steam-piston 10 approaches the top or bottom head of the steam-cylinder.

Steam from the boiler being admitted to chamber *m* forces the main-valve upward, which uncovers the lower series of ports in bushing 25, and entering the steam-cylinder above the main-piston 10 drives it downward, while steam used on the previous upward stroke is discharged from the under side of the lower main-valve piston through the lower series of ports in bushing 26, which were also uncovered by this upward movement of the main-valve, thence through a suitably arranged passage *f*, shown in dotted lines, communicating with exhaust-chamber *g*, whence it is discharged by a pipe connected at union swivel 57, through the smoke box and stack to the atmosphere. As the main-piston reaches the termination of its downward stroke, plate 18, striking the button-head on the lower end of the reversing-valve rod 17, draws the rod and its valve 16 downward, uncovering port *a* in the upper head and admitting steam above reversing-piston 23, which forces it and the main-valve 7 downward to the position shown in the cut, and permits steam from above the main-piston 10 to be discharged through the upper series of port-holes in bushing 25, thence through passage *ff* to exhaust-chamber *g* and the atmosphere, while live steam is admitted from chamber *m* through the upper series of ports in bushing 26 to the under side of main-piston 10, driving it upward until plate 18 strikes the shoulder *n* of reversing-rod 17, which pushes

valve 16 upward, and brings the small exhaust-cavity in its seat opposite ports *b* and *c*, exhausting the pressure from above reversing-piston 23 into exhaust-passage *ff*, which permits the main-valve to again move upward as previously described.

The upward movement of air-piston 11 causes the lower receiving-valve 33 to lift, and air to be drawn through the series of inlet-ports in the under side of the valve-chamber cap 34, thence past the valve and through port *p'* to the cylinder; the downward movement of the air-piston closes receiving-valve 33, and compresses the air contained in the cylinder to a point in excess of that which may already be stored in the main reservoir, which lifts discharge-valve 32, and permits the compressed air to flow into chamber *s* and to the main reservoir through pipes connected at union swivel 53. The downward movement of the air-piston similarly causes the air to be drawn into the upper end of the cylinder through the upper air-inlet ports to chamber *v* through upper receiving-valve 31 and passage *p*.

The air on this side of the air-piston in being compressed during the upward stroke closes the receiving-valve, and raising upper discharge-valve 30 is forced into chamber *t*, and thence through communication port *r* to chamber *s* and the main reservoir.

The lift of the receiving-valves should be $\frac{5}{32}$ of an inch, and that of the discharge-valves $\frac{1}{8}$.

It is most important that the prescribed amount of lift of air-valves be maintained, and if exceeded by wear from action, which will ultimately occur, should not be permitted to become excessive, in which event valves

and seats may both be ruined by pounding upon each other, while prompt attention may save both, and prevent disagreeable pounding.

In renewing bushing 43 the shoulders upon which it rests in position should be carefully ground in to prevent leakage of air past these, then adjust set-screw 46, when cap-nut 29 may be screwed firmly, but not harshly, upon it.

With 125 pounds steam-pressure, the 8-inch pump when in good condition will compress 0 to 70 pounds pressure of air in a standard main reservoir 26 $\frac{1}{2}$ inches in diameter by 34 inches long (outside measurement), about 9 cubic feet capacity in 88 seconds, and from 20 to 70 pounds in 62 seconds.

The efficiency of the pump and its condition may therefore be readily ascertained at any time desired.

If other reservoirs are used than the dimensions given, the duty may be calculated in exact proportion.

THE QUICK-ACTION TRIPLE-VALVE.

A large view of the triple-valve in cross-section is shown in Fig. 152, a transparent view of the slide-valve in Fig. 153, and of the slide-valve seat in Fig. 154, to which references will be made in the following explanation of its purpose and functions.

The quick-action triple-valve is wholly automatic in principle, that feature existing in the construction of the plain automatic triple-valve by which its mechanism could be "cut out" or made inoperative, or permitting the use of the "straight-air" or non-automatic form of brake, being entirely omitted.

As its name implies, the quick-action triple-valve is designed to facilitate rapidity of action of the brakes upon railway trains, particularly those of considerable length, where desired.

Simultaneous action, as nearly as possible, is quite necessary to avoid shock consequent upon link or drawbar slack between cars. Such action, however, is only necessary in an emergency, its ordinary action for service applications of the brake being in entire harmony with that of the old-style triple-valves, either method of application being entirely dependent upon the rapidity with which the air is discharged from the train-pipe, and consequently under the control of the engineer.

Under each car in the main train-pipe is a drain-cup forming a tee, from which a branch-pipe extends to the triple-valve, to which it is connected at *A*, and a stop-cock is placed in this branch-pipe for the purpose of rendering inoperative the brakes upon any particular car when occasion requires, by reason of accident to the brake gear or apparatus leaving the main train-pipe unobstructed to supply air to the remaining vehicles.

The opening *B* communicates with a chamber in the cylinder-head, from which a pipe leads to the auxiliary reservoir. The opening *C* communicates with a port in the cylinder-head through which air is conducted to and from the brake-cylinder.

Air from the main reservoir on the engine, being discharged into the train-pipe by the operation of the engineer's brake-valve, enters triple-valve at *A*, and passes thence through ports *ee* and *gg*, to piston-

chamber *h*, forcing the piston 4 to the normal position shown, which it occupies when brakes are released, uncovering feed-port *i*, permitting the air to pass by the piston, thence through port *k* to chamber

QUICK ACTION TRIPLE VALVE.

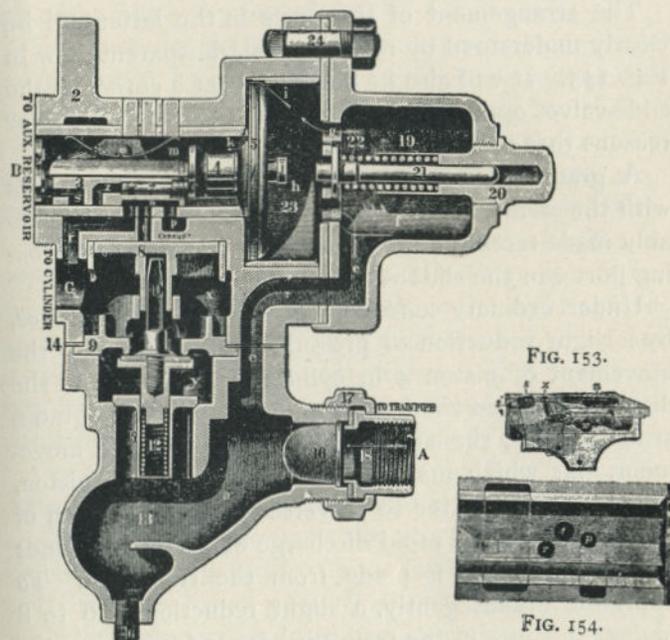


FIG. 152.

m, occupied by the slide-valve 3, from which it has free egress at opening *B* to the auxiliary reservoir, charging the latter to the same pressure as that in the train-pipe.

That portion of the stem of the piston 4 between

the shoulders *u* and *c* is semicircular in form, and passes between two flanges of the slide-valve 3, the length of the latter being slightly less than the distance between these shoulders, permitting a limited movement of the piston, without moving the slide valve.

The arrangement of the ports in the latter will be clearly understood by reference to transparent view in Fig. 153. It will also be observed that a corner of the slide-valve opposite ports *s* and *z* is cut away, for reasons that will appear later.

A graduating-valve, 7, is attached to and moves with the stem of the piston 4, and extends into a suitably made recess in the slide-valve, opening and closing port *z* in the slide-valve.

Under ordinary conditions of operating the brakes, by a slight reduction of pressure in the train-pipe the movement of piston 4 in cylinder *h* is limited to the distance between the knob *j* and the end of the graduating-stem 21, the spring 22 resisting further movement, but which may be compressed by the piston, permitting the latter to traverse the entire length of the cylinder *h*, if a rapid discharge of 10 or 12 pounds pressure or more is made from the train-pipe. To apply the brakes gently, a slight reduction of 6 to 8 pounds pressure in the train-pipe is made, causing the greater pressure remaining in the auxiliary reservoir, with which chamber *m* is in constant communication, to force piston 4 to the right, closing feed-port *i*, and moving the graduating valve away from its seat in port *z* until the shoulder *u* on the piston-stem, engaging the slide-valve 3, moves it with the piston

until the latter is stopped in its traverse, by knob *j* meeting the graduating-stem 21, the spring 22 resisting further movement. In this position port *z* is opposite port *r* in the valve-seat, and air from the auxiliary reservoir passes into the brake-cylinder through ports *w*, *z*, *r*, *r* and *C*, forcing the piston outward and applying the brakes.

The pressure in the auxiliary reservoir having now been reduced by expansion into the brake-cylinder to an amount slightly less than that in the train-pipe, piston 4 is forced to the left and graduating-valve 7 to its seat, closing port *z*, the slide-valve remaining stationary, retaining the pressure in the brake-cylinder.

Further reductions of pressure in the train-pipe, as may be desired to apply the brakes with greater force, cause the piston 4 to again move to the right against graduating-stem 21, pulling graduating-valve 7 from its seat, admitting additional pressure from the auxiliary reservoir to the brake-cylinder until entirely equalized in each, or to about 50 pounds, from an original pressure of 70 pounds in the auxiliary reservoir. This effect is caused by a reduction of air-pressure in the train-pipe of about 20 pounds, from which it will be seen that any further reduction is a waste of air, and that the force with which the brakes may be applied is proportionate to the reduction of pressure in the train-pipe within this limit.

The brakes are released by admitting pressure to the train-pipe, which forces piston 4 to the left to the position shown, permitting pressure in the brake-cylinder to escape to the atmosphere through ports *c*, *r*, *r* and ex-

haust-ports u and p , the latter being cored to the atmosphere around the valve body.

The action of the brakes just described is that used in ordinary station stoppages, and is termed a "service application," and is caused, as will have been observed, by a gradual discharge of pressure from the main train-pipe at the engine.

To apply the brakes with their full force, a quick reduction of the pressure in the train-pipe of 10 to 12 pounds is made, causing the piston 4 to move through the entire length of its cylinder h , compressing graduating-spring 22, and bringing port s in the slide-valve opposite port r in its seat, admitting pressure from the auxiliary reservoir to the brake-cylinder, at the same time the removed corner of the slide-valve 3, before referred to, uncovers port t in its seat, admitting auxiliary-reservoir pressure above piston 8, forcing it downward, and emergency-valve 10 from its seat; while train-pipe pressure, lifting valve 15, rushes to the brake-cylinder through the openings made, in a large volume, uniting with that from the auxiliary reservoir, giving a pressure on the piston of about 60 pounds per square inch, from 70 pounds auxiliary-reservoir and train-pipe pressure, or about 20 per cent greater than from a service application of the brakes.

The check-valve 15 closing when the pressure is equalized, prevents pressure from the brake-cylinder re-entering the train-pipe. A restoration of pressure in the train-pipe releases the brakes, as already described, port t being brought into communication with exhaust-port u of the slide-valve, permitting the air used in forcing piston 8 downward to escape into the

atmosphere, and spring 12 then restores emergency-valve 10 to its seat.

This action of the brake apparatus, as will have been noted, causes a local reduction of train-pipe pressure under each car, by discharging this air into the cylinder for braking purposes, instead of having it wholly pass to the atmosphere at the engine, as was necessarily the case with the plain form of the automatic brake apparatus, economizing the use of air-pressure and producing practically instantaneous action of the brakes throughout an indefinite length of train; but they should be used in this manner in cases of emergency only.

To prevent the application from a slight reduction of pressure caused by leakage in the train-pipe, an oval groove is cut in the bore of the car-cylinder $\frac{9}{16}$ of an inch in width and $\frac{5}{16}$ of an inch in depth, and of such length that the piston must travel three inches before the groove is covered by the packing leather.

A small quantity of air, such as results from a leak, passing from the triple-valve into the brake-cylinder, may have the effect of moving the piston slightly forward, but not sufficiently to close the groove, which permits the air to flow, to the atmosphere past the piston. If, however, the brakes are applied in the usual manner the piston will be moved forward, notwithstanding the slight leak, and will cover the groove. It is very important that the groove shall be of the dimensions given.

The triple-valve should be drained occasionally of any moisture that may accumulate, by the removal of the bottom plug.

In an "emergency" action of the brakes, when, as previously stated, air from the train-pipe is vented into the brake-cylinder, the strong current of air toward the triple-valve carries with it any foreign matter in the air-pipes, and this lodging in the conical strainer 16, at the union of the branch-pipe and the triple-valve, may clog the meshes of the strainer and prevent the free passage of air, and should therefore be cleaned occasionally, but this may be largely avoided if the hose, when not coupled to that on adjoining vehicles, is placed in its dummy coupling and the air-pipes are carefully blown out with steam previous to their erection on the car.

Should a continuous leak manifest itself at the exhaust-port of the triple-valve, or the pressure-retaining valve, it will usually be found to be due to the presence of dirt on the seat of the emergency-valve 10, which should be cleaned.

On account of slight differences in sizes of ports, triple-valves intended for freight or passenger car brakes must not be used in the opposite service.

The passenger-car triple-valve having a letter *P* cast upon its body, may be readily distinguished from that intended for freight service.

THE PLAIN AUTOMATIC TRIPLE-VALVE.

A perspective view of the plain automatic triple-valve and locomotive-tender brake apparatus is shown in Fig. 155, and cross-sections of the triple-valve in Fig. 156, which will clearly show its construction.

It is desirable that this triple-valve be perpetuated

for use with locomotive driving-wheel and tender brakes, to give a slightly slower action to the brakes thereon in cases of emergency action of the quick-action apparatus on the cars.

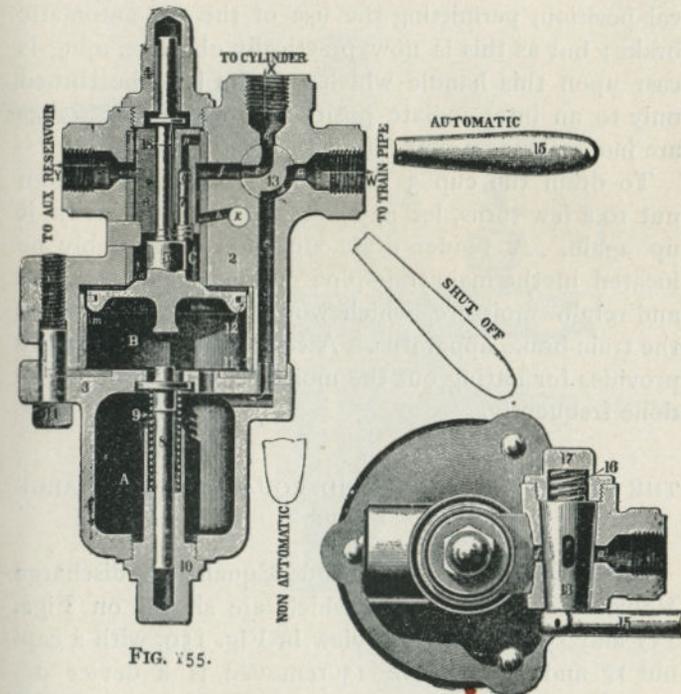


FIG. 155.

FIG. 156.

The construction and operation of the plain automatic triple-valve is substantially the same as that of the quick-action form, the quick-action valves being omitted, and pressure used only from the auxiliary

reservoir in applying the brakes, and will not, therefore, require specific description.

As constructed formerly, the handle, 15, could be turned from a horizontal position, which it occupies when the brakes are operated as automatic, to a vertical position, permitting the use of the non-automatic brake; but as this is now practically obsolete, a lug is cast upon this handle which permits it to be turned only to an intermediate position, in which the brakes are inoperative or shut off on that particular vehicle.

To drain the cup 3 of moisture, slack the bottom nut 10 a few turns, let any water escape, and screw it up again. A tender drain-cup should invariably be located in the main train-pipe on the tender to catch and retain moisture, which would otherwise pass to the train-brake apparatus. A cock in this cup readily provides for letting out the moisture, which should be done frequently.

THE ENGINEER'S BRAKE AND EQUALIZING-DISCHARGE VALVE.

The Engineer's Brake and Equalizing-discharge Valve, sectional cuts of which are shown on Figs. 157 and 158, and a plate view in Fig. 159, with a cap-nut 12 and rotary-valve 13 removed, is a device designed especially to assist the engineer in operating train-brakes in a more perfect manner than has hitherto been possible with the three-way cock or brake-valves formerly used for this purpose, without considerable personal skill from the operator.

It is of the greatest importance to perfect train-

braking that gradual exhaust or discharge of air pressure from the train-pipe should be made in applying the brakes under ordinary conditions of station stopping, and a gentle closing or stoppage of this exhaust in order to thoroughly equalize the pressure

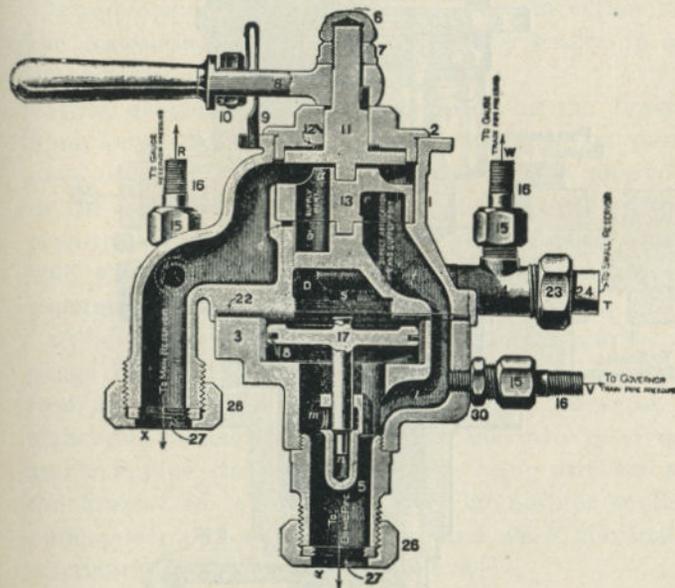


FIG. 157.

remaining in the train-pipe, thus preventing the release of some of the front brakes of the train, which may occur, particularly on long trains, by the abrupt opening and closure of the ordinary three-way cock, which causes a violent surge of air from the rear to the front end of the train, affecting the brakes as stated.

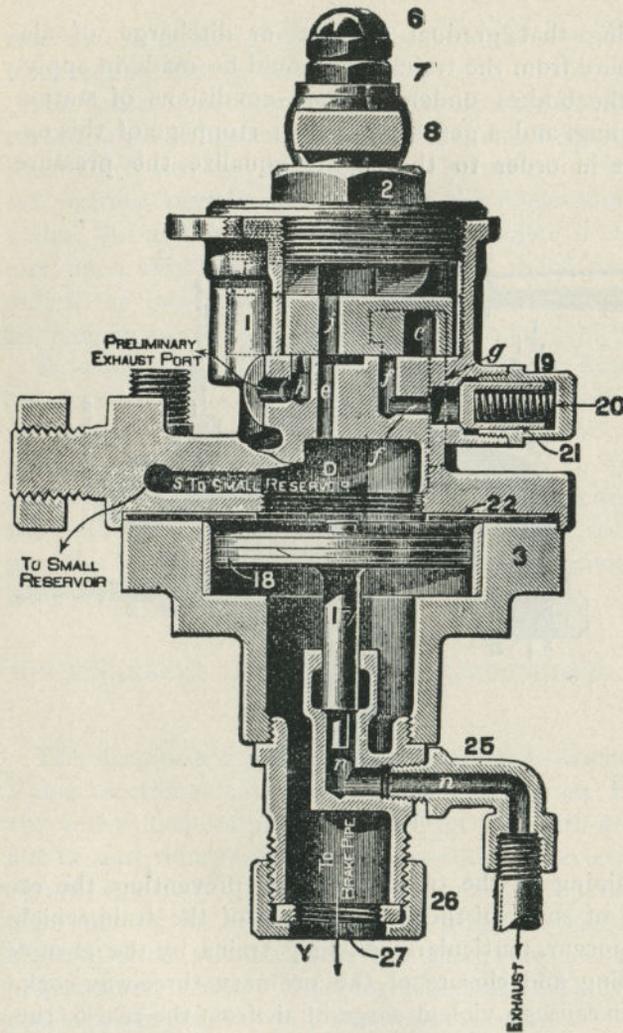


FIG. 158.

The brake-valve here illustrated entirely prevents this, and *mechanically measures the volume of air required to be discharged from the train-pipe and limits the rate of its discharge when applying the brakes for ordinary stoppages*, and is equally efficient on short or long trains.

Large openings are provided in its construction for the instantaneous application of the brakes in an emergency.

It is absolutely essential in operating the brakes upon long trains, and is of great importance on short ones, to store a pressure of air in the main reservoir on the engine of twenty to twenty-five pounds greater than train-pipe and auxiliary-reservoir pressure, which will, when discharged into the train-pipe, insure a prompt release of all the brakes.

A full set of engine-brake fixtures includes a pressure-gauge having two sets of works, and two indicators (red and black) on a single dial, which shows at a glance the presence respectively in the main reservoir and train-pipe, the connecting pipes being attached to the brake-valve at *R* and *W*. The air-pipe to the pump-governor should be connected at *V*, the main reservoir-pipe at *X*, and train-pipe at *Y*.

By preparing a diagram similar to Fig. 160, representing the rotary-valve 13 and handle 8, of tracing-cloth or other transparent material, cutting the ports *a* and *j* out of the diagram on their boundary-lines to show through openings, and then reversing same and placing it upon the seat of the valve, Fig. 159, where it may be rotated at will on its centre, the explanation following may be made clear.

piston 17, the stem of which, forming a valve, is seated in the position shown in "bottom-cap" 5, and permits the escape of air from the train-pipe to the atmosphere through ports *m* and *n* when raised from its seat.

When applying brakes for ordinary or station stops, move handle 8 to "on lap" position. This blanks all ports in the rotary-valve and seat. Then moving the valve-handle to the position "application of brakes, service-stop," the small exhaust-cavity *p* in the lower surface of the rotary valve 13 establishes communication between the two "preliminary exhaust-ports" *e* and *h*, the latter leading to the atmosphere, and after discharging about 8 pounds of pressure as shown by the gauge, restore the handle to "on lap" position.

This preliminary discharge of air from the chamber *D* will cause the piston 17 and its stem to rise, which operation is followed by a discharge of air from the train-pipe to the atmosphere through ports *m* and *n*, applying the brakes gently.

This discharge of air from the train-pipe *continues after the valve-handle is carried to "on lap" position* (gradually equalizing train-pipe pressure), *and until the train-pipe pressure has been reduced slightly lower than that yet remaining in the chamber above the piston*, when the latter is forced downward and its stem to its seat, closing the outlet *n*, and preventing the further escape of air, until the operation is repeated, which may be necessary to apply the brakes with the desired degree of force.

To throw off brakes, push handle 8 to "position for releasing brakes," causing the excess of air-pressure in

the main reservoir to be discharged into the train-pipe, insuring their prompt and certain release.

For an "emergency" application of brakes, push the handle to the extreme right, to position "application of brake emergency-stop." This operation establishes direct communication between the train-pipe and the atmosphere, through the "direct application and supply-port" 1, cavity *c*, and the "direct application and exhaust-port" *k*, applying the brakes with their full force instantly.

When handling trains on down-grades, let the brake-valve handle remain in full release position, except when applying brakes, which will insure the full and prompt recharging of auxiliary reservoirs under cars.

If the engineer's brake-valve bracket is to be located against the boiler-head, it must be made of sufficient length to prevent injury to the valve-gaskets by heat.

After being placed in position on the engine, and before using, it is a good practice to remove valve 13, and wipe its face and seat quite clean of any grit that may have lodged thereon in transit; rub a *little* tallow on the surfaces, and replace.

Care in this respect will prevent the valve and seat from cutting. Any leakage between the valve and seat may result in establishing communication between the several passages or ports therein, and thus prevent the very desirable results for which the valve was particularly designed. When this occurs it is necessary to regrind valve 13, which may be done by carefully facing and scraping the surfaces to a good seat, after which use a *small* quantity of fine-ground glass, sieved

through cloth of close texture, and a little oil. Usually the valve only requires facing.

It is of the utmost importance that *direct communication be made from the engineer's brake-valve to the main reservoir*, instead of connecting to the discharge-pipe leading from air-pump to main reservoir.

The latter practice is very undesirable, as a great deal of moisture and oil is discharged into the train-brake system which would otherwise be deposited in the main reservoir from which it can be readily drained.

A one-inch stop-cock should be placed in the train-pipe, a short distance below the engineer's brake-valve, within convenient reach of the engineer, and should be closed upon all but the leading engine of the train, where two or more engines are coupled in the same train, in order that the head engine may operate the train-brakes.

It is important that the pipe-connections to the brake-valve be perfectly air-tight, and that the valve should occasionally be cleaned. The feed-valve 21 can be readily removed for cleaning by the engineer, by placing the valve-handle in "emergency" application position, which will retain the air in the main reservoir, then unscrewing the cap-nut 19.

This should be done occasionally, as any derangement by which its functions of maintaining an excess pressure in the main reservoir is usually found to be due to the presence of dirt or gum from the use of too much oil or lubricant of an inferior quality. The piston should also be removed for cleaning, at intervals, as the presence of gum interferes with its free movement.

THE PUMP-GOVERNOR.

The construction of the pump-governor is illustrated in cross-section in Fig. 161. Its purpose is to automatically shut off the supply of steam to the pump when the air-pressure in the train-pipe and auxiliary reservoirs has reached the limit allowable, say 70 pounds, this pressure forming the basis upon which the maximum power of the brake-gear used on cars and engines is designed, thus avoiding excessive air-pressure, which, used indiscreetly, will result in sliding wheels. With a judicious use of the brake and maintenance of pressure to the maximum allowable, sliding of wheels may be avoided.

The simplicity of construction of the governor is such that the following description of its mechanism will make it readily understood:

By reference to Fig. 161 it will be seen that suitable provisions are made for attaching the end *Y* of the governor directly to the steam-pipe union connection of the air-pump, the opposite end *X* being piped to the source of steam-supply. Another pipe connection, with union swivel 21 at *W*, is also made and extended to the fitting 30, Fig. 157, in the engineer's brake-valve. This fitting, it will be observed, is tapped into a port of the brake-valve, *which is always in direct communication with the train-pipe, the pressure to be governed*, and which, acting upon the under side of the flexible diaphragm 19, forces it upward against the resistance of the regulating spring 18, when the desired train-pipe pressure has been reached, lifting valve

PUMP GOVERNOR.

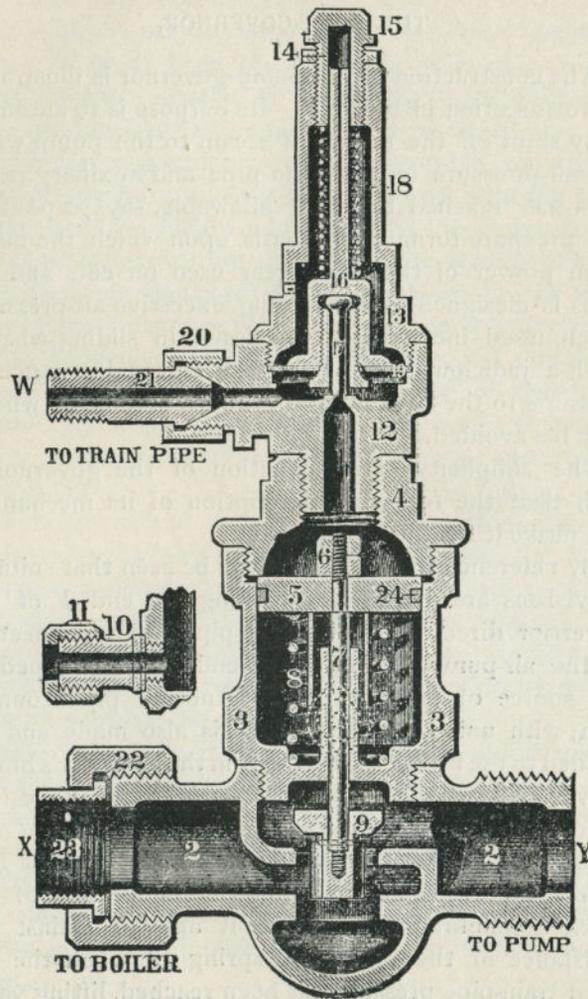


FIG. 161.

17 from its seat, admitting air-pressure on top of piston 5, forcing steam-valve 9, with which it is connected by stem 7, to its seat, shutting off the supply of steam.

A reduction of air-pressure in the train-pipe by applying brakes causes a reverse movement of the governor, valve 17 closing, and the pressure contained in the chamber above piston 5 leaking away past its edges to the atmosphere through the exhaust connection 10 in cylinder 3.

Spring 8 then forces the piston upward, opening steam-valve 9, and permitting steam to again pass to the pump. Any necessary adjustment of the regular spring 18 is readily made by means of nuts 14 and 15.

A good quality of lubricant should be continuously fed to the steam-cylinder of the pump while in operation. A small quantity of 32° gravity West Virginia well-oil should be used at intervals in the air-cylinder, it being particularly desirable to use a quality of oil which will cause the least gummy deposit in the air-passages, reducing their dimensions and preventing the free discharge of air in the main reservoir. Tallow, lard-oil, or kerosene must not be used in the air-cylinder.

Attention is drawn particularly to the description of the brake-valve contained in this work, and the fullest advantages should be taken of the opportunity it affords for the correct operation of the brakes.

Care should be taken to discharge six or eight pounds of air by the gauge in the first instance in applying brakes for ordinary stoppages, which will cause the pistons in the brake-cylinders to move outward suffi-

ciently to close the leakage-groove, forcing the brake-shoes lightly against the wheels. Further reductions of pressure may thereafter be made to suit circumstances.

The brakes are fully applied when the pressure in the train-pipe, and as shown on the gauge, has been reduced 20 pounds.

Any further reduction is a waste of air. It is of great importance that the engineer should remember that the gradual application of the brakes is caused by a gentle discharge of air-pressure from the train-pipe to the atmosphere, and that a rapid discharge causes the quick action of the brakes to ensue.

It is therefore essential that he exercise some degree of care and moderation in applying brakes, taking advantage of the emergency action of the brakes only when absolutely necessary to avoid accidents.

Engineers, upon finding that the brakes have been applied by the trainmen or automatically, must at once aid in stopping the train by using the brake-valve as in making ordinary stoppages, which will prevent the loss of pressure from the main reservoir, and enable the prompt release of brakes when necessary.

It is important that the main reservoir be drained of water at regular intervals, especially in moist climates and seasons. As much of this accumulation is condensed from the steam-cylinder and passes into the air-cylinder through imperfectly-packed piston stuffing-boxes, care should be taken to avoid this.

The shoes of driving-wheel brakes should be so adjusted, by means of the cam-screws, that the pistons move from 3 to 5 inches when the brakes are applied.

If cars having different air-pressures be coupled together, the brakes will apply themselves to those having the highest pressures in the auxiliary reservoirs.

To insure the certain release of all the brakes in the train, and also that the reservoirs may be quickly charged, the engineer must carry the maximum pressure in the main reservoir before connecting to a train.

On long down-grades it is important to be able to control the speed of the train, and at the same time to maintain a good working air-pressure.

This is readily accomplished on ordinary gradients, where the pressure-retaining valve is not necessary, by running the pump at a good speed, so that a comparatively high pressure will have been accumulated in the main reservoir while the brakes are on, and which when released enables the auxiliary reservoirs to be speedily recharged before the speed has increased to any considerable extent.

It should be sought to control the train on any grade by the use of the smallest quantity of air possible and the fewest number of applications of the brakes.

QUESTIONS ON 8" AIR-PUMP, FIG. 151.

What is the purpose of the third or top piston-head?

The third or top piston-head helps to reverse the valve-motion and to force the main piston-head or valves downward so as to open the bottom port.

Which piston-head or valve in main valve-chamber has the larger diameter?

The top one.

Which is the reversing-valve, and where is it situated?

The reversing-valve is the top head of steam-cylinder.

What is the shape of this valve?

It is a small slide-valve.

How is it moved?

By a valve-rod which extends down into the main piston-rod, this rod being hollow. The reverse-valve rod has a shoulder on its end, which comes in contact with a plate on main steam piston-head, which pulls the valve down, and the reverse-valve rod is pushed up by the main piston-rod, by the end of reverse-valve abutting against the main piston-rod.

How does the slide-valve reverse the movement of pump piston-heads?

By letting steam in on top of the third or top piston-head of valve-motion, also by exhausting from the same. Suitable ports are provided for the same.

How is the air-pressure accumulated

By the air-pump.

What are the principal parts of a pump?

The steam-cylinder and the air-cylinder.

Which is the air-cylinder in the Westinghouse Pump?

The bottom cylinder.

How is the air drawn into the air-cylinder?

A piston-head works in the air-cylinder which is fastened to the piston-rod, extending to the steam-cylinder and also attached to the steam piston-head. When the piston goes up and down in cylinder it causes a displacement in the air-cylinder, into which the atmosphere rushes, filling up the air-cylinder.

How is the inlet and outlet of air controlled?

By suitable valves called receiving and discharging valves. (Fig. 151.)

How many small piston-heads are in the steam-valve motion?

Three. Two on the main-valve stem, in the steam-chamber, and the third one is in the chamber above the main chamber. This head has a stem extending through the chamber resting on top of the top piston-head in main steam-chamber.

Why are the piston-heads in main valve-chamber of different diameters?

In order that the piston-heads which serve as valves will move in the direction of the larger head, the steam entering between the heads.

In what do these valves work?

In bushings forced into the chambers.

Why is this done?

In order that the bushing can be renewed without dispensing with the pump when they become much worn.

Describe the movement of the pump in Fig. 151.

As shown in the figure, the steam is entering the lower ports, driving the piston-head upward. The exhaust is passing out the upper ports, into the exhaust-passages around the pump, to exhaust-pipe. The third or top piston-head has steam on the upper side, which has forced it down with the main valves. When the main steam piston-head is near the end of its upward travel, it will strike the reverse-valve rod, and that will move the valve over the ports leading to top piston-head and exhaust the steam from it, when

the main valves will move upward and open the upper ports to drive piston-head downward again.

How is the piston-rod packed in main pump?

By a composition packing.

What is the effect on a pump when this packing leaks badly?

It makes one end of the pump useless, because the air will escape into the atmosphere instead of being forced into the reservoir.

When a pump-piston rod is packed, what is necessary to keep it from burning out?

It should be well lubricated, and kept tight to piston-rod, for if it leaks badly around the piston-rod it will burn the packing out, for the air under a pressure causes a great friction when escaping, which will set the packing on fire. Air under pressure gives off its latent heat.

What are the other causes which make an air-pump run hot?

Running the pump without lubrication in either air or steam end, which causes the rings to cut; too high air-pressure in reservoir, rapid running of pump, and valves gummed up in air-cylinder, which causes an excessive friction.

What causes a pump to stop working?

A reversing-valve rod broken; plate on piston-head loose; piston valve-rings broken or leaking; steam passage to reversing-valve stopped; bottom or air-cylinder piston-head broken off from piston-rod.

THE NINE-AND-ONE-HALF-INCH IMPROVED WESTINGHOUSE AIR-PUMP.

IT will be seen from the cuts of the Nine-and-one-half-inch Pump, here presented, that the valve-motion is entirely in the top head of the steam-cylinder, while in the ordinary eight-inch pump a portion of it is located in the steam-cylinder proper. In repairing the valve-motion it has heretofore been necessary to get at both the steam-cylinder and the top head, but in the new pump, as all of the moving parts are concentrated in the top head alone, its repair is greatly facilitated. A square-top head can be carried on the locomotive and readily substituted for a defective one during a run should there be any necessity for an operation of this kind. The number of parts of the valve-motion has been considerably reduced, and they are less delicate constructively than those used in our standard eight-inch pump.

The principal improvement in the air-cylinder is in the arrangement of the air-valves. Each one is contained in a separate case, and all are made of the same size. It is therefore necessary to carry but one kind in stock for the complete repair of this portion of the air-pump. By this general arrangement the lift of each valve is controlled by an ample contact surface with the cap of the valve-case, or with the case itself, and a change in the lift of one valve has no effect upon any of the others. An air-strainer is provided for the inlet opening, which is on the left side of the pump, and so located as to offer the least chance for taking dust and

cinders in the air-cylinder. In all matters of detail, such as the size of the bolts and proportioning of parts,

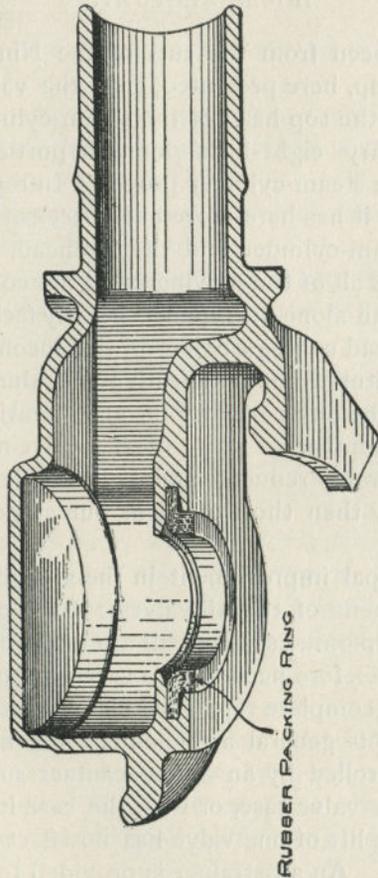
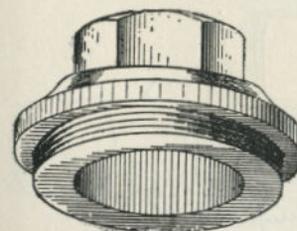


FIG. 162.—NEW STYLE HOSE COUPLING.

great care has been exercised to make them ample for their intended use. We have carefully examined into

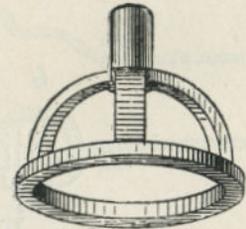
the nature of the repairs that we have heretofore furnished on our standard pump, and have been guided by our observations on this point in the character of some of the changes made in detail construction. This pump, as compared with our standard eight-inch pump, has an increased capacity of 65 per cent, and to compress a given amount of air at 90 pounds requires 20 per cent less of steam.

Description.—As will be seen by reference to Figs. 167



Coupling Cap.

FIG. 163.



Packing Ring Washer

FIG. 164.

OLD STYLE.

and 168, the valve-motion of the pump consist of two pistons 77 and 79 of unequal diameter, mounted on rod 76, while a slide-valve 83, of the D type, held in position between them, provides for the distribution of steam to the upper and lower sides of main steam-piston 65, as required. Steam enters the pump at *X*, where a suitable stud and nut admit of the direct attachment of the pump-governor, and by means of passages *a* and *a'*, and port *a''*, is admitted to slide-valve chamber *A*, between the two pistons 77 and 79, where, by reason of the greater area of the former, tends to force it to the right to the position in which the valve is shown in

Fig. 167, thus admitting steam to the under side of main piston 65 through port *b* and passages *b*¹ and *b*², forcing it upward, while the steam previously used on the opposite side in forcing the main piston downward is exhausted to the atmosphere through passage *c*, port *c*¹, cavity *B* of the slide-valve 83, port *d*, and passage *d*¹ and *d*² at the connection *Y*, from whence it is conveyed by suitable pipe to the smoke-box of the locomotive.

In Fig. 168 is illustrated an outside view of main-

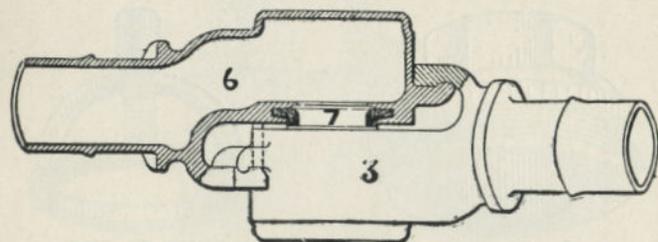


FIG. 165.

valve bushing 75, showing the several ports and steam-passages therein, of which port *t* communicates between chamber *E* in the main-valve head 85 and exhaust-passage *f*¹, and hence is in constant communication with the outside atmosphere, relieving the pressure on the surface of main-valve piston 79 exposed to chamber *E*. A reversing-valve 72 operates in chamber *C* in the centre of the steam-cylinder head, steam being supplied thereto from slide-valve chamber *A* through ports *e* and *e*¹, and which is given motion through the medium of a rod 71 extending into the space *k* of the hollow main-piston rod. The duty of this valve is that of admitting steam to and exhausting it from space *D* between main-

valve piston 77 and the head 84, and is shown in Fig. 167 in position to exhaust the steam previously used, from the space *D* through port *h* (Fig. 169), port *h*¹, reversing-valve cavity *H*, and ports *f* and *f*¹ to the main exhaust. ports *d* and *d*¹ and *d*².

It will at once be apparent, having described how the surface of main-valve pistons 77 and 79 exposed in

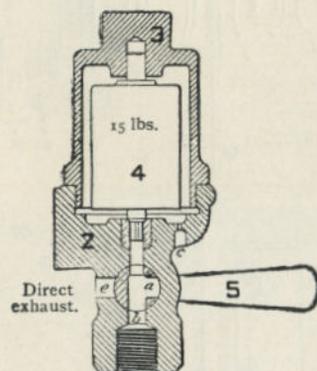


FIG. 166.—RETAINING-VALVE (set).

chambers *D*, and *E*, respectively, being free from pressure other than the outside atmosphere, that the steam on the opposite side in chamber *A* is exerting a force in both directions, but the total force toward the right is greater by the sum of the steam-pressure in chamber *A* multiplied into the difference between their areas. This effect, however, is reversed when the main piston, approaching the upward termination of its stroke, strikes the shoulder *j* of the reversing-valve rod 71, forcing the rod and its valve 72 upward, causing the admission of steam from chamber *C* to chamber *D* through

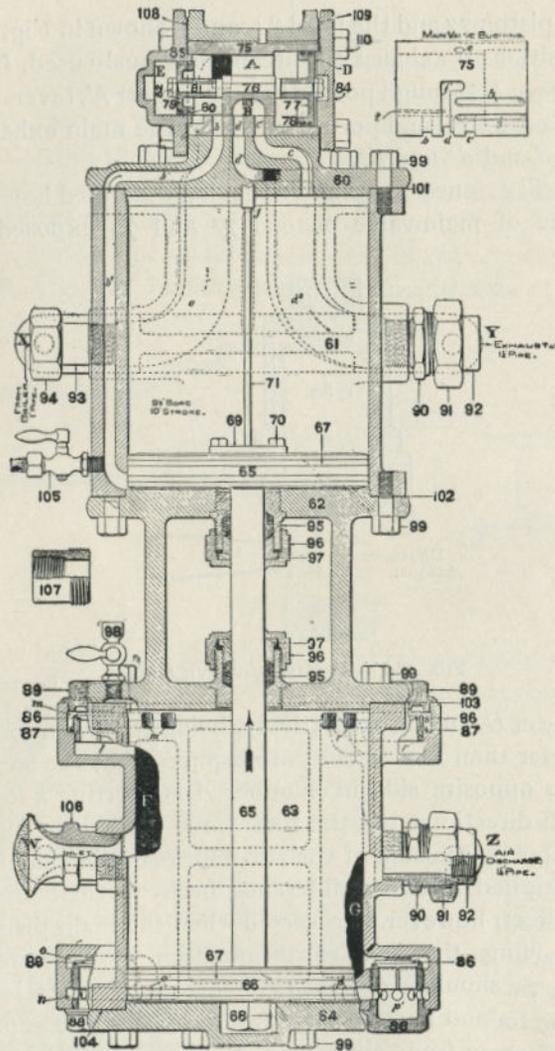


FIG. 168.

FIG. 167.

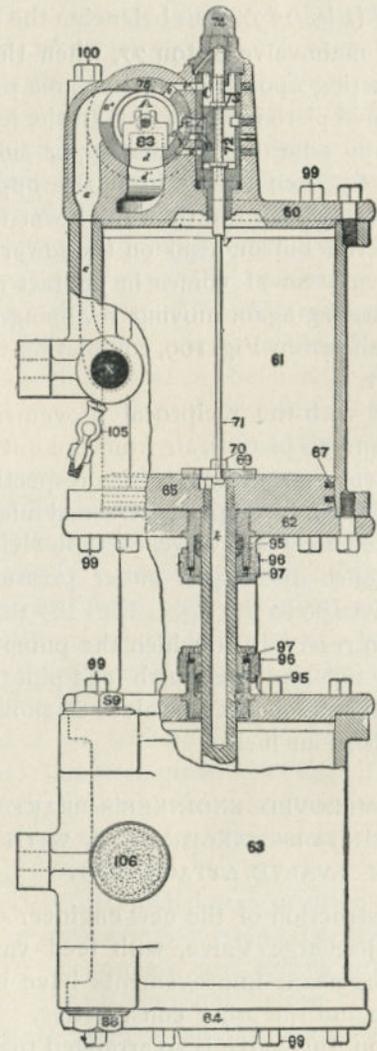


FIG 169.

ports g and g^1 (Fig. 169), thus balancing the pressure on both sides of main-valve piston 77, when the steam in chamber A , acting upon the effective area presented to it of main-valve piston 79, forces it to the left, and live steam is again admitted to the upper side of main steam-piston 65, exhausting from the opposite side, and forcing it downward until at the lower termination of its stroke the button-head on the lower end of the reversing-valve stem 71 comes in contact with reversing-valve plate 69, again moving reversing-valve 72 to the position shown in Fig. 169, completing the cycle of its movement.

Coincident with the reciprocal movements of the main steam and air pistons, air from the outside atmosphere is drawn alternately into the respective ends of the air-cylinder 63, through the screened inlet 106 at W , chamber F , and receiving-valves 86 to the left, Fig. 167, and from thence discharged under pressure through discharge-valves 86 to the right, Fig. 167 to chamber G and the main reservoir, to which the pump should be connected by one and one-fourth inch pipe at Z . The lift of receiving and discharge valves 86 should be three thirty-seconds of an inch.

THE IMPROVED ENGINEER'S BRAKE AND EQUALIZING-DISCHARGE VALVE, WITH FEED- VALVE ATTACHMENT.

In the construction of the new engineer's brake and Equalizing-discharge Valve, with feed-valve attachment, two important improvements have been made, one operative and the other constructive.

In operation, this valve is so arranged that when the

handle is in "running position" the pressure in the train-pipe is automatically cut off when it reaches 70 pounds, regardless of any higher pressure that may be in the main reservoir, and any loss in the train-pipe, due to leakage, is automatically supplied. The amount of excess pressure to be carried in the main reservoir for the purpose of recharging and releasing promptly is regulated by the pump-governor, which is adjusted to stop the pump when the maximum pressure has been reached therein. The construction of the previous engineer's brake and equalizing-discharge valve (Fig. 158) is such that when the handle is in "running position" the regulation of pressure in the train-pipe is dependent upon the operation of the pump-governor, and the amount of excess pressure in the main reservoir is controlled by what is called an excess-pressure valve, but which is more accurately described as a valve for creating a predetermined difference of pressure between the main reservoir and train-pipe. This valve is usually so adjusted that when a pressure in the main reservoir of 20 pounds in excess of that in the train-pipe is reached it will open and supply air to the train-pipe, but no communication between the main reservoir and the train-pipe exists until this difference in pressure is secured. It is therefore evident that when the handle of the engineer's valve is returned to "running position," after having been placed in full release position (in which latter position the pressure in the main reservoir and train-pipe equalizes), it is necessary to accumulate an excess pressure of 20 pounds in the main reservoir before air can pass the excess pressure-valve to supply any deficiency in the

train-pipe, due to leakage or the charging of auxiliary reservoirs.

From the above explanation it will be seen that the differences in operation between these two valves are:

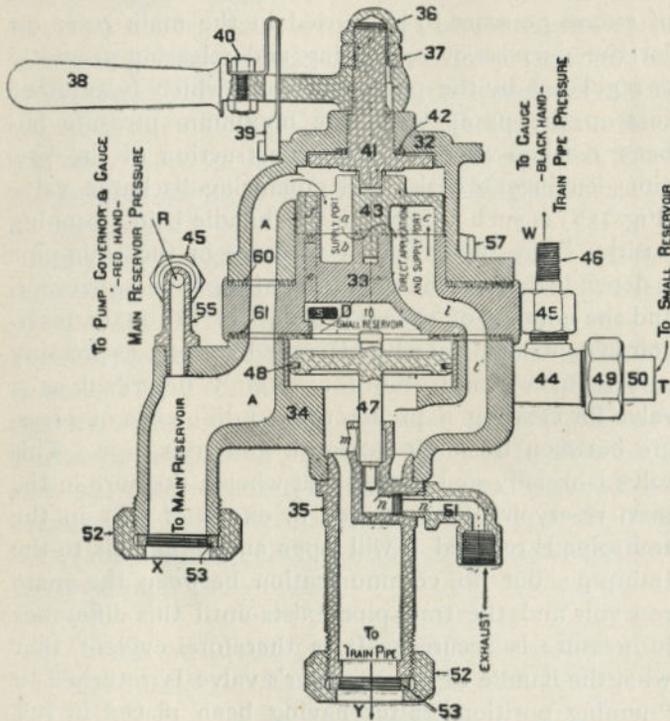


FIG. 170.

First. With the new valve air is automatically supplied to the train-pipe until 70 pounds pressure is reached, if there is a pressure of 70 pounds or greater in the main reservoir. Train-pipe pressure in the pre-

vious valve is regulated by the pump-governor. It therefore dispense with the pump-governor for the purpose of controlling train-pipe pressure with the new valve.

Second. With the new valve, when the handle is in "running position," provision is made for constantly supplying the train-pipe with air for any loss of press-

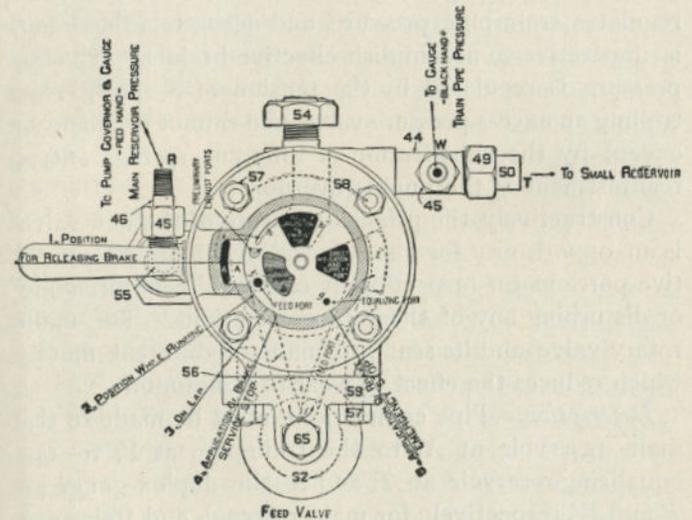


FIG. 171.

ure due to leakage at the pipe-joints, or from other sources. With the old valve it is necessary to have an excess pressure in the main reservoir of not less than 20 pounds before air can be supplied to the train-pipe for the purpose of compensating for leakages when the handle of the valve is in "running position."

Third. With the new valve, the only duty of the

pump-governor is to regulate the degree of excess pressure in the main reservoir, and as this may, and often should be, varied within considerable limits, the sensitive and delicate operation of the pump-governor is not essential. A desired variation of excess pressure is readily had by an adjustment of the tension-nut of the governor-spring. With the old valve the governor regulates train-pipe pressure, and accurate adjustment is imperative to accomplish effective braking. Excess pressure is regulated by the tension of a spring controlling an excess-pressure valve, and cannot be changed except by the substitution of different springs and a readjustment of the pump-governor.

Constructively, the principal feature of the new valve is an opportunity for the removal of all of the operative portions for inspection or repair, without breaking or disturbing any of the pipe connections. The main rotary valve and its seat are made of different metals which reduces the effect of wear to a minimum.

Description.—Pipe connections must be made to the main reservoir at *X*, to the train-pipe at *Y*, to the equalizing-reservoir at *T*, and to the duplex gauge at *R* and *W*, respectively for main reservoir and train-pipe pressures. The gauge-pipe from *R* should be extended to the air-pump governor, which latter device should be set to stop the pump at 85 to 100 pounds pressure, thus providing for an excess pressure of 15 to 30 pounds above standard train pipe pressure of 70 pounds per square inch. The amount of excess pressure required depends upon the length of trains and character of the road—whether level or with long and severe gradients. Ordinarily 15 to 20 pounds excess pressure

is ample for the safe operation of brakes on the ordinary railway.

While the handle is in position 1, "for releasing brakes,"* air from the main reservoir enters the brake-valve at *X*, passing through ports *A, A*, thence through port *a* in the rotary valve 43 to the port *b* in its seat 33, thence upward into cavity *c* of the rotary valve, and finally to ports *l* and *l'* and the train-pipe at *Y*. Port *j* in the rotary valve and *e* in its seat are in register in this position, and admit air to chamber *D* above equalizing-piston 47, and passing thence through ports *s* and *s*, charges the small equalizing-reservoir connected at *T*. The train-pipe and auxiliary reservoirs of the brake apparatus being charged, the handle 38 of the brake-valve being moved to 2, "position while running," ports *a* and *b*, and *j* and *e*, are no longer in communication, and air then reaches the train-pipe through port *j* in the rotary valve 43, and ports *f* and *f'* in its seat 33, passing thence through feed valve 63 to port *i*, ports *l* and *l'* to the train-pipe, and continues to flow thereto until the pressure in chamber *B* upon diagram 72 exceeds the resistance of spring 68, and, forcing the diaphragm and its attachments downward, feed-valve 63 closes until such time as by reason of any leaks in the train-pipe the pressure therein has been reduced below 70 pounds, when the valve 63 is again automatically pushed open by the diaphragm rising, replenishing train-pipe pressure. Equalizing-port *g* is now in communication with chamber *D*, maintaining train-pipe pressure therein, through ports *l', l*, and cavity *C* in the rotary-valve 43. The

* See Figs. 171 and 172.

necessary adjustment of spring 68 is readily accomplished by means of adjusting-nut 70, to which access is had by the removal of cap check-nut 71.

To apply the brakes the handle 38 of the valve is moved to position 4, "application of brake—service stop," bringing into conjunction port *p* (a groove in the under side of rotary valve 43) and ports *e* and *h* (the latter also a groove) in its seat, causing air to any desired extent to be discharged to the atmosphere from the chamber *D* above piston 47 and the equalizing-reservoir, through the large direct-application and exhaust port *h*, thus reducing the pressure above piston 47 and causing that in the train-pipe below to force it upward from its seat, permitting air to flow from the train-pipe through ports *m*, *n*, and *n'* to the atmosphere through exhaust-connection 51. The desired reduction of pressure in chamber *D* being made, the handle of the valve is moved backward to position 3, "on lap." It must be borne in mind that after the handle of the valve has been moved to lap position air will continue to flow from exhaust-fitting 51 until the pressure in the train-pipe has been reduced to an amount approximating that in chamber *D*. Ordinarily, a reduction of 6 to 8 pounds pressure by the gauge from chamber *D* is sufficient to apply the brakes in the first instance slightly, and will cause a corresponding reduction of train-pipe pressure by the rising of piston 47, which latter, when such reduction has taken place, is automatically forced to its seat by the preponderance of pressure on its upper surface from air remaining in chamber *D*.

The release of the brakes is effected by moving the

valve-handle 38 to "position for releasing brake," causing air from the main reservoir to again freely flow

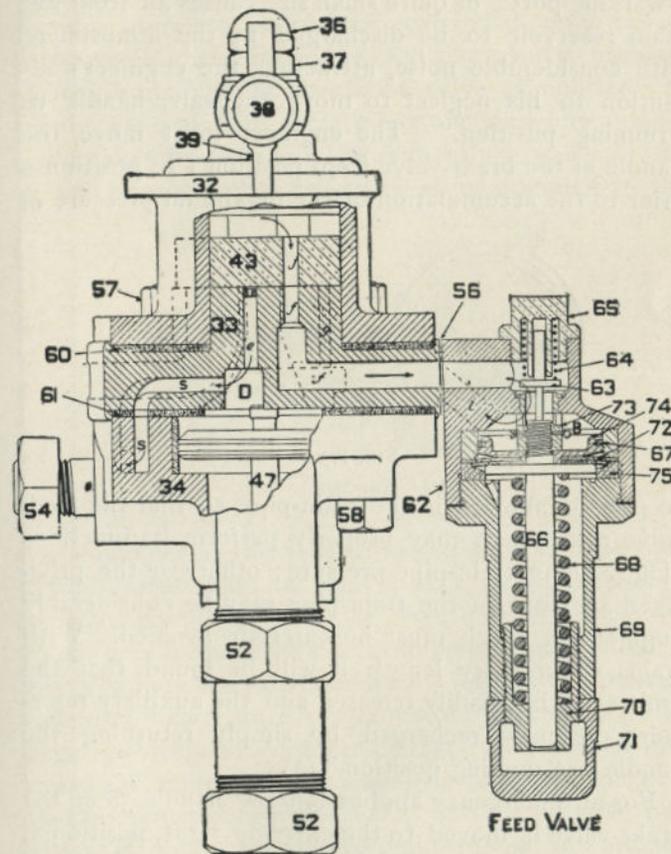


FIG. 172

to the train-pipe, forcing the triple-valve pistons to release position, and exhausting air used in applying

the brakes and recharging the auxiliary reservoirs. While the handle of the valve is in this position a "warning-port" of quite small size causes air from the main reservoir to be discharged to the atmosphere with considerable noise, attracting the engineer's attention to his neglect to move the valve-handle to "running position." The engineer must move the handle of the brake-valve from position 1 to position 2 prior to the accumulation of the maximum pressure of

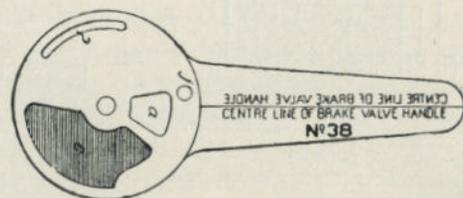


FIG. 173.

70 pounds allowed in the train-pipe, so that the feed-valve attachment may properly perform its functions of governing train-pipe pressure; otherwise the privileged pressure in the train-pipe may be considerably augmented, which must be carefully avoided. With trains of ordinary length it will be found that the brakes can be readily released and the auxiliary reservoirs promptly recharged by simply returning the handle to "running position" (2).

For an emergency application the handle 38 of the brake-valve is moved to the extreme right, position 5, "application of brake—emergency-stop," when "direct-application and exhaust port" *k* and "direct-application and supply port" *l* are brought into conjunction by means of a large cavity *c* in the under surface of the

rotary valve 43, thus admitting of the discharge from the train-pipe of a large volume of air to the atmosphere, causing the quick action of the brakes. Such action, however, should be employed only in an emergency. A reduction of 20 to 25 pounds pressure in the train-pipe at the brake-valve is sufficient to apply the brakes to their maximum, and any further reduction of pressure is consequently a waste of air. It will be noted that this valve is manipulated in the

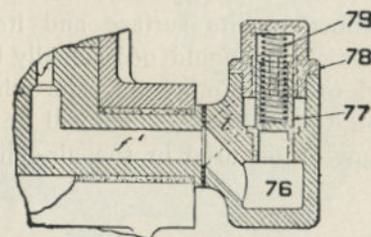


FIG. 174.

same manner as the preceding pattern, and that additional instructions in this respect to engineers are unnecessary.

An excess-pressure-valve arrangement, illustrated in Fig. 174, may be substituted for the feed-valve if desired, restoring that feature substantially as arranged in the Fig. 158 form of engineer's brake-valve, and in that event the pump-governor should be similarly connected to the train-pipe, and for which purpose suitable provision is made when new brake-valves are ordered accordingly.

By preparing a diagram of tracing-cloth or gelatine similar to Fig. 173, and placing it in a reversed position

on Fig. 171, where it may be rotated on a centre, the foregoing explanation may be followed with ease by those interested.

In erecting the valve on a locomotive it should be placed at a reasonable distance from the boiler, in order to prevent its gaskets drying out and shrinking, and care taken to make the pipe-joints absolutely tight. After it has been erected, and all of the connecting pipes have been carefully blown out, it is advised that rotary valve 43 be removed and a little tallow be rubbed on its surface and its seat, then replaced. The valve should occasionally be removed and cleansed of the gummy deposits which will be found thereon, the extent of which will be determined by the amount of oil used in the air-cylinder of the pump.

THE THREE-FOURTHS-INCH IMPROVED PUMP-GOVERNOR.

The improvements in the new Three-fourths-inch Pump-governor illustrated have been dictated largely by past experience, and it is believed the source of complaints in earlier constructions have been entirely eliminated.

Three notable changes have been made:

First. The adjusting-spring has been made more substantial and resilient, and consequently more sensitive to variations in pressure.

Second. The form of steam-valve has been modified to lessen the abrading effect of steam and the obstruction of its passage to the pump.

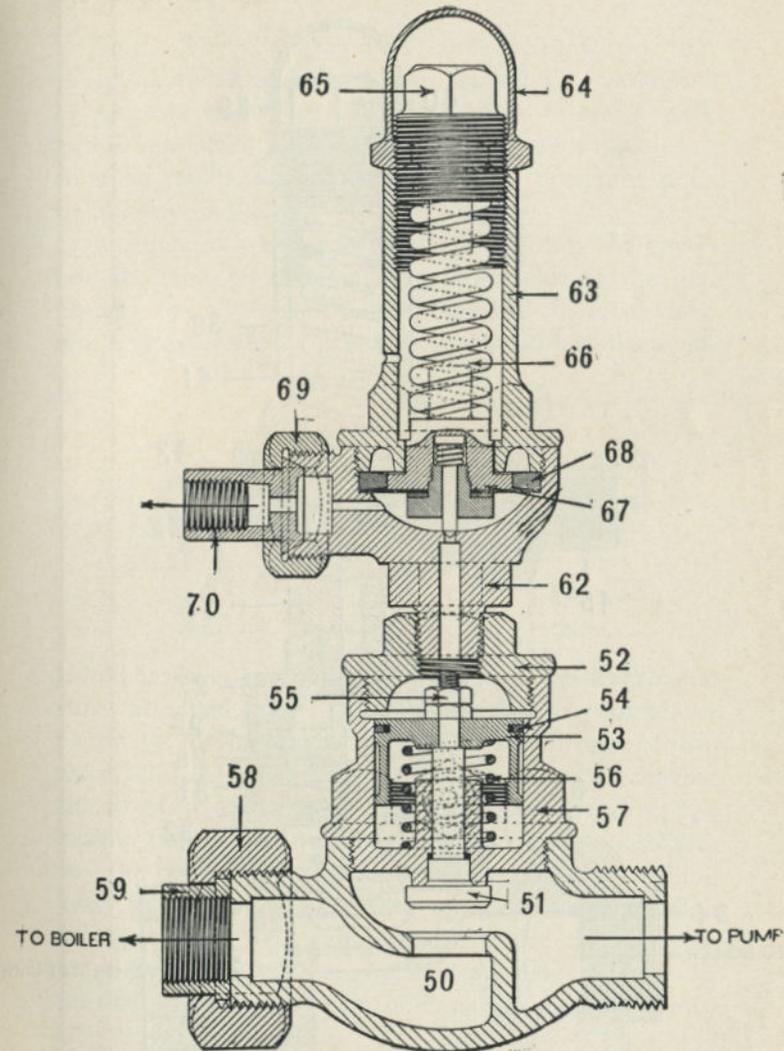


FIG. 175.

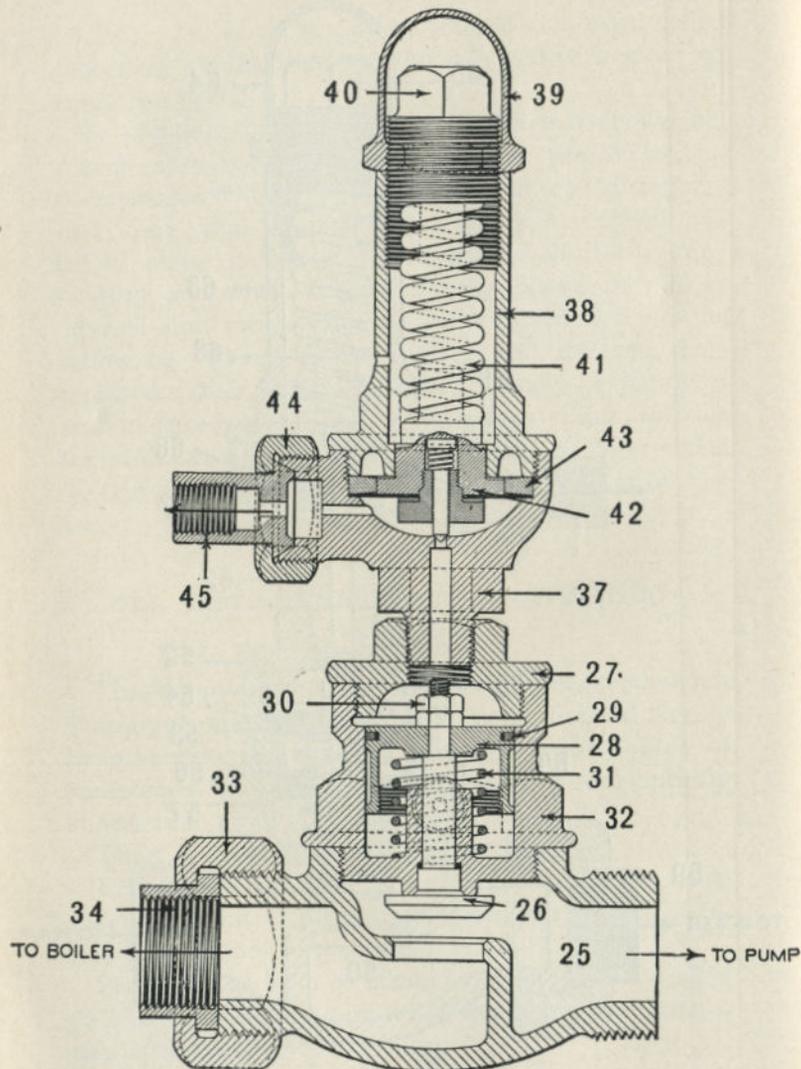


FIG. 176. *

* 1-INCH GOVERNOR.

Third. The diaphragm is composed of two thin sheets of metal, making it more sensitive to variations of pressure than with the single plate formerly used, and is supported by metallic walls in such a manner as to make its distortion under extreme pressures practically impossible.

Description.—Air under pressure entering the governor at fitting 70 acts upon the under side of the diaphragm 67 and forces the latter upward when the maximum pressure for which the governor has been ad-

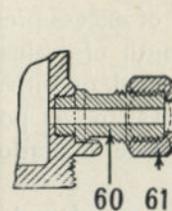


FIG. 177

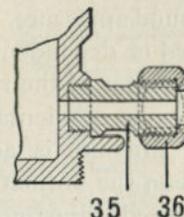


FIG. 178.

justed has been reached, lifting the small conical-shaped valve attached from its seat, and admitting air above piston 53, forcing the latter and its steam-valve downward, shutting off steam to the pump. By relieving the pressure under the diaphragm, in operating the brakes, the conical valve referred to is again seated, and the pressure in the space above piston 53 leaking away to the atmosphere past the piston and through fittings 60 and 61, steam-pressure under the valve 51, aided by spring 56, forces the steam-valve open to its normal position shown in the illustration, again admitting steam to the pump.

When the pump-governor is used in connection

with an engineer's brake-valve fitted with a feed-valve, the union swivel 70 must be connected by suitable pipe to the main reservoir, and likewise must be connected to the train-pipe when used in connection with an engineer's brake-valve having an excess-pressure valve in its construction. In either case suitable attachments are provided on the brake-valve.

If the governor is attached to the train-pipe, it should be adjusted to stop the pump at 70 pounds pressure per square inch; if coupled to the main reservoir, it should be adjusted to stop the pump at 85 to 100 pounds pressure, as the amount of excess pressure required is dependent upon the length of trains and the character of the road—whether level, or with long and heavy gradients. Ordinarily 15 to 20 pounds excess pressure is ample for the safe operation of brakes on the ordinary railway.

Required adjustments of the governor for desired pressures at which it will stop the pump are readily made by means of regulating-nut 65, to which access is had by the removal of cap-nut 64.

HIGH-SPEED BRAKE.

This brake is due to the fact that train-speeds are increasing, and also the weights. It is evident that if the brake were adjusted to brake a train making 70 miles an hour, and that pressure were retained when the speed was reduced to 50 miles or less, the wheels would become locked and slide on the rail and be flattened. It is to overcome this objectionable feature that the brake was put on the market, and was thoroughly tested on the Empire Express on the New York Central and Hudson River Railroad. The idea is to have

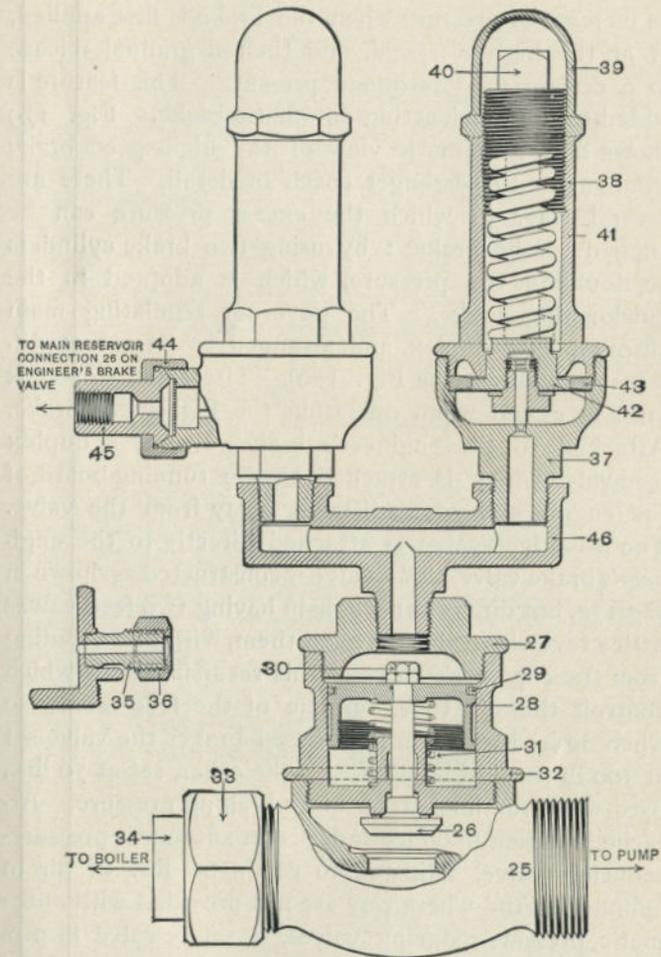


FIG. 180.—DUPLEX GOVERNOR.

an increase of pressure when the brake is first applied, or at the highest speed, and then a gradual release to a certain predetermined pressure. This feature is added to the quick-acting automatic brake. Fig. 179 shows a diagrammatic view of the high-speed brake from engine to passenger coach in detail. There are several ways in which the excess pressure can be applied to the brakes: by using two brake cylinders or doubling the pressure, which is adopted in the quick-acting brake. The governor regulating main air-pump is a duplex, and arranged to be set at different pressures (see Fig. 180). The small stop-cock must be closed when operating the high-speed brake. Attached to the engineer's brake-valve is a duplex feed-valve which is attached to the running-board of the engine and some distance away from the valve. The usual feed-valve is attached directly to the engineer's brake-valve. This valve is constructed as shown in Fig. 172, but differs as a whole in having two feed-valves with a reversing-valve between them, with pipes leading from the engineer's valve to this reversing-valve which controls the air to either one of the feed-valves, so when desired to use in high-speed brakes the valve set at 100 lbs. would be used, and the other, set at 70 lbs., used when running at ordinary braking pressure. Attached to each brake-cylinder is an automatic pressure-reducing valve, adjusted to retain 60 lbs. of air in cylinder. And where cars are not provided with automatic pressure-reducing valves, a safety-valve is provided as shown in Fig. 179. The valve-body is bushed and contains a piston-valve to which is attached a stem on each side of the piston. The upper stem has two

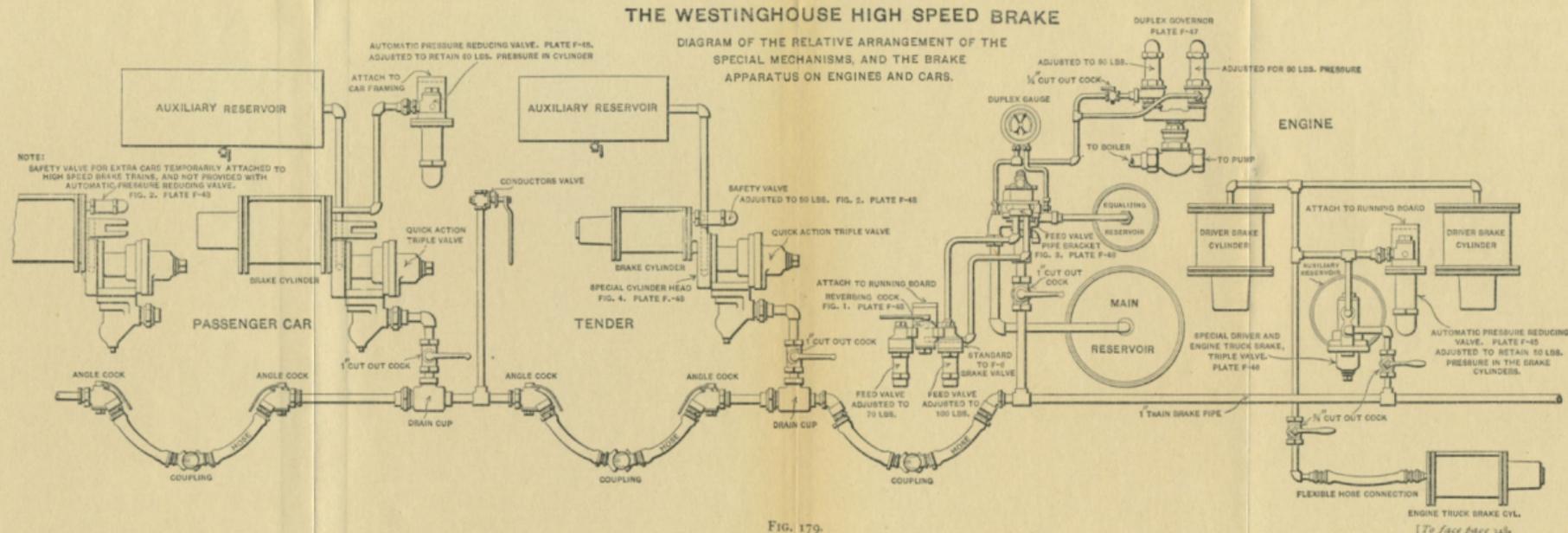
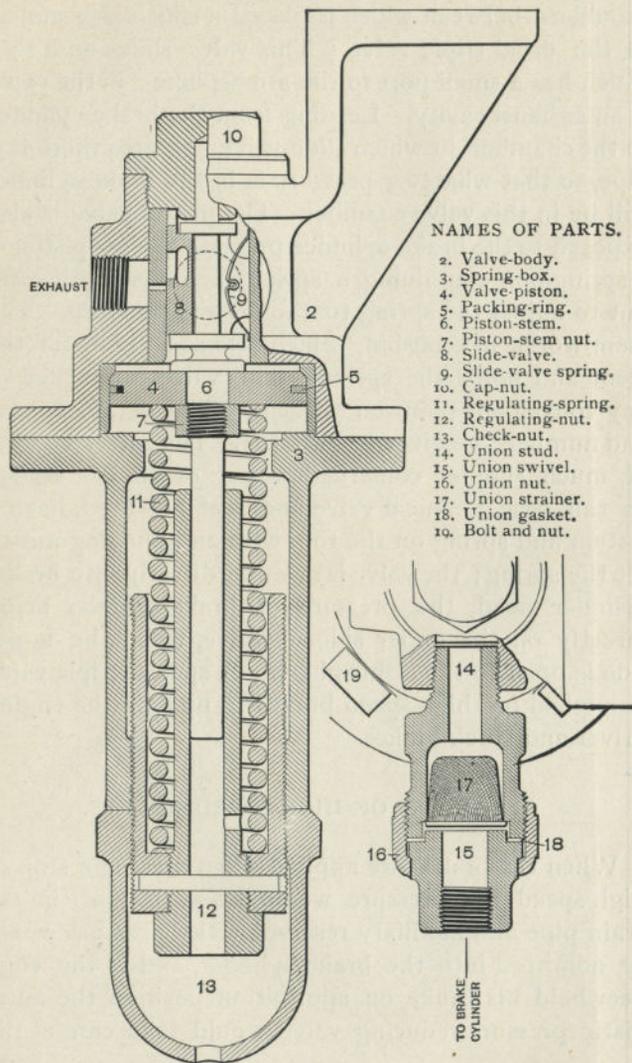


Fig. 179.

shoulders, between which is placed a slide-valve similar to the usual triple valve. This valve slides on a seat which has a small port to the atmosphere; in the valve is an exhaust cavity. Leading from the brake-cylinder to the chamber in which slide-valve operates there is a pipe, so that whatever pressure is in the brake-cylinder will be in this valve-chamber. The piston-valve is also exposed to the brake-cylinder pressure. Below piston is a spring-box containing a spring having an adjusting nut to adjust the spring to the desired pressure. The stem works in a bushing which acts as a guide for the stem and holds the spring. This valve is attached to any convenient point on the car. The detail, names, and numbers are given in Fig. 181. The safety-valve is of much simpler construction but of similar action. In this case a conical valve and seat are used, having a stem and spring on the top, with an adjusting nut to set the spring; the valve is screwed directly into brake-cylinder head, the pressure of brake-cylinder being directly on the under side of valve, while the upper side is open to the atmosphere. A special triple valve is applied for high-speed brakes to operate the engine driver and truck brakes.

OPERATION OF HIGH-SPEED BRAKES.

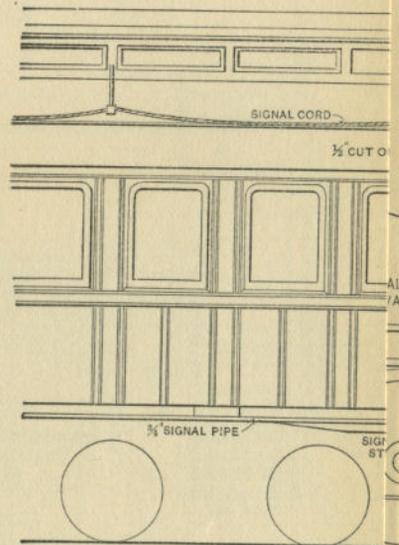
When the brakes are applied when making a stop of high speed the pressure would be at 100 lbs. in the train pipe and auxiliary reservoir; this pressure would be admitted into the brake-cylinder, and if the engineer held his brake on application position the automatic pressure-reducing valve would take care of the



NAMES OF PARTS.

- 2. Valve-body.
- 3. Spring-box.
- 4. Valve-piston.
- 5. Packing-ring.
- 6. Piston-stem.
- 7. Piston-stem nut.
- 8. Slide-valve.
- 9. Slide-valve spring.
- 10. Cap-nut.
- 11. Regulating-spring.
- 12. Regulating-nut.
- 13. Check-nut.
- 14. Union stud.
- 15. Union swivel.
- 16. Union nut.
- 17. Union strainer.
- 18. Union gasket.
- 19. Bolt and nut.

FIG. 181.—AUTOMATIC PRESSURE REDUCING-VALVE.



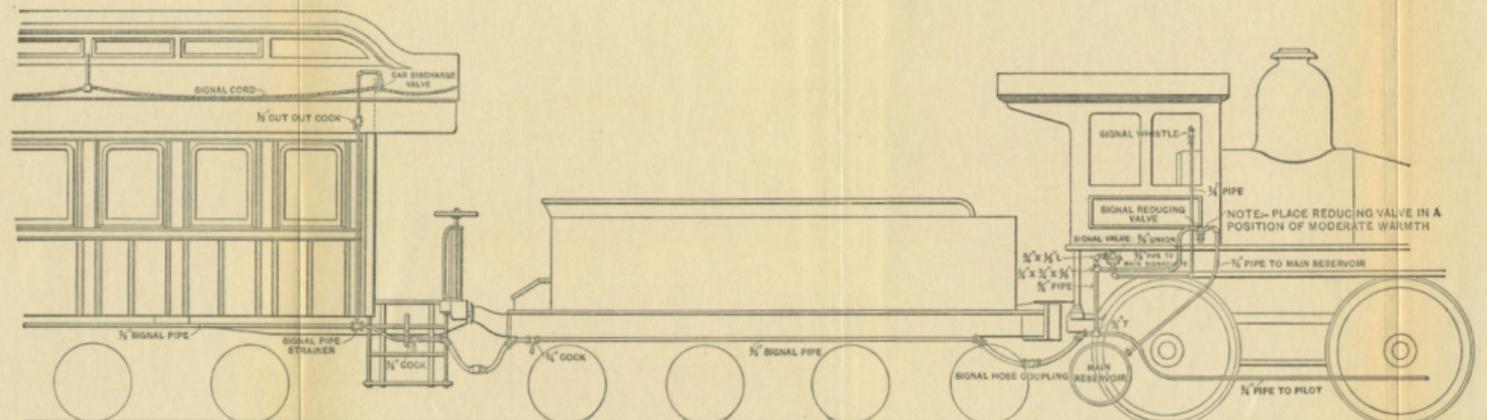
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pressure in the brake-cylinder and prevent the excessive pressure from locking the wheels as the speed was reduced in this manner.

As shown, the reducing-valve is set to retain 50 lbs. of air in the brake-cylinder, so that when the high pressure is admitted to the brake-cylinder it will act on the piston-valve of the pressure-reducing valve and force it down so the exhaust port in the slide-valve comes over the exhaust port. This will allow a reduction of pressure in the brake-cylinder until the spring closes the exhaust port at 50 lbs., and retains that pressure until the engineer releases his brake; so it gives a high-speed braking pressure momentarily with a gradual reduction. The safety-valve acts on the same principle. The exhaust opening from pressure-reducing valve is very small, thus allowing a gradual reduction of pressure instead of a rapid one, a feature incorporated in a patent allowed the author on an automatic pressure-retaining and reinforced brake-valve.

TRAIN-SIGNALLING APPARATUS. (Fig. 182).

Improvements over the older style of train air signalling apparatus have taken place so as to warrant a description necessary to keep abreast with the improvements. The system consists of a reducing-valve, a signal-valve train line of pipe and hose connections, with a car discharge-valve in each car for the conductor to use, a cord being attached for that purpose in the car. This system does away with the cord connection between each car, and also the defects due to that feature well known to those who have forgotten to disconnect and given the signal to go ahead. Wet



NOTE.—THE ABOVE DIAGRAM IS SIMPLY ILLUSTRATIVE OF THE METHOD OF ARRANGING THE COMPRESSED AIR TRAIN SIGNALING APPLIANCES, AND MAY BE MODIFIED AS THE CONSTRUCTION OF THE ENGINE DEMANDS.

FIG. 182.—TRAIN-SIGNAL SYSTEM.

[To face page 354.]

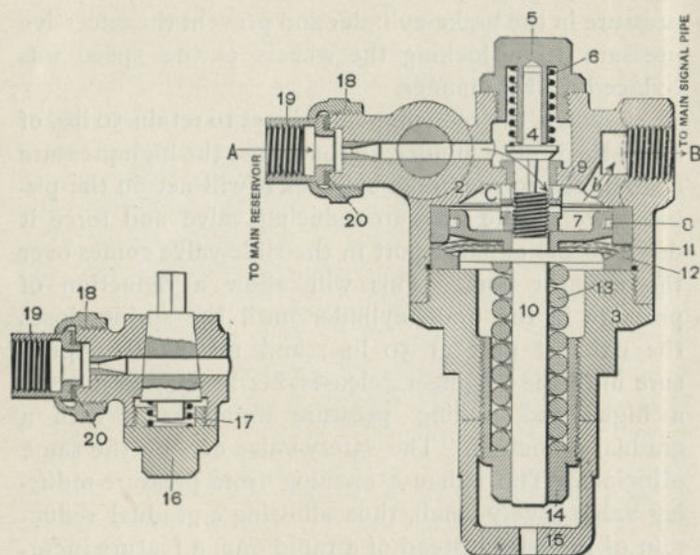


FIG. 183.—REDUCING-VALVE.

NAMES OF PARTS.

- | | |
|-----------------------------|------------------------|
| 2. Reducing-valve body. | 12. Diaphragm-ring. |
| 3. Lower cap. | 13. Regulating-spring. |
| 4. Supply-valve. | 14. Regulating-nut. |
| 5. Supply-valve cap-nut. | 15. Check-nut. |
| 6. Supply-valve spring. | 16. Cock cap-nut. |
| 7. Reducing-valve piston. | 17. Cock-spring. |
| 8. Piston packing-ring. | 18. Union nut. |
| 9. Piston-nut. | 19. Union swivel. |
| 10. Piston-rod. | 20. Gasket. |
| 11. Diaphragm (two pieces). | |

weather and uncertain signals also make the bell-rope a nuisance.

The reducing-valve is somewhat different from those first brought out. (See Fig. 181.) The reducing-valve body contains a bushing of brass in which moves a piston-valve. This valve is made perfectly air-tight by a packing-ring; attached to it are a stem and a shoulder. The stem or piston-rod is enclosed in the lower cap and surrounded by a coil spring which abuts against the lower side of the shoulder on the piston-rod, exerting an upward pressure. The piston-valve is screwed to the piston-rod. In the upper part of the valve-body is a wing-valve having a seat which divides the body into two chambers. This valve has a stem which is surrounded by a coil spring and works in a cap-nut guide. Leading from the upper chamber is a passage having a stop-cock; this portion of the valve is attached to the pipe leading to the main reservoir on the engine. Between the piston-valve and the shoulder on piston-rod is a diaphragm composed of two pieces. Leading from the chamber above the piston-valve is a port which opens to a pipe connection leading to the main signal-pipe and train.

When the pressure in main signal-pipe becomes less than 40 lbs., the spring under the piston-valve forces the piston-valve and rod up, which raises the supply-valve off its seat and allows air to come into main signal-pipe through the ports, as indicated by the arrows; then when the pressure becomes 40 lbs. the piston-valve will be forced down, leaving the supply-valve seated, thus cutting off the supply of air from main reservoir, and keeping it at the predetermined

pressure, the small spring on top of the supply-valve helping this valve to act.

The stop-cock is used to cut off the valve for repairs, etc.

SIGNAL-VALVE. (Fig. 184.)

Attached to the main signal-pipe is a signal-valve which is also carried on the engine, generally under the

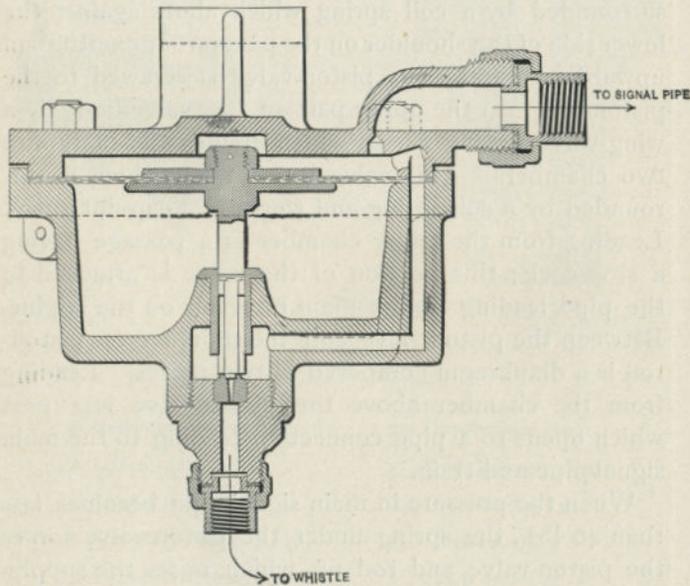


FIG. 184.—SIGNAL-VALVE.

foot-board. This valve-body is divided into compartments or chambers by a diaphragm, a port leading around from one side of the diaphragm to the other. There is also a small port leading from the upper side of diaphragm to the pipe connection to main signal-

pipe. Attached to the diaphragm is a stem which abuts against a valve having a seat in the lower part of the valve-body. The port around diaphragm leads into this seat-chamber. This valve opens into the whistle-pipe. The air that enters the signal-valve can equalize on both sides of this diaphragm. This signal-valve differs somewhat from the old valve, and there is no storage reservoir attached.

CONDUCTOR'S CAR-VALVE. (Fig. 185.)

This valve is placed in each car or at the end; it has a stem on each side working in guides; the under side has a spring which holds the valve against the seat; the upper stem projects through and is adjacent a lever having two pins or fulcrums which engage the hooks or curved arms of the valve-lever. The cord is attached to this lever, and no matter on which side the lever is pulled the valve will open. This valve is attached to the main signal-pipe.

OPERATION OF SIGNAL SYSTEM.

When the conductor's valve is opened it permits some air to escape from the main signal-pipe and above the diaphragm of the signal-valve on the engine; the air which was in the chamber under the diaphragm forces the diaphragm up, which unseats the valve leading to the whistle on the engine, thus allowing air from the signal-pipe to blow the whistle as many times as the conductor's valve is opened. This should not be done too quickly after each signal to make it distinct, as the signals become one long whistle if done too quickly.

NAMES OF PARTS OF CAR DISCHARGE-VALVE.

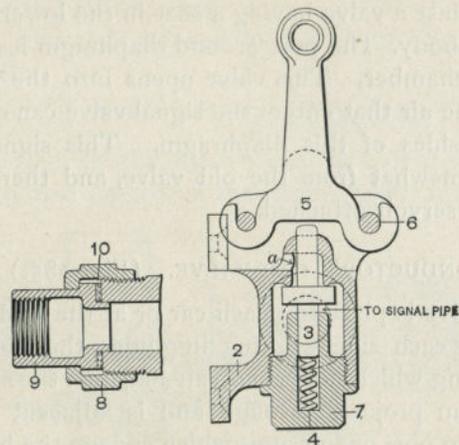


FIG. 185.—CONDUCTOR'S VALVE.

- | | |
|----------------------------|-------------------|
| 2. Discharge-valve body. | 7. Cap-nut. |
| 3. Discharge-valve stem. | 8. Union nut. |
| 4. Discharge-valve spring. | 9. Union swivel. |
| 5. Discharge-valve handle. | 10. Union gasket. |
| 6. Stop-pin. | |

THE MASON AIR-BRAKE PUMP-REGULATOR.

This regulator is designed to automatically control the air-pressure in the brake system for operating the brakes on railroad cars. It is placed in the steam-supply pipe leading to the air-pump, and regulates the amount of steam passing to pump, and allowing the pump to run just sufficiently to maintain the desired air-pressure in the train service-pipe.

*Description.**—The principle on which the Mason Air-

* Figs. 186 and 187.

brake Regulator works is that of an auxiliary-valve 8, controlled by the air-pressure from the train service-pipe, through the medium of a metal diaphragm 24, and admits steam from the initial side of regulators through a port to operate a piston 19, which in turn opens the

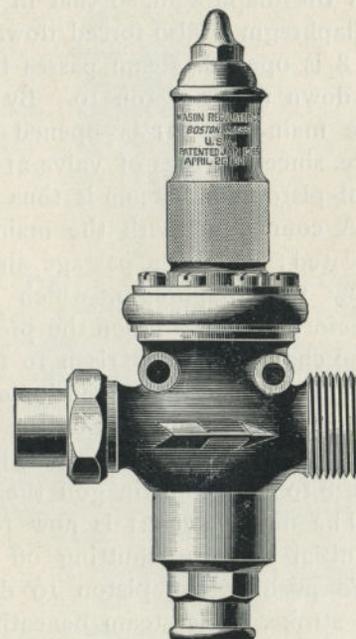


FIG. 186.—GENERAL VIEW OF MASON PUMP-REGULATOR.

main-valve 21, and admits steam to the pump. By referring to the sectional view, it will be seen that the steam enters the regulator at the side marked "steam from boiler," a small portion of it passing up through the passage *XX* to the auxiliary-valve 8. This valve

8 is forced open by the compression of the large spiral spring 5 acting on the cricket through the diaphragm. This cricket 6 has three studs projecting down from the rim, which pass through three loosely fitting holes in the bonnet, the lower ends resting on a button 11 which sits on the diaphragm, so that in opening the valve 8 the diaphragm is also forced down. As soon as the valve 8 is opened, steam passes through and into port Z, down under piston 19. By raising this piston 19 the main-valve 21 is opened against the initial pressure, since the area of valve 21 is only one half of that of piston 19. Steam is thus admitted to the pump. A connection with the main air-pipe is made as indicated; and by a passage air enters the chamber below the diaphragm, which carries the cricket 8, as before stated. When the pressure in the air-pipe 16 and chamber O has risen to the required point, which is determined by the tension of the spring 5, the diaphragm is forced upward by the air-pressure in the chamber, carrying with it the cricket 6, and allowing valve 8 to close, shutting off the steam from piston 19. The main-valve 21 is now forced to its seat by the initial pressure, shutting off steam from the pump and pushing the piston 19 down to the bottom of its stroke. The steam beneath this piston exhausts freely around it—the piston being fitted loosely for this purpose—and passes off into the pump. The leakage past the auxiliary-valve 8 passes up under the cricket and out into the spring-case, where it makes its escape down through the cricket-holes to the upper side of the diaphragm and into the drip. It will be seen from this that when the pressure in the

brake-pipe has reached a predetermined point the pump will be automatically stopped; and when the

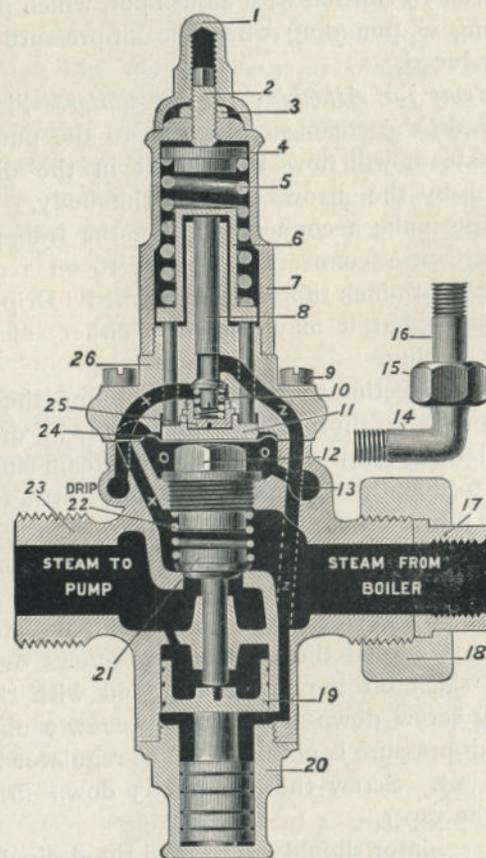


FIG. 187.

pressure in the brake-pipe is reduced by applying the brakes the pump will quickly produce a surplus press-

ure in the main reservoir to insure the speedy release of the brakes and recharge the auxiliary reservoirs. The piston 19 is fitted with a dash-pot, which prevents chattering or pounding when the air-pressure is suddenly reduced.

Directions for Attaching the Regulator.—Place the regulator in the steam-supply pipe to the pump, and so that steam will flow through it in the direction indicated by the arrow cast on the body. With a small pipe make a connection from the train-pipe to the air-pressure connection 15 and 16 on regulator. The one-eighth-inch tapped hole marked "Drip" must be left open, but it may drip from either side by reversing the plug.

Before connecting the regulator to pump, the steam-pipe should be thoroughly blown out, in order to expel all dirt. If the piping is new, steam should be allowed to flow through slowly for some little time, in order to burn off all gummy oil and grease, which would otherwise be carried into the regulator, and thus clog the working parts.

When ready to start, open both steam and air valve wide, then remove the cap 1 which screws over the screw 2, slack off the jam-nut 3, and with the key gradually screw down the adjusting screw 2 until the desired air-pressure is obtained. The regulator is then properly set. Screw the jam-nut 3 down firm and replace the cap 1.

If the regulator should fail to hold the desired pressure, it will probably be due to the fact that some dirt or chips from the pipe have lodged on the seat of the main-valve 21, or possibly under the auxiliary-valve 8.

To open the regulator proceed as follows: Shut off both steam and air pressure from the regulator. Remove the cap 1, and with the key unscrew the adjusting-screw 2 until all tension is removed from spring 5. Then take out the screws 9, and remove bonnet 7, diaphragm 14, and button 11. Take out the plug 12 and the spring 22. The threaded rod which accompanies each regulator can then be screwed into valve 21, which should work easily. Pull out this valve and examine both valve and seat, cleaning them thoroughly. Then insert the rod through the valve-stem guide, screw it into the piston 19, and see if it works up and down easily. It will not be found possible to raise it suddenly, as the dash-pot piston 20 will restrain it. After pulling up, let go of the rod suddenly, and if the piston drops easily it is all right. In case it does not, unscrew the dash-pot cap 20 from bottom of the regulator, pull out the piston 19, and clean it with kerosene or spirits. If it seems somewhat tight, rub it with fine emery-cloth, being very careful to thoroughly wipe it off before replacing. Before screwing on the bonnet, examine the auxiliary-valve 8. To do this, remove the slot-headed plug 25 in bottom of bonnet, also the small spring 10. The valve 8 can then be taken out and examined. This valve should work perfectly free. In taking out the plug 25 there may be a burr, caused by the screw-driver, which should be dressed down before replacing, as this plug forms a guide to centralize the diaphragm button 11, which should fit over it freely. In replacing the bonnet 7, be sure that the zero-marks on the side and those on the body correspond; also see that the diaphragm 24 is

replaced so that the port-holes in it correspond with the holes in the body. Carefully clean the diaphragm as well as the place where it makes its seat. Do not use washers or gaskets of rubber, or any other compound, in making connections. They will burn, and the pieces will get into the regulator. Two copper gaskets are sent with each regulator for making the steam connections.

THE NEW YORK AIR-BRAKE SYSTEM.

The New York Air-brake is perfectly interchangeable with the Westinghouse equipment, and cars equipped with either brake can be indiscriminately mixed in a train and handled with equal facility by the engine equipment of either system; or a New York air-pump, triple-valve, etc., can be used in connection with the Westinghouse apparatus, and *vice versa*. This perfect interchangeability permits any railroad company to adopt the New York Air-brake apparatus either wholly or in part without interfering in any way with its method of operating, and thus the greater efficiency and durability of the New York apparatus can be readily secured without incurring the annoyances which would ensue if the brake were not interchangeable with the Westinghouse system now in general use.

The New York Quick-action Air-brake consists of the following principal parts:

1. The *Duplex Pump*, which compresses the air. The duplex action is extremely easy working, and gives much greater efficiency than the ordinary single-acting

pump, while the construction is very simple, and every valve can be readily examined by unscrewing a plug. The advantages of such simple construction, both in convenience and durability, are evident. Another advantage is that the steam-cylinders are at the bottom, and therefore the drainage is perfectly natural, while the air-cylinders are above the steam-cylinders, thus insuring clean and dry air, as impurities and the condensation from steam-cylinders cannot leak into the air-chambers.

2. The *Main Reservoir*, in which the compressed air is stored on the engine, and in which a greater pressure is maintained than in the other reservoirs or train-pipe to assist in releasing the brakes promptly.

3. The *Engineer's Equalizing-discharge Brake-valve*, which regulates the flow of air into the train-pipe and auxiliary reservoirs to charge the train and release brakes, and from the train-pipe to the atmosphere for applying brakes. The New York Engineer's Valve is less complicated, and its operation easier to understand than the valves heretofore used, and is so constructed that the use of a separate "equalizing-reservoir" is entirely avoided.

4. The *Train-pipe*, which leads from the main reservoir to the engineer's-valve, and thence throughout the train, supplying air to the apparatus on each car. Variations of the pressure maintained in the train-pipe causes the apparatus on each car to operate so as to apply or release the brakes.

5. The *Auxiliary Reservoir*, which receives air-pressure from the train-pipe, and stores it for use on each car

or engine, the air being allowed to pass into the brake-cylinder when an application of the brakes is desired.

The brake-cylinder, which forces the shoes against the wheels when air-pressure from the auxiliary reservoir is admitted against the piston, the end of the piston-rod being suitably connected to the brake-levers. Around the piston-rod, inside of the brake-cylinder, is a large spring, which is compressed by the action of the piston when applying brakes, and which expands when the brakes are released, thus causing the piston to recede to its former position and draw the shoes away from the wheels.

7. The *Quick-action Automatic Triple-valve*, which is connected to the train-pipe, auxiliary reservoir, and brake-cylinder, and is so constructed that variations of pressure in the train-pipe will operate it, causing a moderate application of the brakes or an instantaneous and forcible application, as desired. The operation is as follows: When the train-pipe pressure is reduced five pounds or more the auxiliary reservoir is cut off from the train-pipe, and air-pressure is admitted from auxiliary reservoir into the brake-cylinder proportionately to the reduction of train-pipe pressure. A sharp reduction of the train-pipe pressure of fifteen or twenty pounds produces the same effect, and also admits air direct from the train-pipe into the brake-cylinder, thus applying the brakes instantly, and with about 20 per cent greater force than when the train-pipe pressure is not utilized in this manner. The quick reduction of train-pipe pressure at each car by this means rapidly operates the valves on succeeding cars, so that the

action of all brakes in the train is practically instantaneous.

The following are also parts of the brake equipment:

The Plain Triple-valve, which is used only on engine and tender. It is of the same construction as the quick-action valve previously described, except that the emergency or quick-action parts are omitted, leaving only the service mechanism.

As the valves on locomotive and tender are always the first to receive pressure, and it is not desirable to have the locomotive and tender brakes operate before those on the train, the plain triple-valves are always used here, as they answer the requirements perfectly.

The Pump-governor, which regulates the amount of steam supplied to the pump, and shuts off steam when the maximum air-pressure has been accumulated in the train-pipe and reservoirs.

The Duplex Air-gauge, which shows simultaneously the pressure in the main reservoir and in the train-pipe.

The Conductor's Valve, which is placed in passenger cars and connected with a cord running the entire length of the car, so that any of the trainmen, by pulling this cord, can open the valve, which allows the air to escape from the train-pipe and apply the brakes. It is intended for use only when it is desirable or necessary to stop the train without depending upon or waiting for the engineer to do so.

The Couplings, which are attached to rubber hose, and connect the train-pipe from one car to another.

The Pressure-retaining Valve, which is used upon

freight cars for retaining about fifteen pounds pressure in the brake-cylinders while descending heavy grades. It is a weighted valve of such size that fifteen pounds pressure is required to raise it, and is connected by suitable piping to the exhaust-port of triple-valve. It is provided with a small cock, and when handle is placed in horizontal position the air issuing from exhaust-port of triple-valve when brakes are released has to lift the weight before escaping to the atmosphere, and as this does not affect the working of the triple-valve, the brakes will remain on and check the speed of train while the auxiliary reservoirs are recharging. With handle turned down the brakes release as usual, the escaping air having a free passage to the atmosphere without passing the weighted valve.

DUPLEX AIR-PUMP.

Fig. 188 shows the No. 1 duplex air-pump, which is adapted for passenger and light freight locomotives. The duplex action is extremely easy, and gives much greater efficiency than the ordinary single-acting pump.* The steam-cylinders are underneath the air-cylinders, which allows natural drainage and insures clean, dry air, as impurities and the condensation from steam-cylinders cannot leak into the air-chambers. The action of the pump in compressing air is similar to that of using steam in a compound engine, and results in a corresponding economy; both steam-cylinders and the high-pressure air-cylinder are 5" in diameter. The low-pressure air-cylinder is 7", and is twice the capacity of the steam-cylinder that actuates it. In

* Manufacturer's claim.

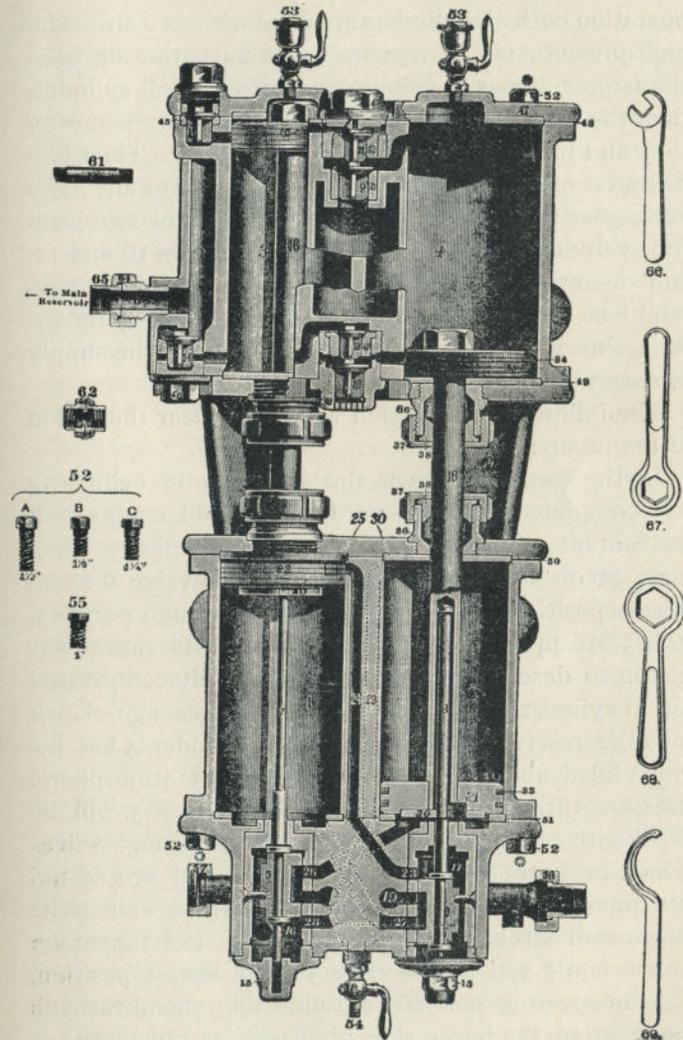


FIG. 188.

operation both air-cylinders are filled with free air. The high-pressure piston remains quiet until the air from the large cylinder is compressed into a small cylinder, then the high-pressure piston completes the compression and forces the air into the reservoir. Thus two measures of steam compress three measures of air. The valve-gear for the steam-cylinder consists of two plain slide-valves 5 and 6, moving in steam-chests 16 and 17, and operated by small tappet-rods 7 and 8, which extend into the hollow piston-rods of the steam-cylinders. As is shown, the valve on one side controls the supply of steam on the opposite side.

The following description will make clear the action of the pump:

In the position shown, the air-piston in cylinder 4 has completed its downward stroke, and compressed its contents through valve 12 into cylinder 3. The plate 20 on steam-piston 21 has moved valve 6 to its lowest position. This admits steam through ports 23, 24, 25 to upper side of piston 22, and will cause that piston to descend and expel the partially compressed air in cylinder 3 through valve 14 and passage shown into the reservoir. Meanwhile the cylinder 4 has become filled above the piston with air at atmospheric pressure through valve 9, and the cylinder 3 will be filled with air at atmospheric pressure through valves 9 and 11, both of which open inward and are seated by gravity. When piston 22 reaches the end of its downward stroke the plate 20 strikes the tappet on valve-stem 7 and moves valve 5 to its lowest position, thus uncovering port 26 and admitting steam through port 26 to the lower side of piston 21, thus causing

piston 21 to rise and compress the air which is in cylinder 4, through valve 11 into upper part of cylinder 3. Just as piston 21 completes its stroke, its plate 20 strikes the tappet on valve-stem 8 and moves valve 6 to its highest position, uncovering port 27 and admitting steam through port 27 to the lower side of piston 22, causing that piston to rise and expel the partially compressed air in cylinder 3, through valve 13 into passage shown, and thence into the reservoir.

While the pistons are compressing the air above them into the reservoir, the air-cylinders below the pistons will be filled with air at atmospheric pressure through valves 10 and 12 ready for another cycle of operation. The duplex construction makes it possible for the valve-gear to be extremely simple. The air-valves are simple poppet-valves, which seat by gravity while the pistons wait, and therefore are not liable to pound themselves to pieces. All parts of the pump are durable and easily accessible. Steam and air valves may be examined by unscrewing plugs without taking down the pump.

PUMP-GOVERNOR.

Fig. 189 shows the construction of the pump-governor. Its purpose is to automatically shut off the supply of steam to the pump when the air-pressure in the train-pipe and auxiliary reservoirs has reached the desired limit. The brake-gear used on cars and engines is designed for a maximum air-pressure of 70 pounds in train-pipe. This limit should not be exceeded.

Referring to the illustration, the steam-valve 5 is

opened by steam-pressure, but is closed by air-pressure on top of piston 4 when the train-pipe pressure has

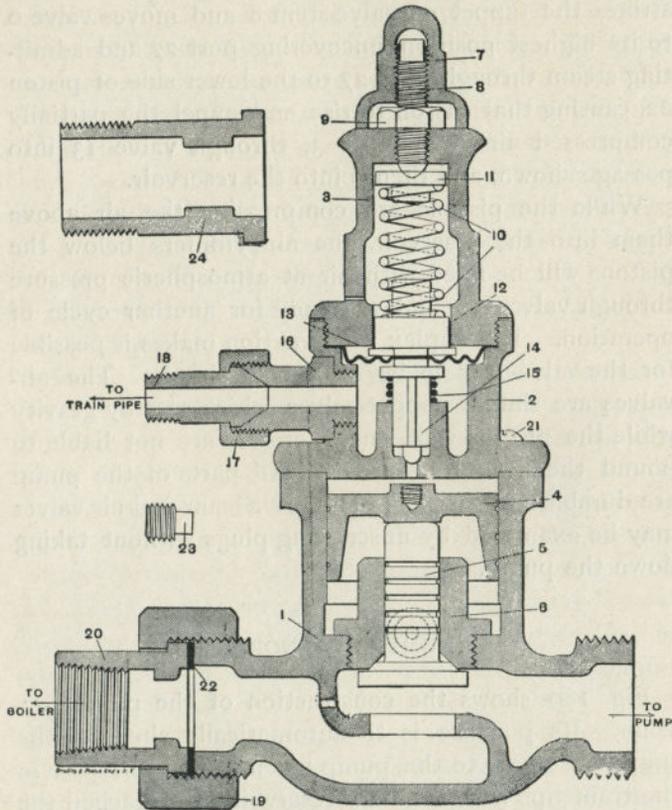


FIG. 189.

reached the limit for which the governor is adjusted. The action of the train-pipe pressure is controlled by

diaphragm 13 and spring 10. When the train-pipe pressure underneath the diaphragm overcomes the tension of spring 10, the diaphragm will rise and allow valve 14 to open the train-pipe pressure to the top of piston 4. When the train-pipe pressure becomes less than the desired limit the spring 10 will close the valve 14. The air above piston 4 will then leak by the piston and allow the steam-pressure to open the steam-valve 5. An opening is provided in the chamber under piston 4, for any leakage of steam or air. Any necessary adjustment of the regulating spring 10 may be made by means of screw 8 and lock-nut 9. In order that steam may keep the exhaust from freezing, a small hole above the steam-valve is always open.

Instructions.—Place the pump-governor in the steam-supply pipe leading to the pump, so that steam will flow through it in the direction indicated by the arrow. The end of the governor which goes toward the pump is made to fit the union connection furnished with the pump, and as a rule it is best to attach the governor here. Do not use rubber gaskets in making connections. Connect the quarter-inch union in the upper part of the governor with the train-pipe. After piping up, but before connecting in the governor, blow out both steam and air-pipes, to expel any dirt or scale which may be in the pipes. Two leakage or drip holes, tapped to take $\frac{1}{8}$ -inch pipe, are provided in the body of the governor. One of these holes must always be left open, but the other one may be plugged.

ENGINEER'S VALVE.

Fig. 150 shows the Engineer's Valve. The different positions of handle are "release," "running position," "lap," "service," and "emergency," corresponding to the effect produced with the handle standing in those positions.

The following description will make its operation plain: The chamber above piston 32 is connected with the train-pipe; the chamber below the piston is connected with the main reservoir. Exhaust-valve 42 regulates the discharge of air from the train-pipe. It is opened by handle 50, but closed automatically by piston 32. Lever 67, which is fulcrumed on eccentric-pin 44, is for opening valve 42. Lever 65, which is fulcrumed on pin 47, and connected to eccentric-pin 44 by link 66, is for opening main feed-valve 64 and small feed-valve 70. To apply the brakes, the handle (which is attached to the spindle that carries the eccentric-pin 44) is moved beyond the second notch (lap). This raises the outside end of the lever 67, and with it valve 42, thus allowing air to escape from the train-pipe, as the pressure tends to raise the inside end of lever 67 and allow valve 42 to close and stop the escape of air from the train-pipe. If the eccentric-pin is raised but a little, the piston will have to rise but little to close the valve. If it is raised higher, the piston will need to rise higher to close the valve, and consequently will allow more air to escape from the train-pipe before the valve closes. This piston is made automatic in its action by means of the bell-crank 34 and spring 33.

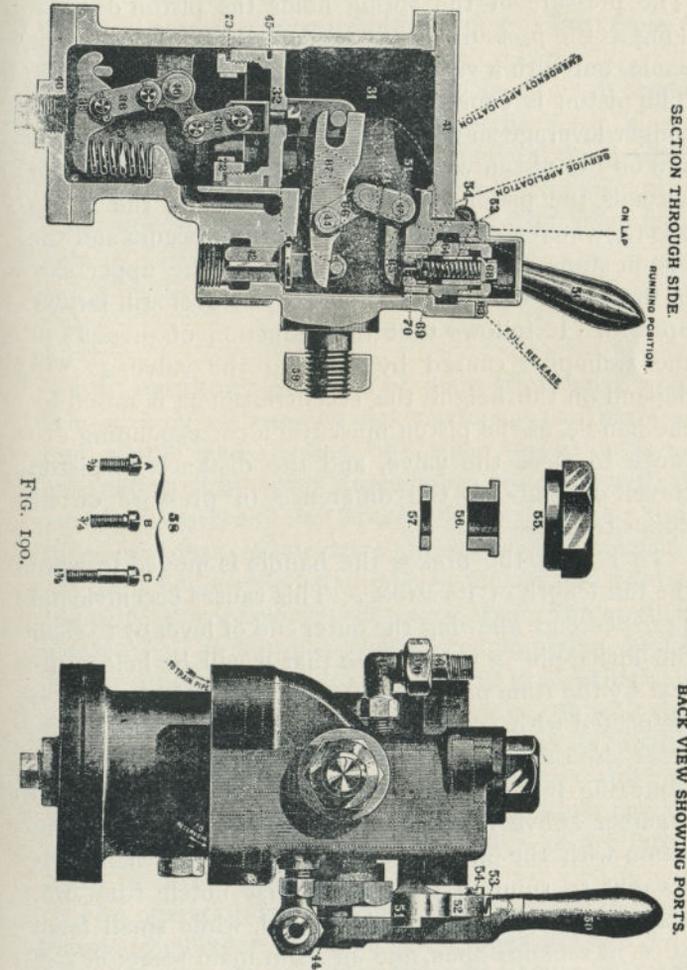


FIG. 190.

The pressure of the spring holds the piston down as long as the pressure on both sides of the piston is the same, but with a very short leverage on the bell-crank. The piston is connected to the bell-crank with a much longer leverage so that a very slight difference in pressure on the piston will allow it to start upward, but as it ascends the piston leverage decreases and the spring leverage increases until an equilibrium occurs and the piston stops. A further reduction on the upper side of the piston will cause the piston to travel still farther upward. It follows that the reduction of pressure in the train-pipe caused by opening the valve 42 will depend on the height the eccentric-pin 44 is raised by the handle, as the piston must rise a corresponding distance to close the valve, and the distance of piston travel depends on the difference in pressure on its opposite sides.

To release the brakes the handle is moved forward the full length of its stroke. This causes eccentric-pin 44 to descend, allowing the outer end of lever 67 to clear the lifting-pin in valve 42, so that it will be held to its seat by the train-pipe pressure above it. As lever 65 is connected with eccentric-pin 44 by link 66, this movement also causes it to rotate and lift main feed-valve 64, admitting full reservoir-pressure to the train-pipe; the chamber above feed-valve 64 being in direct communication with the main reservoir. When the handle is brought to running position or first notch from full release, main feed-valve 64 is closed, while small feed-valve 70 remains open, and air from main reservoir can get to train-pipe only by passing through excess-pressure valve 68, by compressing spring 69, and thence

through small feed-valve 70 to train-pipe. In the running position the pressure in train-pipe is kept from 20 to 25 lbs. lower than main-reservoir pressure.

When handle is brought to lap position or second notch from full release, main feed-valve 64 is closed, together with small feed-valve 70, and in this position no air can get from main reservoir to train-pipe; or, in other words, the train-pipe is blanked from main reservoir.

PLAIN TRIPLE-VALVE.

Fig. 191 shows a section of plain triple-valve which is used only on engines and tenders. The parts are few, simple, and durable, and their operation is not easily affected by dirt. Connections are made with the auxiliary reservoir, the brake-cylinder, and the train-pipe, as shown. Slide-valve 38 controls the exhaust of air from brake-cylinder to release brakes, and graduating-valve 48 controls the admission of air from auxiliary reservoir to the brake-cylinder for applying brakes. Piston 40 actuates slide-valve 38 and graduating-valve 48, and in such a manner that valve 38 will close exhaust-port before graduating-valve 48 is opened. The slide-valve 38 can remain stationary while the piston 40 returns part way and closes graduating-valve 48, as the abutments that move valve 38 are farther apart than the length of the valve.

The operation is as follows: Air from the train-pipe passes to cylinder *A*, and thence through passage *B* and *C* to chamber *D*, and then through passage *E* to the auxiliary reservoir. When the train-pipe pressure is

reduced the piston 40 moves its full stroke, first shutting off the auxiliary reservoir from the train-pipe by

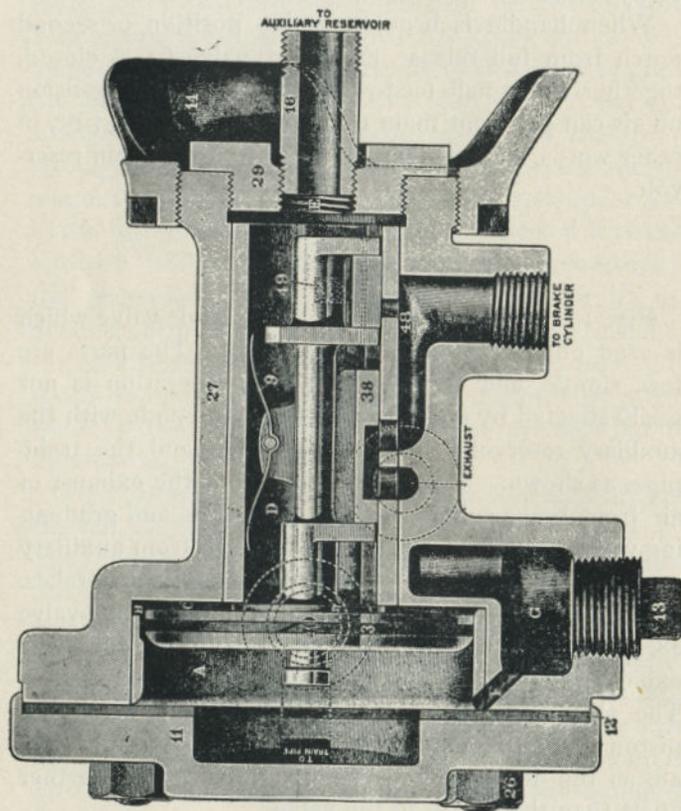


FIG. 191.

closing the connection between passage *B* and cylinder *A*, next closing exhaust-valve 38 and opening graduat-

ing valve, 48 which will admit air into the brake-cylinder, the amount admitted being in proportion to the reduction of the train-pipe pressure. If the train-pipe pressure is reduced but little, the pressure in the reservoir is soon reduced to less than that in the train-pipe, and the piston 40 starts back and closes graduating-valve 48 without disturbing slide-valve 38, which is held with some force by the air-pressure, aided by spring 9, and checks the return-stroke when valve 48 is closed. A further reduction of train-pipe pressure would repeat the same action and apply the brakes a little harder. If the train-pipe pressure is reduced 5 to 8 lbs. the brakes will be applied with but moderate force, but if the train-pipe pressure is reduced 20 lbs. the graduating-valve 48 will remain open and the brakes go full on, as the auxiliary-reservoir pressure will then continue to flow into the brake-cylinder until the pressure in each is equalized. An increase of pressure in the train-pipe will cause all the valves to move back to the position shown in the plate, thus releasing the brakes and allowing the reservoir to be recharged.

Passage *F* allows moisture from the train-pipe to collect into chamber *G*, where it can be readily drained by unscrewing plug 13.

Fig. 192 shows a section of the quick-action triple valve, the upper part of which is a duplicate of the plain triple-valve. For ordinary service stops the quick-action parts shown in the lower half of the cut remain inoperative, and the upper part operates in precisely the same way as the plain triple-valve, admitting auxiliary-reservoir pressure only to the brake-cylinder. The quick-action parts are for the purpose of giving a more

powerful action of the brake than is necessary in ordinary service, and in emergencies, where such powerful

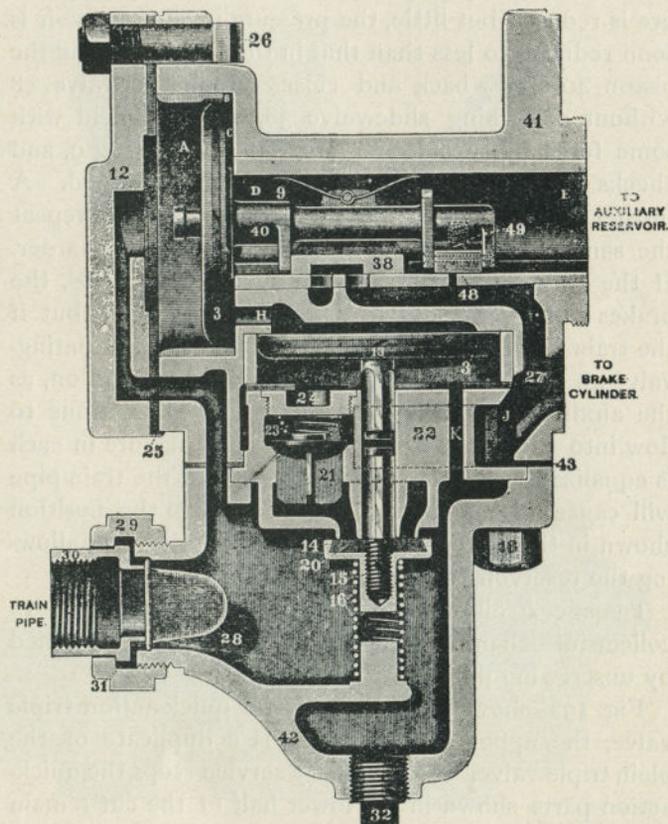


FIG. 192.

action is needed, they admit additional pressure direct from the train-pipe through a comparatively large

opening to the brake-cylinder, thus reinforcing the pressure derived from the auxiliary reservoir. The parts are few, simple, and durable, and have been improved so that the operation of the graduating and emergency features is unfailing on trains of any length and under any conditions of service. They have been thoroughly tested in the shops and in actual use on 50-car freight trains, demonstrating their reliability under most unfavorable conditions.

The emergency or quick-action portion consists of three moving parts; 1st, a valve 20,* controlling a passage from the train-pipe to the brake-cylinder; 2d, a piston 13 for actuating valve 20; 3d, a check-valve 21 to prevent air in brake-cylinder from passing back into the train-pipe. Valve 20 is held on its seat partly by spring 16, but principally by train-pipe pressure on its under side. Piston 13 is open to reservoir pressure on its upper side, through passage *H*, and to train-pipe pressure on its lower side through passage *K*. In order to open valve 20 it is necessary to decrease the train-pipe pressure so much that the sum of the upward pressures on valve 20 and on piston 13 is less than the amount of reservoir pressure on the top of piston 13. A quick reduction of 10 lbs. or more in the train-pipe pressure causes piston 13 to move down and force valve 20 from its seat, allowing the train-pipe pressure to lift and pass under check-valve 21, and through passage *J* directly into the brake-cylinder, thus quickly reducing the train-pipe pressure to actuate valves on succeeding cars, at the same time applying the brakes

* To get the proper names of the different parts of the brake mechanism, look to the numbers given in the text and drawings.

with greater force than would be possible if the brake-cylinder received air from the reservoir only. Check-valve 21 will close as soon as the brake-cylinder pressure is as high as that in the train-pipe, and the brake-cylinder pressure will be increased from the auxiliary reservoir through valve 48.

To release the brake the train-pipe pressure is restored. This raises piston 13 and allows the spring to seat valve 20 before piston 40 has sufficient force to overcome the resistance of slide-valve 38 and cause it to return to the position shown and thus release the brake.

Moisture from the train-pipe collects in the bottom of the valve, where it can be easily drained by unscrewing the plug.

WORK REPORTS.

Locomotive engineers and firemen should try to become familiar with each part of the locomotive mechanism, as the parts are constantly increasing, due to improvements; and the question is often asked, What shall I call this or that part which is broken, when a work report is to be made out. It is much better for those in charge of the repairs to know from the report of the engineer just what part is broken, instead of having to guess, or get the inspector to look for it; and in a measure the work report will show the engineer's knowledge of the machine he controls. The work reports given on the next page are not fictitious but those respectively of an engineer who is progressive and of one who is not so inclined.

I.

Sy. Div., Jan. 15, 1893. 10.20 A.M.

(Engine Track.)

Buddly sock lost off the Jumbo.

Have flues corked.

Piston-packing wants to be fixed.

Air-pipe is busted somewhere under foot-board; have the inspector look for it.

Safety valve { lifts at 165 lbs.
 { seats " " "

JOHN AMOS, Engineman.

II.

Sy. Div., Jan. 15, 1893. 10.20 A.M.

(Engine Track.)

Cinder hopper-cap lost.

Have flues caulked; leaking in bottom row. (Fire-box end.)

Piston-rod packing-rings broken on right side.

Air-pipe leading from main brake-pipe to auxiliary reservoir on the engine burst near the triple-valve.

Safety-valve { lifts at 165 lbs.
 { seats " 160 "

THOS. ALLEN, Engineman.

Report I is made out by a man who doesn't care to read any books about his business or keep posted on improvements. All that he desires is that pay-day shall come once a month.

Report II is made out by a progressive man, who believes that he can advance himself by reading and keeping abreast of the improvements in his business.

CHAPTER XI.

LOCOMOTIVE PACKINGS.

THE first metallic packing for locomotives simply furnished metal rings in place of the fibrous ones formerly used. It failed to provide all the essentials that have since been found necessary to success.

Fibrous packing had at best more or less elasticity. It was possible to compress it between its gland and the bottom of the stuffing-box enough to make it contract on its rod and make a joint.

If its rod moved out of the centre of the stuffing-box when at work, it pushed the packing aside, and when it moved back its packing followed it or leaked.

Some means must be provided to make the soft metal rings fit the rod and be free to move with it.

They must fit tighter on the rod when the steam is on than when it is off.

The first improvement was in adopting a cone-cup on the gland end of the packing and fitting the soft metal rings into it. These rings were kept into the cone by a spring.

This kept the rings in contact with the rod and the steam itself increased the pressure when the piston was doing work—but it leaked.

When the rod left the centre of the stuffing-box the packing could not follow it, and it was pulled off its seat, crushed and distorted. Then the flat-faced adjusting ring was invented.

The cone-cup had a ground joint on a flat ring that rested on a ground joint on the gland and was bored out a little larger than the diameter of rod. If the rod was moved up or down the packing could go with it; but this packing still leaked, because it did not provide for the "cramping" of the rod—for its being more out of centre at one end than at the other.

This trouble was entirely overcome by the invention of the ball-and-socket joint.

The sliding ring was left with a flat joint against the cone, but with a ball joint on the gland. Then wherever the rod went, straight or crooked, the packing followed it with ease, always maintaining a joint between the soft metal rings and the rod, between the vibrating cup and the adjusting ring by means of the flat joint and between the gland and adjusting ring by the ball joint. This double-bearing ring we call the ball joint, for short.

The next step was to abandon the old internal fitting gland and make a gland that was fitted steam-tight against the cylinder head, its only office being to keep the backing in the stuffing-box.

It took years of experience to find these things out—to demonstrate the proper angle to make these cones, for instance.

In the early days it was not uncommon for an engineer to find his babbitt rings coming out around the

piston-rod in a sheet, actually hammered through the narrow opening of the vibrating cup. This was because the angle was too acute for the pressure and too much space between cup and rod.

If the angle was made more obtuse the lower ring would not be forced through the vibrating cup, but

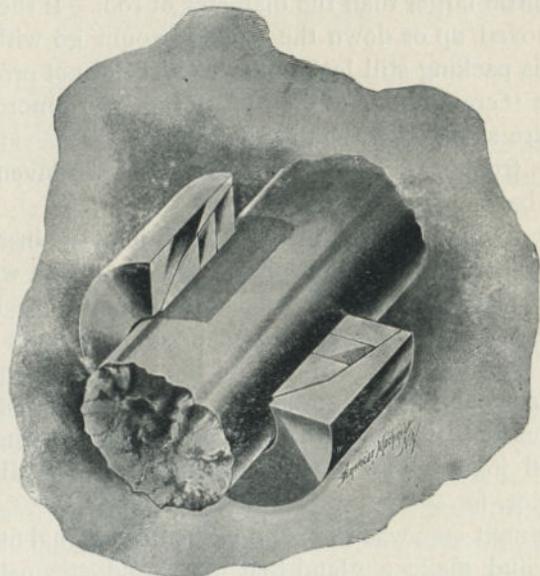


FIG. 192*a*.—DOUBLE-ANGLE VIBRATING CUP.

there was trouble with the other rings. The centre ring would not close up on the rod, and would stick the upper ring.

The United States Metallic Packing Company brought out the double-angle vibrating cup, as shown in Fig. 192*a*.

The lower ring will stand the pressure behind it, and the two other rings have sharp enough angle to go up to the rod and do their work. This angle must be in proportion to the steam pressure, within reasonable bounds, and what is just right for one pressure may not give good results at another pressure.

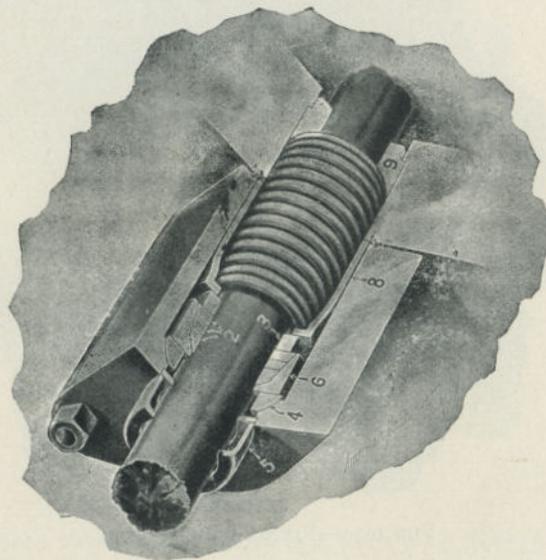


FIG. 192*b*.—VALVE-STEM PACKING.

Parts referred to by numbers are as follows: 2. Three Babbitt Rings in halves, known as one ring; 3. Follower; 4. Ball Joint; 5. Swab Cup; 6. Vibrating Cup; 7. Gland; 8. Preventer; 9. Support.

Before the invention of the ball joint it was utterly impossible to pack locomotive valve-stems with metallic packing—they "wobbled" too much.

There are lots of locomotives running this very day with metallic packing on their piston-rods but not on their valve-stems.

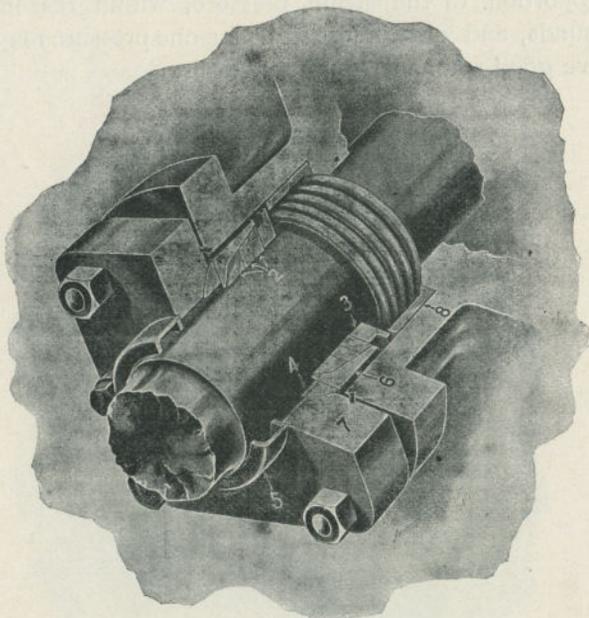


FIG. 192*c*.—PISTON-ROD PACKING.

Parts referred to by numbers are as follows: 2. Three Babbitt Rings, known as one ring; 3. Flange Follower; 4. Ball Joint; 5. Swab Cup; 6. Vibrating Cup; 7. Gland; 8. Preventer.

It took a long time to determine the fact that the trouble was not in that "wobble" that had worried folks.

It was in the varying travel of the stem.

At the cut-off most used the valve-rod travelled a

short distance and wore a "notch" in its under side where it rested on the neck-ring.

Then when the engine was full-stroked this "notch"

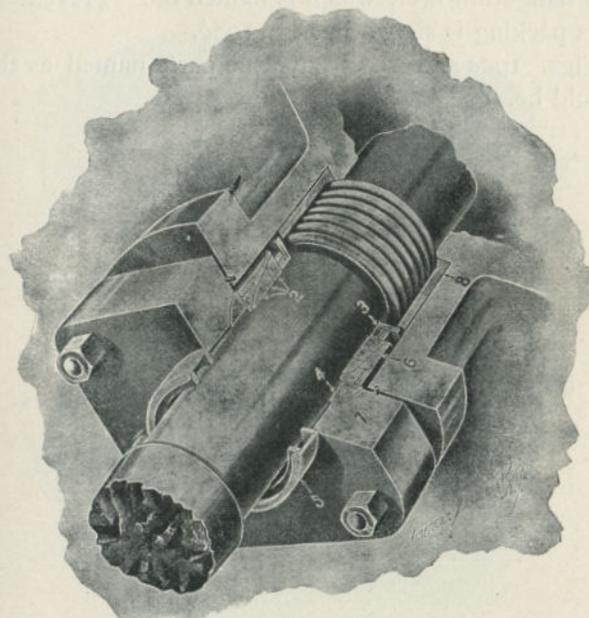


FIG. 192*d*.—PISTON-ROD PACKING FOR RODS WITH SHOULDER.

Parts referred to by numbers are as follows: 2. Three Babbitt Rings in halves, known as one ring; 3. Flange Follower; 4. Ball Joint; 5. Swab Cup; 6. Vibrating Cup; 7. Gland; 8. Preventer.

was pulled through the packing rings and became a broach, crushing and cutting them out of shape, and leak!—John Alexander expressed it when he said it was a good thing there was a yoke on the valve itself or *it* would have leaked out. This trouble was overcome

by simply carrying the valve-stem packing out on the rod to a point where that "notch" couldn't touch it. This was done by an extension gland and an extension flange follower, which is named the "Preventer." This packing is shown in Fig. 192b.

Figs. 192c and 192d have the parts named as they should be.

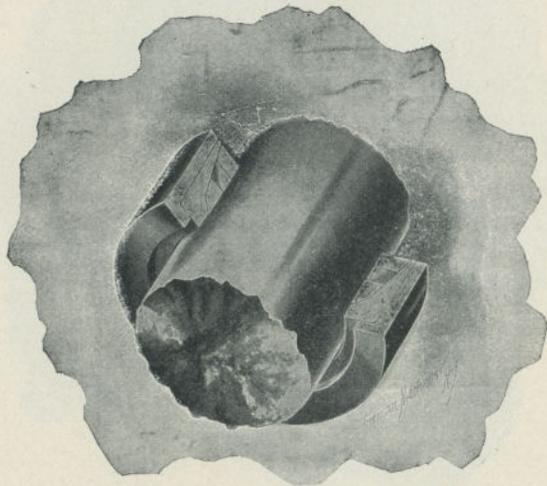


FIG. 192e.—GIBBS VIBRATING CUP.

Fig. 192d shows a style of packing so made that it can be put on a rod having a shoulder or enlarged end of rod.

This is done by making the smaller part of its vibrating cup in halves and securing it in the other part of cup after the packing is on the rod.

Fig. 192e shows the Gibbs Vibrating Cup, designed

for engines having an enlarged end on rod. This is recommended as an improvement over the regular vibrating cup for this purpose, especially where packing

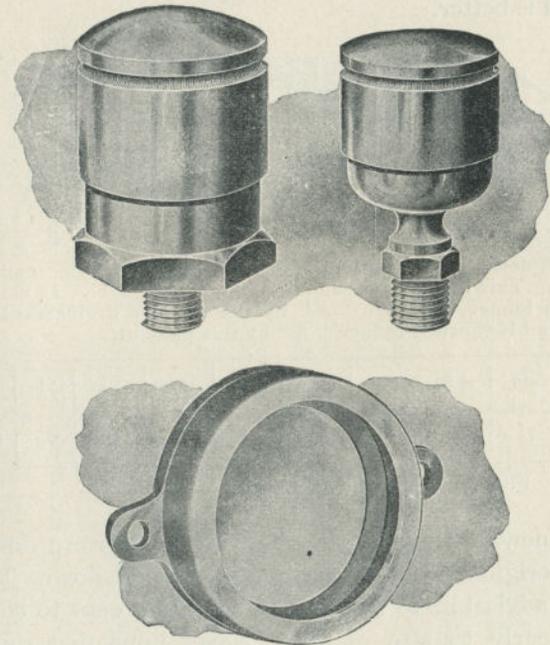


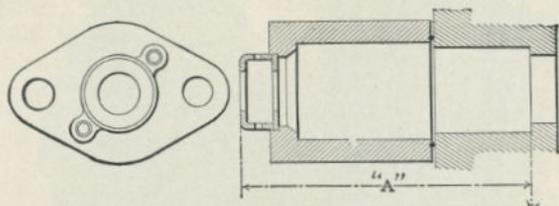
FIG. 192f.—OILING DEVICES.

is maintained by the progressive system. This cup has an inner ring, in halves. In designing new work, using this cup, it is desirable to increase the diameter of stuffing-box one-half of an inch.

In all United States packings the soft metal rings are

in halves; not necessary to disconnect anything to put them in.

When packings are applied to old engines the rods and valve-stems should be turned as true as possible—ground is better.



Length desired from bottom of stuffing-box to extreme end of packing. This length is based on $4\frac{1}{2}$ " of valve-travel. If valve-travel is longer, lengthen "A" by the amount of increase of travel, and if shorter, reduce "A" by this amount.

Diam. of Stem.	1 in.	$1\frac{1}{4}$ in.	$1\frac{1}{2}$ in.	$1\frac{3}{4}$ in.	$1\frac{1}{2}$ in.	$1\frac{3}{4}$ in.	$1\frac{1}{2}$ in.	$1\frac{3}{4}$ in.	2 in.
"A"	$7\frac{7}{8}$	$7\frac{7}{8}$	$7\frac{7}{8}$	$7\frac{7}{8}$	8	8	$8\frac{1}{8}$	$8\frac{1}{8}$	$8\frac{1}{8}$

FIG. 192*g*.—PROPORTIONS FOR VALVE-STEMS.

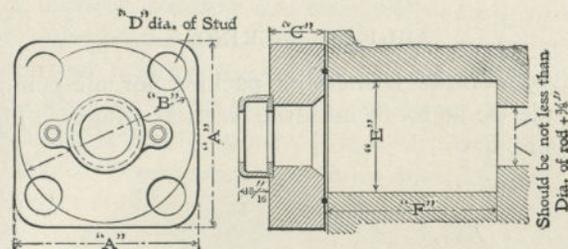
In renewing rings on rods that are much worn down below original size, or have been turned down, it is always advisable to supply new vibrating cups to conform nearly to size of rod. Never hope that rings larger or smaller than the rod will "wear down"—they won't.

Oiling devices are shown in Fig. 192*f*. Care should be taken to keep these clean and in good shape. When the swab collects a lot of dirt and cinders, either wash it out thoroughly or renew it.

Remember that metallic packing is a bearing—a

babbitted bearing—and needs oil and attention just as much as it would if the shaft turned around.

One hundred thousand miles is often made, and seventy-five thousand is common, without renewing rings.



DIMENSIONS DESIRED FOR U. S. METALLIC PACKING.

Diam. of Rod.	"A."	"B."	"C."	"D."	"E."	"F."
Inches.	Inches.	Inches.	Inches.	Inches.	Inches.	Inches.
$1\frac{1}{2}$	$5\frac{1}{2}$	5	$1\frac{1}{4}$		$3\frac{1}{2}$	$4\frac{3}{8}$
$1\frac{3}{4}$	$5\frac{1}{2}$	$5\frac{3}{8}$	$1\frac{1}{4}$		$3\frac{3}{4}$	4
2	$5\frac{3}{4}$	$5\frac{7}{8}$	$1\frac{1}{4}$		$3\frac{3}{4}$	$4\frac{3}{8}$
$2\frac{1}{4}$	6	$5\frac{7}{8}$	$1\frac{1}{2}$		4	4
$2\frac{1}{2}$	$6\frac{1}{4}$	$6\frac{1}{8}$	$1\frac{1}{2}$		$4\frac{1}{4}$	5
$2\frac{3}{4}$	$6\frac{1}{2}$	$6\frac{3}{8}$	$1\frac{1}{2}$		$4\frac{1}{2}$	5
3	$6\frac{3}{4}$	6	$1\frac{1}{2}$		$4\frac{3}{4}$	$5\frac{1}{8}$
$3\frac{1}{4}$	7	7	$1\frac{3}{8}$		5	5
$3\frac{1}{2}$	$7\frac{1}{4}$	$7\frac{3}{8}$	$1\frac{3}{8}$		$5\frac{1}{4}$	$5\frac{1}{8}$
$3\frac{3}{4}$	$7\frac{1}{2}$	$7\frac{3}{8}$	$1\frac{3}{8}$		$5\frac{1}{4}$	5
4	$7\frac{3}{4}$	8	$1\frac{3}{8}$		$5\frac{1}{2}$	$5\frac{1}{8}$
$4\frac{1}{4}$	8	$8\frac{1}{8}$	2		$6\frac{1}{4}$	5
$4\frac{1}{2}$	$8\frac{1}{4}$	$8\frac{3}{8}$	2		$6\frac{3}{4}$	$5\frac{1}{8}$

FIG. 192*h*.—PROPORTIONS FOR PISTON-ROD STUFFING-BOXES.

The principal repairs consist of renewing the babbitted rings. The following formula of the compositions is: 100 lbs. tin, 9 lbs. copper and 6 lbs. antimony, known as No. 1 Mixture, for old style or single-angle metals.

It also gives good results in the multiangular type of ring for high pressures, No. 4, composed of $83\frac{1}{3}$ per cent. lead, $8\frac{1}{3}$ per cent. tin and $8\frac{1}{3}$ per cent. antimony, which gives excellent results and is also very much cheaper than the No. 1 metal.

AIR-PUMP PACKING.

Fig. 192i shows a metallic packing for air-pumps, and made so as to fit into the regular gland. This

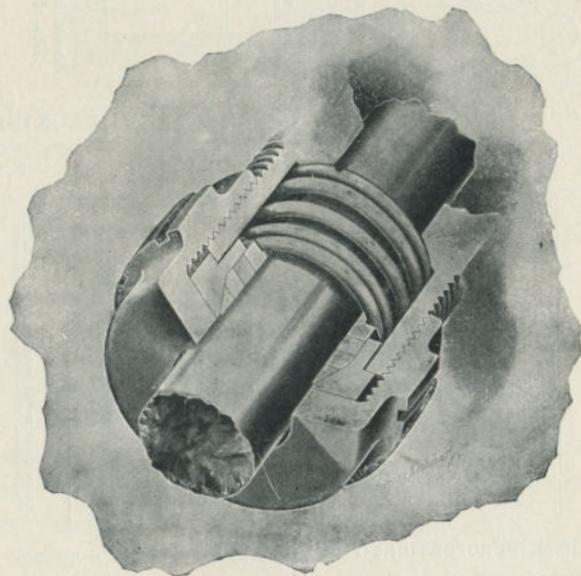


FIG. 192i.—AIR-PUMP PACKING.

packing takes the place of the usual fibrous packing, and keeps the piston-rod very smooth and prevents

scoring. The fibrous packing has a tendency to burn when the piston-rod becomes warm, and the leak will continue to get worse if the pump is not cooled off. The charred packing, if tightened down by the nut, will have a tendency to cut the rod and create heat. The metallic packing will wear well and give a long life under proper care. The construct is similar to the piston-rod packing except the ball-joint between cups and gland-nut is omitted, the movement of rod being free from lateral motion. It is a very annoying thing to have a fibrous packing to burn out and blow; it has the effect of reducing the efficiency of the pump fifty per cent., and where much braking is to be done, it is a serious matter. In order to maintain a pressure the speed of the pump must be doubled, which will cause heating, which will further decrease the amount of air compressed.

APPENDIX.

THE MODERN ELECTRIC LOCOMOTIVE,

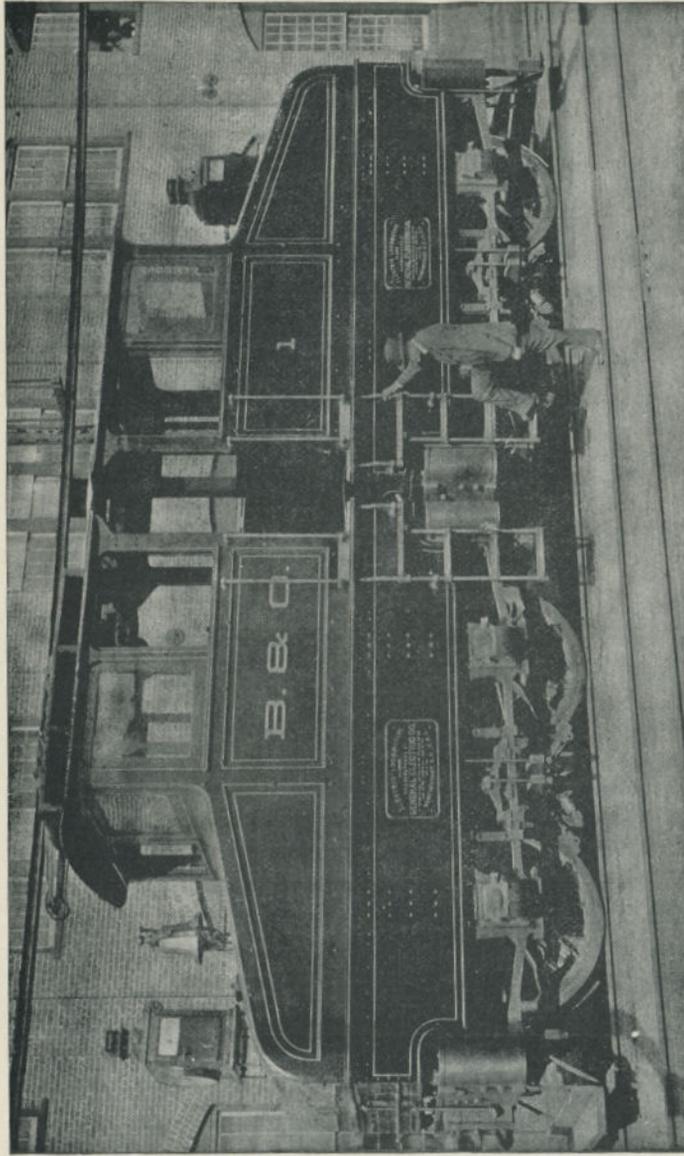


FIG. 193.—THE 96-TON ELECTRIC LOCOMOTIVE.

Weight on 8 driving-wheels, 192,000 lbs.
Diameter of drivers, 62".

Draw-bar pull, 42,000 lbs.
Height to top of cab, 14' 3".

Starting draw-bar pull, 60,000 lbs
Length over all, 25'.

APPENDIX.

GENERATING CURRENT FOR THE ELECTRIC LOCOMOTIVE.

As there are several ways of generating an electric current, it was thought proper to give a brief explanation of the manner of generating current for the electric locomotive. The current generated for this purpose is produced by machines called in railroad work generators or dynamos, which are of large size and capacity, directly coupled to a slow-speed engine. Fig. 194 shows a vertical compound engine driving a 1500 k.w. generator. The principle of a generator is this: As shown, a circular yoke has projecting inwardly several poles or fields thus multipolar; these poles are wound with wire. In the centre of these fields is an armature which is caused to revolve by the engine. On this armature is wound a lot of copper wire or bars insulated. The ends of the wire are connected to the commutator in the proper manner. Bearing against the commutator are brushes for taking off the current. There are as many brushes as circuits through the armature when so desired. Now, if the engine is started, the armature revolves, generating a current, due to the fact that the wires on the armature are within a magnetic field

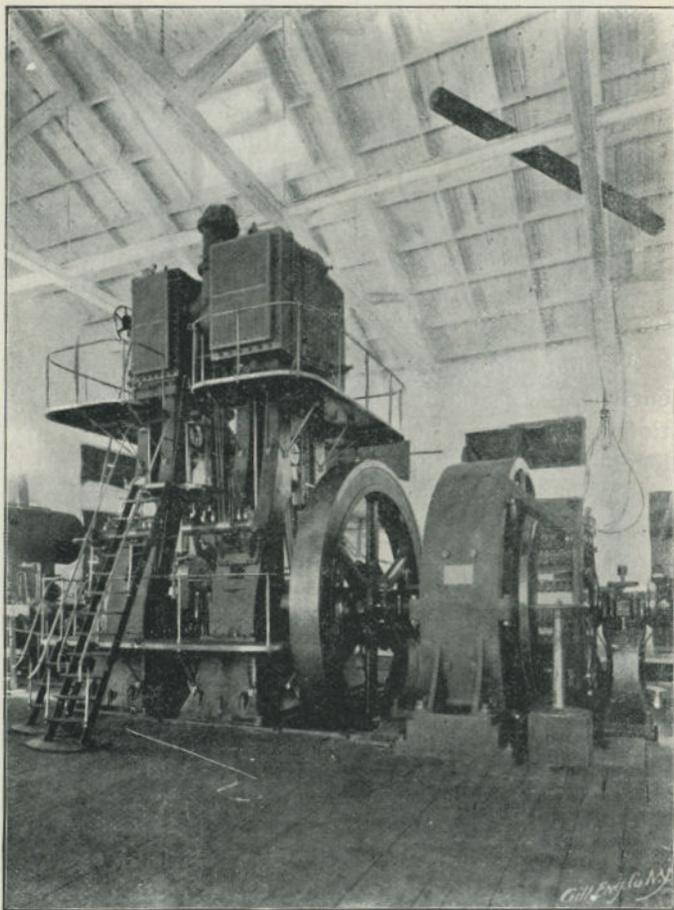


FIG. 194. —GENERAL ELECTRIC CO.'S DIRECT CONNECTED RAILROAD GENERATOR (MULTIPOLAR TYPE) DRIVEN BY A VERTICAL COMPOUND CONDENSING ENGINE.

and are cutting lines of force or magnetic flux, which are generated in the poles by a part or whole of current passing through the field winding from the armature, the original lines of force being the residual magnetism in the poles. Thus the current generated is proportional to the voltage and resistance, and the voltage or pressure of the current to the speed, number of inductors or wire on the armature, and number of lines of force cut by these wires on the armature. The current thus generated is passed to a switch-board, and from there to the proper feeder-wires over the line to the electric locomotive. For further information regarding generators the reader is referred to books on that subject.

ELECTRIC LOCOMOTIVES.

As the electric locomotive has developed into practical use, and has been tested under heavy loads and high speed, it is thought that a clear and simple explanation would be a benefit to those handling our steam locomotives.

The first subject will be to show the principle of an electro-magnet, or a magnet produced by a current of electricity. Get a piece of soft iron, round or square, preferably round, as in Fig. 195, and wind a coil of insulated copper wire around it in the manner shown; then connect the two ends to the poles of a primary battery. A current of electricity will flow through this coil of wire surrounding the soft-iron core. What is the effect? Let us see. Before there was any cur-

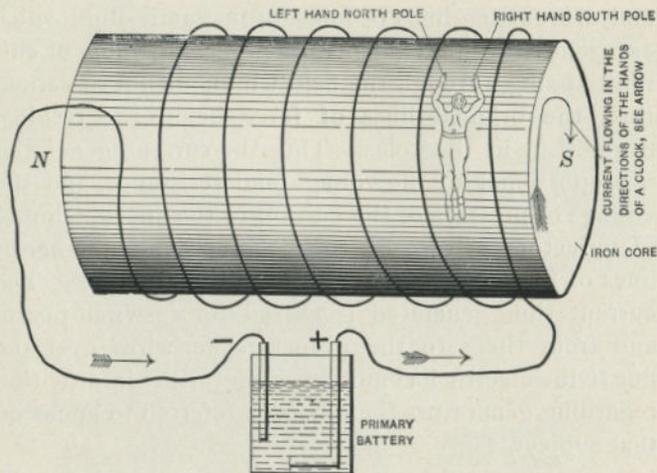


FIG. 195.—ELECTRO-MAGNET CURRENT PASSING FROM RIGHT TO LEFT.

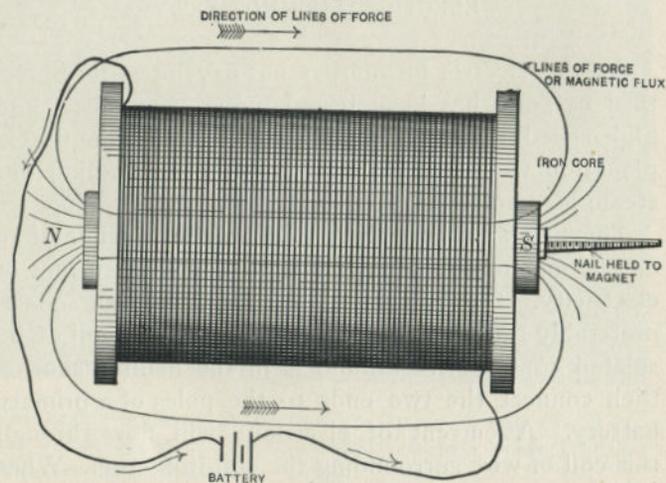


FIG. 196.—COMPLETE ELECTRO-MAGNET ENERGIZED.

rent passing through the wire, if we should hold a nail or iron filing to the end of the soft-iron core, we would see no effect whatever. But since the current is flowing we find that our nail would be drawn or attracted to the iron core. In Fig 196 it shows the core completely covered with wire. It is seen that the current flowing around the iron core causes lines of force to pass through the iron. These lines of force or magnetism cause the nail to be drawn to the iron. Fig. 201 shows the lines of force as they pass through the iron from one pole to the other. The best way to see the lines of force actually is to get a small horseshoe magnet and a piece of glass, distribute some iron filings over the glass, put the magnet directly under them, and they will arrange themselves in the direction of the lines of force.

It will be found that there is a difference in the polarity of the two ends of the soft-iron core. One is a north pole, while the other is a south pole. (See Fig. 196.) There are two conditions which govern this: the direction in which the wire is wound around the iron core, and the direction in which the current is passed through the coil of wire surrounding the core. In Fig. 195 the wire is wound in a right hand-spiral, or in the direction of a right-hand screw. In Fig. 195 we see that the current is entering the coil at the right-hand end, and is passing over the iron core, or as in the direction in which the man is swimming. It is a good plan to bear in mind that if the man is swimming with the current in the direction as shown in Fig. 195 the south pole of the magnet will be on his right hand

and the north pole on his left hand.* To change the polarity by passing the current in the opposite direction, Fig. 197, we see that the man is turned around, and his right hand points to the south pole and his left to the north pole, or the polarity is the reverse of the first case (Fig. 195). Now, if the wire is wound as a

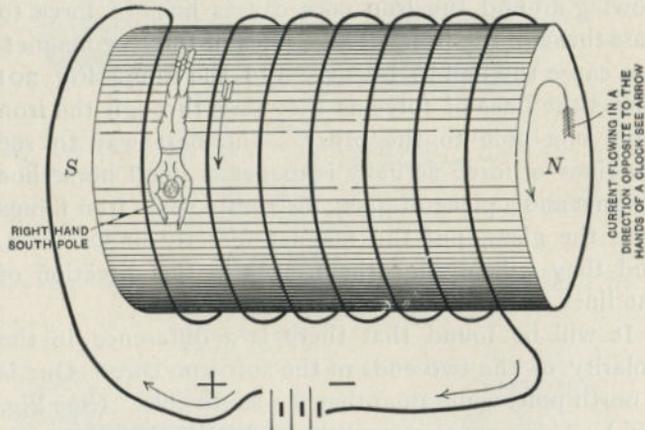


FIG. 197.—RESULT OF PASSING THE CURRENT THROUGH THE COIL FROM LEFT TO RIGHT.

left-hand spiral (Fig 198), and the current entered from the right-hand end, we see that the polarity is opposite to that of the right-handed spiral. Remember to produce opposite poles the current must pass around the spools in reverse directions in a horseshoe magnet (Fig. 199). The magnet just explained is a bar type, and the lines of force must pass from the north to the south pole through the air (Fig. 196), which forms a great

*This will apply no matter in which direction the current is flowing.

resistance to them. The closer the poles are to each other the less the magnetic leakage, and the shorter the distance the lines have to pass from one pole to the other the less is the resistance to their flow.

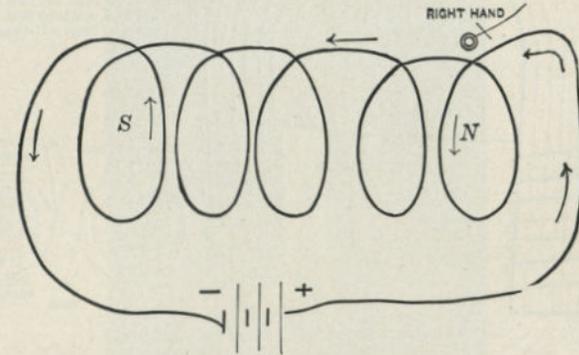


FIG. 198.—A LEFT-HAND SPIRAL CURRENT ENTERING FROM RIGHT-HAND SIDE. POLARITY OPPOSITE TO THAT OF FIG. 155.

Then the most desirable form of magnet generally used is the horseshoe magnet (Fig 199); the two poles are bent around near to each other, thus shortening the distance which lines of force have to travel. If two magnets whose poles are of the same polarity are held close together, they will repel each other, and the lines of force or magnetic flux will be diverted as shown in Fig. 200, and produce consequent poles, as NN , SS . This is made use of in motors and dynamos.

But if the two magnets are brought close together with opposite poles, or N and S , the magnets will be drawn together or attracted, the attraction becoming stronger as the poles approach each other. The law is, similar poles repel, and dissimilar attract. As the action of an electric magnet and what causes it to

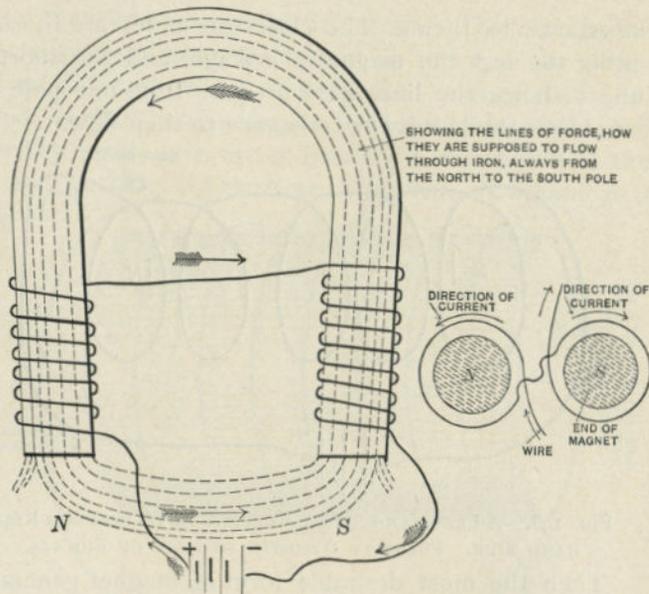


FIG. 199.—HORSESHOE ELECTRO-MAGNET.

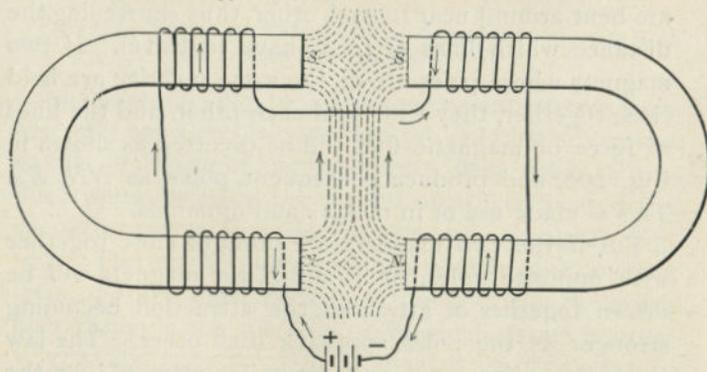


FIG. 200.—FORMING CONSEQUENT POLES. MAGNETS WITH SIMILAR POLES OPPOSITE EACH OTHER.

be a magnet has been explained to the reader, the fundamental principle of an electric motor or locomotive will be understood. Fig. 201 shows the lines of



FIG. 201.—SHOWING LINES OF FORCE AS TAKEN FROM A PHOTOGRAPH. force as produced by iron filing on glass held under a horseshoe magnet.

THE ELECTRIC MOTOR FIELDS.

The electric motor is composed of two parts in simplest form, one stationary and the other revolvable. The stationary portion is called field magnets, and on them is wound the wire which carries the current to produce the necessary poles, taking the present form as shown in Fig. 202, which is of the horseshoe type.*

* And sometimes called the under type.

The fields are not in one piece, but are composed of the field-pieces, the yoke, which is bolted on to each field-

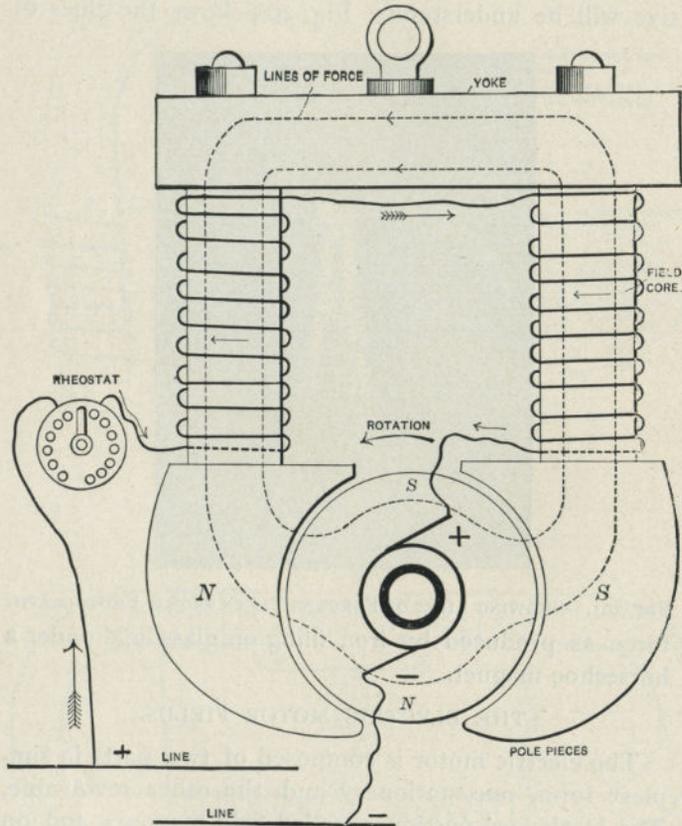


FIG. 202.—ELECTRIC MOTOR, FIELDS SERIES-WOUND.

piece, and at the bottom are the pole-pieces *N* and *S*. The field-pieces should be of the softest iron and of ample size to carry the magnetic flux. They are gen-

erally made of wrought iron and of soft steel, and in a great many motors the pole-pieces are laminated to prevent Foucault or eddy currents. These are currents induced in the solid pole-pieces, and flow across the axis of the pole as shown in Fig. 203, and produce heating. Laminating prevents this cross-flow, as shown. The field-winding is wound on spools, and

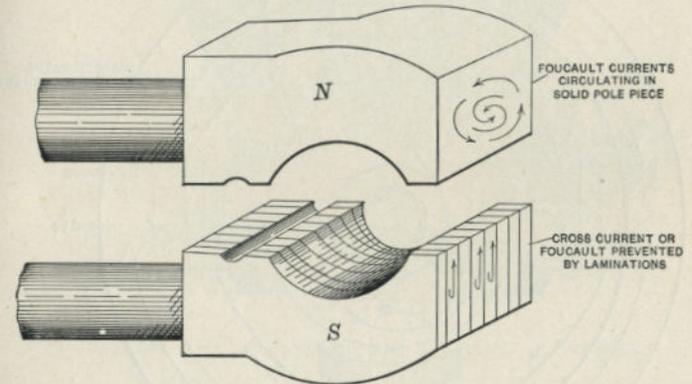


FIG. 203.—ONE POLE LAMINATED, THE OTHER SOLID (SHOWING THE EFFECT OF FOUCAULT CURRENT).

then the yoke is taken off and the spools are slipped on the field-pieces. There should be as few joints as possible in the fields, and they should be as short as the winding will permit, so as to produce as short a magnet circuit as possible. Iron-clad field-magnets are the best. The motor fields may be of many different forms. Figs. 204 and 205 show a multipolar type of motor; in these there are four pole-pieces projecting inwardly from the yoke, which is circular in form and in two halves bolted in the centre. Any number of poles could be used if desired. The

magnetic paths are plainly shown by Figs. 202 and 204; also the manner of winding and the flow of the current. Each field-coil is wound in the reverse direction, thus producing north and south poles. Another form

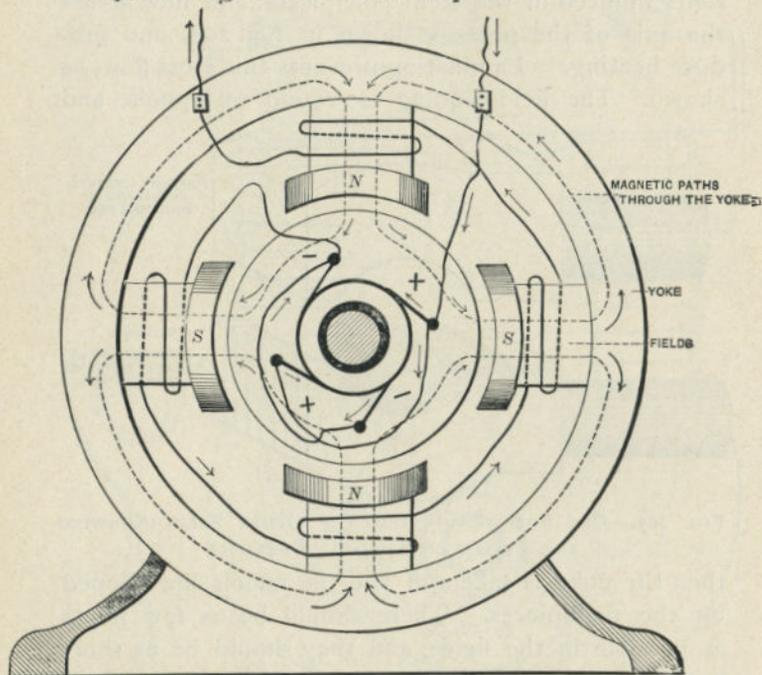


FIG. 204.—MULTIPOLAR FIELD-MAGNET, SERIES-WOUND MOTOR.

of field is that which produces consequent poles, as in Figs. 206 and 207. This is the same as a double horse-shoe magnet, the pole-pieces being in the centre, and the field so wound as to produce north and south poles together, this causing the lines of force to be diverted, as shown in Fig. 200.

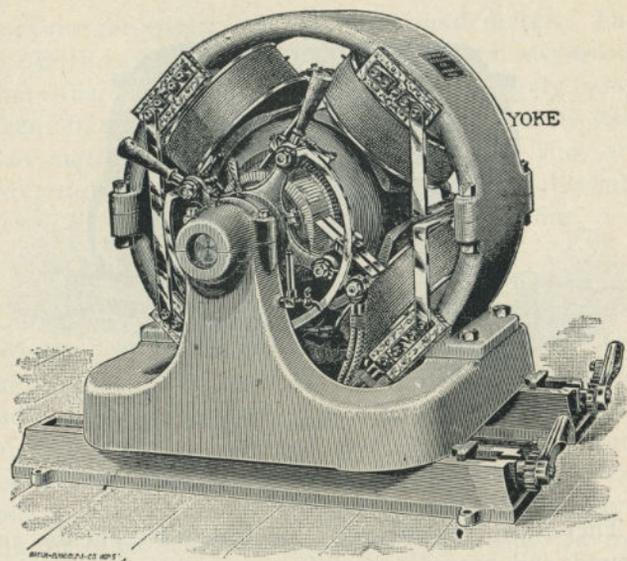


FIG. 205.—MULTIPOLAR MOTORS, 4 CIRCUIT, 4 BRUSHES.

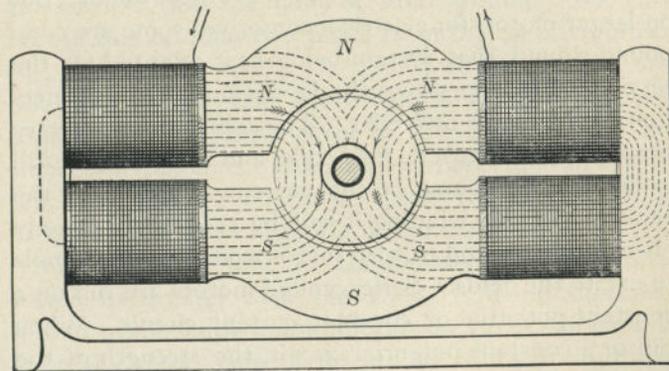


FIG. 206.—CONSEQUENT-POLE MOTOR FIELD, 2 CIRCUIT.

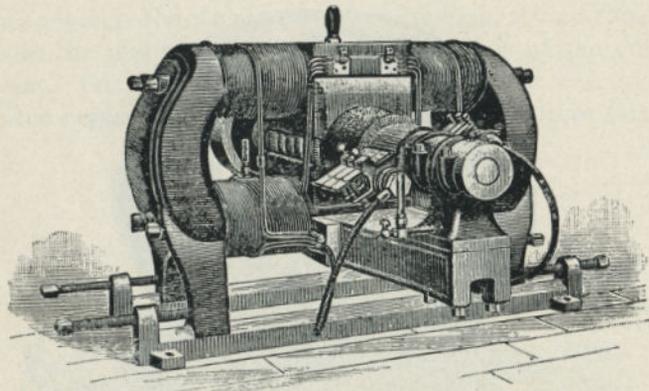


FIG. 207. —CONSEQUENT-POLE MOTOR.

MOTOR FIELD-MAGNET WINDING.

There are several ways in which the fields are wound, and accordingly different results are obtained from the motor. In most electric motors used for street-railroad service the fields are series-wound. But on larger motors for electric locomotives some are compound-wound, that system being best adapted for the service. Fig. 202 shows the field-winding and connection to the mains or feeder. The connections are very simple. The rheostat, field-coils, and armature are all in series; the course of the current is shown by the arrows. In this winding it will be seen there is only one continuous coil of wire that is wound on the spools to excite the fields. Series-wound motors are run on a constant potential or constant current circuit. When run on a constant potential circuit, the strength of the motor varies with the current, and does not tend to run

at a constant speed like a shunt-wound motor. The best work to which they are adapted is railway work, where there is no danger of the load suddenly being taken off, and where variable speed is desired, as railroad motors are subject to these changes. They are also an advantage on circuits where the potential is subject to sudden drops, as on the end of a long line.

SHUNT-WINDING.

In shunt-wound motors the field-coils are not in series with the armature as in the series-wound motor. The field-winding is of very fine wire of high resistance, and it takes but a small amount of current to excite the field-magnets. Fig. 208 shows the manner of connecting the field-coils. As is shown, one end of the coils is connected to the positive (+) brush of armature, and the other end to the negative (-) brush. In this the whole current supplied to the motor does not flow through the field-winding—only a portion, as shown by the arrows; thus the name of shunt-wound. The current in this case has two paths from the positive brush (+) to the negative (-). Shunt-wound motors are not used to any great extent on railways. There are some features against them in this capacity; for instance, on the ends of long lines where the fall of potential or pressure might be great the motor would be converted into a dynamo for an instant.

From the fact that the counter-electro-motive force would be greater than the E. M. F. being supplied, also in using shunt-wound motors on street railways, if from any cause, such as dirt, stones, sticks, or anything that would raise the wheels clear of the rail, so as to

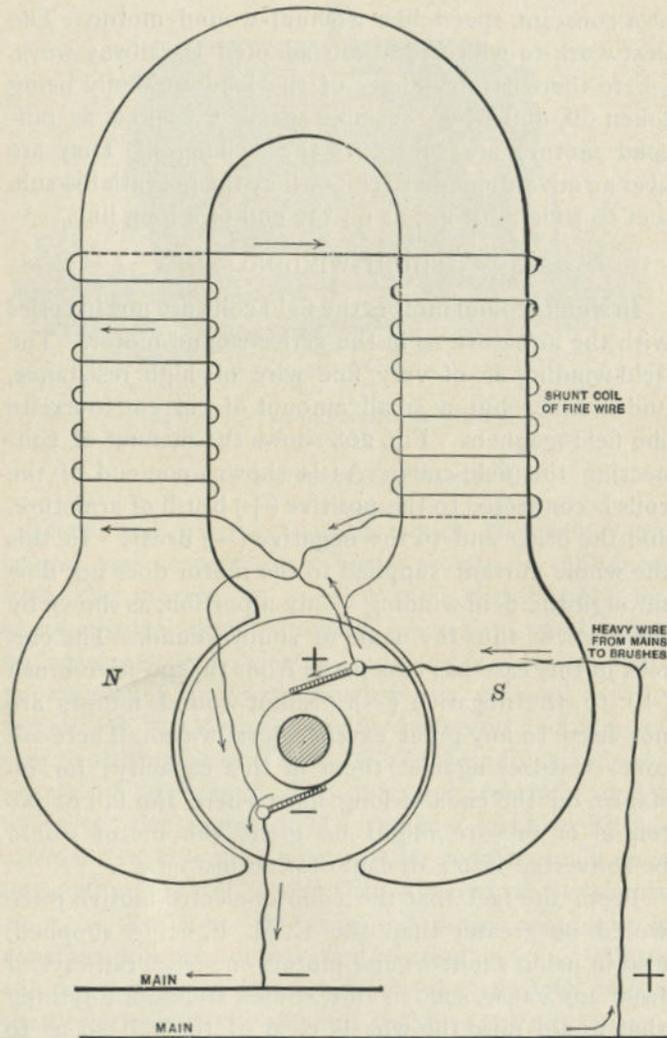


FIG. 208.—SHUNT-WOUND MOTOR FIELDS AND CONNECTIONS TO ARMATURE.

break the circuit, would cause the motor to fail to start, due to the fact that the current would leave the shunt-winding, which is of high resistance, when the

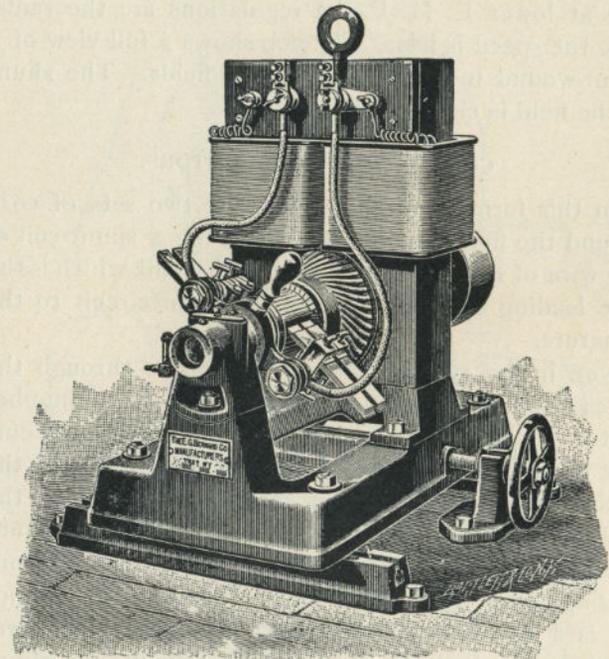


FIG. 209.—TWO-POLE SHUNT-WOUND MOTOR.

current returned it would rush through the armature-winding, which is of less resistance, and not build up the field-magnetism. This rush of current is detrimental. On stationary motors shunt-wound it is policy to raise one brush from the commutator, so as to cause the current to pass through the field-winding or

shunt. One good feature of a shunt-wound motor is that it is nearly self-regulating on constant potential circuit and run at constant speed whatever the load, and at lower E. M. F. the regulations are the same, only the speed is less. Fig. 209 shows a full view of a shunt-wound motor having square fields. The shunt to the field is clearly shown.

COMPOUND-WOUND MOTORS.

In this form of winding there are two sets of coils around the fields, as shown in Fig. 210: a shunt-coil of fine wire of many turns, and the series coil, which is the wire leading the current from the main circuit to the armature.

Now in this type all the current passes through the series winding, which is generally of a small number of turns, and at the same time that amount of current passing through the shunt also passes around the fields. But that current in series coil passes to the positive brush (+) of armature, while that of the shunt passes from the positive to the negative brush without passing through the armature. This method of winding is a combination of series and shunt. This form of winding has this advantage over the simple shunt winding: if the circuit should be broken at any time, the fields would be magnetized on the circuit being again closed, because the current would pass through the series winding around the fields. Then the counter E. M. F. would have a tendency to force a part of the current through the shunt-coil, thus building up the fields and producing the proper counter E. M. F. speed and torque.

ARMATURES.

Next after the fields comes the armature; it is this part of the motor which produces the motion and is

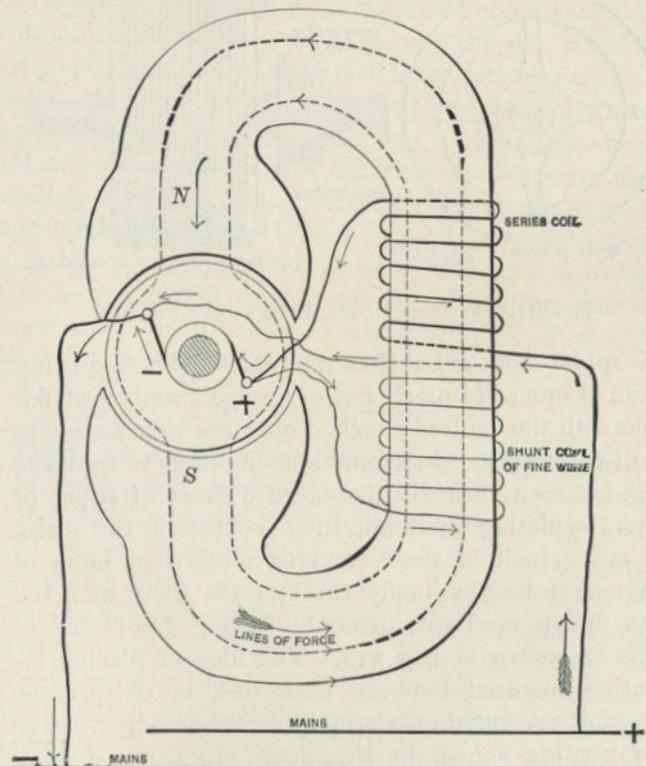


FIG. 210.—COMPOUND-WOUND MOTOR FIELDS AND CONNECTIONS TO ARMATURE.

the movable portion of the motor. There are two styles which will be explained: first, the ring type; second, the drum type. The easiest type to explain to the reader is the ring armature. The general con-

struction is as follows (see Fig. 211): On a shaft is keyed a spider of non-magnetic material, as brass; on

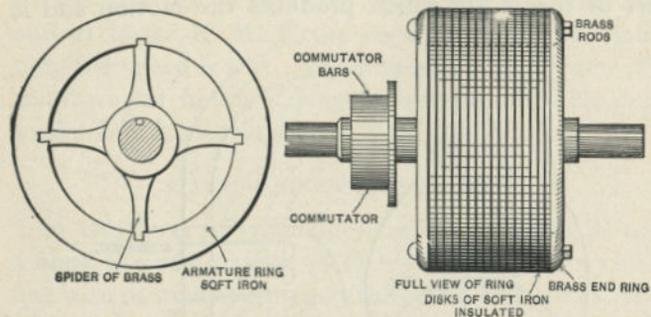


FIG. 211.—ARMATURE-CORE, RING TYPE.—FIG. 212.

this spider is mounted the armature. This ring is not made of one solid piece, but of a great number of flat disks with the centres punched out; the iron used is to be of the softest. In assembling the disks to form the ring, between each disk is placed a sheet of paper or other insulating material, thus separating the disks. In order to hold these in one solid ring, bolts of brass pass longitudinally through the ring, and the nuts drawn up tight, generally having end-plates of brass as shown in Fig. 212. The idea of placing insulating material between each disk is to prevent Foucault currents in the armature-core or ring. These currents are shown in Fig. 203. In using a solid core these currents induced in the iron and generally parallel to the axis of core, produce heat, and reduce efficiency of the motor; by using the laminated core these defects are mostly prevented, because the insulation between each disk prevents the currents from flowing as described. The same method is used in the

construction of a drum armature. The next thing to do is to thoroughly cover this iron armature with an insulating material, so as to prevent the winding coming in contact with the iron of the core. A good duck cloth is usually used and is wrapped around the ring when it is a plain ring. This cloth is well saturated with a good shellac varnish. Some cover first with thick paper shellacked, then put the cloth on. Others use cloth and adhesive rubber tape. After the shellac is dry the winding is next, it being ascertained that the core is thoroughly insulated. Where a motor is to do heavy work, the shaft should be of best steel and short as possible to prevent its springing, as this, if excessive, would allow the armature to strike the pole-faces and injure the insulation, causing a short circuit.

ARMATURE-WINDING.

There are two methods of winding an armature—ring winding and drum winding. The method shown in Fig. 213 is what is called closed-circuit winding, and is in the form of a right-hand spiral. The winding covers the entire ring in the actual armature and is generally called a Gramme ring. But in most forms the ring is toothed or slotted across its length and the wire is wound in the slots. This fulfils two purposes: one is that it mechanically strengthens the armature-winding by forming a bearing for the wire to resist the pull due to fixed poles;* another point is that it produces what is called an iron clad armature, which increases the efficiency of the armature and reduces the

* It is to be understood that a wire having an electric current passing around it, and in front of a magnetic pole, is subject to a torque or pull.

clearance between the pole-faces and the armature. Wires are iron-clad, due to their being imbedded in the grooves. The wire can be wound around the ring in one continuous coil if desired, and is done by some manufacturers, but is generally wound in separate coils. As shown by Fig. 213, at equal distances around the

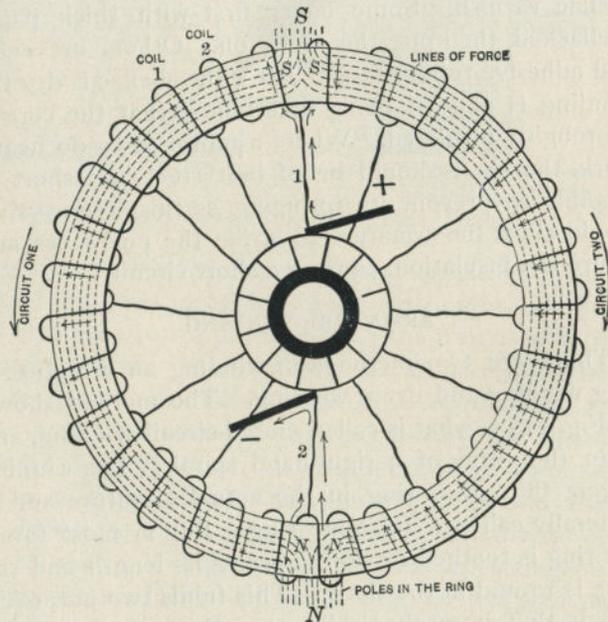


FIG. 213.—RING ARMATURE. CLOSED-CIRCUIT WINDING, TWO CIRCUITS AROUND THE RING FORMING CONSEQUENT POLES *S* AND *N*. ring are short leads of wire connected to the winding on the ring and to the commutator.

This commutator is composed of bars of copper insulated from each other and from the shaft. As shown, there are two coils connected to one commuta-

tor-bar. When the armature is wound in coils, the end of one coil and the beginning of the other coil must be connected to one commutator-bar same as Fig. 213. This also forms a two-circuit winding. This is the most simple form of winding and the easiest to be understood. There are many different forms of ring winding in dynamo and motor construction. By looking at Fig. 213 the course of the current through the winding is shown by the arrows. The positive brush (+) is on the top of commutator and touching a bar. The current passes into the lead 1 or wire to the winding on the ring; here it divides, part passing around the ring to the right and part to the left. That portion which passes to the right passes under the ring; the portion to left passes over the ring. The divided current then emerges into lead 2 at the bottom of the ring and unites, passing into the negative brush and then to main back to dynamo.

It was explained on a former page that when a current of electricity was passed around a piece of iron it formed an electro-magnet. The armature-ring being iron, what must be the result in Fig. 213? The result is that the ring is a consequent-pole magnet, and the pole at the top is a south pole, and that at the bottom a north pole. These poles are the result of two N. and two S. poles, because the current had two paths around the ring, forming on each half of the ring a north and a south pole. The result is that the poles repel each other, as shown in Figs. 200 and 213, which show the lines of force passing from pole to pole. It is now that the reader should remember that poles of dissimilar kind attract, like poles repel; also that the armature-ring is now a magnet having two poles.

OPERATION.

The construction of the motor fields and armature has been fully explained. The next step is to assemble the parts into the complete motor. Fig. 214 shows a

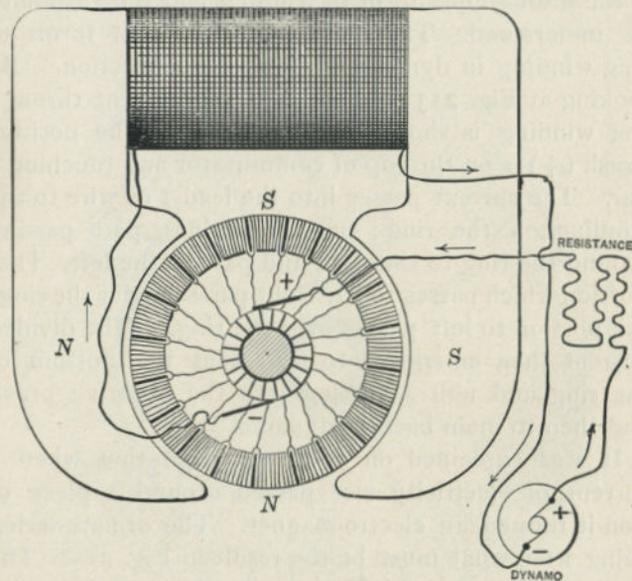


FIG. 214.—SERIES-WOUND MOTOR.

Rotation from right to left. The south pole in armature being drawn to the north pole of field, north pole of ring to south pole of field. The poles at right angles to each other, brushes bearing on separate commutator-bars and at opposite diameters. The poles being formed in the ring at the point where the leads from commutator-bars connect to the two coils.

diagrammatic view; the arrows show the course of the current through the armature and fields, this being a series motor field and armature in series. The current from the main or feeder passes into the positive brush (+)

and then into the ring winding, dividing, passing around both sides of the ring and out to the negative brush (-). As was explained on page 333, this forms two poles in the iron core of the ring, N. and S. poles. After the current leaves the armature-winding it passes to the field-coil on the left, forming a north pole as shown, then passes around to the field-coil on the right, forming a south pole; from there it passes to the ground or rail in most street-car motors or locomotives. This puts the field-winding on the ground side, but in most stationary motors the current passes through the field-coils first (see Fig. 202) and then to the armature; this also applies to motors on cars, as in this case the field-coils will form a resistance to the flow of current. When the lightning strikes the line from overhead, in the other the fields form a resistance between the earth and the armature. There are two sets of magnets: one set in the ring of armature, the other the field-poles on each side of the ring. These poles are at right angles to each other in Fig. 214; rotation of the armature will be from right to left. Why? Because the north pole of the field-magnet is attracting the south pole of the armature-ring, and the north pole of the ring is being drawn to the south pole of the field-magnet on the right. It is seen now why it is well to understand the electro-magnet. It may be thought that when the poles get opposite to each other they will become locked, but they never get together. This is due to the construction of the commutator. If there are thirty coils of wire on the armature-ring, there will be thirty commutator-bars in the commutator-ring, and these bars are insulated from each other; and as

the beginning of one coil and the end of the other is connected to one bar, and the brush bears on one bar at a time, as in Fig. 215, a pole will be formed on the

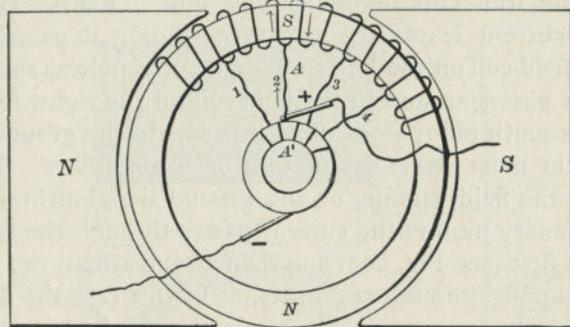


FIG. 215.

ring where the wire from the commutator connects to the winding, as *A*, Fig. 208. The pole will remain at this part of the ring as long as the brush remains on the

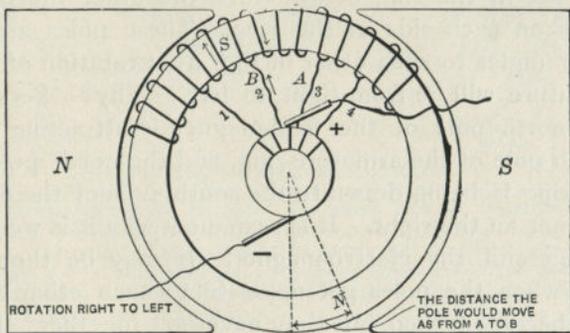


FIG. 216.

commutator-bar *A'*; the pole *S* on the ring will move with the ring through an arc of a circle due to the width of the commutator-bar, or from *A* to *B*, Fig. 216. Then

the brush will leave the bar and pass to the next one, forming the N. pole at right angles again, as Fig. 217,

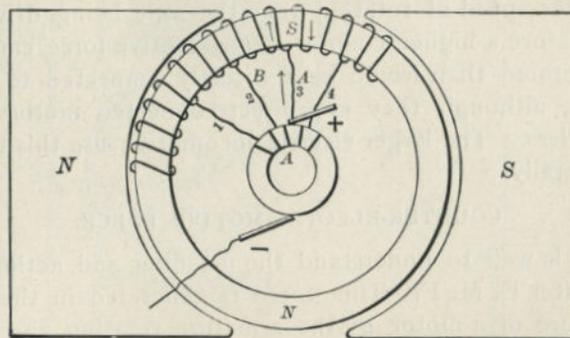


FIG. 217.

which, with Figs. 215 and 216, shows the cause of rotation of a motor armature and of shifting the poles in the armature-ring. As it appears, the poles jump backward after travelling ahead, but in no case can the poles of the fields and those of the ring get together, as has been explained. The action is the same for the negative brush (-). The width of the commutator-bar determines the distance the poles formed in the ring will travel and how near they will approach the field-poles.* This action is continued as long as current is supplied to the motor, and this is why a motor armature revolves. This action is the same with a drum armature. In smaller motors as applied to street-cars and some locomotives the armature is not connected directly on to the axle to be driven, but they have a small pinion on the armature-axle; this meshes with a large gear-wheel

* It is to be understood that the attraction between the poles in the ring and the field-poles causes the ring to rotate.

on the car-axle. This is called a single-reduction motor. By this it will be seen that the armature has a much higher speed of rotation than the axle being driven; therefore a higher counter electro-motive force can be generated than would be if directly connected to the axle, although they are direct-connected motors or gearless. The larger electric locomotive use this type generally.

COUNTER-ELECTRO-MOTIVE FORCE.

It is well to understand the meaning and action of counter E. M. F. This force is generated in the armature of a motor by the armature rotating and the winding on the core cutting the lines of force of the fields through which they are passing, or, in other words, the motor is acting as a dynamo; and it would be well to state here that a dynamo and motor are one and the same, that is, the dynamo will act as a motor if current is applied to it, and the motor will generate current if driven.

The construction of the motor and dynamo is nearly the same, the only difference being in details and conditions of winding. Railroad generators are much larger in dimensions, and usually compound wound, while the motor can be made as large as the generator if so desired. This counter-electro-motive force thus generated in the motor armature has the effect of opposing the flow of the current that is being delivered to the motor to operate it. At first thought this might seem to be a detriment, but it is in reality a benefit. Fig. 218 shows the action of C. E. M. F. The one is a motor and the other a dynamo; the arrows show

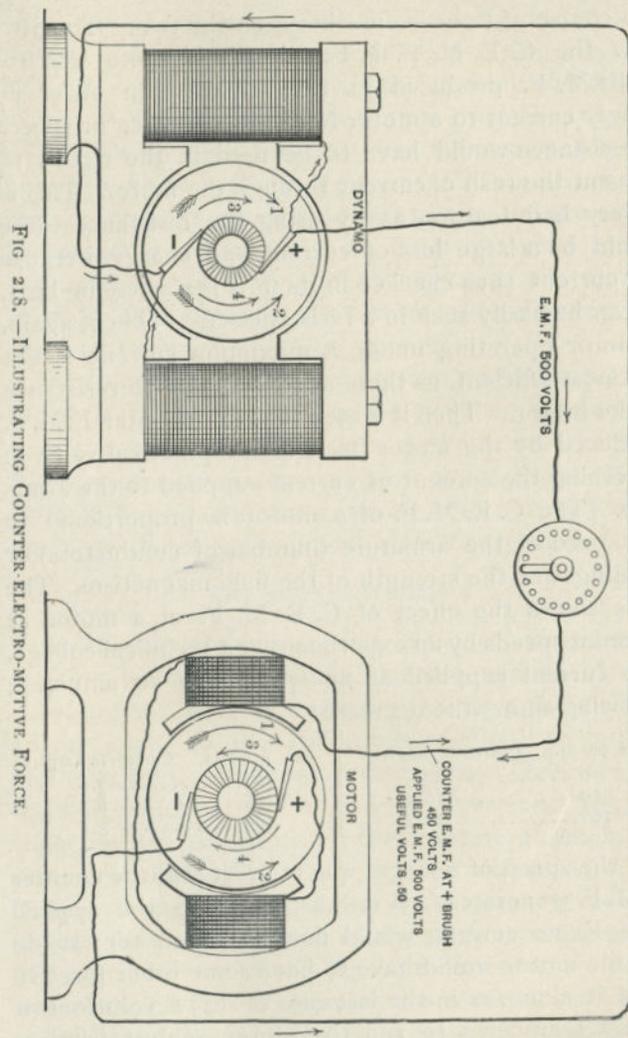


FIG. 218.—ILLUSTRATING COUNTER-ELECTRO-MOTIVE FORCE.

the course of the currents between the two. To show how the C. E. M. F. is beneficial: If there was no C. E. M. F. produced in the armature in order to supply current to a motor for a given power or speed, a resistance would have to be used in the circuit to prevent the rush of current through the motor. This is a very bad feature, as by using the resistance there would be a large loss of current and energy, because the current thus checked in its flow is wasted in heat, as can be easily seen in a resistance-coil. Then, again, a motor operating under a maximum current is not the most efficient, as there are losses due to resistance in the motor. Then it is seen that this counter E. M. F. produced by the motor itself is of a practical value in governing the amount of current supplied to the armature. The C. E. M. F. of a motor is proportional to the speed of the armature (number of conductors) or windings and the strength of the field-magnetism. The table shows the effect of C. E. M. F. of a motor at different speeds by an experiment at a technical college. The current supplied at no speed was 20 ampères; following shows the decrease:

Rev. per Min.	Current in Ampères.	Rev. per Min.	Current in Ampères.
0.....	20	160.....	7.8
50.....	16.2	186.....	6.1
100.....	12.2	195.....	5.1

If the speed of a motor was so great that the counter E. M. F. generated by it was equal to the applied E. M. F., no current would flow to the motor; to do this the motor would have to have some other force to drive it along, as in the last case of 195 revolutions it took 5.1 ampères to run the motor against friction.

The idea of explaining this C. E. M. F. clearly is for future use, as in motor regulation. In Fig. 218 C. E. M. F. is clearly shown by the dynamo and motor, which are connected by the proper circuits; they are both rotating right-handed. As an example it is supposed that the dynamo or generator is supplying current at 500 volts pressure to the motor, and the motor is producing a counter E. M. F. of 450 volts at the brush; then the C. E. M. F. is opposing the applied E. M. F., as is shown by the arrows in the drawing, and the useful voltage would be 50 volts.

In the dynamo-armature arrows 1 and 2 represent the E. M. F., and arrows 3 and 4 represent the current; and it is seen that they flow in the same direction. Now in the motor the arrows 1 and 2 represent the C. E. M. F. of the motor-armature, and arrows 3 and 4 represent the current applied from the dynamo.

REVERSING A MOTOR.

An electric motor is capable of being reversed in its rotation, which is a valuable feature, and the law of changing the flow of current to change the polarity adapts itself to the conditions required to cause a motor to rotate in different directions. There are two ways in which a motor may be reversed: first, by changing the direction of the current through the armature; second, by changing the direction of the current through the fields. But if the current is reversed in both field and armature at the same time the motor will continue to rotate in the same direction in which it was running before the current was reversed; so then it is seen that the fixed law is, the current must be re-

versed in only one of the parts to cause a reversal of motor. Fig. 219 shows the action very clearly; the motor rotating from right to left, north pole of the field on the left side and south pole on the right; in the armature the S. pole is at the top of ring and the N.

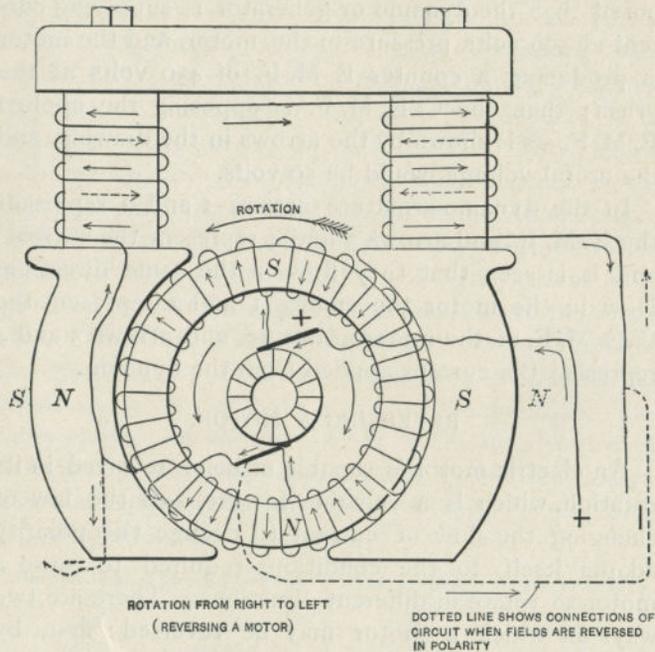


FIG. 219.

pole at the bottom. The S. pole of armature is being drawn to the N. pole of field. The current is entering the positive brush (+) of armature on top of commutator, and the current is flowing downward on both sides of the ring and passing into negative brush in

bottom of commutator-ring. Fig. 220 shows the armature rotating from left to right. The poles of the field remain the same as in Fig. 219, but the polarity in the armature-ring is changed. The N. pole is at the top of ring and the S. pole is at the bottom.

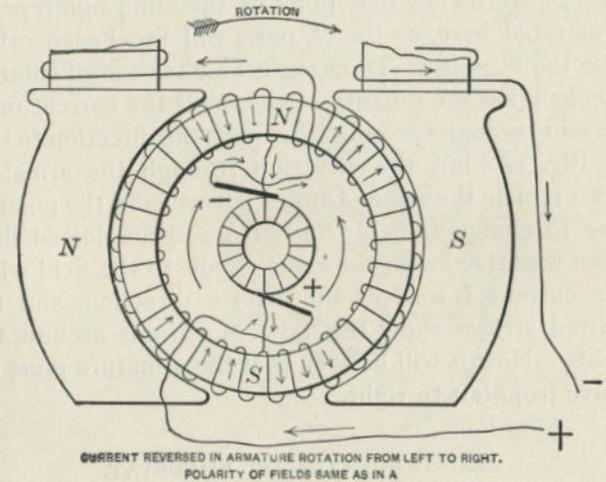


FIG. 220.

What is the cause of this? The direction of current through the armature is changed; instead of it entering the brush on top of commutator and entering the ring at the top, the current is entering the brush at the bottom of commutator-ring and is entering the armature-winding at the bottom, and is flowing upward toward the top of armature-ring and passes into the negative brush, thus forming poles of opposite sign to that of Fig. 219. Now it is seen that the motor must rotate from left to right, as the N. pole in armature will be

drawn to the S. pole of the field on the right, and from S. pole on armature to the N. pole of field on the left.

It is to be understood that all the leads to the commutator are not shown in Figs. 219 and 220, only those two in which the current is entering and leaving the ring; also the law that poles of the same sign repel is illustrated here, as the N. poles will repel each other, also the S. poles. To change the direction of rotation by changing the polarity of the fields the current must be sent through the coils in an opposite direction to that in Fig. 180, but the direction through the armature must remain the same. Dotted letters show the polarity due to change in field (Fig. 219), and the dotted lines from negative brush show the circuit to the field when the current is sent in the reverse direction, and the dotted arrows show the flow of current around the fields. Now it will be seen that the armature must revolve from left to right.

RESISTANCE-COIL OR RHEOSTAT.

The object of a rheostat is to control or regulate the amount of current that is to flow to a motor if used in connection with one, and is the same as a throttle-valve to a steam-engine. The amount of current that will flow in a circuit depends on the voltage and resistance in the circuit, so that if it is desired to take a small amount of current from a circuit having a large current and voltage a resistance must be used to check the flow of current and allow only that which is desired. It is for that purpose a rheostat is used. As an example, the main circuit has a voltage or press-

ure of 50 volts and the rheostat has a resistance of 10 ohms. The amount of current that will flow from the main circuit through the rheostat will be 50 volts divided by the resistance, which equals 5 ampères of cur-

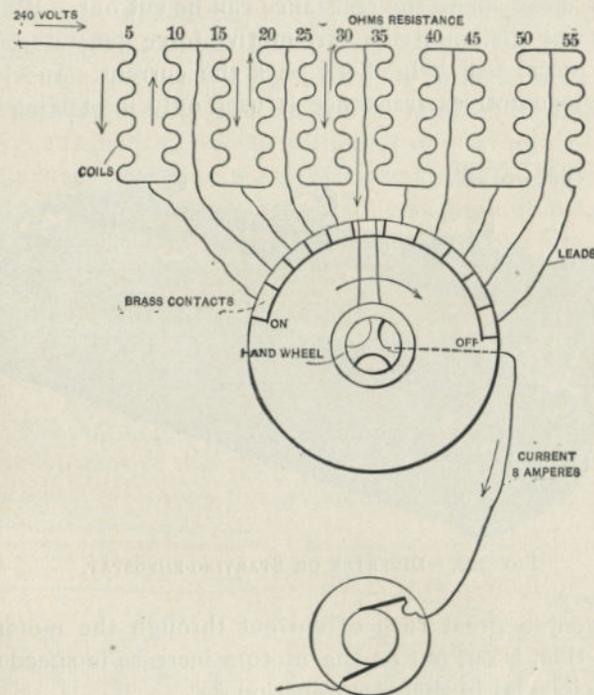


FIG. 221.—RHEOSTAT OR RESISTANCE-BOX.

rent. Or if it is desired to find what resistance a rheostat must have for a motor on a circuit of 230 volts to allow a current of 20 ampères to flow through it: According to Ohm's law resistance equals electro-motive

force divided by current; then $230 \div 20 = 11.5$ ohms as the resistance of the rheostat. As has been stated before, the resistance is reduced as much as possible to prevent loss of current due to heat, so as the motor gets up to speed the resistance can be cut out. Why? Because the counter-electro-motive force generated by the motor will help check back the current. In electric locomotives resistance is used only in starting to

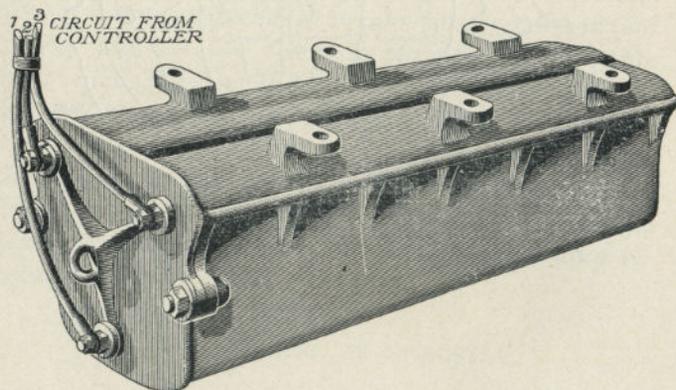


FIG. 222.—DIVERTER OR STARTING-RHEOSTAT.

prevent a great rush of current through the motors, and then is cut out as the motors increase in speed or are changed in their combination.

A rheostat as usually made is a box full of coils of wire connected in series, as Fig. 221; the current enters the first coil on the left. In the centre of this box is a lever, which can be pushed over the brass pieces or contacts. Wires lead from each of the coils to each brass segment. These segments are insulated from

each other, so the current must pass through the coils as shown. The lever is on the centre segment. The current passes from the centre coil into the lever to the motor circuit as shown. The different coils represent different resistances, so that any resistance within the limit of the rheostat can be had by moving the lever over the segments or contacts. The general form of resistance used in the electric locomotive is shown in Fig. 222, which is called a diverter or starting-rheostat. Resistance-coils are made of German silver, iron wire, and carbon, also sheet metal with insulation of mica and asbestos between the sheets. These sheets are connected in series, and suitable leads are connected to contacts. In the controller the use of the diverter can best be seen as in Fig. 234, 1 to 10.

VOLTMETER.

The voltmeter fulfils the same purpose on the electric locomotive that the steam-gauge does on the steam locomotive—shows the pressure of the current. The

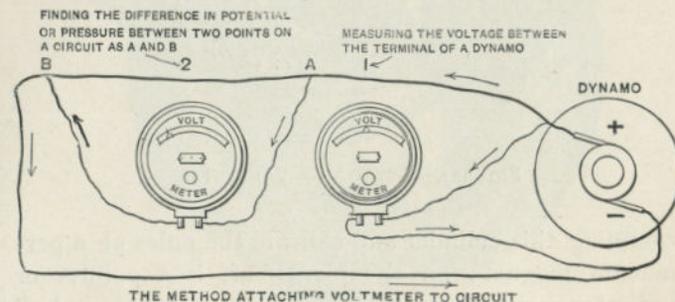


FIG. 223.

voltmeter is attached across the main circuits, as shown in Fig. 223. Thus acts as a shunt to the mains.

The general construction is shown in Fig. 216, which is a Weston voltmeter. In the centre is a small cylinder of iron. Surrounding the cylinder is a small coil of fine wire of high resistance mounted on a spindle; the pivots rotate in sapphire jewels. To counteract the movement of coil are two spiral springs. Sur-

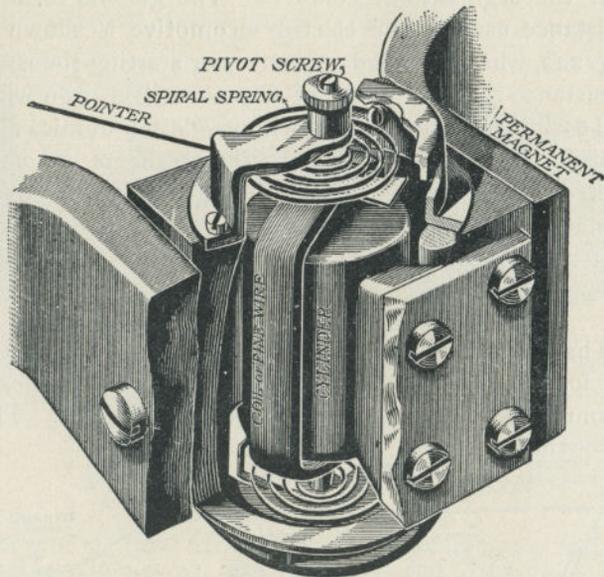
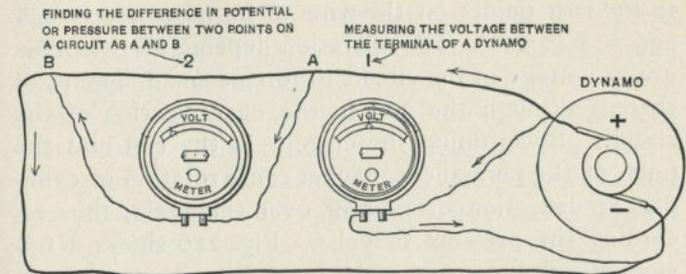


FIG. 224.—DETAILS OF VOLTMETER.

rounding this cylinder and coil are the poles of a permanent magnet; on the pivot-shaft is a pointer or indicator same as a steam-gauge hand; at the end of this pointer is a scale in volts and fractions of volts, although the meter used on a locomotive would be a

direct-reading, dead-beat instrument. What is meant by this is that direct reading there is no multiplying



THE METHOD ATTACHING VOLTMETER TO CIRCUIT

FIG. 225.—THE METHOD OF ATTACHING VOLTMETER TO CIRCUIT. constant used, as the scale shows the volts pressure. Dead-beat means that the pointer comes to a rest im-

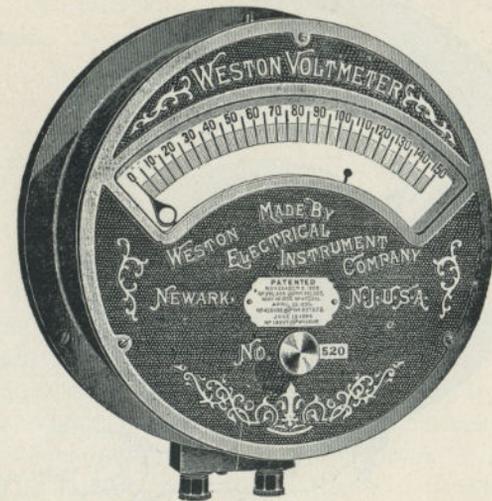


FIG. 226.—WESTON VOLTMETER.

mediately without any swing. To find the difference

in potential or pressure between any two points on a circuit the two terminals of the voltmeter are attached to the two points on the wire to be measured (see *A* and *B*, Fig. 225). The operation depends on the pressure or voltage in the circuit to force a small amount of current through the coil to the negative side of the circuit. By so doing the current in the coil and the poles of the permanent magnet cause rotation of cylinder or deflection of pointer over the scale, thus recording the pressure in volts. Fig. 226 shows a full view of voltmeter and scale.

AMMETERS.

The use of the ammeter is to indicate the amount of

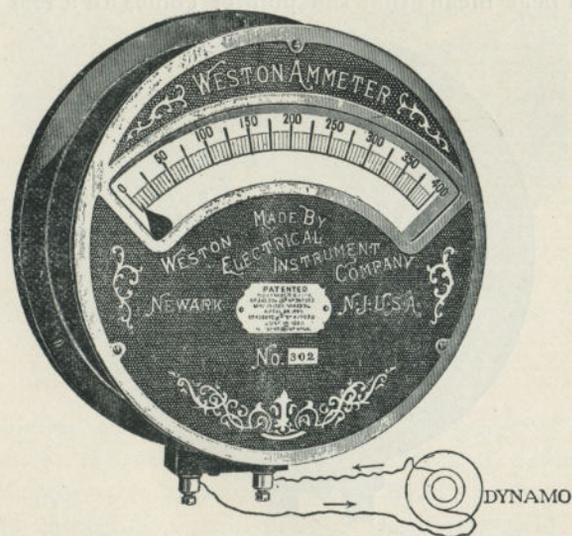


FIG 227.—WESTON "ROUND-PATTERN" AMMETER, IN SERIES WITH CIRCUIT.

current flowing through the circuit in ampères. Instead of the terminals being connected across the circuits as with the voltmeter the ammeter is in series with one side of the circuit or forms part of the circuit and thus takes the whole current through it, and is wound with a small number of heavy wires, depending on the current it is to carry. Fig. 227 shows a Weston ammeter; the construction is the same as the voltmeter except the wire on the cylinder. The reading depends on the amount of current flowing through the coil. There are many kinds of ammeters, but depending on the principle described. They are also made that only a part of the current shall flow through the meter; this is for exceedingly large currents. The ammeter is connected in parallel with the main circuit, the scale being calibrated.

AUTOMATIC CIRCUIT-BREAKER.

The automatic circuit-breaker acts the same as the safety-valve to a steam-boiler and protects the motor or generator, in case of a ground or overload. The current-breaker will be found on all electric locomotives. There are several types used, but the action depends on one principle, that is, a magnet so wound that when a certain number of ampères flow through the magnet-winding it will attract an armature which forms a trigger or lock; this causes the release of a spring which opens the switch, thus breaking the circuit. The number of ampères that will flow through the circuit can be readily adjusted to any desired amount. The point in all designs is to prevent spark-

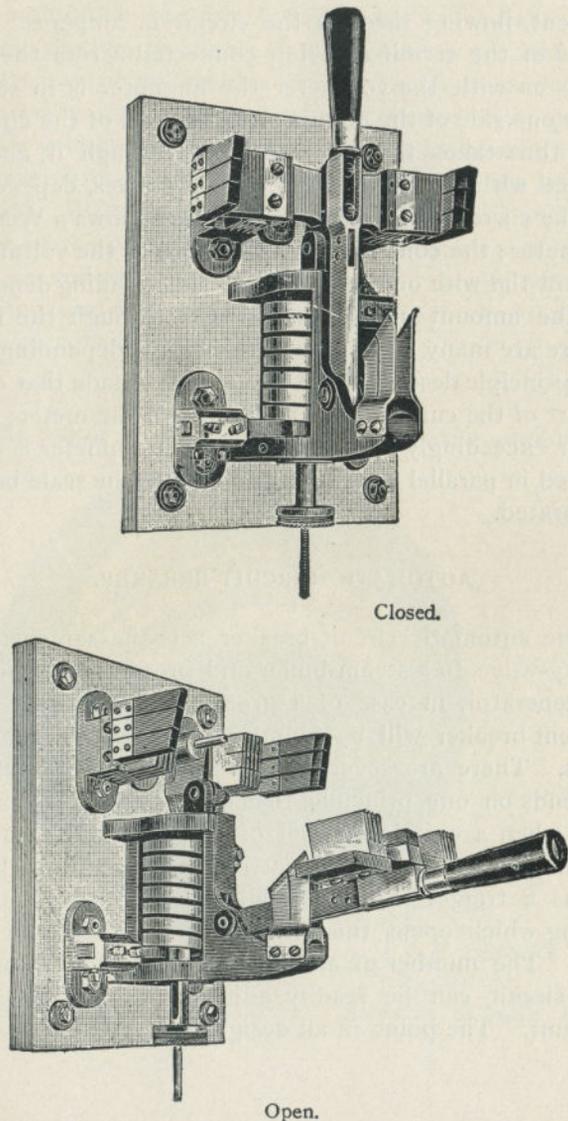


FIG 228.—DIRECT-CURRENT AUTOMATIC MAGNETIC CIRCUIT-BREAKERS. 500 VOLTS.

ing or arching at the switch-points, which is destructive and breaks the switch down. One way is to provide a magnetic blowout, which blows the arc out and thus prevents breaking down of switch. Another is to make the final break on high-resistance carbon points

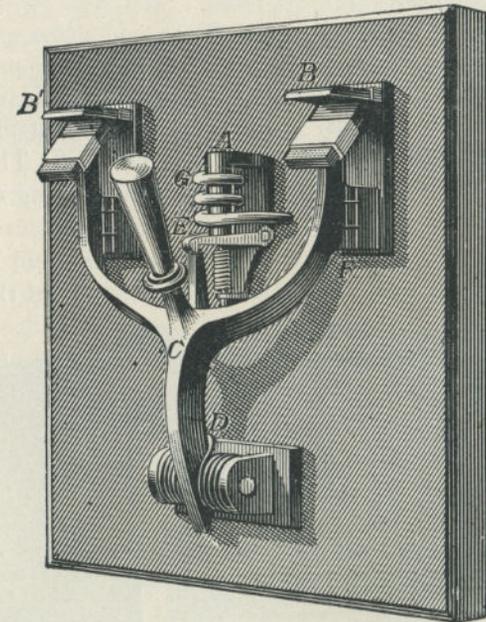


FIG. 229.—CIRCUIT-BREAKER.

A, magnet; *BB*, carbon points; *C*, switch; *D*, spring; *E*, trigger; *F*, switch-points; *G*, magnet-wire (main circuit).

In the breaker shown in Fig. 228 a fuse is used in shunt with the circuit, and after the switch is at the point of opening the fuse will take part of the current, thus provide a by-path and prevent the arcing at switch. When

the fuse takes the full load, it is blown, and the circuit is broken complete.

Fig. 229 shows the general principle of construction of an automatic breaker more plainly than Fig. 228. In Fig. 228 the breaker is shown in two positions, open and closed.

FUSE.

The object of having a fuse is to provide against heavy currents or overloads. A fuse can be made of an alloy of tin and lead; a copper wire may be used. The idea is that the fuse, being of certain size and having certain fusing-points, will carry a certain amount of current in ampères, and if from any cause there should be an extra amount of flow over what the capacity of the fuse

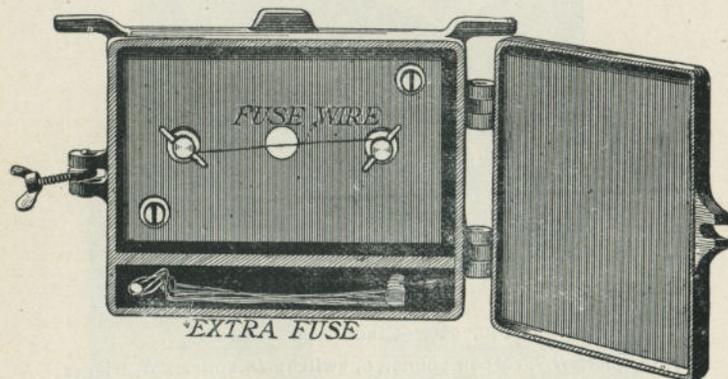


FIG. 230.—FUSE-BLOCK.

is the fuse will melt, thus opening the circuit, and save the motor from being burned out. Fig. 230 shows fuse-block. This is made of iron, slate, and asbestos and is of a novel design. The fuse is a simple copper wire.

It is placed upon the slate back of an iron box, which is entirely closed with the exception of a hole in the slate before which the fuse-wire passes. The rush of the heated air through this hole when the fuse is blown effectually blows out the arc. A pocket at the bottom of the box inside the door is provided for carrying extra fuses. This fuse is placed in the circuit between motors and trolley-wire when used on street-car motors and electric locomotives which take their current from a trolley-wire.

LIGHTNING-ARRESTERS.

The purpose of a lightning-arrester is to act as a safeguard to the insulation of the motors from the lightning discharge. Lightning, in striking the line, will find the shortest path possible to earth. Then the motors of a locomotive, being in parallel with the line and the earth, afford a path for the lightning discharge. Lightning, being of high electro-motive force and small current, can leap across a gap where the current from the generator would not. This fact is taken advantage of in constructing arresters. If there are no arresters provided, the lightning will enter the winding of the motor fields when they are on the trolley side, and the field-windings, being of many turns of wire, form a high resistance to the flow of the lightning discharge, and form a high self-induction, which also has the effect to choke back or retard the passage of the discharge. The discharge, as has been stated, having a high E. M. F., seeks the shortest path to ground by disrupting or breaking down the insula

tion of the field-winding and finding its way to earth through the field-cores or the iron of the motor and wheels of the locomotive. This provides a path for the current from the generator to the ground and thus short-circuits the motor, and where an arc is formed, if in the winding, will burn the insulation. There are many different forms of arresters, all depending on the principle that the discharge will leap a gap between two points rather than pass through a more tortuous path through the motor (Fig. 231), The one point de-

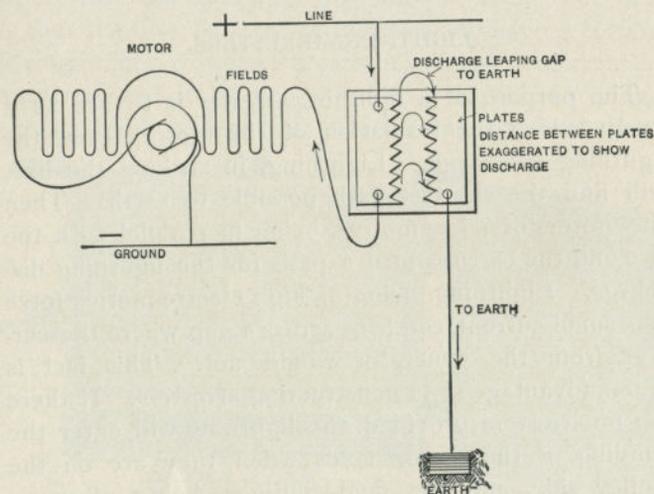


FIG. 231.—LIGHTNING-ARRESTER, COMMON STYLE.

sired in a good arrester is that it will act promptly and disrupt the arc formed across the air-gap so as to stop the flow of the current from the circuit which will follow the lightning discharge.

There are different ways of doing this,—magnetic

blowout; magnetic attraction of an armature, which forms one end of the circuit to earth,—but the most common is two brass plates having teeth similar to saw-teeth, one connected to the line and the other connected to the earth circuit, the two plates set with teeth separated $\frac{1}{16}$ of an inch from each other. Fig. 223 shows the action of the lightning leaping across the gap and passing to earth. In the magnetic blowout the advantage is taken of the fact that if an arc is placed between two poles of a magnet the arc will be deflected to one side, and if strong enough will disrupt or blow the arc out. So it is with this style of arrester: the discharge takes place between the two poles of an electro-magnet which is energized by the flow of current, which blows the arc out and breaks the circuit to ground. (See Fig. 232.)



FIG. 232.—MAGNETIC BLOWOUT.

CHANGE OF SPEED.

The method mostly used to change the speed of motors is to change the strength of the fields, and in practice motors are wound with a large amount of winding on the fields, so that a maximum strength of field is attained with a small current as compared with

the maximum current. This is equivalent to saying that the magnetism given by a small current is yet sufficient to saturate, or nearly saturate, the iron of the magnets. If the fields be kept below the point of saturation and be varied in strength, the speed can be varied to a certain degree; if a car is moving on a level, to produce a counter E. M. F. of 400 volts and the applied E. M. F. is 500, and the resistance of armature circuit is 10 ohms, the current flowing should

$$= \frac{500 \text{ volts} - 400 \text{ volts}}{10 \text{ ohms}} = 10 \text{ ampères of current.}$$

Then the mechanical work done would be 400 volts \times 10 ampères = 4000 watts. Now if it is desired to run slower and the field strength is increased 10 per cent, the counter E. M. F. at the same speed would be 440 volts;

the current = $\frac{500 \text{ volts} - 440 \text{ volts}}{10 \text{ ohms}} = 6 \text{ ampères of}$

current. Then 6 ampères \times 440 volts = 2640 watts. Now the motors required 4000 watts to maintain the former speed; it is evident that the motors will run at a slower speed under the new condition, due to greater field strength.

The second important method of regulating speed under varying loads is found in the variation of the E. M. F. applied to the armature. From what has been said concerning the measure of work done it will be readily seen that, other things being equal, decrease of applied E. M. F. must be followed by decrease of output, and increase of E. M. F. by increase of output. Let us again consider the case of a motor developing 400 volts counter E. M. F., the applied E. M. F. being 500 volts, the current being 10 ampères, and

the resistance to motion being uniform. If now we reduce the applied E. M. F. (E .) to 450 volts, and if we conceive that for a moment the counter E. M. F. (E' .) remains at 400, the current would be reduced to 5 ampères; thus, $\frac{450 \text{ volts} - 400 \text{ volts}}{10 \text{ ohms}} = 5 \text{ ampères.}$

Such a change would reduce the output to one half its former value. The speed would then necessarily drop to one half unless this decrease of output be checked in some way. This check would come through the fact that a decrease in speed would be followed by a corresponding decrease of E' which would at once increase C' . In case two or more motors be used on one car or train there remains a third method of producing a considerable range of control, namely, by changing the machines from the multiple to the series arrangement with respect to each other, and *vice versa*. The applied E. M. F. is just one half in the second case what it is in the first if there be two motors, one third if there be three, and so on. A variation of this method might be had by changing the field-winding, leaving the armatures permanently in series or permanently in multiple. The series arrangement of the two machines is of special value in starting a car and in maintaining low speeds. In both cases it may become the equivalent in effect and the superior in economy of either of the above, described methods of control. Through this method it is indeed possible to make the same motors fulfil widely different service conditions. Thus, suppose cars are to begin their trips in the most populous portions of a city where many stops and relatively slow running are unavoidable, while on reaching

the suburbs long runs at high speed are desired. We may then design motors which if placed in multiple and permitted to run at say 25 miles an hour will develop each 25 horse-power. If placed in series, they would each develop 12.5 horse-power at 12.5 miles per hour, and at both speeds their efficiency may be high.

To meet speeds lower than 12.5 miles per hour, the load such as would permit only that speed if the impressed E. M. F. be 250 volts (half of 500 for each), we may resort to either of the two methods of general control, the motors as a whole being kept in series. So for speeds between 12.5 and 25 miles per hour, the torsional effect required being still the same, we may in like manner control the two motors placed in multiple. In case of any heavy and long grade this latter arrangement would be used.*

CONTROLLER AND SPEED-REGULATOR.

The electric locomotive is as capable of control as a steam locomotive, and can be made to run under various speeds and loads. To regulate speed there is a controller on the locomotive usually of the series-parallel type. In the older forms of controllers the rheostat was used to regulate the amount of current that would flow to the motors, on street-cars and the smaller types of locomotives having two motors. These motors were connected permanently in parallel, the current dividing, one branch passing through each motor, and then joined again in a single circuit, passing to the ground. The reduction of the line-pressure to

*Crosby and Bell.

a point at which the motors would start was regulated by the rheostat placed in the circuit between the trolley and the motors. As the current divided, half flowing through each motor, the amount of current required would be double that required by one motor to move its share of the load. All this current had to flow through the rheostat. The pressure dropped in the rheostat is dead loss, and produces no work, but is wasted in heat. By multiplying the drop by the current flowing the total loss can be found. Of course when the motors get up to speed, the resistance is gradually cut out. An effort was made to overcome this loss, and the series-parallel controller was devised. In this the motors are first connected in series; the circuit passes first through one motor and then the other without division. By this means, together with a very slight resistance, which is instantly cut out, the proper starting-pressure is applied without loss; and, the motors being in series, the same current that starts one motor flows through and is used over again in the second motor, thus taking one half as much current from the line as in the rheostatic method of control. After the car is started, current to each motor is increased by gradually throwing the motors in parallel with no resistance in circuit. It will be seen that the final or full speed connections are the same in both methods. Fig. 233 is a full view of a series-parallel controller open, showing the contacts, revolving cylinder, and reverser. The figures marked from 1 to 10 in Fig. 234 show the various combinations that the controller will put the motors in to start and vary the speed and power of the locomotive or car. The controller shown in

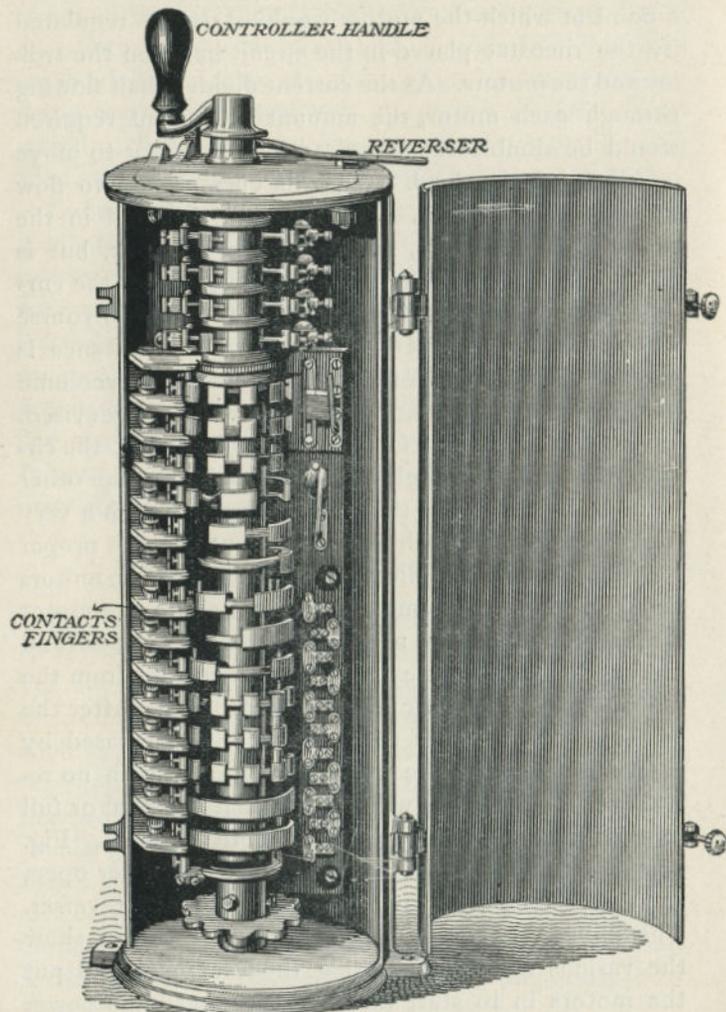


FIG. 233.—CONTROLLER, OPEN.

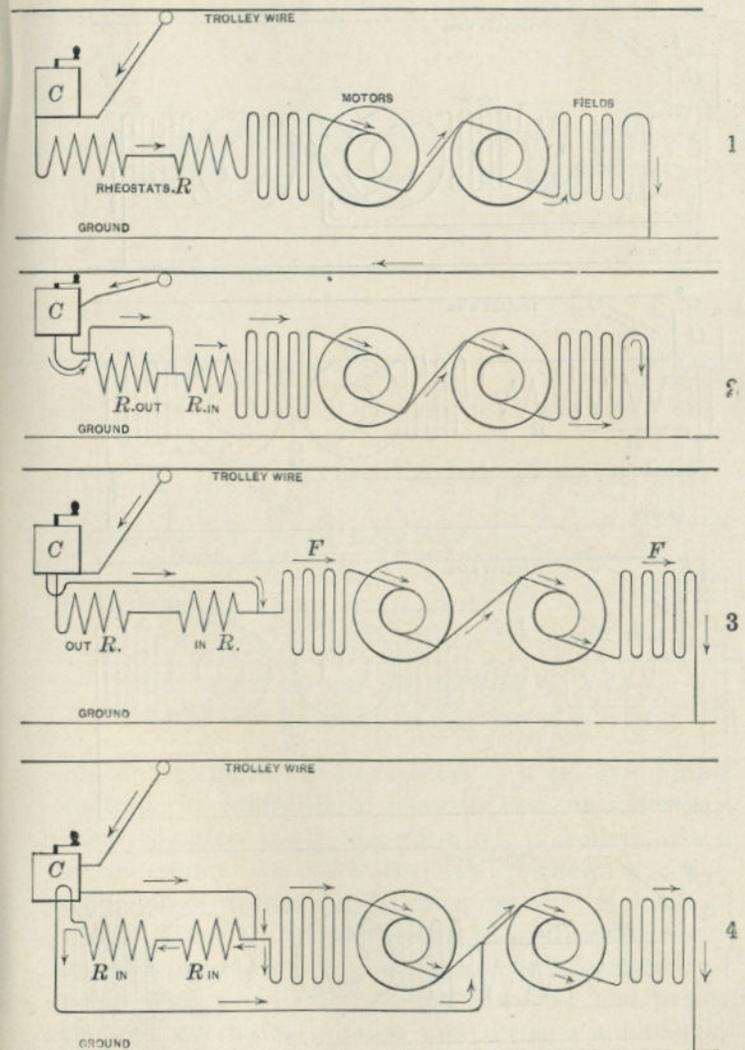


FIG. 234. (1 TO 4).—SERIES PARALLEL CONTROLLER COMBINATIONS.

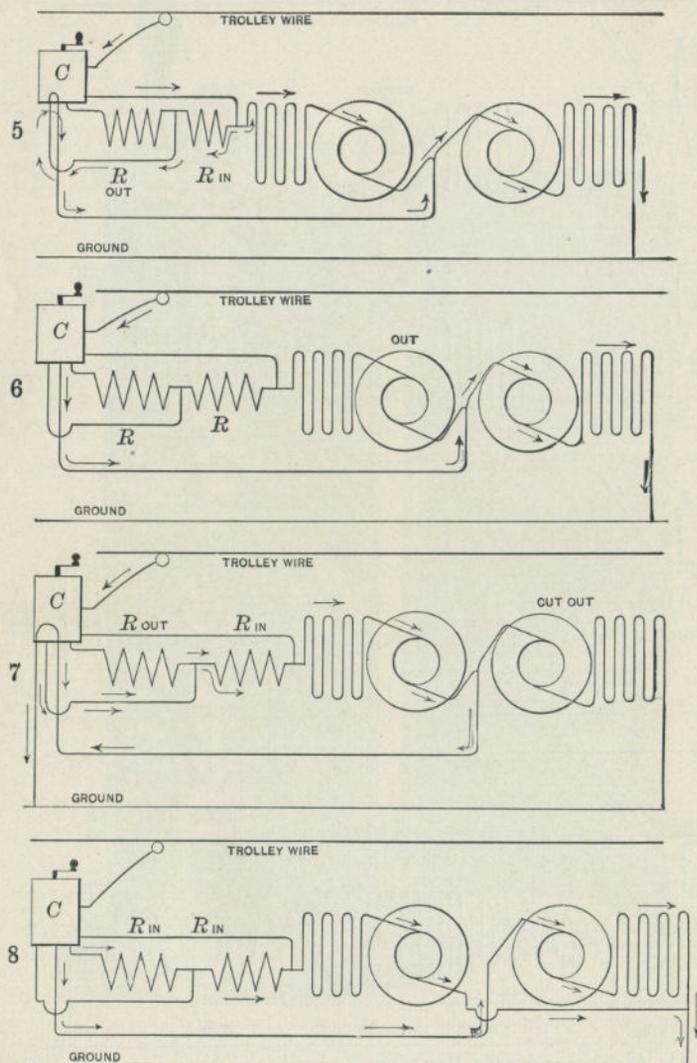


FIG. 234 (5 TO 8)—Continued.

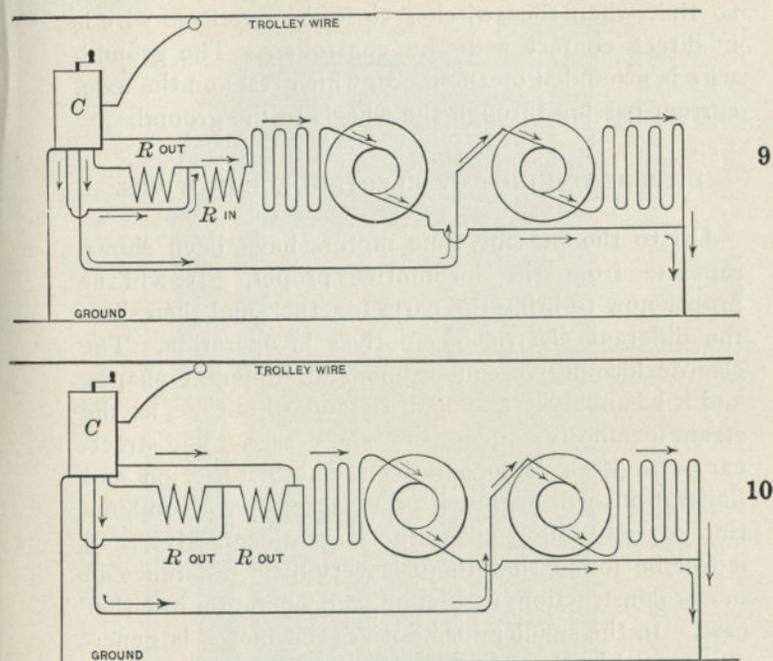


FIG. 234 (9 TO 10)—Continued.

NOTE.—Follow the arrows for the course of current.

Fig. 233 contains for two motors 13 wires going from controller to controller, as generally two controllers are used—8 motor- and 3 rheostat-wires, 1 trolley- and 1 ground-wire. The wires are joined to their respective binding-posts in the cut-out box, except the rheostat-wires. There are also short wires going from the binding-post to motors and ground, also one wire to trolley pole. This wire is led to the fuse-box, and passes through overhead switches and through a fuse-box,

so that when the switches close the overhead wire is in direct contact with the controllers. The ground-wire is grounded on the motor which rests on the axle, current passing through the wheels to the ground.

DIFFERENT KINDS OF ELECTRIC LOCOMOTIVES.

Up to the present time motors have been shown separate from the locomotive proper. It will be proper now to bring the parts together, and then show the different electric locomotives in operation. The electric locomotive can be made in different shapes, and it has not yet assumed a standard outline, as the steam locomotive, except in certain cases. The street-car is in itself a locomotive. The description and illustrations will begin with the motors on a combination car and follow up to the larger locomotive, and it will be found that there is very little difference in motor construction, regulation, and operation in either case. In the smaller locomotives the motor is generally geared to the driving-axle by what is called single reduction, that is, a small pinion on the armature-shaft and a large gear-wheel on the driving-axle. By this method the armature can run much faster than the axle, and thus can produce the proper counter E. M. F. and speed. Motors used to be of double reduction. On the large electric locomotive the motor is directly connected without any gearing, which will be explained in the description of same. The locomotive shown in Fig. 235 is of the combination type, and is a little smaller in dimensions than a standard passenger coach. Four Westinghouse motors, each motor being

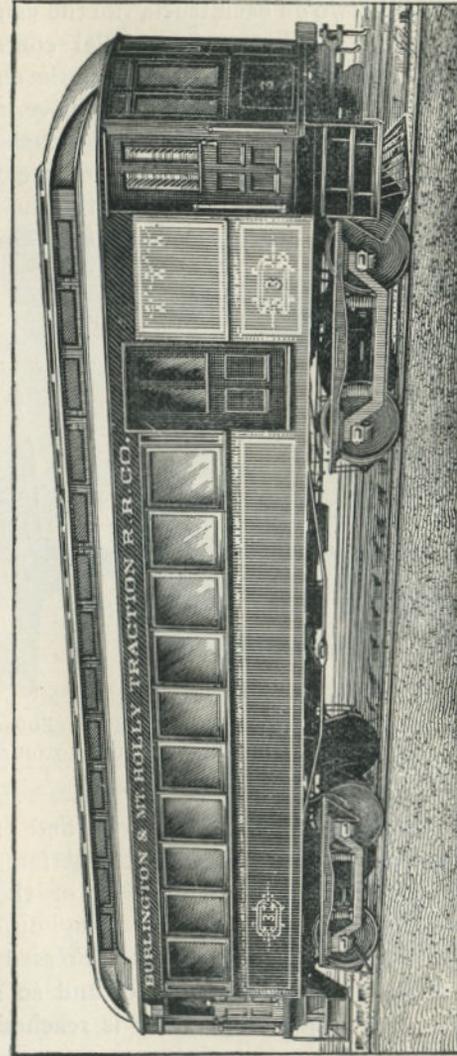


Fig. 235.—COMBINATION PASSENGER AND BAGGAGE MOTOR CAR, MT. HOLLY & BURLINGTON R. R.

Motorman's Position.

of 50 H.P. capacity, two on each truck, run the car. At either end of the car is a series-parallel controller and the usual equipment; also an automatic circuit-breaker is provided in this style of locomotive. The man in charge of running the car is protected from the weather and has a very clear view of the track ahead of him. It will be seen by the cut that his position is on the platform of the car, and doors open at

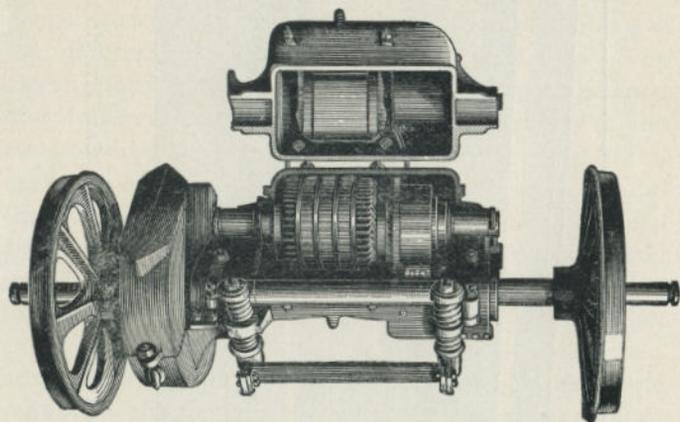


FIG. 236.—WESTINGHOUSE STEEL MOTOR, 50 H. P., FOUR-POLE, TWO-CIRCUIT, DRUM ARMATURE, USED ON BURLINGTON & MT. HOLLY MOTOR CAR.

the sides to permit passengers to get on and off, although only at one end, so it does not interfere with the man running the car. One portion of the car is used for baggage, as shown. The Westinghouse air-brake is used to stop with. The air is compressed by a pump operated by a small electric motor and so regulated that when the required pressure is reached the

motor will be stopped, this being similar to an air-pump governor used to regulate the air-pressure on a steam locomotive. The method of attaching motors to the axles of a locomotive or motor car of this style is shown in Fig. 236. Another method of suspending motors is shown in Fig. 237, a full view.

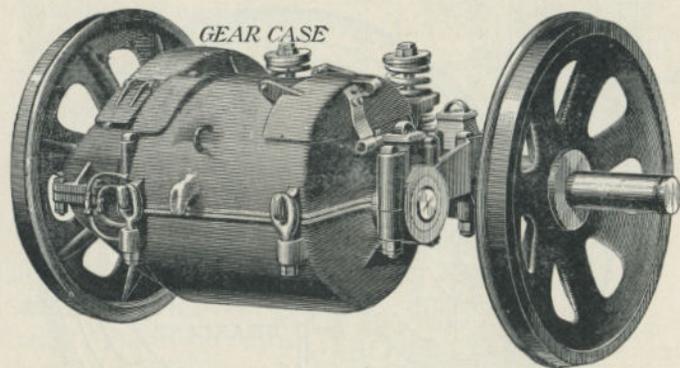


FIG. 237.—SPRING-MOUNTED STEEL RAILWAY MOTOR. (Front View.)

The method used to accomplish this is shown in Fig. 238 which is an end elevation of the motor with one wheel taken away. *B* is a U-shaped frame, the rounded end of the U being journalled on the car-axle in the ordinary way. Swinging freely between the arms of this U is the motor *A*, trunnioned by its bearing-cases. The motor is then supported at the rear by spiral springs *C*, between the lugs on the frame—which have a factor of safety in strength of twenty—and the arms of the U. This feature is also shown in Fig. 237. At the front end it is supported

by a swinging arm from the ordinary spring truck-bar *D*. It can be seen that, with this suspension, the motor rides freely on springs, readily adjusting itself to varying conditions without bringing a strain or check on any part. The gear-centres are always maintained because of the U-shaped frame.

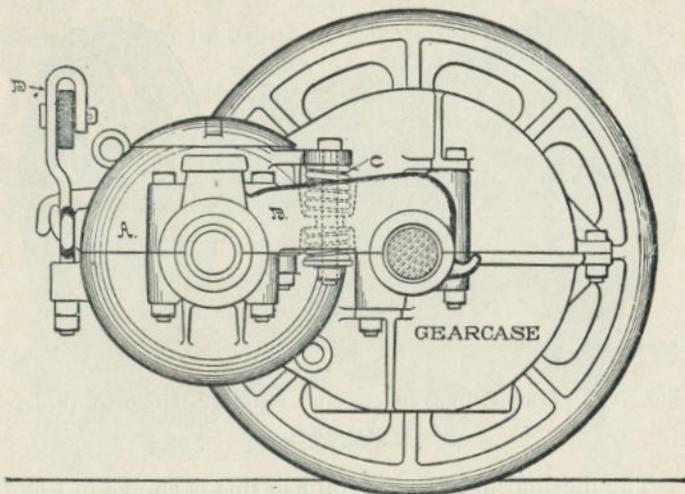
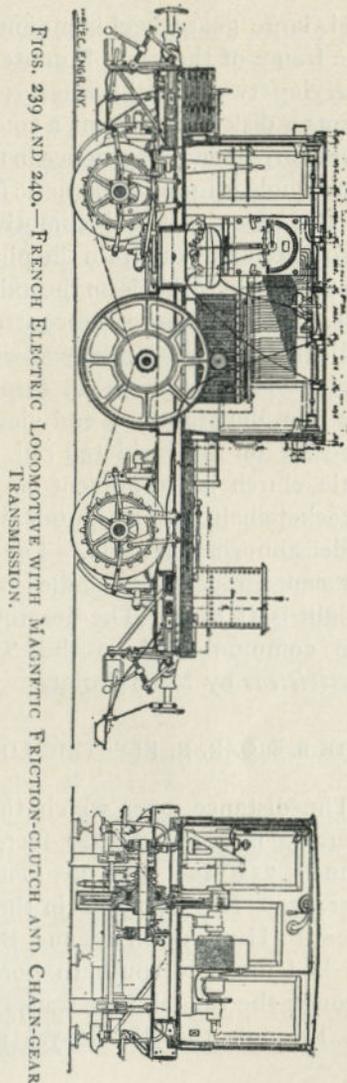


FIG. 238.—METHOD OF SUSPENSION.

ELECTRIC LOCOMOTIVE, FRANCE.

Figs. 239 and 240 show an electric locomotive that has taken the place of a steam locomotive in hauling coal and freight through tunnels, which the electric locomotive is particularly adapted to on account of the absence of dirt and smoke. In this design it will be seen how readily a locomotive can be constructed. This was in reality a flat car, which was loaded down with iron to get the required tractive adhesion. The motor was then mounted on the car. It is a series-wound motor. In order to drive the wheels a bronze pinion meshes with a large gear-wheel which forms a combined gear and magnetic clutch. The centre or hub is surrounded by a coil of wire for the purpose of making a magnet of it.



This large gear-wheel is mounted on a shaft carried on the frame of the car. Mounted on this axle is a sleeve carrying two sprocketwheels; the end of this sleeve forms a disk which forms a cone ring on its face, which fit in corresponding grooves in the large gear-wheel hub. As a whole it forms a magnetic friction-clutch. Fastened to the axles of the locomotive are sprocket-wheels; sprocket-chains run from the pinions of friction-clutch to these sprocket-wheels on the axles and drive the locomotive. The cut shows the controller, wiring-motor, magnetic friction-clutch, and gear-wheels very plainly. The current is taken from an insulated rail placed in any position, illustrated by end view; contact-shoes on the car slide on this insulated rail. The idea of the magnetic clutch is to prevent any undue strain on the sprocket-chain, as the clutch is so calculated as to slip under abnormal tension. The speed, $3\frac{3}{4}$ miles on 1.4 per cent grade, and 6 miles on the level. The total weight is 15 tons. The description of this locomotive was communicated to the *Société Internationale des Electriciens* by M. Hillariet.

THE B. & O. R. R. ELECTRIC LOCOMOTIVE. (Fig. 193).

The distance over which the electrical locomotive operates is about 15,000 feet, passing through two tunnels, 7339 feet and 265 feet long respectively, and over 7396 feet of track in the open from Hamburg street to Huntington avenue, Baltimore. Three tracks are laid into the southern portal, two tracks passing through the tunnel, four tracks from the northern portal, through the Mt. Royal avenue arch, and two

tracks as far as Huntington avenue, where a siding is provided for the electrical locomotives. There is a steady grade of .8 per cent from the southern through to the northern portal, and the lines in the open have two equated curves of 10 degrees, with a steady gradient of $1\frac{1}{2}$ per cent. At the power-house end of the line the locomotives run on a siding at the beginning of the long open cut running down to the southern portal.

The operation of the freight trains begins at the main tracks south of the Camden station, where they will be switched into the cut. The electric locomotive then couples on behind, without stopping the train, and pushes it through as far as the Mt. Royal avenue portal, a distance of 8146 feet, the steam locomotive doing no work. After passing out of the tunnel both steam and electric locomotives pull and push together up the heavier grade as far as Huntington avenue, the average speed over the entire distance being about fifteen miles an hour. At Huntington avenue the electric locomotive will uncouple and run into its siding.

The plan of pushing the passenger trains through the tunnels has been abandoned, in view of the possible results if one of the cars or the steam locomotive should leave the track in front of the heavy electric locomotive travelling at thirty miles an hour. The passenger trains will, therefore, be pulled through from the Lombard street station near the south end of the tunnel to the Bolton street station at the north end.

The 96-ton locomotive, built by the General Electric Co., has the following dimensions and capacity:

Number of trucks.....	2
Number of motors.....	4-2 to each truck
Weight on driving-wheels	192,000 lbs. (96 tons)
Number of driving-wheels.....	8
Draw-bar pull	42,000 lbs.
Starting draw-bar pull.....	60,000 lbs.
Gauge.....	4 ft. 8½ in.
Diameter of drivers.....	62 in. outside of tires
Length over all.....	35 ft.
Height to top of cab.....	14 ft. 3 in.
Wheel-base of each truck.....	6 ft. 10 in.
Extreme width.....	9 ft. 6½ in.
Diameter of sleeve-bearings.....	13 in.

The driving-gear consists of a cast-steel spider, shrunk on and keyed to a cast-steel driving-sleeve, having a tensile strength of 80,000 lbs.

The draw-heads are of the Janney type, similar to those used on the Baltimore & Ohio passenger locomotive tenders, and are made of cast steel with wrought-iron knuckles. In coupling with freight trains the ordinary link and pin will suffice; but for passenger service the Janney couplers, with which each locomotive is provided, are used. The front and back of the locomotive is provided with safety-chains, and in addition to the regular couplings, between the trucks, safety-links are used. The buffers between the motors act as spacers for, and fit between plane surfaces in, the field-magnets. These spacers have a complete freedom of movement which allows the field-magnets to rotate when the motor is in action. These buffers and spacers are so placed as to permit the interchange and reversal of the positions of the field-magnet without requiring change in the position of the spacers. The motors are supported on carriers bolted to the field-

magnets, and rest in adjustable hangers carried on half-elliptical springs placed on top of the frame and bumpers. The frames thus carry the motors by car-

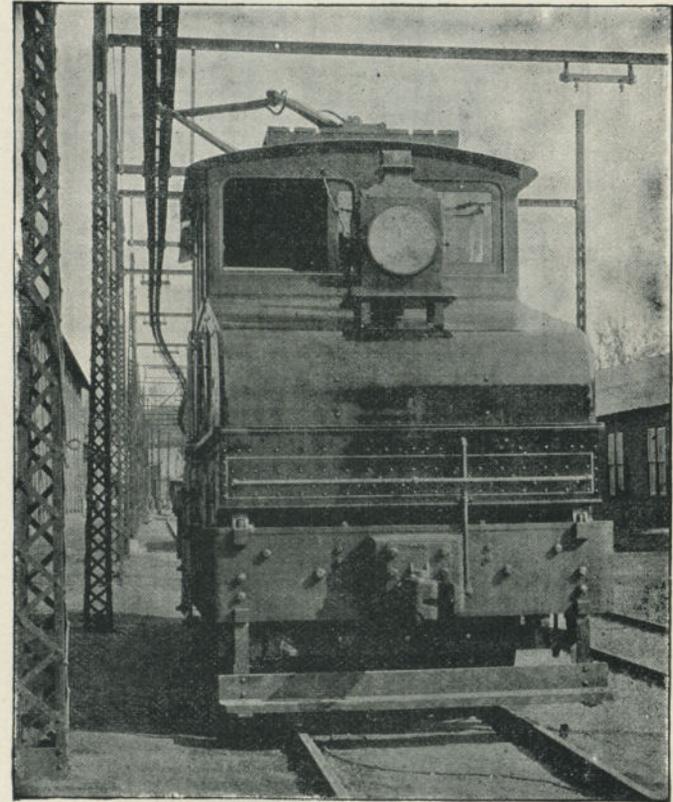


FIG. 241.—END VIEW OF B. & O. ELECTRIC LOCOMOTIVE.

riers and springs, and this load is carried in turn by rubber blocks in a cast iron casing. (Fig. 242.)

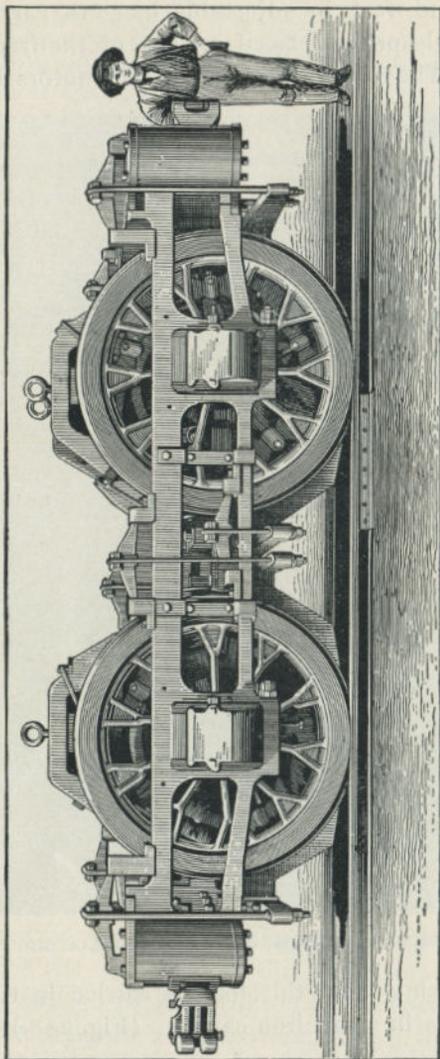


FIG. 242.—SIDE VIEW OF ONE TRUCK.

The cab is of sheet steel and the arrangement is such that all the commutators are visible to the motor-men.

The locomotive is fitted with sand-boxes, and Westinghouse automatic driver- and train-brakes are provided for all wheels, bearing upon the flanges and outside tread only. A brass signal-gong 8 inches in diameter is placed in the cab to be rung from either end of the locomotive. The headlights, of which there are two, are placed on the top of the shields at each end, and are twenty-three-inch lights of Baltimore & Ohio standard pattern. (See Fig. 241.) One shield also carries a Baltimore & Ohio standard whistle, blown by compressed air. The other shield carries a standard bell, operated by an automatic air-pressure bell-ringer. The locomotive is painted with the standard color and design of the Baltimore & Ohio Company.

The gearless motors are four in number, two to each truck, flexibly supported and transmitting their power to the wheels through the flexible connections described above. They are of pyramidal shape, are the largest railway motors in the world, and, while ponderous in appearance, are by no means so bulky as might be expected from the heavy work they have to perform. Each has six poles and six sets of carbon brushes, the brushes being connected to a yoke revolving through 360 degrees to facilitate accessibility to them. It is possible to remove four brushes without disabling the motor. The field-spools are encased in sheet-iron cases and fitted over the pole-pieces bolted to the field-frame. The armatures are built of sheet-iron laminations, and are series drum-wound iron-clad.

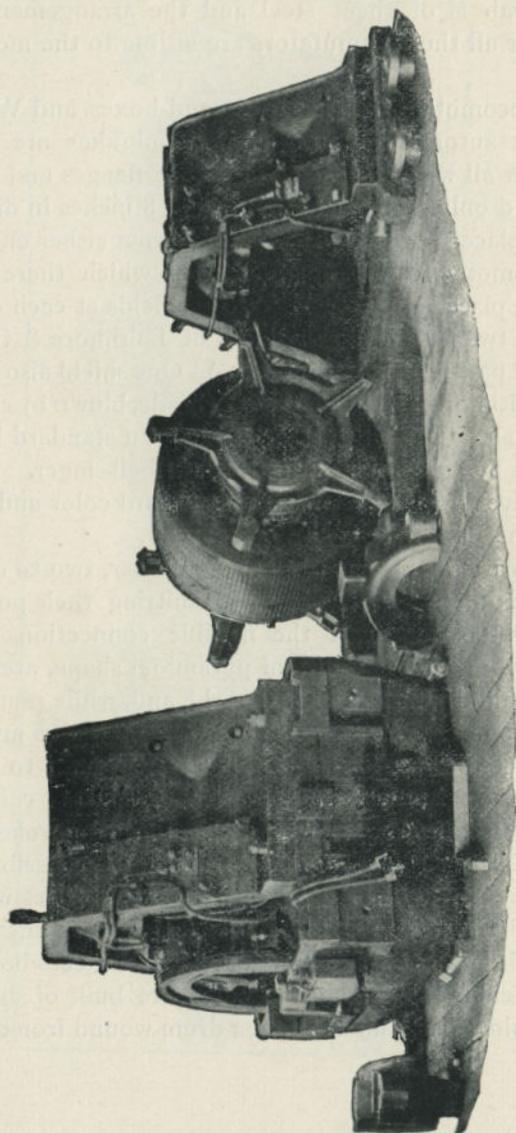


FIG. 243.—THE MOTOR UNASSEMBLED.

The armature, with the commutator, is mounted upon and keyed to the hollow sleeve which is carried on the journals on the truck-frame. The inside diameter of the sleeve is about two and a half inches larger than the axle. The entire motor is practically fireproof. Each motor is rated at 360 H. P. and takes a normal current of 900 ampères.

When normally placed, the motor rests in a position concentric to the axle, the clearance between the axle and the sleeve allowing of a flexible support. The interposition of the rubber cushions, through which the torque of the armature is transmitted to the driving-wheels, allows the armature to run eccentric to the axle when the motor departs from its normal position on account of any unevenness in the track. The motor is designed to allow of ready removal of the field-frame for inspection or repair.

A test of the first completed truck, representing one half of the locomotive, was made upon the tracks at the Schenectady shops of the General Electric Company. In order to obtain the necessary load a heavy six-wheel engine was made use of and the electric locomotive truck coupled to it. The machines were then sent in opposite directions and tugged at the connecting coupling as in a tug of war. The electric locomotive had a slight advantage over the steam-engine in weight on the driving-wheels, and pulled it up and down the track with apparent ease. For the same weight upon the drivers it was shown that the electric locomotive starts a greater load than the steam locomotive. The pull being constant throughout the entire revolution of the wheel, the difficulty of variation of pull with the

crank-angle, as in the steam locomotive, is eliminated. The test also proved the driving-mechanism and armature-couplings amply strong to transmit the torque of the armature to the axle. The controlling devices, etc., occupy the interior of the cab. The controller is erected in one half of the cab, and is of the series-parallel type. The reversing-lever projects through the upper plate of the controller-cover. The resistances are placed around the frame beneath the floor of the cab. The locomotive is equipped with a 1200 to 3500 automatic circuit-breaker and one 2000-ampère magnetic cut-out, a 5000-ampère illuminated dial Weston ammeter, and one illuminated dial Weston voltmeter. The compressed air for the whistle and brakes is supplied by an oscillating cylinder electric air-pump, the air-tanks being placed at each end of the complete locomotive. In the cab are incandescent lights.

Contact with the overhead conductor is effected by means of a sliding shuttlelike shoe of brass (Fig. 244),

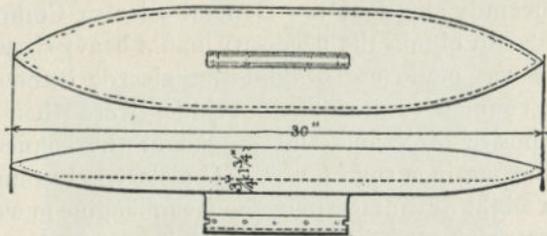


FIG. 244.—SHOE FOR TROLLEY.

which is fixed to a flexible support fastened to the top of the cab. This "trolley" support is diamond-shaped and compressible, contracting and expanding as the height demands, and is arranged to lean on one side

or the other as the locomotive runs on one side or the other of the overhead conductor. It is, however, rigid in so far as movement forward or backward over the locomotive is concerned. The current is brought to the locomotive by means of cables connected to the shoe and fastened to the "trolley" support.

The conductor is simply a reversed iron conduit or

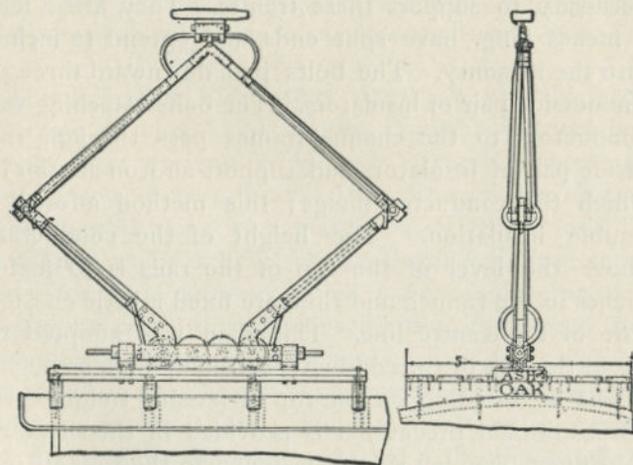


FIG. 245.—SIDE AND END VIEW OF TROLLEY.

trough erected overhead on trusses in the open, and in the tunnel attached to the crown of the arch. In the open the conductor is directly over the centre of the track; in the tunnel over the centre line of the space between the tracks. It extends from Henrietta street on the south to Huntington avenue on the north, a distance of 15,000 feet. The conductor consists of two 3-inch iron Z bars $\frac{3}{8}$ inch thick, riveted to a cover-

plate $\frac{1}{4}$ inch thick and $11\frac{1}{2}$ inches wide, and is constructed in sections 30 feet long. It weighs about 30 pounds per foot. At intervals of 15 feet inside the tunnel there are suspended from the arch transverse frames, consisting of two 3-inch channels, held together by plates 4 inches wide, and holding four castings into which are fitted conical porcelain insulators. In the masonry of the tunnel are fitted the bolts necessary to support these frames. They are 2 feet 6 inches long, have split ends, and extend 12 inches into the masonry. The bolts pass downward through the outside pair of insulators. The bolts attaching the conductors to the channel-frames pass through the inside pair of insulators and support an iron stirrup in which the conductor hangs; this method affords a double insulation. The height of the conductors above the level of the top of the rails is 17 feet 6 inches in the tunnel, and they are fixed a little on each side of the centre line. This plan was adopted to avoid the risk of the conductors striking brakemen who might be standing on the top of passing freight cars. An additional precaution is provided in the shape of continuous wooden shields fastened to the iron stirrup which supports the conductors.

From the positive bus on the railway switchboard eight cables of stranded copper, each of 500,000 c.m. cross-section, or a total cross-section of 4,000,000 c.m., pass to the overhead structure immediately outside the power-house, where connection is made to three feeder-cables of 1,000,000 c.m. cross-section each, and to the overhead conductor itself, which has an equivalent of 1,000,000 c.m. cross-section. The negative bus is

similarly connected to the rails, which are double-bonded with No. 0000 wire, and also to the return-cables laid in a wooden box between the tracks. Perfect contact between bonds and web is obtained by using a hollow rivet on each end of each bond and expanding it, when inserted in the rail by, means of a conical steel pin.

THE SPRAGUE ELECTRIC LOCOMOTIVE.

A Sixty-seven-ton Locomotive for Handling Heavy Freight.

(Fig. 246.)

The following illustration shows an electric locomotive just completed at the Baldwin Locomotive Works after designs by Messrs. Sprague, Duncan & Hutchinson, of New York. It is intended for special experimental work in handling heavy freight and in switching, and was built for the North American company for this purpose. The locomotive resembles somewhat the ordinary consolidation type used for heavy freight-yard work. There are four pairs of drivers coupled together by quarter-cranked connecting-rods. The frame and the superstructure are symmetrical and the former is provided with freight-buffers and iron pilots. The pedestal-boxes are a special form made of cast steel and project inward, forming the brackets which carry the motors. The lower sides are arranged to be dropped out, so that the brasses can be readily replaced in the usual manner. These boxes are very large and heavy and perform the duty of carrying both the axles upon which the armatures are rigidly mounted and the field-magnets concentric to them. A stirrup projects from the upper part of each to engage

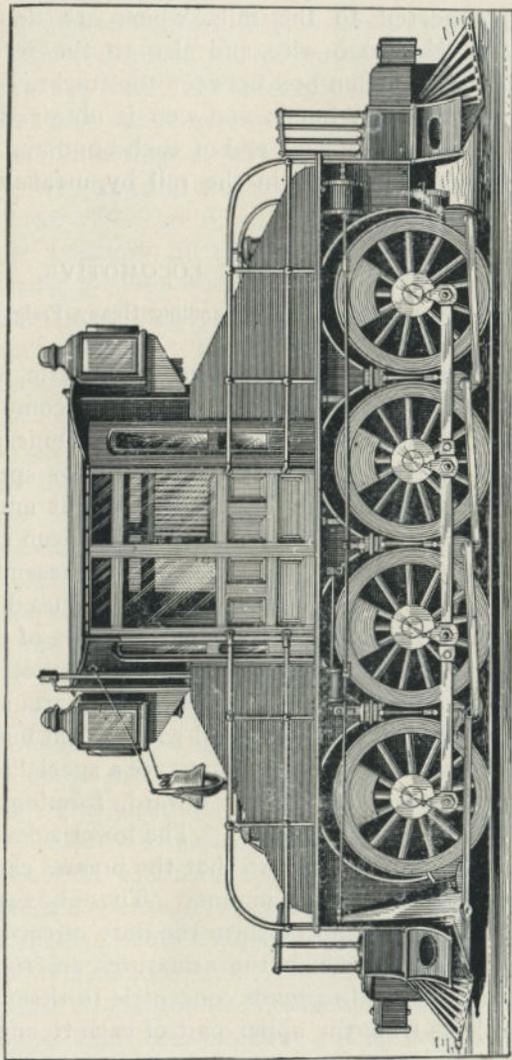


FIG. 246.—SPRAGUE SIXTY-SEVEN-TON ELECTRIC LOCOMOTIVE, 1000 H.P.

the middle section of inverted elliptical springs. There are four sets of springs arranged on the double three-point suspension system. In this way the whole superstructure is carried on equalizing springs. The drivers are 56 inches in diameter, the end ones only being flanged. The motors, four in number and alternating in position, are of the "Continental" iron-clad type, the field-magnets being formed of two steel castings, and having two field-coils placed at the ends of the motors, with their planes vertical, thus forming two consequent and two salient poles. The magnets are compound-wound, the shunt-field being light, and only sufficient to keep the speed within reasonable limits at light roads and for returning current to the line when running on down grades. The armatures, which were built by the Westinghouse Electric and Manufacturing Company, are of the slotted type, the slots having curved bottoms and tops and contracted gaps. Each slot carries four wires, but there is only one turn of wire to each bar of the commutator, and the wires are threaded through tubes imbedded in the slots. The winding is of the two-path type, giving the current only two paths in the armature.

The motors are wound for 800 volts at 225 revolutions, this being the equivalent of thirty-five miles an hour when in multiple. They will safely carry 250 ampères of current, giving each motor about 250 horse-power output at 93 per cent efficiency, and in emergencies can easily stand a great deal more than 250 ampères of current. The motors will readily exert a constant draw-bar pull of over 10,000 pounds, and have a system of regulation, giving any speed from zero to

thirty-five miles an hour, under full normal tractive effort. They can start very heavy loads, and have ample capacity to slip the wheels. The regulation is of the series-parallel system, with resistance thrown into, then cut out of, circuit, then again into circuit while changing. The groups are: first, all in series with and without variable resistance, then two in parallel by two in series, then four in parallel, with similar use of rheostat. The four motors are used all the time, there being no position in which one alone is cut out, not even in changing over. These various changes are effected by means of a large contact-cylinder on which the three main combinations are made, and a fireproof rheostat system, with the contact-arm geared in the proper ratio to the main cylinder.

To effect the prompt operation of this controlling system, which can be moved slowly by hand, air-pressure from the same tanks that supply the air-brakes is employed. This is automatically kept at a constant pressure by a special electric pump. It was deemed essential that it should be unnecessary for the engineer to watch indicators or gauges of any kind in order to know on what switch position he was running, and to this end the air-valve, which he controls, is mounted on a small lever, so geared as to move back and forth as the main cylinder revolves. His hand is thus carried along, so that he knows intuitively the position of the cylinder, and has no reason, ordinarily, to use his eyes and ears for purposes inside the cab. There is a reversing-switch, which is automatically locked in all but the "off" position on the main cylinder, thus preventing reversal under wrong conditions. There are

ammeters, voltmeters, a whistle, bell, headlights, and the usual accessories. The system of brakes is that known as the "American," and is applied to every wheel. The controlling apparatus is all carried in the cab, which is centrally mounted, has wedge-shaped ends and forward inclined sections running down to each end of the locomotive. The cab is heavily framed, so as to carry two trolleys, the ends are narrowed, and hand-rails flank it on either side.

The cab is provided with seats on either side, and the controlling apparatus is so arranged that the engineer sits at the right side looking forward, no matter which way he is running, and has similar hand movement. Steps give access to the pilot platforms at either end, and ladders to the top of the cab. The total weight of the locomotive is about 134,000 pounds, equally distributed on the drivers.

THE HEILMANN ELECTRIC LOCOMOTIVE.

The Heilmann electric locomotive, which was tried in January on the Havre section of the Chemin de Fer de l'Ouest in France, is a wide departure from the usual methods of electric traction. The system consists of a locomotive which carries a boiler and engine to furnish power to an electric generator, which supplies current to gearless motors on the eight axles of the locomotive.

It is claimed that by this method of driving a greater stability or smoothness over the steam locomotive is attained at high speeds, due to the smaller wheels that can be used at a greater number of revo-

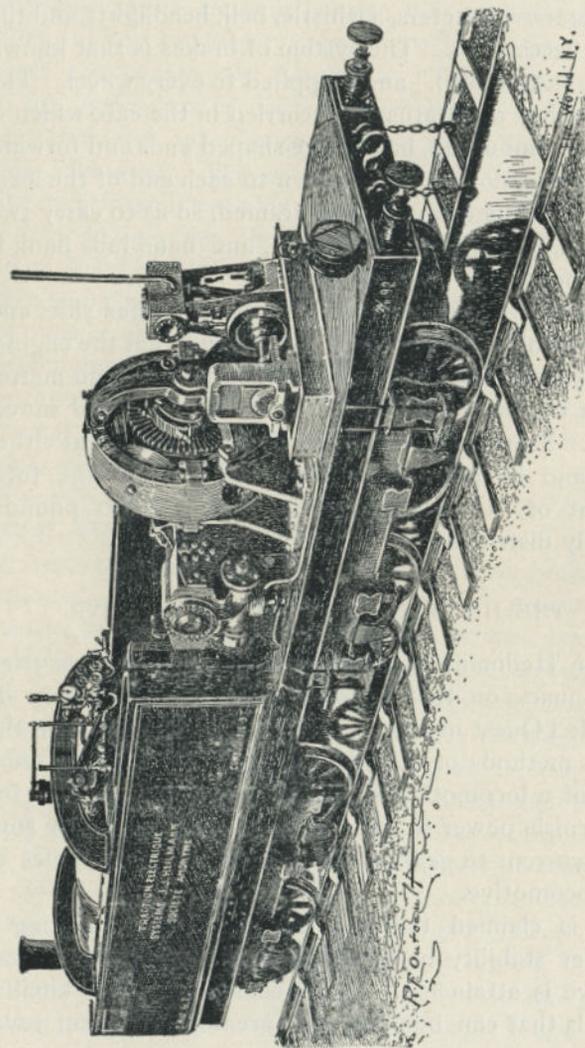


FIG. 247.—HEILMANN ELECTRIC LOCOMOTIVE.

lutions and the absence of oscillations. The adherence and flexibility are greater, as a greater weight can be distributed and in a more advantageous manner with sixteen wheels than with four, to which the steam locomotive is limited in order to possess sufficient flexibility to round curves. The boiler capacity in the new system can be made much larger, and by the use of economical engines power can be supplied more cheaply even at the points of final application than with wasteful locomotive engines. Accessory advantages claimed are that all parts of the machinery requiring attention are readily accessible and as directly under the eye of the attendant as the machinery of a steamship; the analogy is further carried out by the fire-room and machinery being entirely separated. The lubrication is more efficient and easily attended to, and the track is subjected to lighter wear on account of the absence of the "pounding" incident to the use of steam locomotives.

The locomotive is 52 feet long between buffers, and supported by two trucks with four axles each, with an electric motor on each axle; the entire weight is 110 tons.

The boiler is of the marine locomotive type with a corrugated furnace. It is 26 feet in length and somewhat over 6 feet in diameter, with 1550 square feet of heating-surface; the pressure is 160 pounds. A coal-bunker and water-tank of 6 and 10 tons capacity respectively are placed on each side of the boiler. The engine is of the compound type, the high- and low-pressure cylinders being on opposite sides of the cranks, which are at an angle of 180 degrees. Its

weight is 11,000 pounds, or 20 pounds per effective horse-power. The consumption of steam is 23 pounds per horse-power hour.

The engine is direct-connected to a 6-pole, ring-armature (see Fig. 240), continuous-current dynamo, which is so wound as to work with three, two, or even one pair of carbon brushes. The external diameter of

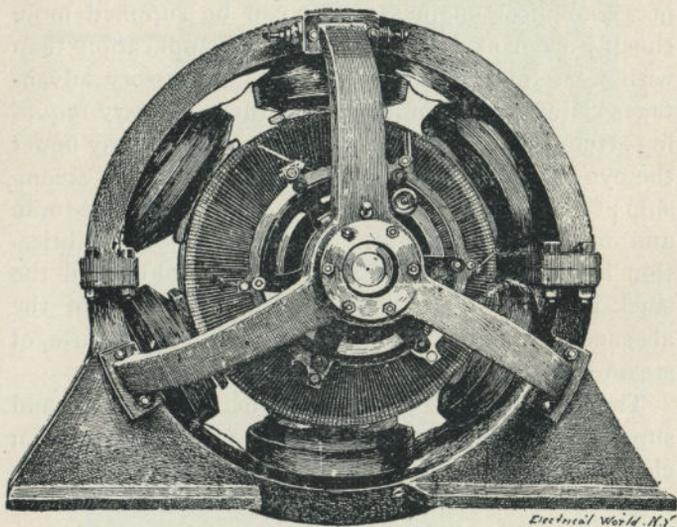


FIG. 248.—GENERATOR OF HEILMANN LOCOMOTIVE.

the frame is 79 inches and of the armature 49 inches. The dynamo is separately excited by a compound dynamo run by a small engine, and with 360 revolutions produces an available horse-power of 600, with a maximum horse-power of 800 with 800 revolutions. If the dynamo stops at one of the engine dead-points,

the exciter is connected to the armature for an instant, which causes the former to work as a motor, and carry the engine beyond the dead point.

The motors have four poles and steel frames cast in a single piece. The toothed armature is 25 inches in

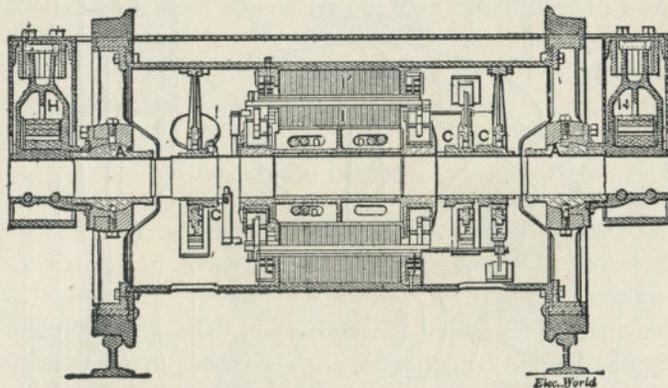


FIG. 249.—MOTOR OF HEILMANN LOCOMOTIVE.

diameter, with a large air-gap to reduce eddy currents. It is mounted on a steel tube, supporting the whole weight, which is fitted on the axle with a bushing of woodite, an elastic insulating material impervious to oil. The steel tube terminates at one of its extremities in an elastic coupling, which prevents jerking in starting. The eight motors form two groups, each comprising four motors coupled in parallel. In starting the two groups are connected in series and then in parallel after a certain speed has been attained.

These motors are of the iron-clad type. As shown in Fig. 249 cross-section of motor, the fields are connected to the axle, which is stationary; the four poles

of the armature are fastened to the large cylinder, which is rigidly connected to the driving-wheels; the driving-wheels revolve on the axle. In Fig. 250 it will

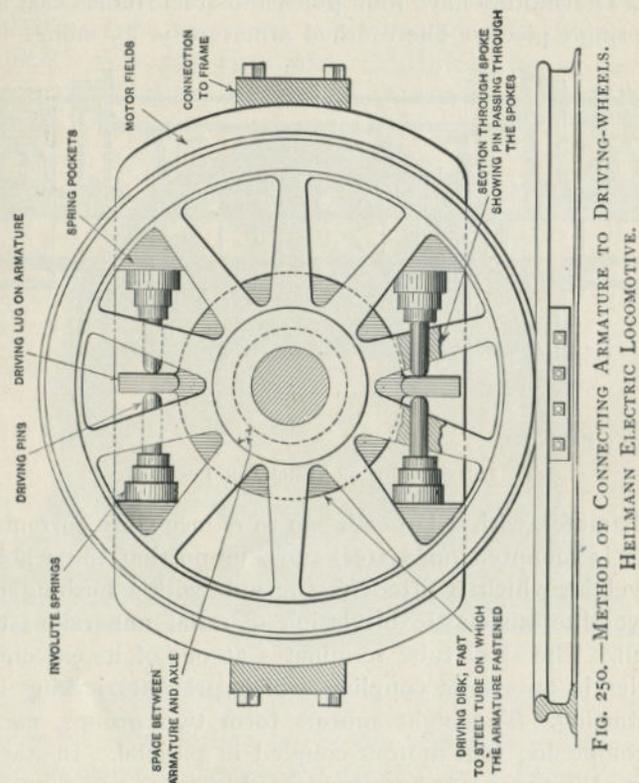


FIG. 250.—METHOD OF CONNECTING ARMATURE TO DRIVING-WHEELS.
HEILMANN ELECTRIC LOCOMOTIVE.

be seen that the method of mounting the motors is different. In this case the fields are carried by a cross-connection from each side of the frames. The armature is mounted on the axle by a steel tube, which is

larger in diameter than the axle proper. This is for the purpose of allowing for oscillation of the frame or axle. In order to start the motors without a jerk there are driving-pins fit through spokes in the wheels which have heavy involute springs attached to them. These pins bear against a lug which is attached to a disk connected to the armature, so that in any position the armature may drive the wheels and still run true with the bore of the pole-pieces.

REGULATION.

As the motor fields must have a fair degree of saturation to prevent sparking when the locomotive is running and pulling no train, it will be evident that under all operating conditions the motor fields are constant and fully saturated, which makes them entirely sparkless. The fields of the generator is separately excited by means of a small auxiliary engine and constant-potential dynamo which supplies the electric light. The main engine has a fixed cut-off at the most economical point at one-fourth stroke, and the speed is adjusted by the throttle. The engine varies in speed from 50 to 500 revolutions, and the strength of the generator from zero to the maximum strength. Steam is used expansively at a fixed cut-off. In starting an almost unlimited torque is secured by gradually increasing the generator field strength and speed, which sends a current through the motors rising smoothly from zero to the current sufficient to start the motor armature. If the field-controller and throttle are left in this initial position, the train will

start smoothly, and will continue to move slowly, using the full current strength, but producing the current with about 50 volts, or one tenth of the full voltage, and producing the power about $\frac{1}{10}$ of that required at full speed by a steam-engine using steam expansively instead of as in a steam locomotive using steam full stroke. In order to increase the speed of the train the field-controller and throttle of the engine are manipulated until the engine is driving the generator at full speed in a field of full strength.

This, then, being the full power of the locomotive when a grade is reached which requires three times the former torque, the field is weakened to one third of its full strength. Then the train will move up the grade at one third of the full speed on the level, while using the same power as was required on the level. Under this method of control the electrical energy is used in such a way that its voltage is varied in proportion to the speed desired, and the ampères in proportion to the torque required.

Weight of locomotive, 114 long tons, about 15,000 pounds on each driver; draw-bar power, 50,000 pounds. A load of 90 tons was hauled up gradients of 3 and 8 in 1000 respectively, at a speed of 50 miles per hour in the former case, and in the latter 38 miles per hour.

ALTERNATING-CURRENT LOCOMOTION.

In writing the direct-current motor has only been dealt with, as that class is the most used and developed. There is another current, called the alternating current, which promises to develop into commercial value

as a motive power. It has this advantage: that it can be varied at will by a transformer. A large current of small voltage can be transformed to a small current of high voltage or pressure, and for long-distance transmission it is better adapted than the direct current, as it can be conveyed a great distance with a smaller wire than a direct current, because a small current of high voltage can be passed over the wire and then transformed to the desired current and pressure.

The following description is of an alternating system, and it will be seen that the current that is used in the motors that run the locomotives is a direct current in the end:

HOW SHALL WE OPERATE AN ELECTRIC RAILWAY EXTENDING ONE HUNDRED MILES FROM THE POWER-STATION?*

BY H. WARD LEONARD.

Let us suppose that we are called upon to act as engineers for a steam railway desiring to operate its line by electric locomotives. There exists a very economical source of power, possibly a water-power, so situated that the length of railway to be operated in either direction is one hundred miles.

Let us determine the leading points of the specification for such a road based upon our experience to this date, and after making the specification let us see whether we are to-day able to comply with the specification, and if not what must be done before we can comply with it.

* Read before the American Institute of Electrical Engineers, February 21, 1894.

The following features seem desirable, if not essential, in such a railway :

1. A single trolley contact shall be used for supplying current to the locomotive.
2. The electro-motive force upon the trolley shall not exceed 500 volts.
3. There shall be no apparatus in motion and requiring attention between the power-station and the locomotive.
4. No commutator, rheostat, or controlling device on the locomotive shall be subjected to a higher electro-motive force than 250 volts, and there shall be no sparking on any of the apparatus under any normal conditions.
5. The entire control of the locomotive in either direction shall be effected by the movement of one lever.
6. The load shall be started from dead rest by an amount of energy taken from the source of supply, which shall not exceed one quarter of the energy required to operate at full speed on the level.
7. The retardation of the load in coming down grades, and in stopping, shall be effected by converting the motors into generators, which shall feed back current to the line, and thereby assist the power-stations in operating other locomotives.
8. The motor must be reversible when operating at full speed, without damage to the motors or other apparatus.
9. The efficiency of the system from power on the generator-shaft to the draw-bar pull of the locomotive shall be at least 50 per cent.

10. The locomotive shall produce at least 500 horsepower when operating at a speed of 80 miles per hour.

It will be evident that we must use a high electro-motive force for operating over such great distances. The average distance over which the power is to be transmitted is 50 miles, and we find that in order to operate with a loss in conductors of 20 per cent we must have an initial electro-motive force of 20,000 volts, in order to make the cost of copper about \$20 per kilowatt, which is about the best figure for cost of copper under the conditions.

The alternating current must evidently be used for such an electro-motive force as this, and the single-phase alternating, since we have but one trolley contact.

Let us start (see Fig. 251) with the standard 1000-volt single-phase alternators in our power-station, and convert by step-up transformers from 1000 to 20,000 volts required for the transmission-circuit. Since we are limited to 500 volts upon the trolley, we must insert at suitable points, say every two miles, a converter, which will transform the energy at 20,000 volts in the transmission-circuit to energy at 500 volts in the trolley-circuit, one pole of which latter circuit will be the rails.

We have our energy delivered at our point of use with reasonable cost and efficiency and by simple and well-tried apparatus. But the energy is in the form of a single-phase alternating current which is not very flexible.

We can operate a synchronous alternating-current motor by this current, but it cannot be regulated in

speed or reversed in direction, and cannot be started under load, and will be thrown out of step if a large load be suddenly applied. As all of these conditions are required of locomotives, a motor operating by the alternating current evidently cannot be used directly.

But it is a simple matter to start the synchronous motor without load, and when it reaches its synchronous speed it will perform work efficiently and satisfactorily, provided it be not subjected to violent fluctuations in the load applied to it.

Evidently, then, what we need is some form of gearing between the synchronous motor and the axle which will give us the desired control and enable us to operate at any speed and in either direction.

It is quite possible that this can be accomplished mechanically, and many ingenious devices for this purpose have been invented, but none seems to be sufficiently simple, reliable, and lasting for use on such a large scale.

The equivalent of such a mechanical gear can, however, be secured if we will make use of the synchronous motor merely to drive a continuous-current generator on the same shaft at a constant speed, and use the continuous current so generated to supply the propelling motors connected with the axles of the locomotives.

Since the generator is used for the motors on one particular locomotive only, we can vary its electro-motive force at pleasure, and hence can produce a low electro-motive force for low speeds, and increase the electro-motive force to increase the speed, and by this means avoid the loss of energy which is wasted in

rheostats when motors are started under load, and when connected as usual upon a source of constant electro-motive force.

In order to secure rapid changes in the electro-motive force of this continuous-current generator at will it will be best to have its field separately excited, which will also enable us to reverse its field at pleasure. The propelling motors can be series, shunt, or separately excited. The best results will be obtained by separately exciting the field, and keeping it fully and constantly excited, and reversing the motors by reversing the field of the generator, which of course will reverse the current in the armature alone of the motor.

To secure this exciting current for the synchronous alternating motor, and also for the fields of the continuous-current generator and motor, it will be best to drive by means of the alternating-motor armature, and if desired in the same field a continuous-current winding connected to a commutator, from which will be led the current for exciting the fields of all three machines.

Let us wind the fields for 250 volts, and also use this voltage for the continuous-current armatures. This pressure is perfectly safe and can be handled with impunity.

Suppose now the locomotive to be at rest. The synchronous motor is running and driving the generator armature at full speed in a field of no intensity, hence the propelling motors receive no current. We now make the first contact upon the rheostat in the generator field-circuit and let the resistance in the rheostat be such as to produce say 25 volts at the generator-brushes.

This 25 volts will supply a very large current to the motor armature at rest in its saturated field, and consequently will produce a sufficient torque to start the entire load and continue to move it at a slow speed.

We are using 25 volts and let us say 2500 ampères in this circuit; this means 62,500 watts, and, disregarding transformation losses for simplicity, this means a current of 125 ampères from the trolley. When operating at the rate of 500 horse-power at full speed, we shall need say 1800 ampères and 250 volts in our propelling circuit, which is 450 kilowatts, and means roughly 900 ampères from the trolley. It is evident, therefore, that we can start the load with but a small fraction of the energy required for operation at full speed, and that there will be no danger of throwing the alternator out of step by applying but about one sixth of its full load and applying that gradually, as will be the case, as the load will follow the increase of the generator field strength, which, although rapid, is gradual, and not instantaneous.

If we are operating at full speed, and desire to bring the locomotive to rest, we gradually but rapidly reduce the strength of the generator field by manipulating the rheostat in its field-circuit so as to reduce to zero the current exciting this field; the electro-motive force produced by the generator then rapidly falls below the counter-electro-motive force of the motors, which are being driven in a constant field by the momentum of the moving load, and the motors consequently become generators, and supply current to the former generator, which now becomes a motor, and, driving the alternator, feeds current back through the trolley,

thereby not only bringing the locomotive smoothly and rapidly to rest, but saving the energy usually wasted upon the brake-shoes.

Under this arrangement, if we are using steam-engines as the source of power, we never subject the engines to the violent fluctuations ordinarily met with in electric railways, and by reason of having a comparatively steady load can secure very high economy in the consumption of steam; and since we have eliminated the excessive load in starting, we can very much reduce the capacity of the engines, generators, and conductors over usual requirements.

The reversal of the motors is very simple and smooth by this method. The lever of the rheostat in the generator field-circuit is moved so as first to reduce the current to zero, and then increase it again to its maximum, but in the opposite direction around the field. The reversal of the motor armature, following the gradual change in the strength of the generator field, is extremely smooth, and the armature is not subjected to any sudden strain. No sparking will be met with under any condition, upon either the generator or motor commutators, or upon the field-rheostat.

DRUM-ARMATURE.

It is well now to make further statement in regard to drum-armatures, as these are the armatures mostly used in motors. The armature-core is made up of disks of soft iron rigidly fastened to the shaft. These disks are insulated one from the other as in the ring-armature (Fig. 205). The winding is over the surface of this core from end to end. The motor

armature as now made is slotted, and the wire laid in the grooves. This is of great importance, as it keeps the wire from being drawn or twisted on the core. Fig. 236 shows a drum-armature complete. Its

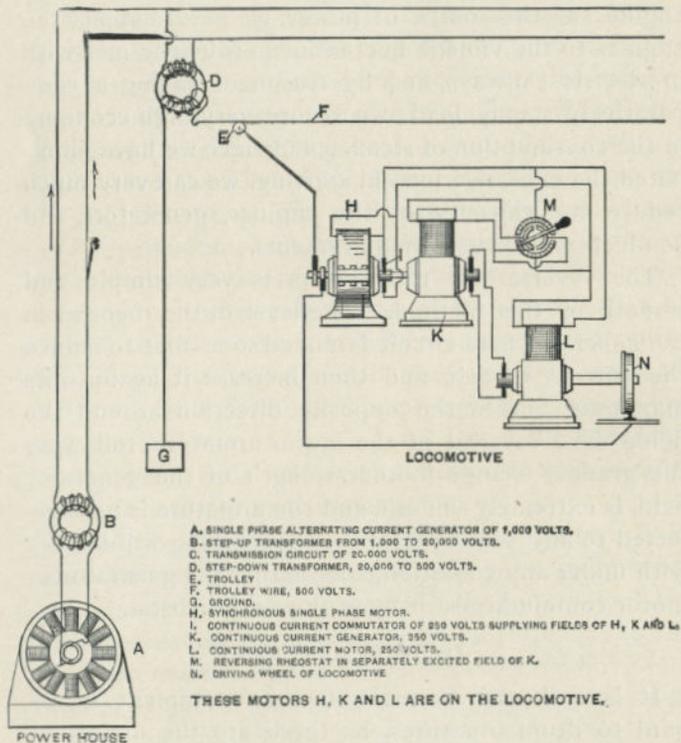


FIG. 251.—METHOD OF OPERATING ELECTRIC LOCOMOTIVE ON A ROAD ONE HUNDRED MILES LONG.

merits are these: The armature can be made very long in proportion to its diameter, and the amount of dead wire is reduced to minimum, where with the

ring-armature the wire on the inner side is of no practical value except to convey the current, that is, in regard to cutting lines of force.

The poles in a drum-armature are formed the same as in a ring-armature, and are attracted the same as a ring armature. The current also passes two ways around the armature. The winding is cross-connected on the ends in various ways. The standard motor armatures have their coils wound on formers and insulated. Then all that is required is for the armature-winder to place the formed coils in their respective slots around the core, and then connect them up to the commutator, there being details in the way of binding, heading, and other minor details.

METHOD OF CALCULATING FOR A MOTOR OF A GIVEN H. P.

In the general method of designing a motor of a given power and speed it is well known that a dynamo will run as a motor, so that calculations for a motor are based on the same principles as applied to a dynamo. If it is desired to construct a motor of, say, 10 H. P. to run at 500 revolutions at 200 volts as an example. The motor if run as a dynamo should be able to generate a current of 7460 watts; as 1 H. P. = 746 watts, 10 H. P. = 7460 watts as the required output. A motor to give out 7460 watts must be allowed to absorb 8776 watts, and if its electrical efficiency is to be 90 per cent it must generate 180 volts. Dividing 8776 watts by 180 volts, we find 48.75 ampères as the current it must take at normal load. Then if the motor is designed

so with powerful field-magnets, and is capable of generating a current of 50 ampères at 180 volts at a speed of 500 revolutions, it will be a 10 H. P. motor.

METHOD OF DESIGNING A MOTOR TO RUN ON A CIRCUIT OF A CERTAIN POTENTIAL OR VOLTAGE.

Suppose it is desired to construct a motor to run on a circuit of 50 volts with a current of 1 ampère. This means if run as a motor it should be able to give out 1 ampère of current at 50 volts pressure. To obtain this voltage about fifty yards of wire must be used on the armature. This is allowing one yard per volt generated, and it will be found in referring to a wire table that about half a pound of wire will answer the requirements. As to the field-magnets, they must be worked with about five pounds of 24 wire, and, connected in series with the armature, will give a total resistance of 49.5 ohms with a voltage of 50 volts. As the resistance of 24 wire to the pound is 9 ohms, then five and a half pounds gives 49.5 ohms. Then, according to Ohm's law, current = E. M. F. divided by resistance = $50 \div 49.5 = 1$ ampère, approximately.

ELECTRICAL UNITS.

AMPÈRE.

The practical unit of electrical current strength. It is the measure of the current produced by an electro-motive force of one volt through the resistance of one ohm in electric quantity is at the rate of one coulomb per second. Its best analogy is derived from water. Assuming the electric current to be represented by a current of water, the pressure-head or descent producing such current would be the electro-motive force. The current might be measured in gallons or other units per second. In analogy these gallons would be coulombs.

AMPÈRE-SECOND.

is a coulomb. The number of coulombs passed per second gives the ampères of current.

AMPÈRE-MINUTE.

The quantity of electricity passed by a current of one ampère in one minute as sixty coulombs.

AMPÈRE-HOUR.

The quantity of electricity passed by a current of one ampère in one hour.

THE VOLT.

The practical unit of electro-motive force or potential difference. An electro-motive force of one volt

will cause a current of ampère to flow through a resistance of one ohm. The rate of cutting 100,000,000 lines of force per second by a conductor produces one volt of E. M. F.

WATT.

The practical unit of electric activity, rate of work or rate of energy. It is the rate of work done by a current of one ampère urged by one volt E. M. F., as 746 watts equal to one electrical H. P., as 50×10 ampères = 500 watts.

KILOWATT.

The kilowatt is a unit of 1000 watts; a machine of 15,000 watts output = 15 k.w.'s, or $15,000 \text{ watts} \div 746 \text{ watts} = 20 \text{ H. P.}$, approximately.

AIR-BRAKES ON ELECTRIC LOCOMOTIVES.

Means for stopping an electric locomotive must be provided as with the steam locomotive. The question naturally arises: How can the air be compressed on an electric locomotive if there is no steam?

This is very easily overcome. Instead of using a compressor-pump driven by steam the compressor is operated by electricity. Fig. 252 shows a compressor complete, and on a locomotive, as shown on the left-hand side, is a small iron-clad electric motor. Fastened to the armature-shaft is a small pinion, which meshes in a gear-wheel of larger diameter. These gears are enclosed in a case, as shown by the drawing, which

case is under the compressor-cylinder. Projecting from the gear-case under the cylinder are two cranks. These cranks are driven by the gears. Leading from

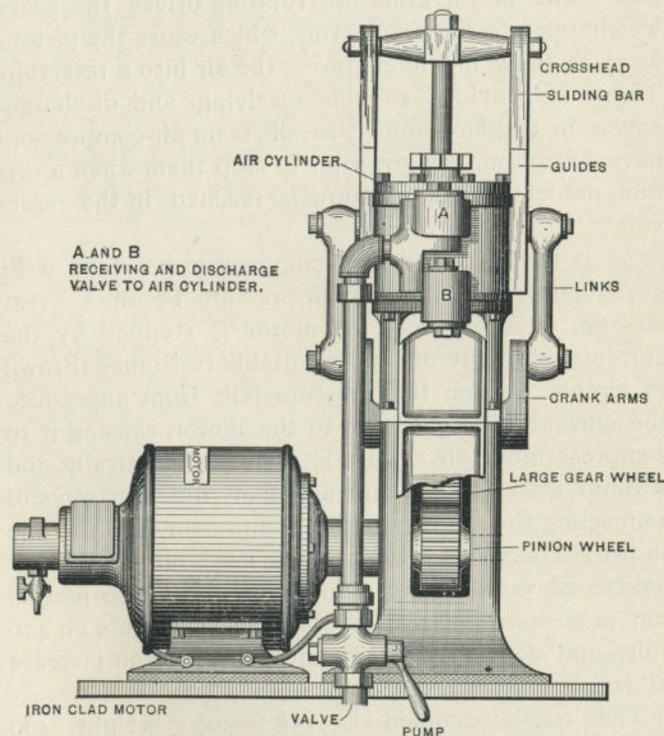


FIG. 252.—ELECTRIC-DRIVEN AIR-COMPRESSOR FOR ELECTRIC LOCOMOTIVE.

these cranks are two rods, whose upper ends are attached to sliding blocks on each side of compressor-cylinder. There is a cross-bar or head attached to these

two sliding blocks. To the cross-head is fastened the piston-rod of the compressor, which enters the cylinder driving the piston-head. The operation then is simple. The motor armature rotating drives the gears which operate the crank-arms, which cause the piston-head to draw in and compress the air into a reservoir. There is provided suitable receiving- and discharge-valves in the air-cylinder, as all steam air-compressors have an automatic governor to stop them when a certain predetermined pressure is reached in the reservoir.

So is the electric-driven compressor provided with a regulator. When the air-pressure becomes great enough, or as desired, the motor is stopped by the current being cut off and a suitable resistance thrown in circuit. When the pressure falls from any cause the current will again flow to the motor, causing it to compress more air. This is done automatically and without attention. There are many different ways of connecting the motor to the compressor, and the one shown is taken as a typical one used on the Metropolitan Elevated Railroad in Chicago. These motors run at a speed of 650 revolutions per minute on 450 volts, and develop $3\frac{1}{2}$ H. P., and will stand an increase of voltage.

The space occupied is $15\frac{1}{8} \times 30\frac{1}{2}$; weight, 400 pounds. The regular standard air-brake systems are used in connection with this compressor, such as the Westinghouse and New York air-brakes, of which a full description is given in the chapter under that head in this book.

CONTROLLER COMBINATIONS.

(Pages 437-439. 1 to 10.)

1. All resistance in, motors in series.
2. One half resistance out, motors in series.
3. All resistance " , " " "
4. All resistance in, series with one motor.
5. One half resistance in, series with one motor.
6. All resistance out, one motor in circuit alone.
7. One half resistance in, circuit with one motor cut out.
8. Motors in parallel, all resistance in.
9. Motors in parallel with half resistance in.
10. Motors in parallel with all resistance out.

HEILMANN ELECTRIC LOCOMOTIVE.
LATEST TYPE. (Fig. 253.)

After the trial of the first electric locomotive of which a description is given in the early part of the chapter, two new ones were built, having improvements which were suggested by the tests given the first. A description of these will be instructive from the fact that it shows the efforts being put forth to put the electric locomotive on the same footing as the steam locomotive. These new locomotives have eight pairs of drivers, as shown in elevation view. An electric motor is mounted on each pair of drivers, as shown in elevation view. An electric motor is mounted on each pair of drivers. These drivers are divided four pair to each truck as shown in Figs. 254, 255. The drivers are not mechanically connected in any way, which is an advantage over the steam locomotive. Resting upon two pivots, one at the centre of each truck, is a rigid platform made of steel beams. This platform or framing carries the boiler, steam-engine, and dynamos.

The steam-engine, supplied by the boiler, runs continuously. The engines are Willans centre-valve, triple-expansion, vertical type. The crank-shaft has six cranks, so set as to produce the most perfect balancing of the engine, so it will not cause any vibration. The full speed of the engines is 450 revolutions per minute. Fig. 256 shows a cross-section view of a Willans triple-expansion engine, of which the following is a description:

This engine is intended as a high-speed engine and makes from 450 to 550 revolutions per minute. The engines are single-acting, that is, steam acts upon the piston only during the down stroke, the up stroke

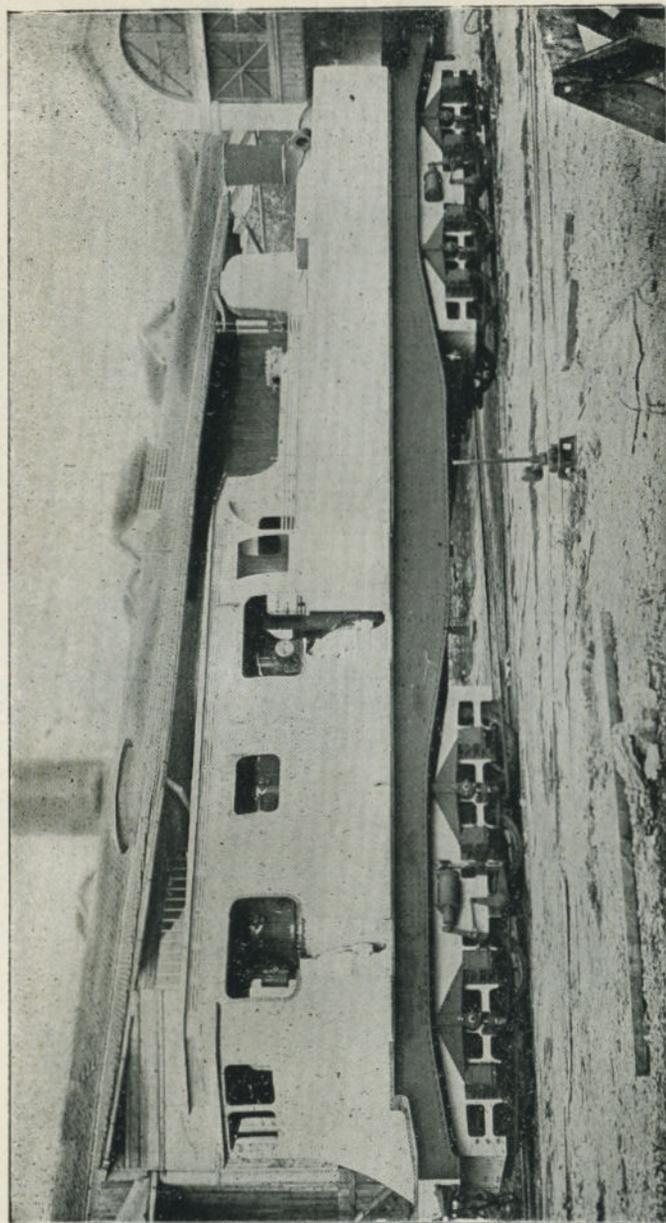


FIG. 253.—HEILMANN ELECTRIC LOCOMOTIVE. Latest type.

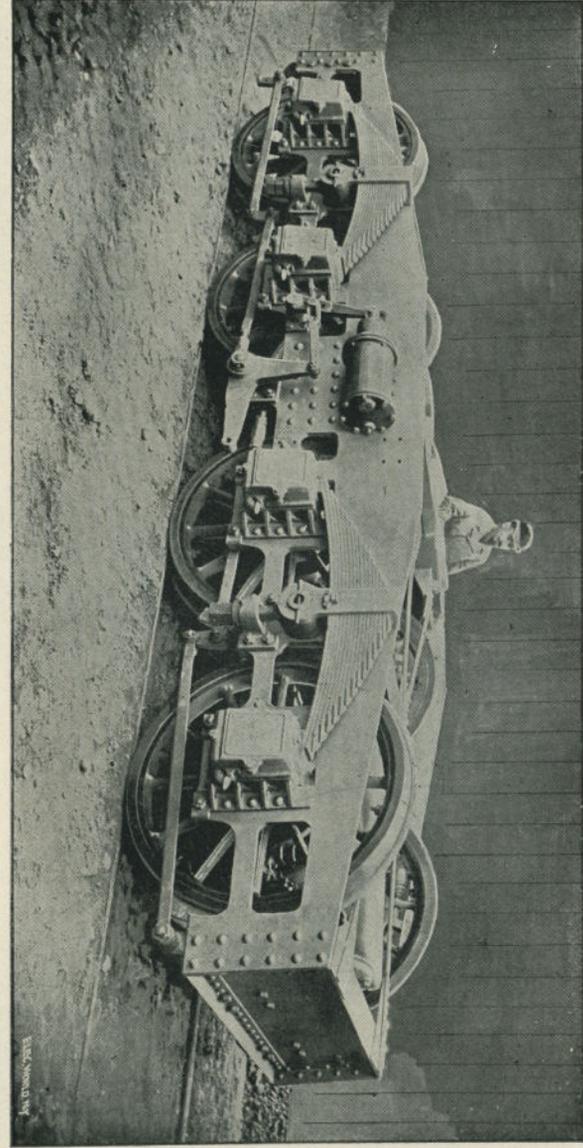
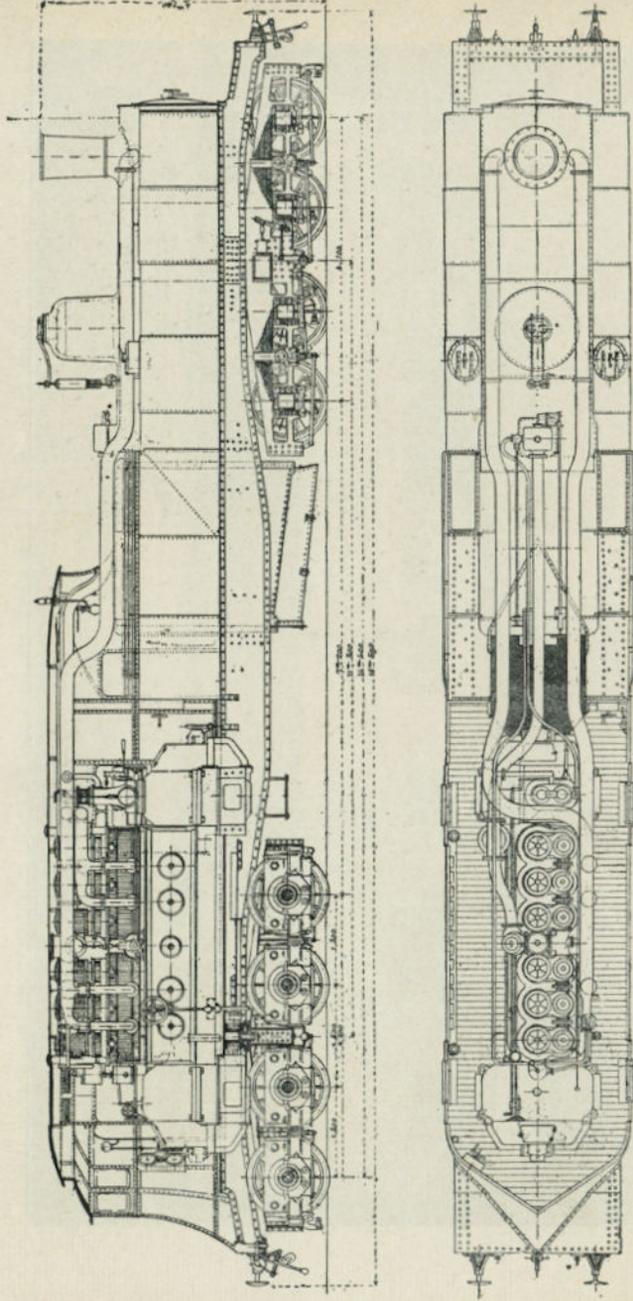


FIG. 255.—VIEW OF TRUCKS, HEILMANN LOCOMOTIVE.

FIG. 254.—ELEVATION AND PLAN VIEW, HEILMANN ELECTRIC LOCOMOTIVE.



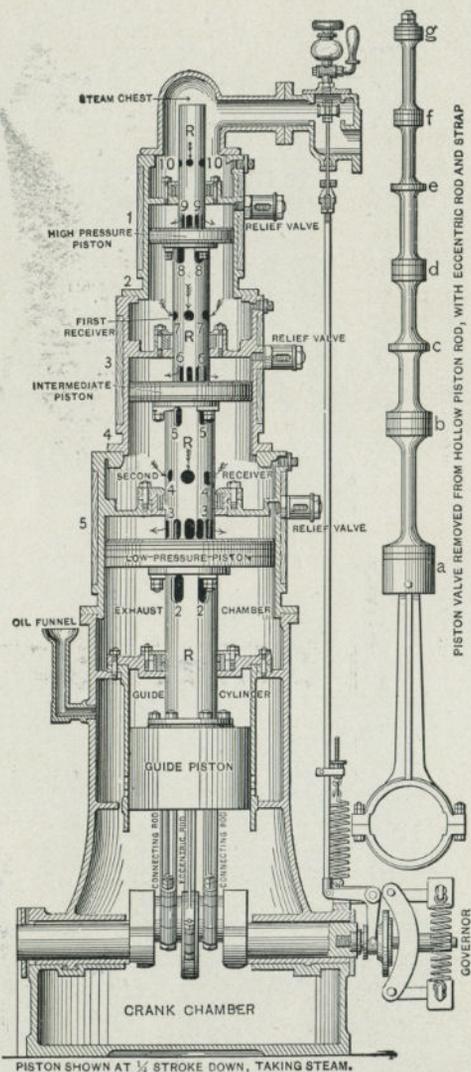


FIG. 256.—WILLANS TRIPLE-EXPANSION ENGINE.

being made by the momentum of fly-wheel against an air-cushion in the lowest cylinder. When used as a single engine, but when more than one set of cylinders are used as in the Heilmann locomotive, the cranks are set so that when one set of pistons are going up the other set are pushing down. This makes a very smooth-running and durable engine, having very little wear on bearings and piston-rings.

The crank-shaft revolves in a chamber filled to a certain extent with oil mixed with water, which splashes it in a fine spray over the rods and movable parts. The main bearings are constantly flooded with oil. The engine is arranged with high-pressure cylinders above the intermediate cylinder, and with the latter above the low-pressure. The rod *R* is of large diameter and is hollow, and the valve for admitting and exhausting the steam from the several cylinders works up and down inside of it in the centre of the engine; hence the name central valve. A separate view of the valve is given in Fig. 256. It is driven in the usual way by an eccentric; but since the valve-seat on the inner surface of the hollow rod moves up and down with the pistons, the source of the valve motion, the eccentric must move up and down with the pistons also. This is effected by mounting the eccentric on the crank-pin instead of the crank-shaft as usual. The ports through which steam enters and leaves the respective cylinders are simply holes in the hollow rod shown at 99, 66, and 33. These are exposed alternately to steam coming from above through the rod and to exhaust also through the rod downward according as the corresponding pistons of the valves marked *f*, *d*, and *b* pass below the holes or above them.

Steam enters at the top through the governor throttle-valve, shown in section, into the steam-chest.

The top of the hollow rod, though uncovered, is closed against the steam-pressure by the uppermost piston *g* of the valve, which works in the part above the holes 10 10. Steam can therefore enter the rod when holes 10 10 are in steam-chest, as they are when the high-pressure piston is near the upper part of its travel. On commencing the down stroke *f* is just passing below the holes *e e*, and therefore admits steam into the first or high-pressure cylinder by way of 10 10 and 9 9. *f* rises again and closes the ports 9 9 when the piston has descended about three quarters of its stroke; but cut-off is effected earlier than this by the holes 10 10 leaving the steam-chest and passing through the gland in the cylinder-cover, thus losing their supply of steam. It is evident that cut-off may be made to take place at any part of the stroke merely by making the holes 10 10 higher or lower in the rod. The lower they are the earlier in the stroke will they leave the steam-chest. The same effect is produced by altering the height of the gland in cylinder-cover. After cut-off the steam acts expansively on the high-pressure-cylinder piston in the usual way. By the time the piston has reached the bottom of its stroke the piston-valve *f* has passed above ports *e e*, and as the valve *e*, Fig. 256, permanently closes the passage between 8 8 and 7 7, a way is opened from above the high-pressure piston through *e e* and out again by 8 8 into the space below the piston and marked "first receiver." During the up stroke steam is merely transferred, practically without change of volume or pressure, into the re-

ceiver. The receiver might be open to the atmosphere, so as to allow the steam to escape at once, the two lower cylinders with their pistons and valves being omitted. In that case the cycle would be already complete, and in fact the above description would be all the description needed for a Willans simple engine such as would be used where only low-pressure steam was available.

In the present engines, however, the receiver, which is partly composed of the lower end of high-pressure cylinder, forms also the steam-chest for another cylinder, which in a compound engine would be the last of a series of two, but which here is the second of three. At the beginning of the succeeding down-stroke steam passes from the receiver by the holes 7 7 into hollow rod again and out by 6 6 into the intermediate cylinder, until cut-off occurs by the descent of the holes 7 7 through the cylinder-cover. On the stroke the steam exhausts, just as described above, through 6 6 and 5 5 into the second receiver; in the next downward stroke it passes into the low-pressure cylinder through 4 4 and 3 3; in the next up stroke it is transferred through 3 3 and 2 2 into exhaust chamber, which is in communication with the atmosphere; but it is not until the third revolution after that in which steam enters the high-pressure cylinder that it is finally expelled from the engines. It will be seen that the full pressure in the steam-chest is constantly acting on the valve-piston *g*. This insures that the eccentric-rod shall be kept constantly pressed against the eccentric as well on the up as on the down stroke.

With the steam-pistons the case is different. They are much heavier, and in the up stroke they are all in

equilibrium, for there is communication existing between the upper and lower sides of them. Means are provided to check their momentum on the up stroke, to keep the connecting-rod brasses in constant thrust. The guide which takes the side-thrust of the connecting-rod is in the form of a piston moving in a cylinder closed at the top. This is shown in Fig. 256.

At the bottom of its stroke it uncovers certain holes, *ll*, which place the guide-cylinder momentarily in communication with the atmosphere. As there is no other outlet from it, the upward movement compresses the air contained in the guide-cylinder, until at the top of the stroke a considerable pressure is reached, sufficient to stop the line of pistons without shock, or the upper brasses leaving the crank-pin. All piston-rods are packed by a cast-iron ring pressed inwardly instead of outwardly.

Attached to each end of the engine-shafts are two electric generators having six poles. These generators are electrically connected in parallel, and the combined output is 3000 amperes at 455 volts; also, for a short period, 4000 amperes can be generated. The field circuits of both these generators and the light-motors are separately excited by a two-cylinder Willans engine and a four-pole dynamo of 28 H.P. This exciter also supplies light for the train. Fig. 257 shows a view of the exciter and its engine. The eight motors each have a normal rated capacity of 125 horse-power at 62 miles per hour. Fig. 258 shows one of the motors and drivers, in which the upper half of the field-yoke is removed, showing the armature, commutator, and two end poles. The motors have four poles. The arma-

ture is mounted on a hollow sleeve through which the axle passes. This hollow sleeve has a spider attached which abuts against involute springs, as in Fig. 259, and

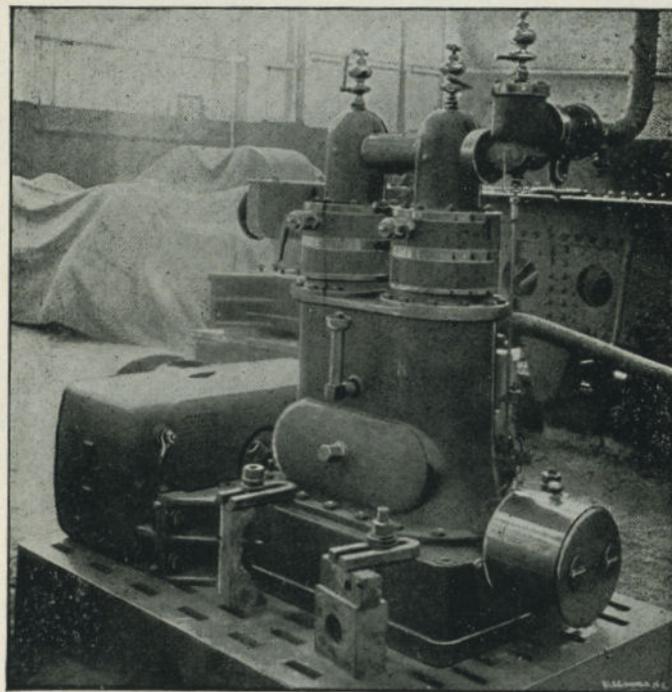


FIG. 257.—EXCITER AND ENGINE.

causes the driver to revolve. This forms a gearless or direct-driven motor. The motor armatures are all in multiple with each other, and across the terminals of the generators there is arranged a commutator in the circuit leading to the motor armatures by which

they can be grouped in two series of four each when it is desired to secure the greatest tractive force and slow

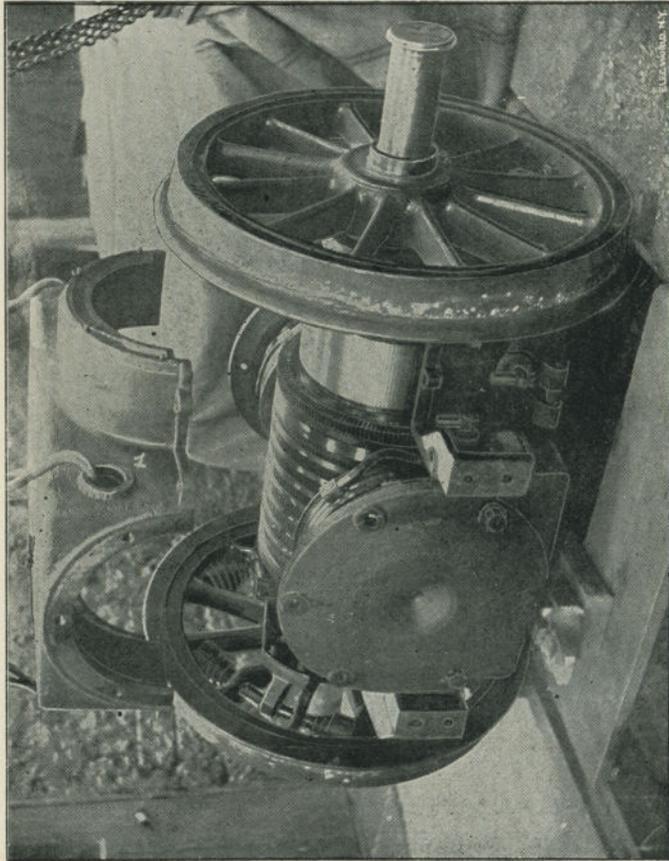


FIG. 258.—HEILMANN ELECTRIC LOCOMOTIVE. View showing the Upper Half of Field-yoke removed, exposing to view the Poles, Armature, and Commutator of Motor.

speed. There is also a reversing-switch in this armature circuit to reverse the direction of circuit through

the motors and change direction in which the locomotive travels. Fig. 260 shows method of wiring the motors and generators for changing direction of

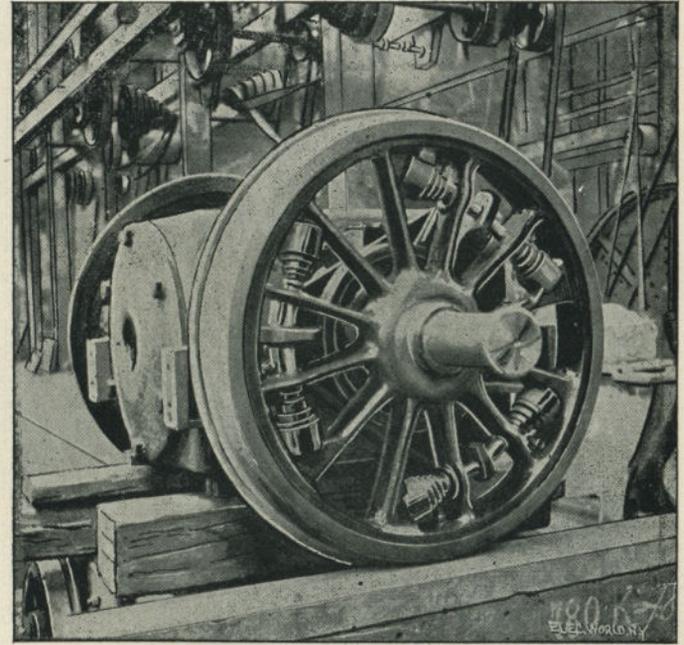


FIG. 259.—SHOWING THE METHOD OF CONNECTING THE SPIDER OF ARMATURE TO DRIVING-WHEELS.

motors by changing the direction of current through armature.* See Fig. 260 for direction of current, indicated by arrows, through one motor.

* The direction of current flowing through the No. 1 motor, as shown in Fig. 260, takes place in all the motors at the same time, as they are in parallel with each other across the circuit.

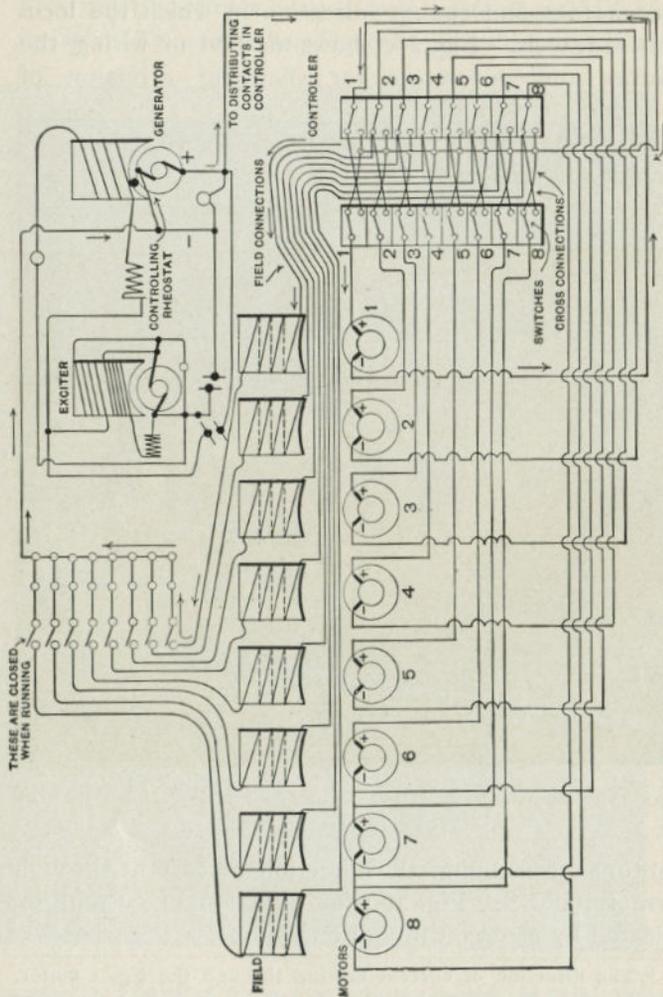


FIG. 260.—METHOD OF WIRING THE GENERATORS AND MOTORS, HEILMANN LOCOMOTIVE.

Fig. 254 is an elevation and plan of the latest type of Heilmann locomotive; the boiler is of the Belpaire type used on a great many steam-locomotives. This occupies the fore part of the locomotive and is carried over one set of trucks. The fire-box drops down between the girders. The principal dimensions are: Grate surface, 36 sq. ft.; heating surface of fire-box,

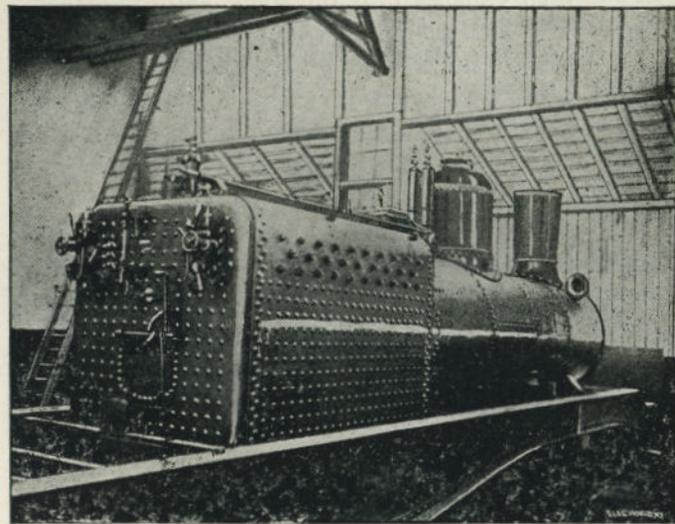


FIG. 261.—BOILER AS MOUNTED ON FRAME.

177 sq. ft.; heating surface of tubes, 1818 sq. ft.—total interior heating surface, 3245 sq. ft.; number of tubes, 177. By pushing the switches down to the other terminals on the controller on both sides the direction of current through cross-connection will be changed; consequently the direction of current through the armatures will be reversed, the fields remaining the same. The motors will reverse their direction.

351; diameter, 1.77 inches; length, 12.46 ft. head to head. The boiler has the usual steam-dome and safety-valves. On the rear end over the second set of trucks are carried the engines, generator, exciter, and controlling mechanism, steam-gauges, voltmeters and ammeters. The exhaust-steam pipes run from the engine forward to and enter the side of the smoke-box and then exhaust into the stack, as in the steam-locomotive. The steam-pipe connects to a small dome in the back of boiler and passes back between the exhaust-pipes to the stop-valve between the two groups of engines. A small steam-pipe also passes to the small exciting-engines. At the back of the engines is placed the air-pump, Westinghouse brake being used. This locomotive is arranged to run in either direction; one end is brought to a sharp point to deflect the wind as a ship cuts the water. Fig. 253 is a full view of the engine.

The principal dimensions of the Heilmann electric locomotive follow:

Length between buffers.....	52.12 feet
Total length of platform.....	50.5 "
Length of truck.....	13.45 "
Distance from centre to centre of axles between two trucks.....	31 "
Width of platform....	8.8 "
Height of stack above rail.....	13.7 "
Diameter of driver	45.67 inches
Weight.....	115 tons
Horse-power developed at engine..	1350

Fig. 259 is a view of one pair of drivers and motor, showing the involute spring and spider; Fig. 256 is a

diagrammic view of the same. Fig. 261 is a view of the boiler as mounted on the girder-frame. In describing this electric locomotive the idea is to show what effort is being put forth to try and perfect an electric locomotive which will generate its own power independent of a supply or central station, and making it an independent unit, as the steam-locomotive. As to whether it will ever be a competitor of the steam-locomotive will require a great deal of consideration and experimenting, although there is a field in which it would have its place.

ELECTRIC SWITCHING-LOCOMOTIVES FOR MINING COMPANIES AND FREIGHT.

The electric locomotive is coming into extensive use in mines, for the reason that it does not require any fire to operate it. In using steam-locomotives the smoke and steam are always a detriment, and although they have been used for years, a better method has been sought for. Compressed air is used also, and many engines are operated with air-pressure; this likewise does away with the fire and smoke in mines. Generally the engine must be very low, and the electric locomotive meets this requirement. It is thought proper to describe these locomotives, as they are in practical use and are in the same class of work as the switch-engine using steam. Fig. 262 shows a switching-engine for the Golden Sceptre Gold Mining Co., built by the Baldwin and the Westinghouse companies, which is a four-wheeled engine having two motors, one on each axle. These motors are of the con-

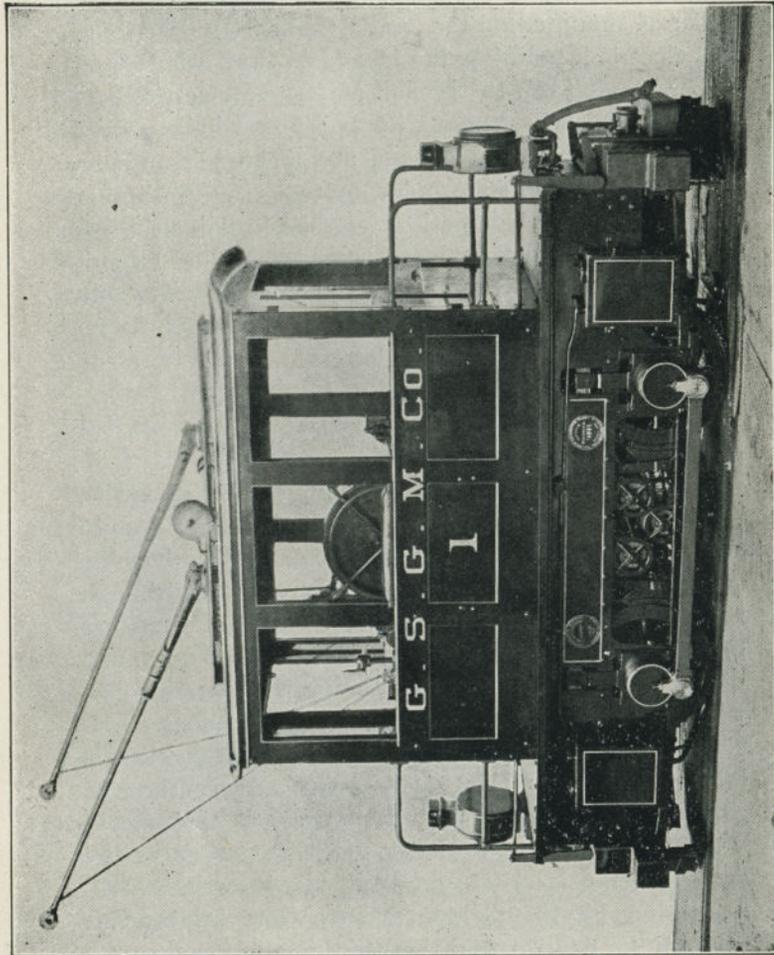


FIG. 262.—SWITCHING-LOCOMOTIVE.

sequent-pole type and have double reduction-gear. Motors were mostly of double reduction type when they first came into practical use, but this required an extra set of gear-wheels and pinions, and caused extra friction wear, making them very noisy. The motor was improved gradually, until now there is only the single reduction used with many advantages. In the locomotive being described it was necessary because of the slow speed of the engine when hauling a load. The capacity is 100 H.P. continuously for three hours at a speed of 6 miles per hour. The frame is of the bar type. The cab is mounted on the frame and contains the controlling apparatus. The engineer has a very clear view either ahead or back. This locomotive is outside-connected, that is, the wheels are inside the frame and the cranks are on the end of driving-axle outside of the boxes, this being a narrow-gauge engine.

Fig. 262 shows controlling-levers very plainly. One lever is the controller-lever and the other is the reversing-lever.

A feature of this locomotive is that of using connecting-rods. The idea is to get an adhesive power without using sand, and to prevent one motor starting ahead of the other or slipping, which is liable to happen without the rods.

The controller is of the series-parallel type. Air-brakes are used; the three-way cock is shown. The air is compressed by a pump driven by a small electric motor which is regulated automatically to a predetermined pressure. The air-pipes are shown on each end with the headlights. The rheostats or directors are carried under the cab as the cut shows, there being

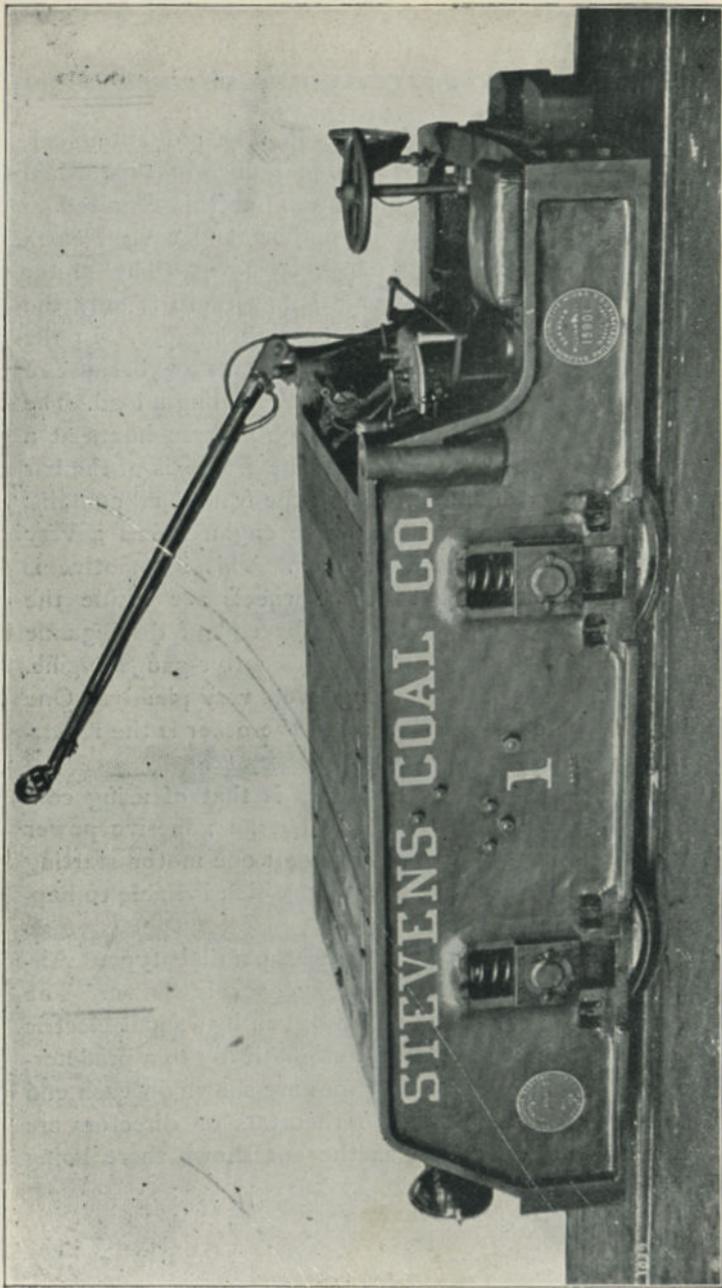


FIG. 263.—INTERIOR MINING LOCOMOTIVE.

three of the coil ribbon type. This locomotive has two trolley-poles to carry the current from the wire. The idea is for safety and to have a large contact area to take off the current. In locomotives of this class when it is desired to increase the adhesive weight the cab floor is generally loaded with cast iron.

Data.

Draw-bar pull.....	4500 lbs. at 6 miles per hour
“ “ “.....	6000 “ “ start
Diam. of drivers.....	33 inches
Wheel-base.....	6 feet
Weight on drivers.....	31,500 lbs.
Total weight.....	31,500 lbs.

Will haul a train of nine cars weighing 35 tons up a maximum grade of 5%.

Fig. 263 shows a mining locomotive of the low-down type to be used in the mines.

The frame forms the side and extension for draw-bars; the motors are in between the axles, and covered up entirely. The controlling apparatus and operator's seat are shown at the end with brake-wheel and head-light. The trolley-pole can be set in either socket cast in the frame. This trolley must be insulated to prevent short-circuiting and shocks to the operator. The current connections are made by insulated cable. The motor body and apparatus are carried on helical springs, which insures easy riding and prevents pounding on the rails. The locomotive has two motors, single reduction-gearing running in oil, one geared to each axle. They are spring-mounted. The motors are of the four-pole

steel-clad, enclosed railway type. The armature windings are laid in slots in the core, which means high efficiency secure against displacement.

The controller is of the rheostatic type with magnetic blowout, preventing arcing at the contacts. This controller permits of six speed-changes. The general workmanship is equal to that on a steam-locomotive. These locomotives show the compactness, flexibility, and few parts required in an engine capable of hauling small trains in mines.

WESTINGHOUSE LOCOMOTIVE (ELECTRIC). FIG. 264.

The electric locomotive shown is a radical departure from the locomotive just described. It is not divided into two parts coupled together. The body is very neat in appearance, and is so constructed as to permit material to be carried in it, or may be used to carry freight or baggage. All the operating appliances, such as controllers, gauges, and brakes, are inside. The trucks are substantially built using a bolster and centre-pin, which makes it very easy riding. The motors are suspended so they can be taken out without disturbing the other portions of the truck.

This locomotive differs from others by using gearing. Other locomotives are direct-connected to the drivers by a hollow sleeve and a spider. It permits of variable speeds. These motors are geared to produce a speed of 75 miles per hour, although 125 miles may be reached if it were required. There are eight wheels or drivers, which are 42 inches in diameter. The motors are rated at 200 H.P. each; they are four in number, one

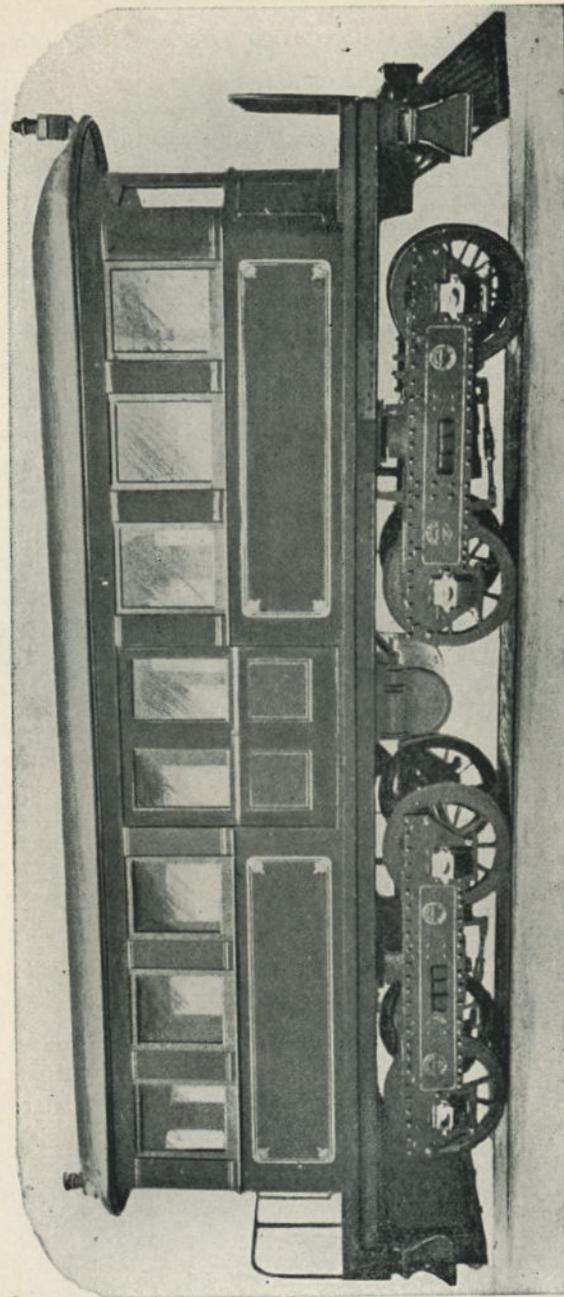


FIG. 264. — BALDWIN-WESTINGHOUSE ELECTRIC LOCOMOTIVE.

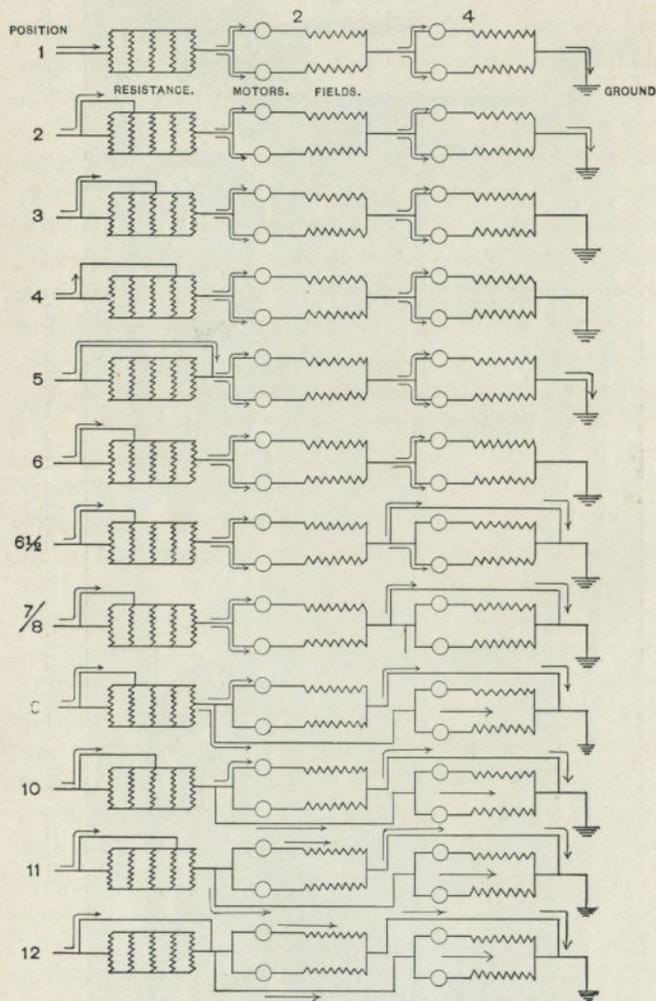


FIG. 265.—DIFFERENT COMBINATIONS OF MOTORS AND RESISTANCE FOR CONTROLLING A LOCOMOTIVE USING FOUR MOTORS.

on each axle. By this construction the entire weight of the locomotive is used as adhesive power. The locomotive complete weighs 160,000 pounds.

Westinghouse air-brakes are used. The air is compressed by an electric compressor placed under the floor of the locomotive.

The length is 38 feet, by 9 feet wide.

By using a geared motor the cost of a locomotive is reduced; a motor using direct connections is very expensive. Under severe test the gear-wheel seems to give good results. The pilot on each end is the only feature suggestive of a steam-locomotive. This locomotive must depend on a central station for its power, therefore is not an independent unit like a steam-locomotive.

The diagrams (Fig. 265) show the method in which an electric locomotive using four motors such as the Westinghouse can be controlled.

LIQUID FUEL.

The heat generated by petroleum fire is much more uniform than that produced by wood or coal. The fire is not as sensitive to the fluctuations of the weather as are other fires. A great advantage is the easy manner in which it can be controlled by the adjusting of a valve; a constant supply of steam can be supplied without the reduction of pressure by replenishing of fuel, as in coal fires. Air-holes and dead spots are not present. A constant degree of heat can be maintained by the adjustment of the regulating-valve. Other important features of oil fuel are as follows: Complete combustion; no ashes; absence of sparks and cinders; and ability to extinguish the flame in case of danger. There being no necessity to open the fire-door for the introduction of fuel, there is no reduction of pressure, chilling of flues, sheets, and leaking due to this cause. The absence of sulphur in the fuel makes its action on the boiler-plate much less destructive than when using coal as fuel.

Oil or residuum is now being used on locomotives. In the construction of the fire-boxes it does not require a combustion-chamber as with coal-burning fire-box. The latter, being solid, requires more time for decomposition and the elimination of the products and supporters of combustion; compared with oil the combustion of coal is slow and requires aid by strong draft. Oil, having no ash or refuse when properly

burned, requires much less space for combustion, for the reason that, being a liquid and the compound of gases being highly inflammable when united in proper proportions, it gives off its heat with utmost rapidity and at the point of ignition is all ready for combustion. By burning oil with a clear white fire it is free from smoke, dust, and soot; also in locomotives the exhaust-nozzles can be made the maximum size, because a strong blast is not required for combustion. This is an item to be considered, as the power of the engine is increased by the reduction of back-pressure against the piston-head.

The possibility of explosion from liquid fuel is small when proper precaution is taken in operating the burners. The one cause of danger lies in the clogging up of the burner or pipe-connections; where more than one burner is used a partial extinction of the fire may take place and the reignition of the oil is delayed by the cooling of the bricks, and the gas is generated in the presence of the air drawn in by the draft; an explosive mixture is thus formed, which requires only the presence of flame to cause it to explode. The term "snapping out" is applied to the above action, but by proper proportioning of pipes and burner, with proper means to prevent dirt getting in and clogging pipes, there is no danger.

In lighting up oil fires care must be exercised to prevent an explosion of the accumulated gases, and the person lighting up should keep away from the fire-door, as there is an outrush of gases in practice; this, however, can be reduced to a minimum by the following procedure: It is necessary to introduce some waste or wood in flames before commencing to spray oil fuel,

in order to insure absolute freedom from the risk of mishap. A little oil allowed to run in the fire-box over some lighted waste will provide a good flame over which the oil may be sprayed and ignited. After allowing this amount of oil to enter the furnace, it is advisable to commence by admitting steam first and then gradually opening oil-valves to burners until the desired heat is obtained.

In order to prevent danger from oil flames, in case of an accident to a locomotive burning oil, automatic devices are used to close the oil-valve in the tank, thereby extinguishing the flame in the fire-box. A simple means is to have a weighted valve in the pipe between engine and tender, with a cord so fixed that it can be operated by hand or broken by concussion or other means.

The following data relative to heating capacity of petroleum are derived from actual tests. The heat of crude petroleum is 20,240 heat-units, while the heat-units pound of coal = 14,300; but this will be reduced by reason of impurities, according to some authorities, to 8000 heat-units pure carbon, as charcoal contains 14,500 heat-units. An evaporation of 17.56 to 18.5 pounds of water has been obtained in a test with oil, against $7\frac{1}{2}$ * pounds of water evaporated with a pound of coal. These tests were made with water from and at 212° F. Three barrels of oil, each of 42 gallons, weigh 913.5 pounds and slightly exceed the

* By careful operation $9\frac{1}{2}$ to 10 pounds of water per pound of coal have been evaporated. The evaporation of $7\frac{1}{2}$ lbs. is in every-day practice.

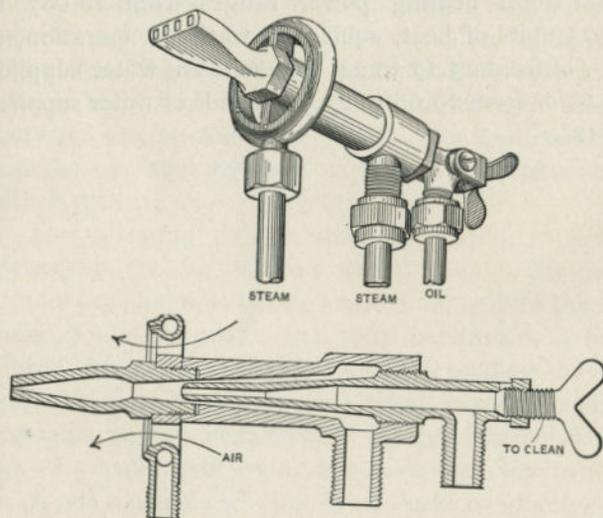
heating capacity of one ton of coal. The chemical composition of petroleum oils are, as per table, from

		Mean.	Authority.
71.42 carbon	to	73.77 carbon	72.60 D. K. C.
28.58 hydrogen		26.23 hydrogen	27.40
<u>100.00</u>		<u>100.00</u>	<u>100.00</u>

The specific gravity ranges from .628 to .792. The boiling-point ranges from 86° to 495° F. The theoretical total heating power ranges from 28,087 to 26,975 units of heat, equivalent to the evaporation, at 212°, of from 25.17 to 24.17 pounds of water supplied at 62°, or from 29.08 to 27.92 pounds of water supplied at 212°.

OIL-BURNING LOCOMOTIVES.

Owing to the recent discovery of vast oil-fields in the southwestern portion of the United States, oil-burning locomotives have been designed and are in operation hauling trains. Oil fuel has been used in Russia for years past, using the Urquhart system; also in England



FIGS. 266 AND 267.—OIL-INJECTOR FOR BURNING OIL.

under the Holden system. There are various methods for burning oil, and that which is best adapted to locomotives is the jet-burner, in which the burner takes the form of an injector, as shown in Figs. 266 and 267, a sectional and perspective view of the burner used

in the Holden system. This is the general form of burners. As shown, the outer shell terminates at one end in a flat nozzle having three holes in it; another nozzle projects into the body, being tapered with a small opening in the end. This nozzle projects back beyond the main portion of burner with a pipe-threaded connection. The outer shell has also a connection projecting downward. The inner nozzle is screwed into the outer shell. Surrounding the forward end of burner is a hollow ring with small holes towards the end of burner; this ring is connected to the steam-supply by a pipe. This is called an air-inducer, to induce a current of air. The outer nozzle is connected to the steam-boiler, while the inner nozzle is connected to oil-tank.

Fig. 268 shows the Holden locomotive equipped with combined coal- and oil-burners, using the above-described burner. In the back leg of fire-box are two pipes 6 inches in diameter; they are below the fire-door. The end of the oil-burners project into these openings. The oil-pipe leads back to the tank containing oil to be burned; this tank sets up above the water-space of tender so as to allow the oil to flow to burner by gravity. The steam connection is tapped into back head of boiler, as shown, with suitable valves for controlling. By this system coal and oil can be used at the same time; a thin layer of coal is spread over the grates, enough to prevent air holes; the ash-pan dampers are kept nearly closed; nearly the whole of the air needed for combustion enters either through the injector-tubes or the fire-door, which is kept open and fitted with a deflector, as when coal alone is

burned. If necessary, a change from liquid fuel to coal can be made while running. The exhaust-pipes are fitted with adjustable nozzle, which can be thrown in or out of action by a lever. When burning oil a very soft blast is required, using a large nozzle and

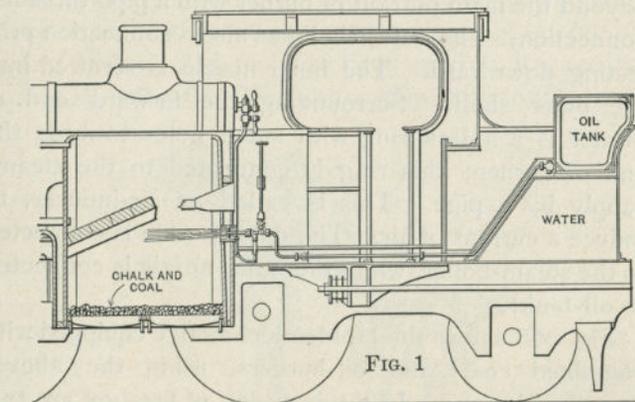


FIG. 1

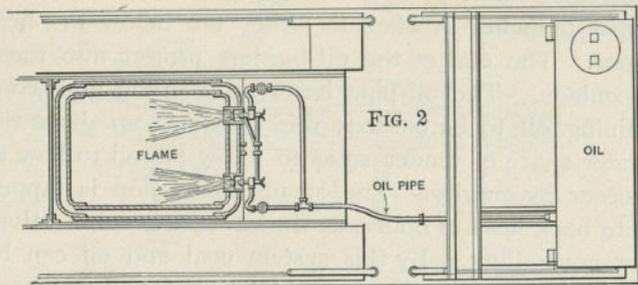


FIG. 2

FIG. 268.—HOLDEN OIL-BURNING LOCOMOTIVE.

reducing the back pressure. The operation of burner is as follows: The valves being opened steam and oil flow into the ejector and combine, and are discharged into the fire-box in the form of a spray, which

is ignited; this combined steam and oil strikes the brick arch in fire-box, which is in an incandescent state, while the air for combustion is drawn in by the inducing-jet, the coal being supplied as required by hand. The fireman must regulate the oil- and steam-supply so that perfect combustion takes place without any smoke issuing, as this denotes unconsumed carbon. The liquid fuel used on these engines is one third green oil, two thirds tar.

VANDERBILT OIL-BURNING LOCOMOTIVE.

The Vanderbilt boiler is adapted to both coal and liquid fuel. The Southern Pacific Railroad has several of these engines in operation. Fig. 269 shows a cross-sectional view of the fire-box as equipped for oil burning. This fire-box being a single cylinder corrugated, is surrounded up the sides and bottom with fire-brick to prevent a direct impact of oil on them; also the fire-brick becomes incandescent and helps support combustion. The back end of fire-box is closed by sheet iron, which is lined inside with fire-brick; this carries the fire-door. Near the bottom of this rear extension are two dampers which are raised or lowered as desired. (See Fig. 270.) Between these two dampers is placed the oil-burner, which projects into the fire-box, as shown. This is of the injector type, with a flat nozzle, a connection for steam, and regulating-valve, as shown; also a pipe-connection to tank, a flexible slip-joint being provided between engine and tender. This engine uses a single burner. The tender is made up of two compartments: the lower portion contains the water, while

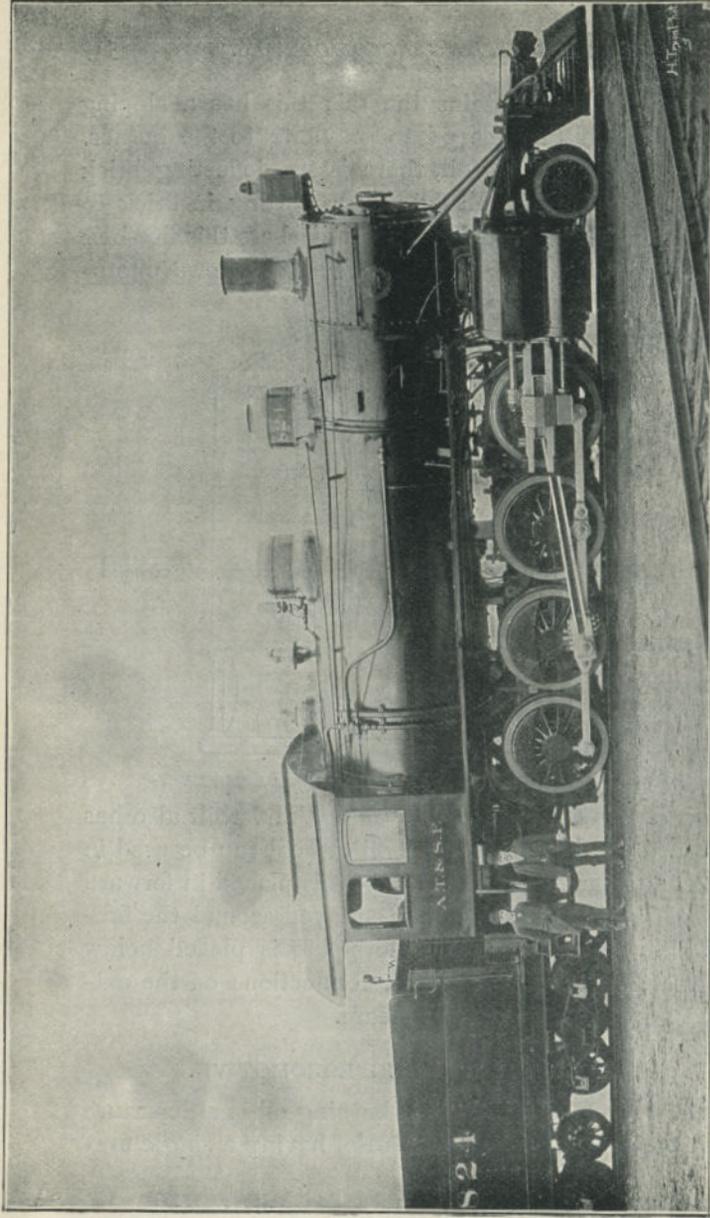


FIG. 271.—FOUR-CYLINDER COMPOUND VAUCLAIR SYSTEM PLAYER OIL-BURNING LOCOMOTIVE.

General dimensions: Gauge, 4' 8½"; cylinders, 17' and 28" X 32"; drivers, 57"; total wheel-base, 24' 6"; driving-wheel base, 15' 4"; weight, total, about 214,620 pounds; weight on drivers, about 191,370 pounds. Player boiler: Diameter, 74"; number of tubes, 652; diameter of tubes, 1½"; length of tubes, 13' 7". Fire-box, 3 tubes: Length, 84"; width inside diameter of tubes, 28". Heating surface, fire-box, 165"; combustion chamber, 70"; tubes, 4031; total, 4266. Tank capacity: Water, 6000 gallons; oil, 2200 gallons.

box this engine has three tubes 28 inches in diameter and 84 inches long. Fig. 272 is sketch of boiler and fire-boxes. The tubes open into a combustion-chamber; the flues extend from combustion-chamber to front sheet in smoke-box. The purpose of using three tubes is to divide the heating effect and not concentrate all in one burner and tube. There is an extension from the back end of boiler. The three tubes open into this extension, which is fire-brick lined; into each tube projects a burner. The steam- and oil-connections are outside of this extension, as shown. At the bottom of the extension is a damper to regulate the amount of air for combustion. The tubes are brick-lined to protect the tube-plate. There is a bridge wall across the tube; the jet of oil strikes against this wall and is spread out against the walls of tube, which are lined; the flame passes into the combustion-chamber and from there passes into the flues. The course of gases is shown by the arrows in Fig. 272. In Fig. 273 is shown the three tubes and back end of boiler. The oil-burners or sprayers project into back end of tubes with the regulating-valves on the outside of extension, as shown in Fig. 274. The valve-rods are brought over to the left side of boiler-head and are held at position set for running by a thumb-latch and rack, as shown in sketch; the steam-pipes and valves are connected to a steam-chamber which has a single connection with valve to boiler; at the left side is shown a valve marked *air-valve*, with a pipe leading to an air-tank. Air or steam can be used with these burners, especially when starting with no steam in the boiler. The oil-pipes connect to a horizontal pipe below the deck floor; this

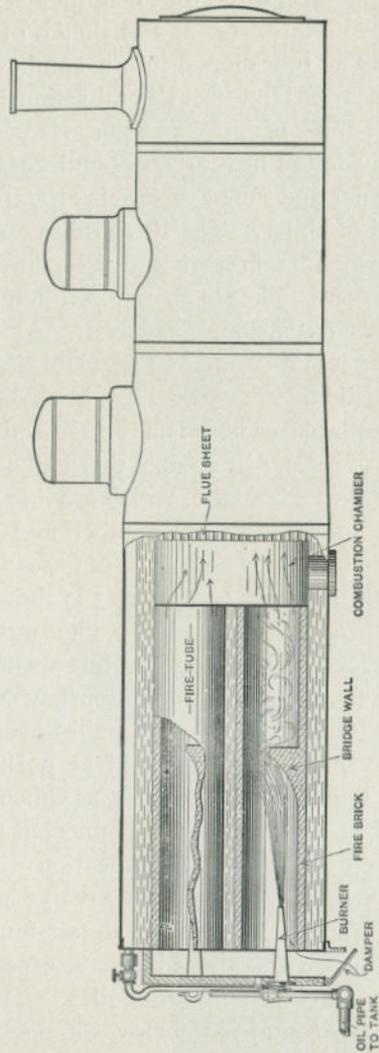


FIG. 272.—PLAYER BOILER.

is also connected to the oil-tank with a flexible or slip-joint pipe, so as to adjust itself to the motion between engine and tender. The air-damper is regulated by a lever extending into cab. One or more burners can be used at a time with this engine. A single burner

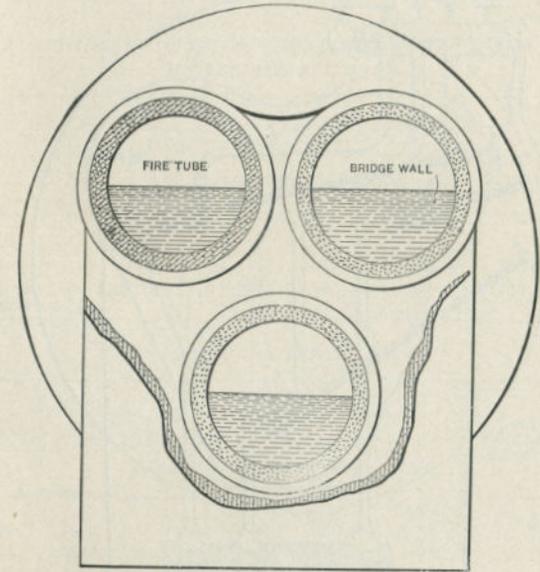


FIG. 273.—BACK END OF BOILER, SHOWING THREE FIRE-TUBES.

will raise the steam-pressure very quickly. The tender is made up of two compartments: the lower compartment is the water-tank, the upper one contains the oil; the top of the oil compartment is very strongly braced with angle iron to prevent sagging or bulging, due to the movement of engine. The capacity of tender is: water, 6000 gallons; oil, 2200 gallons. The general

dimensions of engine are given in Fig. 271, which is a photograph taken at the works; it is a four-cylinder compound engine, Vaucrain system.

The following is a report on oil-burning locomotives

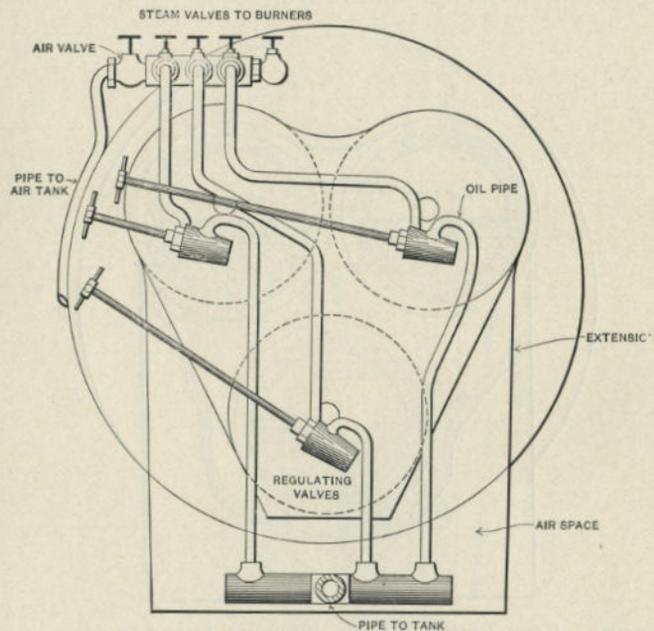


FIG. 274.—PLAN OF REGULATING VALVES FOR OIL-PIPES AND STEAM-VALVES.

used on the Russian railroads. Coal cost at time of report \$5.29 per ton, while crude oil cost 81 cents per barrel, and three barrels of oil would do more work than a ton of coal.

The following table is from a report made by Mr. Urquhart, director:

Coal consumed per mile..... 87 pounds.
 Petroleum. 49 "
 Saving in weight..... 44 per cent.
 Cost of coal per mile..... 23 cents.
 Cost of petroleum per mile..... 13 "
 Saving in cost..... 43 per cent.

TABLE SHOWING COAL AND OIL CONSUMED WITH HOLDEN SYSTEM ON ENGLISH RAILWAYS.

	Miles Run.	Fuel Used (Pounds).				Cost.
		Coal.	Liquid Fuel.	Chalk.	Total.	
Liquid fuel, Engine 193.....	951 $\frac{1}{2}$	13,511	10,505	784	24,800	\$33.99
Coal, Engine 194	951 $\frac{1}{2}$	27,738	27,738	44.33

RESULTS PER MILE.

Engine No.	Coal.	Fuel Used (Pounds).				Per Cent of Liquid Fuel and Chalk to Coal Used.
		Liquid Fuel.	Chalk.	Total.	Cost.	
193	14.2	11.0	0.8	26.0	Cents. 3.58	83
194	29.1	29.1	4.65	

Cost of coal per ton, \$3.58; liquid fuel per gallon, 11 pounds, \$1.25; chalk per ton, \$1.32. (Chalk used for covering grate.)

THE MODERN LOCOMOTIVE BOILER AND FIRE-BOX.

The effort to get a large grate-area and heating-surface has caused changes in boiler design from time to time, with a consequent shifting of the centre of gravity to accommodate these changes. There are several different forms of fire-boxes in service, using different kinds of fuel. Fig. 275 is a wagon-top boiler with a narrow fire-box. This fire-box passes down between the frames and is therefore a deep fire-box; the crown-sheet has a slight radius to accommodate the radial stay-bolts that support the crown-sheet. Where crown-bars are used these bars span across the crown-sheet from side to side, with the ends resting on the corners; the crown-stays are attached to the crown-bars and crown-sheet, with sling-stays supporting the crown-bars also to the outer sheet. The back head is stayed by gusset-stays from the top sheet, also by longitudinal stay-rods. The same style boiler may have a shallow fire-box, which differs from a deep fire-box in that it sets above and over the frames. The deep fire-box is used for burning soft coal, while the shallow one is used for anthracite. In the effort to get an increased grate-area to burn a poor grade of coal or fine culm from the anthracite region, the Wootten type of boiler and fire-box was brought out, as shown in Fig. 276. This type was developed in 1877, and many were put in service and continue to be used. This construction caused the cab to be placed forward of the

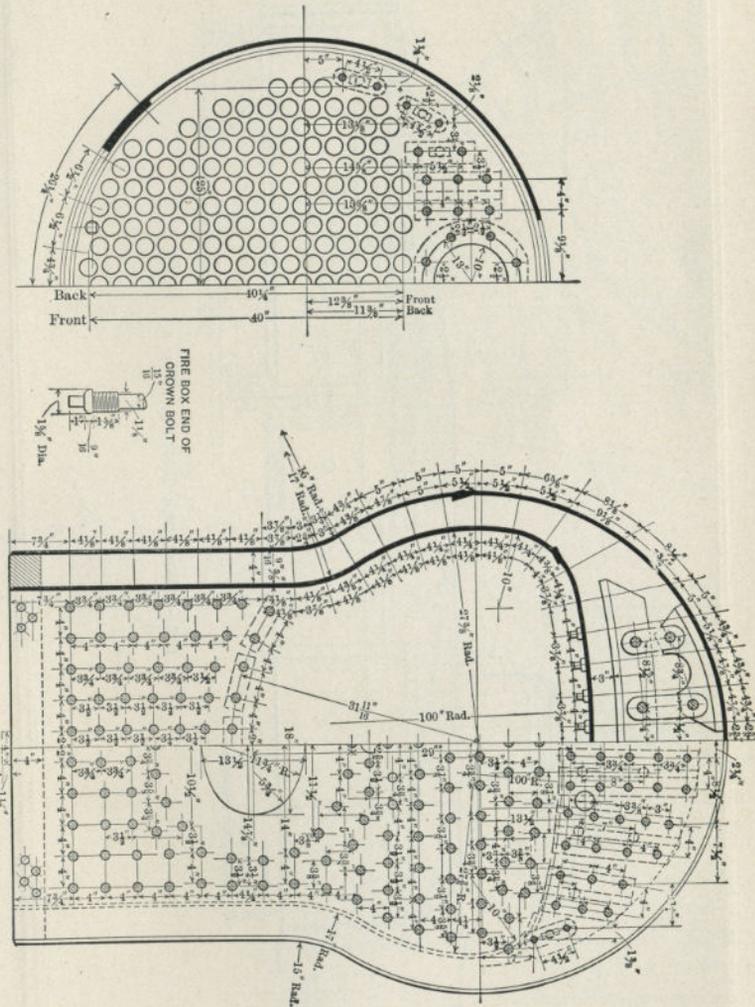


FIG. 275.—TRANSVERSE SECTION OF BOILER WITH NARROW FIRE-BOX.

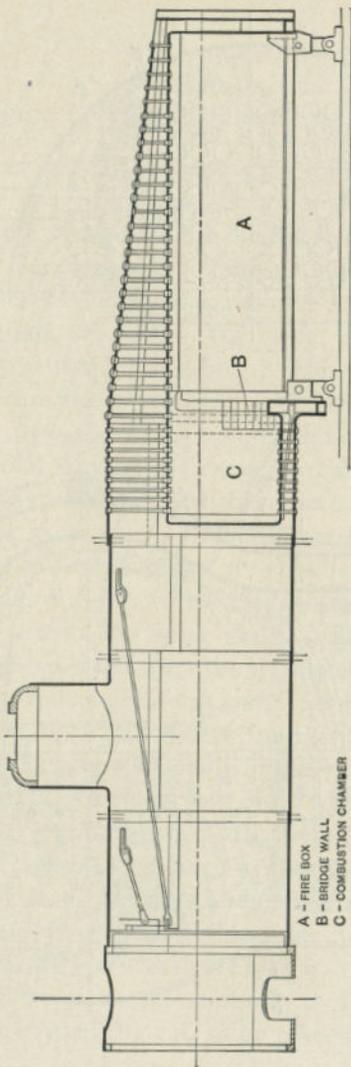


FIG. 276.—WOOTTEN BOILER, 1877.

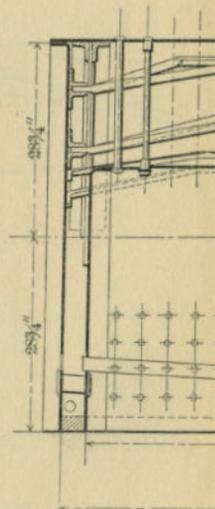
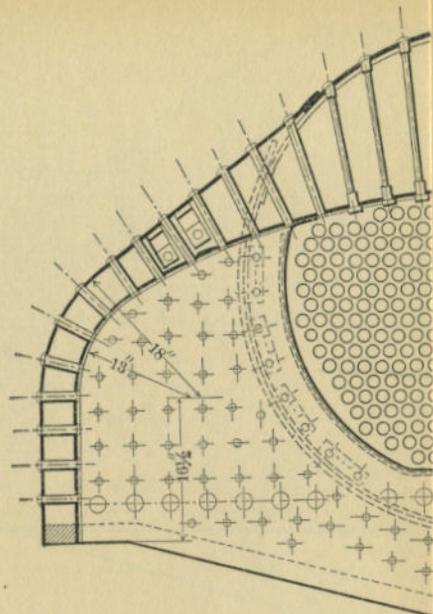


FIG. 277.—

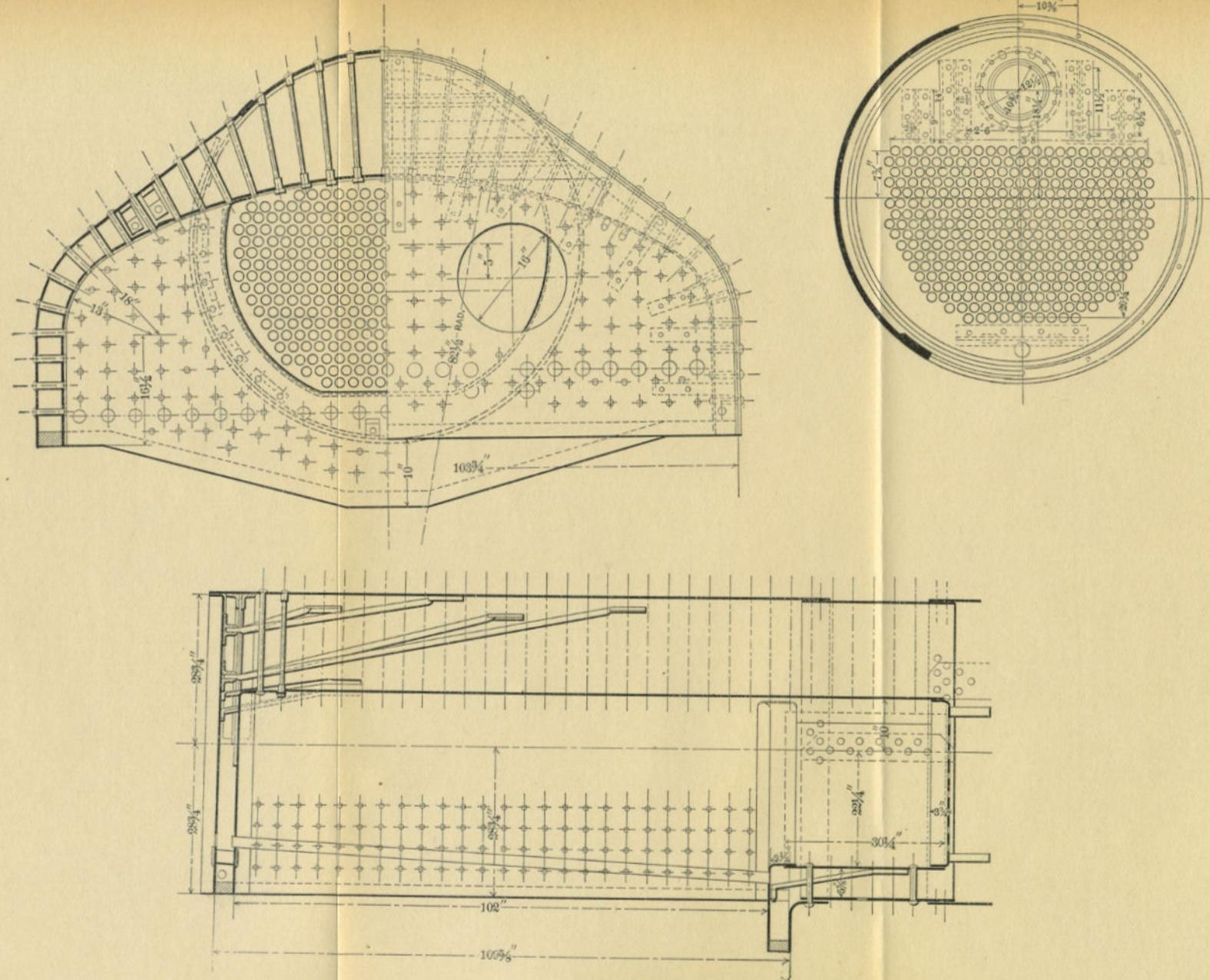


FIG. 277.—WOOTTEN LOCOMOTIVE BOILER, LONGITUDINAL AND TRANSVERSE SECTIONS. [To face page 527.]

fire-box, with the steam-dome in the cab.* The fire-box was spread out to a maximum limit each side of the cylindrical part of the boiler; this caused the fire-box to be raised to clear the driving-wheels, necessarily raising the centre of gravity of the boiler higher than the usual engine at that period. The dimensions of grate were about 8 x 8 feet, or 64 square feet. This made a very wide crown-sheet and a shallow fire-box; the depth from top of grate-bars to crown-sheet at back end being about 29 inches. A combustion-chamber was provided in the forward end; a bridge-wall of fire-brick was between this chamber and fire-box, as shown. In this type the top sheet over crown was sloped down to the back end, leaving a small water-space over the crown-sheet, a feature changed in later designs. This form of boiler required a great many crown stay-bolts, as the drawings show. In the later design of boiler using the Wootten fire-box the top sheet was carried back straight instead of sloping; this was a movement in the right direction, as it provided for a larger water- and steam-space over the crown-sheet, the top sheet from top radius to bend at the sides being flat. (See Fig. 277.) In the modified type of Wootten boiler, the diameter of the cylindrical part of the boiler was increased, which made the fire-box extend beyond the cylindrical portion a very short distance; the height from grate-bars to crown-sheet was increased and the combustion-chamber was omitted. The fire-brick arch, when using soft coal, is used with water-tubes supporting it, (Fig. 278). In all these boilers two fire-doors are used in soft-coal burners,

* The dome is also placed back of the cab, over the crown.

and they burn very successfully the grade of coal for which they were designed. In Figs. 279 and

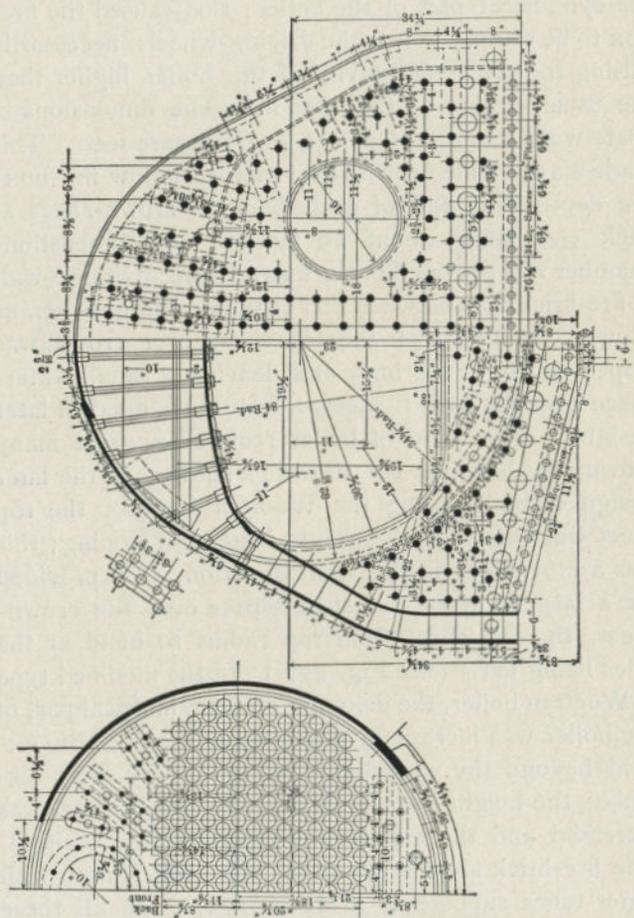
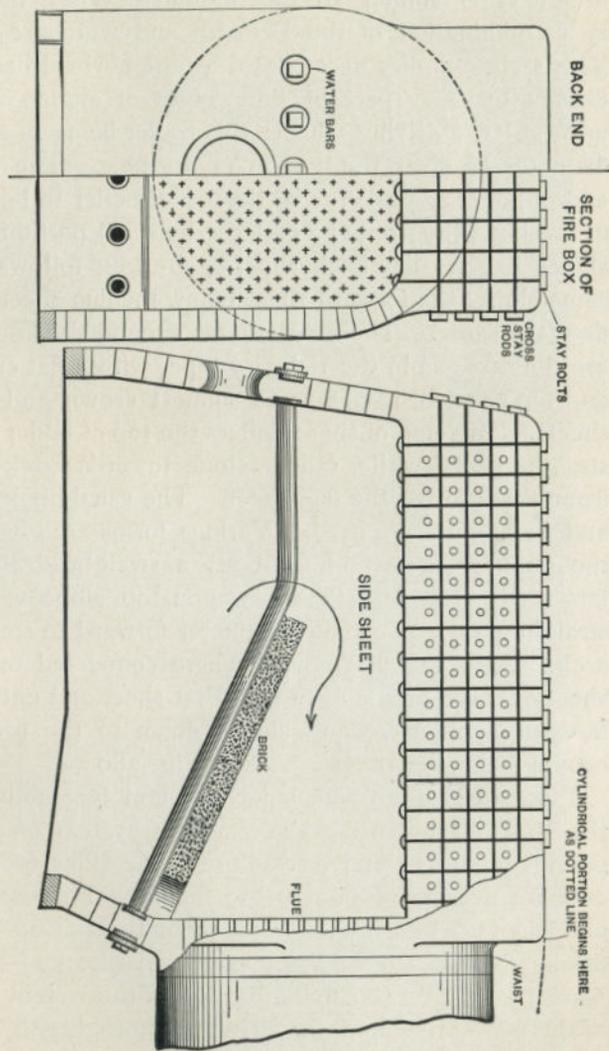


FIG. 279.—TRANSVERSE SECTION OF BOILER WITH MODIFIED WOOTTEN FIRE-BOX.

280 a modern boiler and fire-box are shown. This construction is due to the effort to get increase grate-



FIGS. 279 AND 280.—BELFAIRE-TYPE WIDE FIRE-BOX.

area; it is similar to the modified Wootten, but is a combination of the Belpaire and wide fire-box. This style of boiler necessitates a trailer-wheel back of drivers to carry part of the weight of engine when using a large driving-wheel; this trailer being of small diameter to clear the bottom of fire-box. The back end of boiler slopes off from the top of boiler to bottom of fire-box; the front end under cylindrical portion also slopes back. The back sheet of fire-box follows the same slope; the forward sheet below the flue-sheet also does the same. The outer sheets around the fire-box are the same as in the Belpaire type, with a flat crown and top sheet, using stays to support crown and side sheets. In some of these boilers the top of boiler runs straight back, while others slope towards back end from a point over the flue-sheet. The usual brick arch and water-tube are used. Various forms are given to the strakes forward of fire-box: a straight strake of large diameter, and then a wagon-top slope with a straight strake of smaller diameter forward to smoke-arch. Also the first course where connected to top sheet over fire-box is even with that sheet and extends forward one course and slopes down to the second course of smaller diameter, as in Fig. 280.

Fig. 281 is a ten-wheeled compound locomotive of the Prairie type, using the Vauclain system of compounding and having a wide fire-box. This fire-box extends over the frame to the fullest width possible, and when used for a passenger locomotive having large driving-wheels it requires that a trail-wheel of small diameter be used to carry a portion of the weight back of the main drivers, as shown in the photograph. This

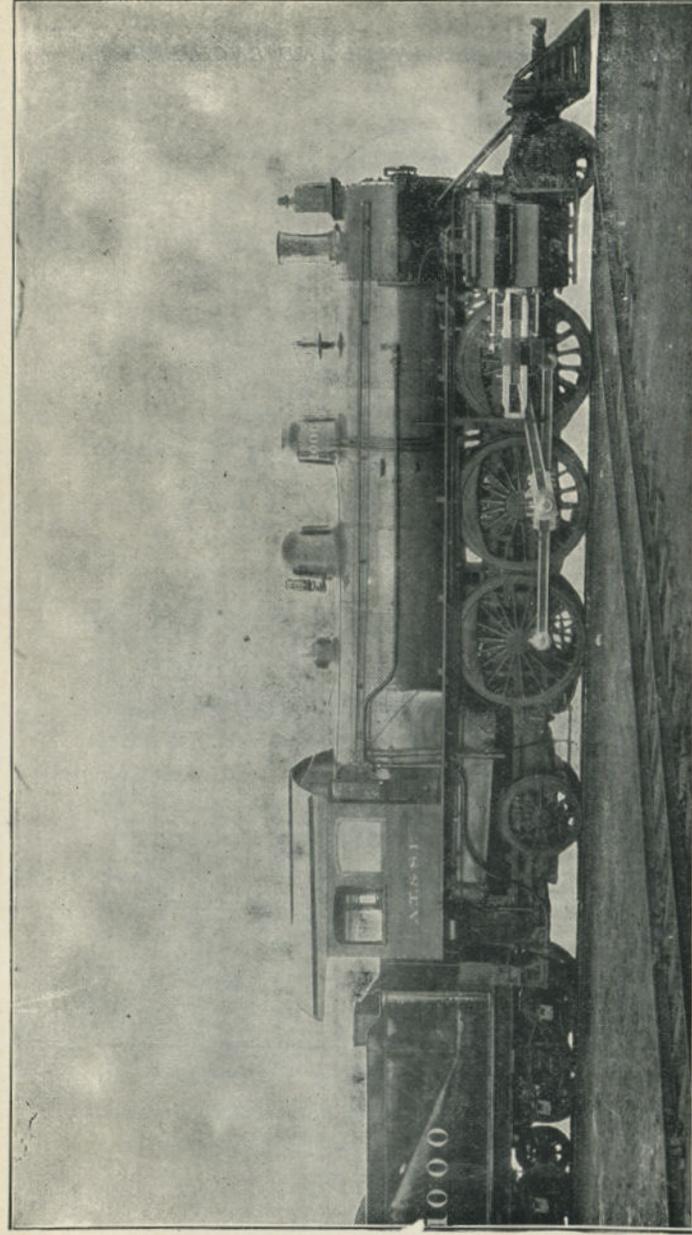


FIG. 281.—FOUR-CYLINDER COMPOUND, VAUCLAINE SYSTEM PRAIRIE TYPE LOCOMOTIVE. BALDWIN LOCOMOTIVE WORKS. General dimensions: Gauge, 48½"; cylinders, 17 and 28 X 28; drivers, 79"; total wheel-base, 32' 2"; driving-wheel base-13' 8". Weight, total, about 209,210 pounds; on drivers, about 144,600 pounds. Boiler, diameter, 70"; number of tubes, 313; diameter of tubes, 2½"; length of tubes, 19' 0"; fire-box, length, 108"; width, 71½". Heating-surface, fire-box, 194.6 sq. ft.; tubes, 3543.4 sq. ft.; total, 3738 sq. ft. Tank capacity, 6000 gals.

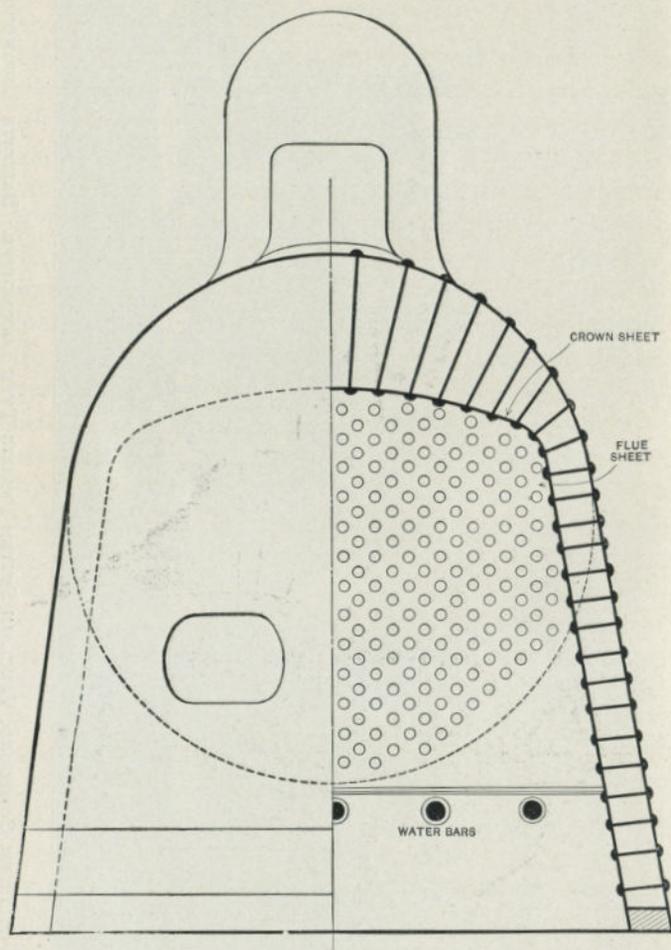


FIG. 282.—BACK END OF PRAIRIE-TYPE BOILER ; TWO FIRE-DOORS.

form of boiler has a large diameter. In the engine shown the boiler is straight and very long, the flues in this boiler having a length of 19 feet. The fire-box is wider at the bottom than at the crown-sheet; the crown-sheet having a curve and being stayed with radial stays. Where the side sheets are joined to crown-sheet a large radius is given, preventing sharp corners. This fire-box has two fire-doors, one being shown in cut. Inside length is 108 inches, width $71\frac{1}{4}$ inches. The boiler diameter is 70 inches. Total heating-surface of flues and fire-box is 3738 square feet. Shaking grates are used in these engines with the usual fire-brick and water-tube. When these fire-boxes are used for freight engines the forward portion has a drop, or the forward end is deeper than the back end; this portion drops down between the drivers (see Fig. 280). The back end of boiler slopes downward; also front leg under the waist. The flue-sheet is straight, while that portion under flues conforms to the slope of outside sheet. The usual cleaning plugs and appurtenances are used with these boilers. Fig. 282 shows clearly the back end and a section across fire-box.

Fig. 286 shows a Vanderbilt boiler as used on several railways. In designing this boiler the idea was to make a true cylindrical fire-box, using no stay-bolts to support it as in the usual construction. This fire-box is a corrugated tube of the Morrison suspension type, the length 11 feet $2\frac{1}{4}$ inches, diameter 59 inches, with a thickness of $\frac{3}{4}$ inch. The length of grate is 7 feet 9 inches to a bridge-wall, which is carried by a half-round iron in one of the grooves. There is a brick arch on top of this. The space in front of this forms

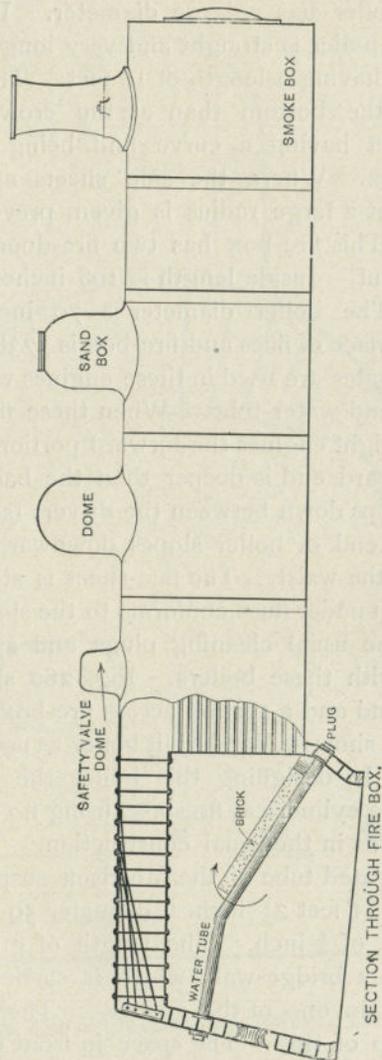


FIG. 283.—PRAIRIE-TYPE BOILER FOR PASSENGER AND FREIGHT ENGINES.

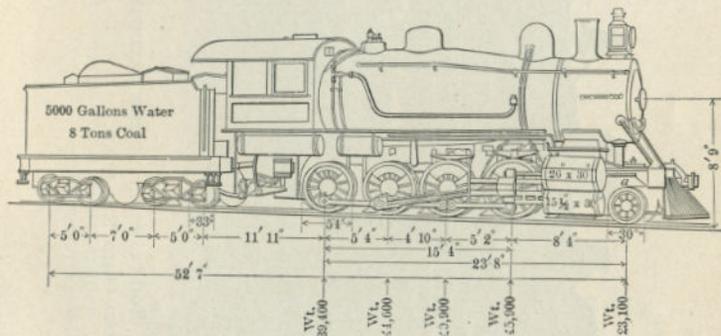


FIG. 284.—GENERAL DIMENSIONS AND WEIGHTS, WITH TANK CAPACITY, OF ENGINE 1940.

that portion forming the ash-chamber; also in combustion-chamber for cleaning out any collection of ashes in that portion: these are closed by manhole-plates. The outlet from ash-chamber has a chute attached to dump the ash. It is evident that this form will make the strongest boiler possible. No stay-bolts are required, and there is little trouble from incrustation and broken stays—a serious item in locomotive maintenance. In a boiler having many stay-bolts the incrustation will collect around the stays and the space between them on the crown-sheet, also where crown-

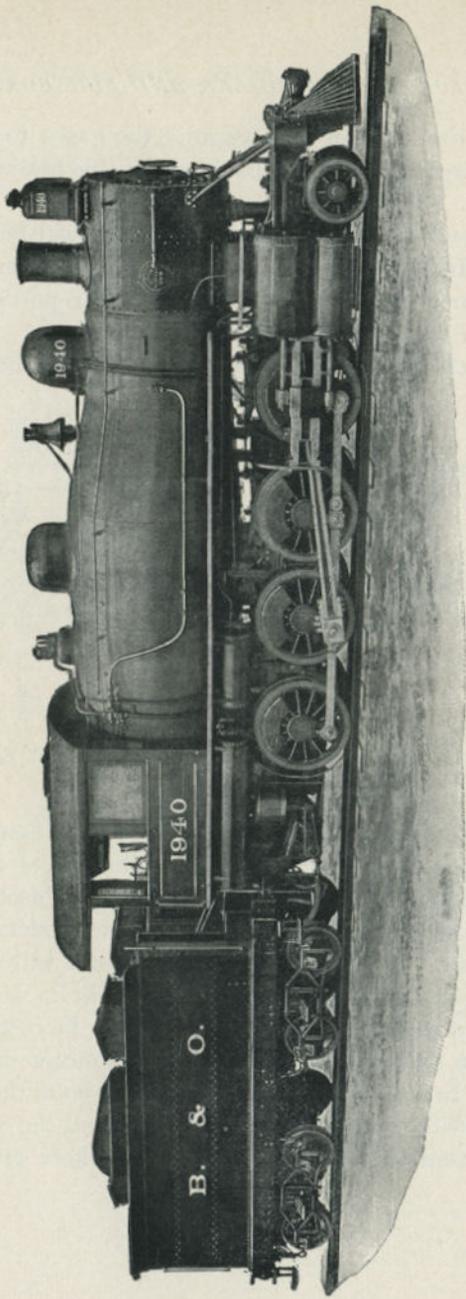
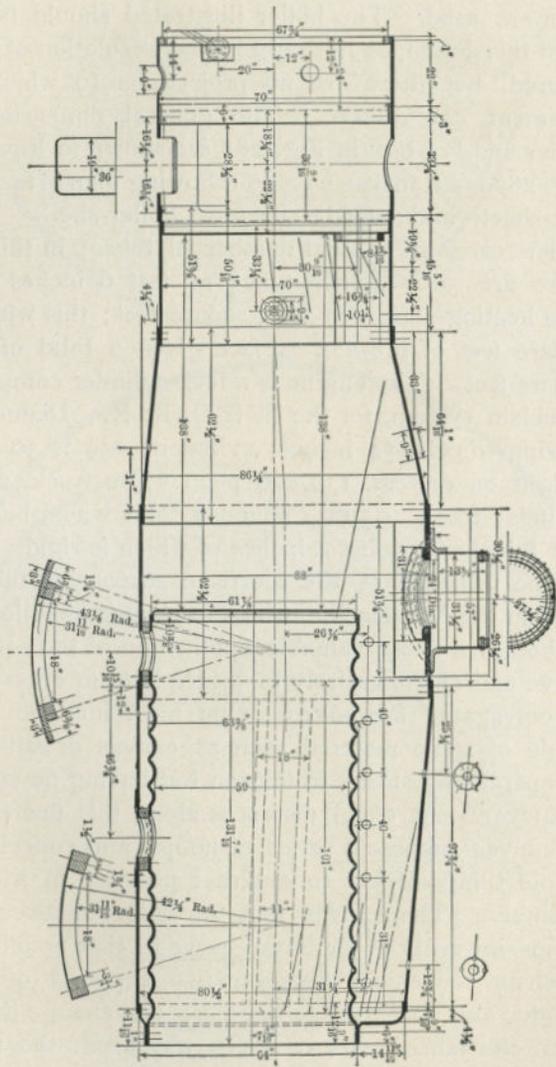


FIG. 285.—CONSOLIDATION LOCOMOTIVE WITH VANDERBILT BOILER, BUILT BY THE BALDWIN LOCOMOTIVE WORKS FOR THE BALTIMORE AND OHIO RAILROAD.

FIG. 286.—BOILER OF LOCOMOTIVE FOR THE BALTIMORE AND OHIO RAILROAD, BUILT BY THE BALDWIN LOCOMOTIVE WORKS.



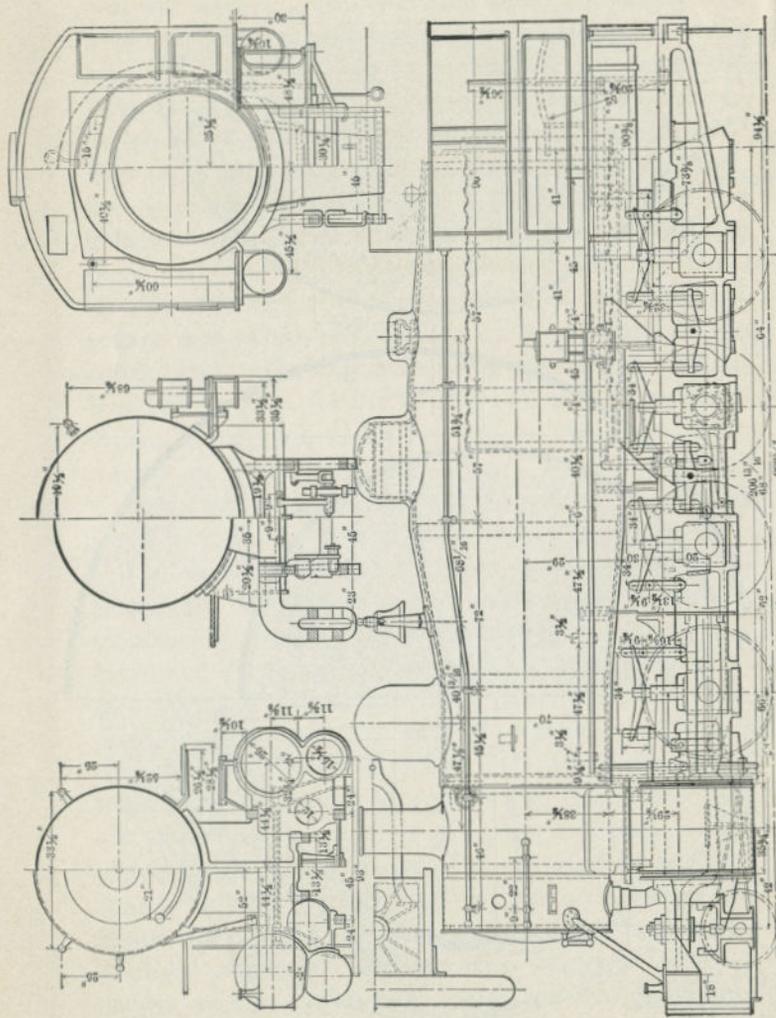


FIG. 288.—ERECTING-CARD OF LOCOMOTIVE FOR THE BALTIMORE AND OHIO RAILROAD, BUILT BY THE BALDWIN LOCOMOTIVE WORKS

stress. There is no crushing or collapsing, even with this material, as long as the hoops which form the series of circular arches are strong enough to resist the compressive stress to which they are alone subjected. Carry this principle out in steel, making the narrow corrugated ribs deep enough to withstand the pressure, and you have the Morrison suspension furnace. It forms the natural converse of the cylindrical boiler-shell, and is as well adapted to withstand collapse as the latter is to stand bursting pressure (see Fig. 286 for corrugations). The point where the grooves join represents the hoops, while the hollows represent the canvas. The pressure is equal in all directions around this fire-box.

LOCOMOTIVE VALVE MECHANISM.

The introduction of the compound locomotive using four cylinders requires several means for transmitting the motion from the eccentrics to the valve, and as these different motions are in daily use on many of the railroads, it is desirable that a clear description be given. The position of cylinders, valves, and number of driving-axles governs the different forms of construction. The number of parts has increased over the older type of motion used to drive the valves in simple engines (single-expansion). Therefore the increase in number of parts in the mechanism, or new principles, causes the men handling the locomotive to give more thought to the operation and construction of such parts, enabling them to quickly overcome delay where a breakdown occurs. The several types of gear shown are mostly used in connection with the Baldwin compound. When the L.P. cylinder is above the centre line through axles, the valve-motion is called direct acting. When the low pressure is below the centre line, the motion used is called indirect acting. In Fig. 289 is shown a direct motion, as applied to either a simple or compound engine. As shown, the direction of rotation is from left to right, and the valve is taking steam in front port, the crank-pin being on the forward centre, the movement of piston-head towards the back end of cylinder. The link is shown in mid-gear position, thus causing the valve to be on lead. These drawings are made this way in order to give a clear

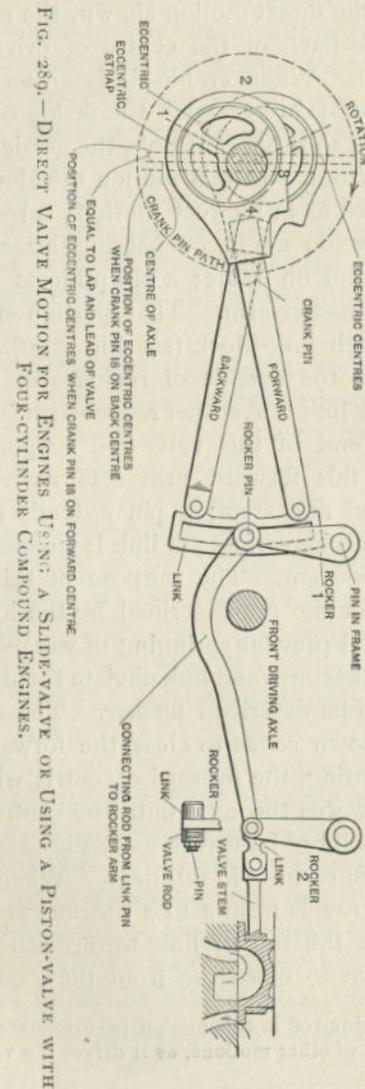


FIG. 289.—DIRECT VALVE MOTION FOR ENGINES USING A SLIDE-VALVE OR USING A PISTON-VALVE WITH FOUR-CYLINDER COMPOUND ENGINES.

outline. In the direct motion shown, the centre of the eccentrics are back of the centre of driving-axle, as clearly shown. When crank-pin is on forward centre the eccentric-rods are crossed, the inside eccentric-rod being attached to the top of link, the outside eccentric-rod to the bottom. In this motion the double rocker-arm is not used as in indirect motion; a rocker-arm or carrier swings on a pin or bearing attached to any convenient point on frame; a pin projects through the lower end of rocker-arm. That portion next to link extends through link-block (see Fig. 289). Attached to the pin on the outside of rocker-arm is the connecting-rod or link.* Another rocker-arm is attached to the forward end of this valve-rod supported as first rocker-arm; this forward arm acts as a carrier for connecting-rod and stem; a pin extends through the lower end of rocker-arm 2; a link is connected to this pin and valve-stem. The purpose of this link is to compensate for the arc described by the lower end of rocker-arm and prevent springing of valve-stem out of line. The rocker-arm and link obviate the use of a small cross-head, to be described further. The connecting-rod is bent down so as to clear the forward driving-axle. In rotating, the forward eccentric will draw the top of link towards the axle until the centre arrives at the extreme point of its travel, as 2, Fig. 289; the valve should be wide open if in full gear. When the centre of eccentric travels from 2 to 3 the forward eccentric-rod will push the top of link towards the valve and cause the valve to close the front port, and when the

* The connecting-rod in this motion performs the same action as the valve-rod of other motions, as it drives the valve direct.

crank-pin is on the back centre, the centre of the eccentrics should be the same distance ahead of the centre of axle as they are behind the centre of axle when the crank-pin is on the forward centre. The backward eccentric or one connected to lower end of link moves in a direction opposite to that of the forward eccentric, and does not control the movement of valve when in the forward gear, as above described. When the crank-pin is on the back centre the eccentric-rods will be open and not crossed, as when on the forward centre.

When the crank-pin leaves the back centre and travels to top quarter, the centre of forward eccentric will travel from 3 to 4, the extreme travel in that direction; this will cause the forward rod to push link towards the valve and open wide the back port. When the crank-pin travels from top quarter to the forward centre the eccentric centre will travel from 4 to 1; this will cause the forward eccentric-rod to pull link towards axle and close the back steam-port and valve to be in position shown in Fig. 289, as on lead forward steam-port. This describes the action of the eccentric controlling the motion in one direction. The action of the backward eccentric in either direction can easily be traced; the exhaust control is the same as with other motions. In this motion, when running forward or backward, the centre of eccentric leads the crank-pin.

When setting up an engine using the direct motion, care must be taken that the eccentrics are set as in Fig. 289. As a rule the men setting valves on locomotives are used to the indirect motion. If the direct-motion eccentrics and rods are set as in indirect motion,

the valve would travel in opposition to the piston-head; if the centres of eccentrics were set as in indirect motion, but with the eccentric-rods crossed, the crank-pin on the forward centre, the valve would overlap the forward port the width of the lap and lead of valve or linear advance of centre of eccentrics, leaving back port open width of lead. When on the back centre the valve would open the forward port this distance and in opposition to piston-head.

When a link-hanger is broken what should be done?

If desired to run, using steam on that side, the link should be dropped down on top of link-block, first inserting a block or waste between the link and block to prevent cutting. The rocker-arm I will carry the link and connecting-rod.

When rocker-pin is broken or disconnected on rocker-arm next to link?

The broken part of pin should be taken out, and it should be seen that the link will clear the rocker-arm, the valve placed in centre of seat to close ports, the valve-stem clamped to hold valve in position, the main rod taken down if far to run. If pin should break that carries the forward end of connecting-rod, the rod should be taken down, valve clamped in centre of seat, and main rod disconnected as before. When the connecting-rod is above the axle it need not be taken down, but tied up to clear, if link-block pin is broken.

If valve-stem should break, or link between rocker-arm and stem, what should be done?

The valve should be placed in centre of seat, clamped in position, and the link taken out. Be sure the

rocker-arm clears stem. Take down main rod and proceed with one side as usual; the other portion of motion can remain in position.

Broken connecting-rod?

Take down broken rod, centre valve on seat; take down main rod and proceed with one side.

If pin in rocker-arm next to link should break, requiring the pin to be taken out as a whole, what should be done?

The connecting-rod taken down, and disconnect as usual; the rocker-arm tied up to clear.

INDIRECT MOTION.

Fig. 290 shows the usual indirect valve-motion used on locomotives employing the upper and lower rocker-arms. The difference between the usual construction and Fig. 290 is in the position of rocker-shaft and means for connecting the lower rocker-arm and the link-block. As shown, the rocker-shaft is set back of the link and close to the eccentric. This permits the whole motion to be set between driving-axles and between the first and second pair of drivers. The reason why it is desirable to place the motion forward is due to the large fire-box used on such engines, the third set of drivers being well under the fire-box; another reason for placing the rocker-shaft in the position shown, is to lengthen the valve-rod, which will allow the rod to adjust itself to the radius of rocker-pin as it swings back and forth. If the rocker-arms were placed in the usual position, directly alongside of the link, the rod would be so short that some device as a

yoke and sliding-block or link would have to be used to compensate for the radius. To drive the rocker-arms a connecting-rod or link extends from the lower rocker-arm to the supporting or swing-link attached to any convenient point ahead of the reversing or slotted link, which drives the valves; each end of this rod is attached by pins, making it free to swing. Opposite the reversing link a pin is connected to the rod; this pin passes into the link-block over which the link slides.

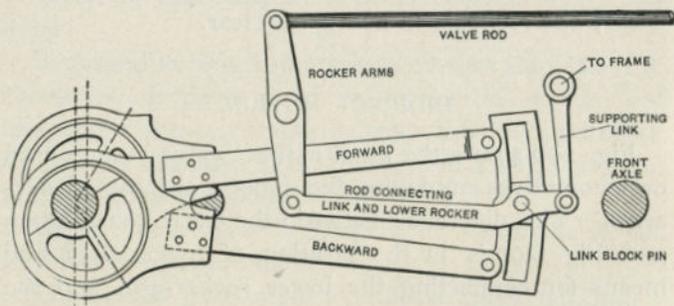


FIG. 290.—INDIRECT MOTION—ROCKER-ARMS BACK OF LINK.

It will be seen in the drawings that the centre of eccentrics are set ahead of the centre of axle, and the crank-pin is on forward centre; the eccentric-rods are open. The fact that the rocker-shaft is back of the reversing link does not alter the travel of valve, as in the position shown in Fig. 290 the valve would open the forward port. When in full gear, the opening would be equal to the lap and lead at which the valve was set. In mid-gear, as in the drawing, the opening would be greater, due to the fact that the link is controlled by both eccentrics and their centres are the same distance ahead

of the centre of axle when crank-pin is on true centre. The back port will be open to the same extent when on back centre from the same cause. In position shown in drawing, it is to be understood that the rod connecting the lower rocker-arm with the link-block does not raise or lower, only that due to the arc swung through by the rocker-pin and the supporting link, but the main link is raised and lowered by the usual means, sliding over the link-block. This motion is used with the piston-valve in four-cylinder compounds or with the plain slide-valve.

Fig. 291 shows another means for driving the valve from the link. In this case the motion is used on a compound engine, wherein the H.P. cylinder is above the L.P.; therefore the valve is placed sufficiently high to use a double rocker-arm, which is placed ahead of the reversing link. At any suitable point in this construction a connecting-link or rod is used between the link and lower rocker-arm; one end is attached to the link-block pin, while the other is attached to the rocker-pin. To support this rod there is provided a swinging or supporting link, placed ahead of the reversing or slotted link; one end is pivoted to any convenient point, in this case the girt or yoke across the frame. The lower end is attached to the rod. In order to avoid the forward driving-axle, the rod is bent so as to pass below the axle and then to the rocker-arm; when so desired, the rod is bent so as to pass above the axle, as dotted lines, due to the short distance between the top of upper rocker-arm and the stuffing-box on valve-chest; it requires a valve-stem, using a yoke in which slides a block; the upper rocker-pin passes through this

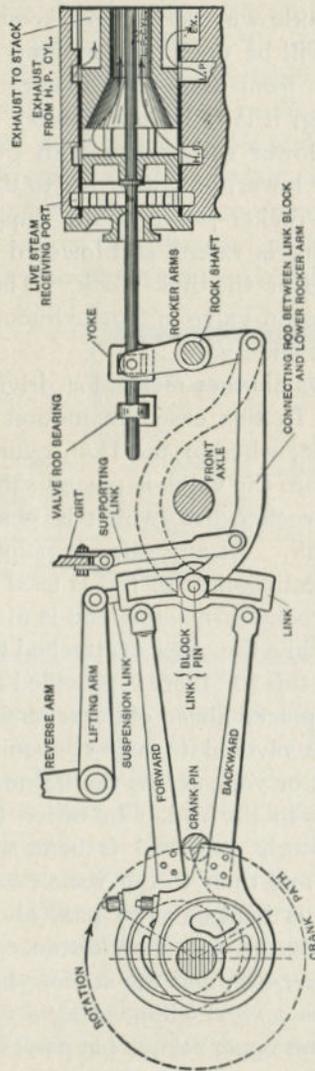


FIG. 291.—INDIRECT-MOTION PISTON-VALVE FOR FOUR-CYLINDER COMPOUND.

block, the back end of stem being carried in a bearing, the valve thus travelling in a straight line. The drawing shows a sectional view of half of a piston-valve used in four-cylinder compounds.

The valve-motion in Figs. 292 and 293* shows some modifications as used for freight engines using large fire-box. In this form the idea is to equalize the points of suspension and motion. In former motions shown, the rod connecting the link-block and lower rocker-arm was bent so as to pass above or below the driving-axle; also the connecting-rod was attached to link-block at one side. It will be seen in Figs. 292 and 293 that the link-saddle spans the link, being attached to the back and passing around each side with the saddle-pins each way; the saddle is made to clear the link-block and connecting-link or rod when the reversing link is raised or lowered to change the travel of valve. Fig. 293 shows a cross-section through link, link-pin, saddle, and rod. The dipping- or lifting-arm has a pin projecting each side and in line with the saddle-pins, the link-hangers or suspension-links are attached to these pins; by this means the weight and thrust on reversing link are carried on each side of the centre line of link, thus overcoming side thrust.

The connecting-rod between link-block and lower rocker-arm is made in three parts and enclosing the axle forming a yoke; the two portions back of the axle extend back to the link-block pin, spanning the link, the link-block pin passing through them and block; between link and axle are two pins, one on each sec-

* In use on Pennsylvania Railroad.

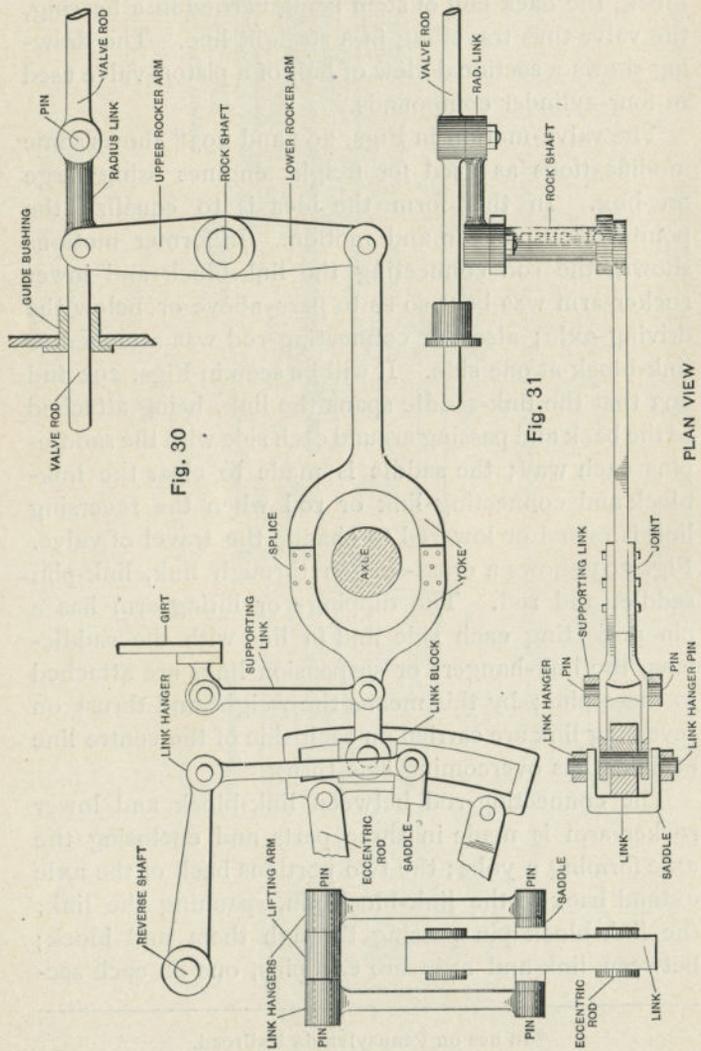


Fig. 30

Fig. 31

PLAN VIEW

FIGS. 29, 2 AND 3 — VALVE-MOTION FOR HEAVY FREIGHT SERVICE.

tion; the two rear sections are brought together and the forward section of rod is placed between, and the whole bolted together top and bottom.

Attached to the pins between link and axle are two supporting links which carry the back end of rod and allow it to travel back and forth. There are two links, one on each side. The suspension is perfectly balanced, without any tendency to twist; also the reversing link will drive the rod and block without side thrust or twist on account of the back end of rod spanning the link. By providing a yoked rod, the strain is evenly divided on each side of axle, thus preventing springing, as sometimes occurs with a single rod bent to clear axle. The rocker-arm in this case is close to the steam-chest and means are provided to allow a short valve-rod to be used, by having a short link attached to the upper rocker-arm and a pin in valve-rod. The back end of valve-rod is carried in a bushing attached to guide yoke.

TRACK-SANDING APPARATUS.

Various means for sanding the rails under a locomotive have been used. The great trouble has been the clogging up of the sand-pipes, due to moisture entering the lower end of sand-pipe. Sand being kiln-dried will absorb water rapidly. The usual means employed to sand the rails in the past has been the old sand-lever and valves over each sand-pipe opening in the sand-box, the sand being broken or loosened by pins on the valve-lever. The sanding apparatus has become an important feature on the present locomotive, and its principle and mechanism call for more study on the part of the men operating locomotives. In the apparatus to be described the sand is caused to flow by compressed air, and insures the sand to be delivered at the proper time, also a saving in sand. An excessive amount of sand is a cause of rapid tire wear. A very important feature is the automatic sanding of the rail without the special attention of the engineer. In the use of the old sand-lever the engineer had to act very quickly when in close quarters to pull open the lever and sand the track, and at times the sand would not run. By the present method the application of the brakes will sand the track if so desired, or only on emergency application. The various forms shown are for the purpose of covering the field as much as possible, as either form may be found on different railroads.

LEACH "D" SANDER.

Fig. 294 shows a Leach "D" sander. This sander has a single opening to the sand-box, with a double branch connected to the trap into which the sand runs from sand-box. Into one side of trap is attached sand-pipe to rail; opposite the sand-pipe opening is the adjustable air-nozzle *D*, which is threaded and screwed into the air-pipe. This nozzle can be screwed in or out, thus increasing the flow of sand, due to the amount of opening between the sand discharge-pipe and the nozzle *D*. This nozzle is held in position by jamb-nut *C*. A small check-valve *B* prevents the air-passage from becoming clogged with sand. To regulate the amount of air flowing to the nozzle, a port *G* is closed by the thumb-screw *F*. The air-pipe is connected to the main reservoir-pipe in cab by a small valve to control the air-flow. The discharge-pipes in this case are bent up 15 degrees to prevent sand from jarring out the trap. At the bottom of trap is an inch plug *E*, which can be removed to take out small stones and dirt that may accumulate in trap.

When desired to sand the track the valve in cab is opened and this causes air to issue from nozzle *D*. The trap being full of sand, the air issuing from nozzle *D* blows the sand out of the discharge-pipe to rail. With a double sander, sand can be applied to the rail running in either direction. In this style the trap contains two nozzles and two discharge-pipes, one in each direction, with two air-pipes and valves in cab. Either valve can be opened.

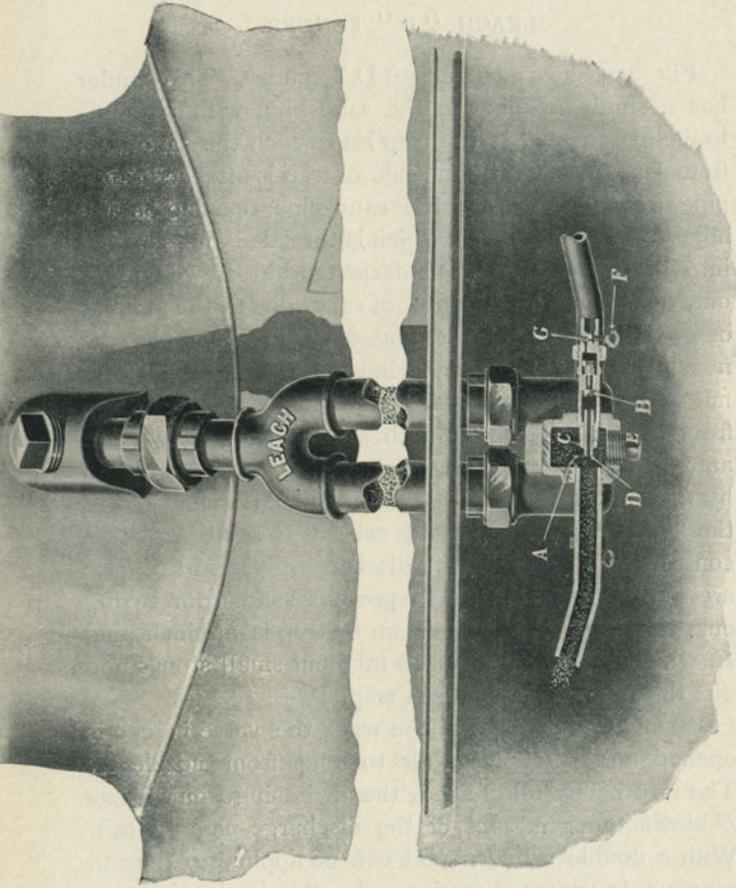


FIG. 294.—LEACH "D" SANDER.
Showing adjustable air-nozzle with check-valve.

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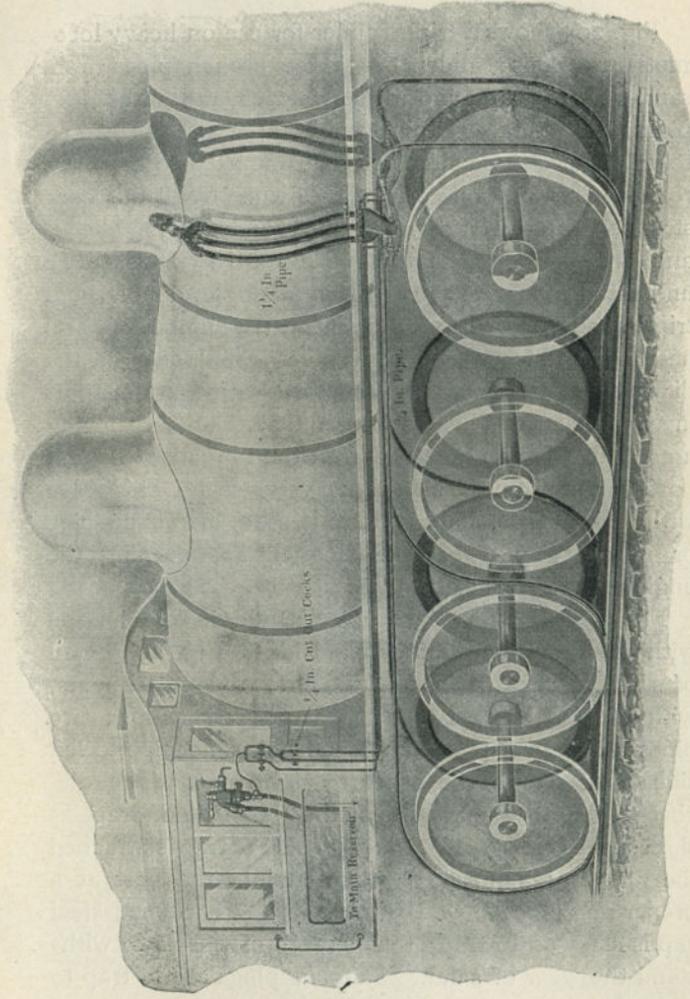


FIG. 295.—LEACH "D" TRIPLE SANDER.

For sanding under two pairs of drivers when going ahead, and also one pair of drivers when backing up. Especially adapted for heavy locomotives in extremely hard service.

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Fig. 295 shows a triple sander for use on heavy locomotives. This sander has three branch pipes from sand-box to trap, and three nozzles and discharge-pipes, with three air-pipes with three valves leading to cab; these three air-pipes are connected to the main reservoir by only one pipe, as shown. With this construction two pair of drivers can be sanded going ahead, and one pair when running backwards. It is to be understood that the construction of single, double, and triple sander is the same, except in the number of parts and form of trap. Fig. 296 gives detail cuts of the different parts, also the cab-valve with warning-port in valve-stem. This valve-stem is bored out, having a conical valve-spring loaded in the top; also a small port leading from the side above valve-seat. This valve will open if too much pressure is used, also if air-pipe or nozzle should become clogged up, warning the engineer to that effect.

Fig. 297 shows a Leach "A" sander in combination with the gravity system or hand-lever, Fig. 298 detail of same. The trap is divided in two compartments, with an opening between the two over partition; two pipes are between trap and sand-box, one pipe to left side of trap and the other to right side. The discharge-pipe to track is attached to left side of trap, as shown in Fig. 297. To the right side of trap is attached the air-pipe; a nozzle is screwed into the port at a proper angle. Above this air-nozzle a hardened-steel cap is screwed to trap; the purpose of this is to withstand the wear of sand. Suitable plugs are in trap to allow for cleaning out trap. When desired to use sand without using the pneumatic sander, the hand-lever

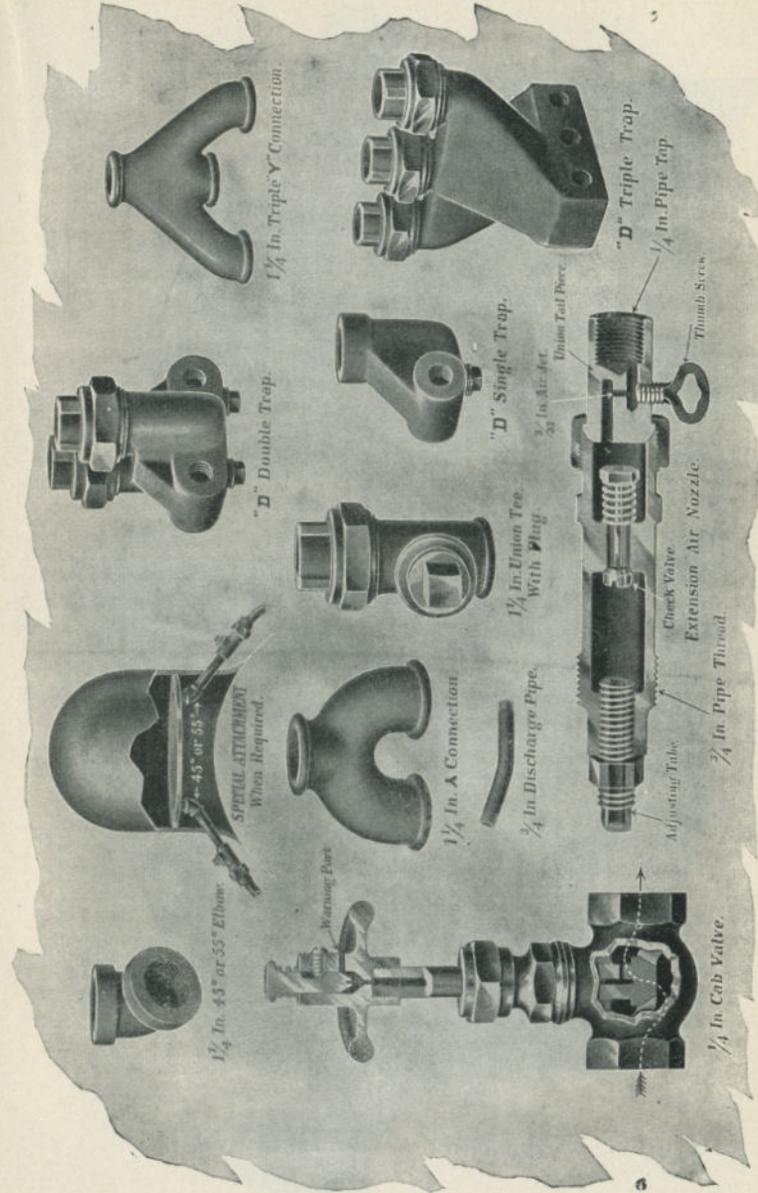


FIG. 296.—DETAIL PARTS LEACH "D" SANDERS.

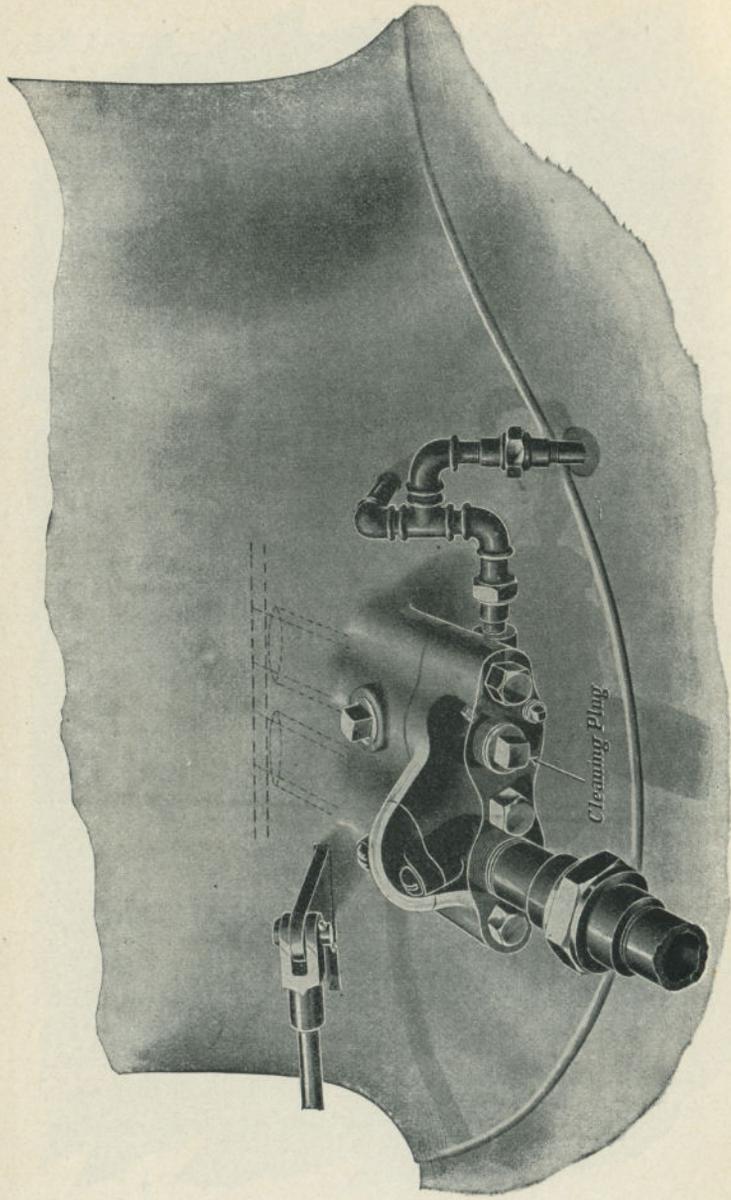


FIG. 297. — LEACH "A" SANDER

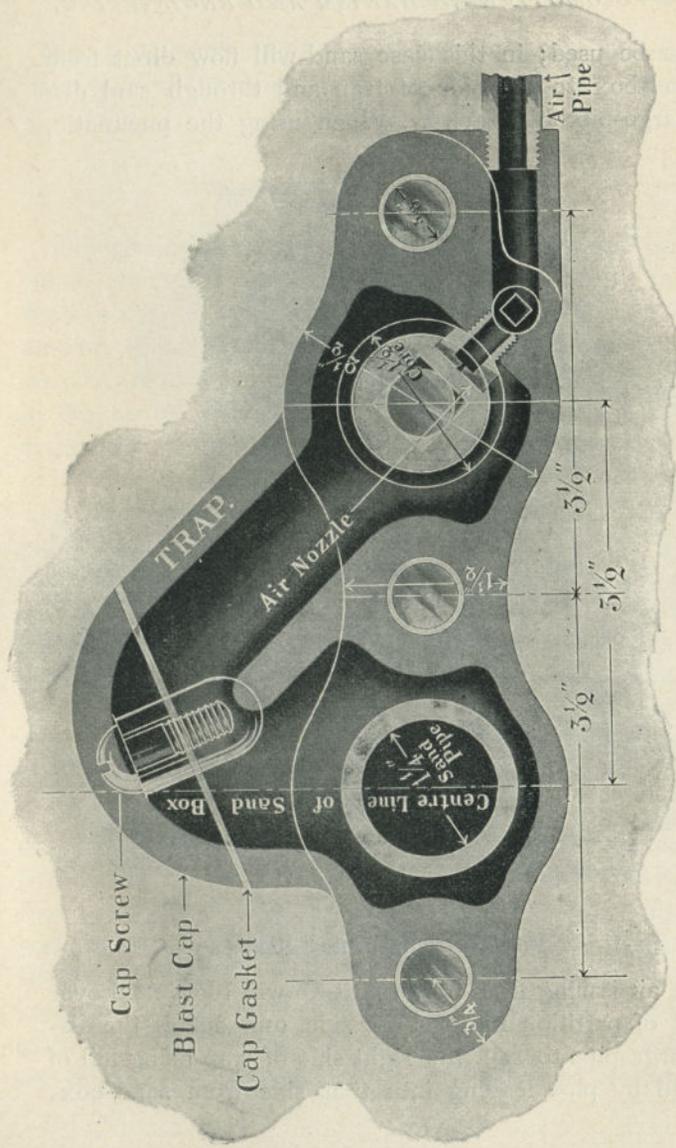


FIG. 298. — DETAIL OF LEACH "A" SANDER.

can be used; in this case sand will flow direct from sand-box to left side of trap and through sand discharge-pipe by gravity. When using the pneumatic,

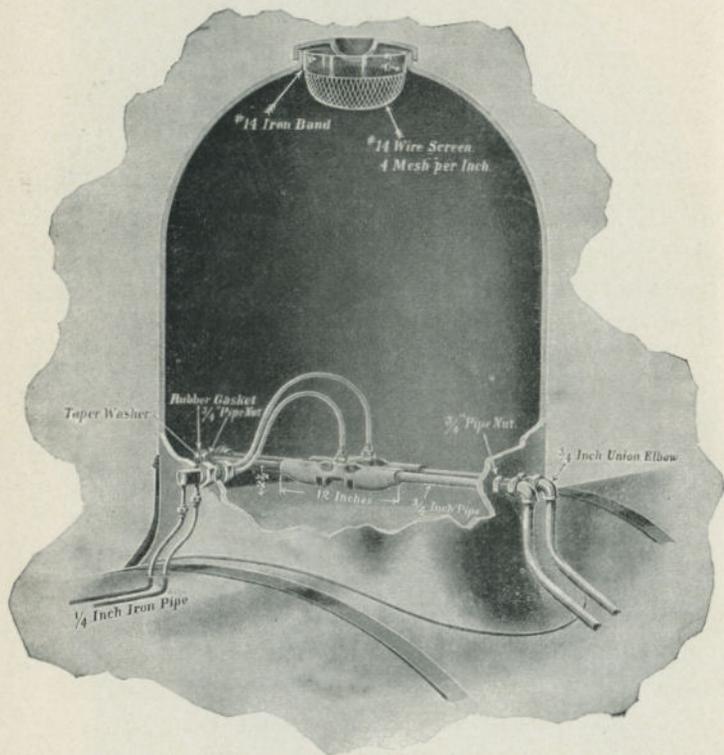


FIG. 299.—THE "SHE" SANDER.

the air issuing from nozzle in trap will blow sand over top of partition into the left side, and out of the discharge-pipe to rail, the right side of trap being full of sand by pipe leading into that side from sand-box.

This is called the auxiliary passage when this sander is applied to old sand-boxes.

SHE SANDER (FIG. 299).

This device is entirely within the sand-box and is a siphon ejector. This form is designed to carry the sand to the rail with great velocity and to use a small amount of air to operate it, so arranged that the air-nozzles are always out of the sand; the siphon being in the centre of the sand-box, where the sand is the driest. It is adapted to be used where sand is baked or becomes damp. Fig. 300 shows the parts in detail. The siphon is formed of a single casting having a pipe connection at each end, bell-mouthed openings each side of centre line, with deflecting wings in front of openings. Above the centre line of openings are ports with a pipe connection to these ports from air-pipes; these ports form the air-nozzles, one each way. The discharge-pipes at each end of siphon lead down to track. The air-pipes are connected, as in the other form of sanders, in cab.

The action is as follows: When air-valve in cab is opened the air issues from nozzles in siphon into the bell-mouth openings, drawing the sand along with it, then forcing it out the discharge-pipe onto rail. Fig. 300 shows the various parts in detail, while Fig. 301 shows the piping. Fig. 302 is the arrangement of valves and piping for the automatic sanding of the track in connection with the engineer's brake-valve. When set to operate with emergency application of brakes,

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