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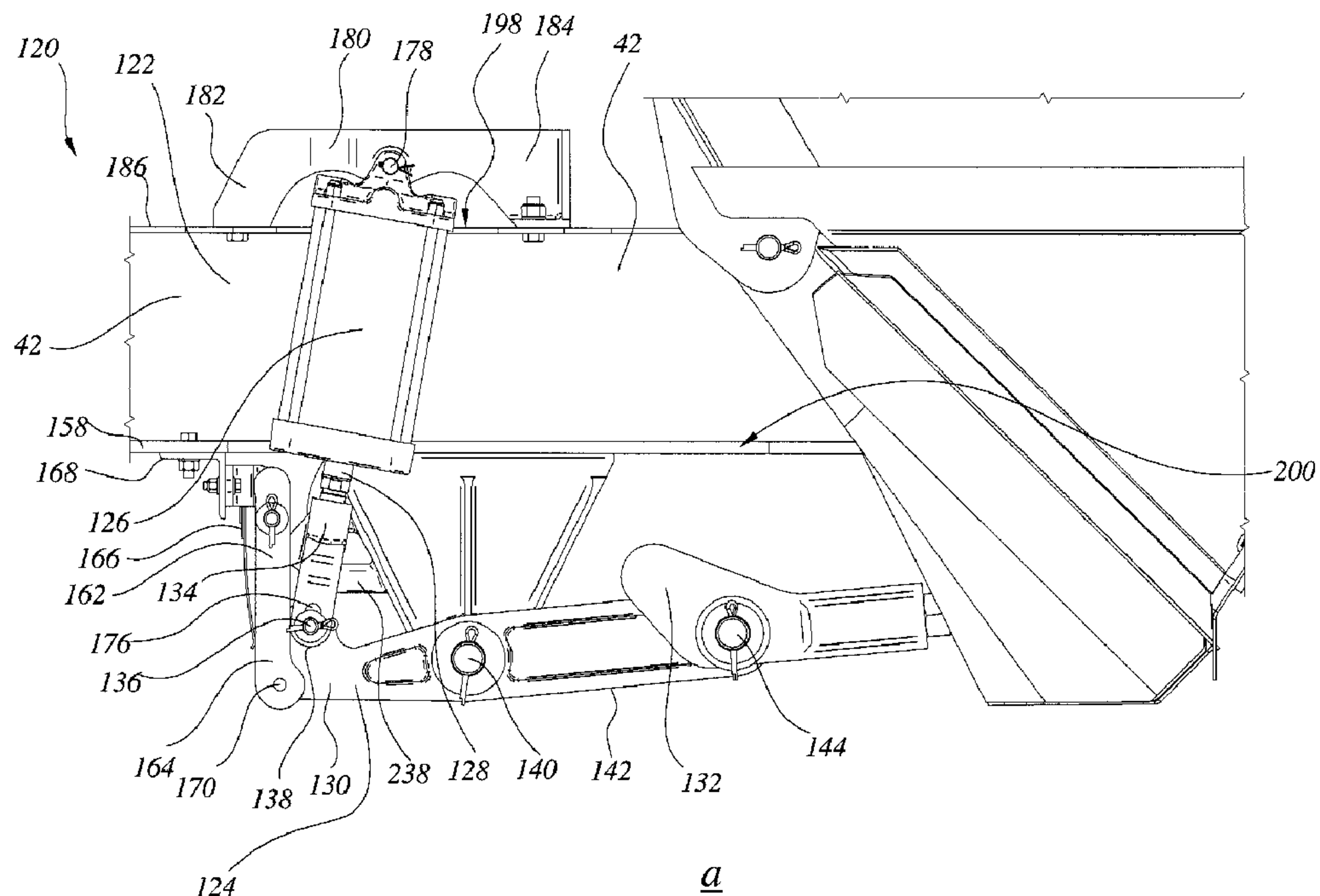
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(54) Title: RAILROAD HOPPER CAR BODY FITTINGS



(57) Abrégé/Abstract:

A railroad hopper car body includes a set of hopper and hopper discharges. Egress of lading from the discharges is governed by movable doors that swing between a closed position and an open position. The motion is driven by a mechanical transmission that

(57) **Abrégé(suite)/Abstract(continued):**

is itself driven by an actuator. Each pair of doors is driven by a single actuator. The actuator is mounted to act through the center sill. A portion, or substantially all, of the actuator may be mounted in a predominantly squat, vertical orientation within the center sill. In alternate embodiments, the transmission output may be bifurcated. The center sill bottom flange may be narrower adjacent to the doors. The mechanism may have a secondary lock. The mechanism may have an auxiliary manual release.

RAILROAD HOPPER CAR BODY FITTINGS**Abstract**

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A railroad hopper car body includes a set of hopper and hopper discharges. Egress of lading from the discharges is governed by movable doors that swing between a closed position and an open position. The motion is driven by a mechanical transmission that is itself driven by an actuator. Each pair of doors is driven by a single actuator. The actuator is mounted to act through the center sill. A portion, or substantially all, of the actuator may be mounted in a predominantly squat, vertical orientation within the center sill. In alternate embodiments, the transmission output may be bifurcated. The center sill bottom flange may be narrower adjacent to the doors. The mechanism may have a secondary lock. The mechanism may have an auxiliary manual release.

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RAILROAD HOPPER CAR BODY FITTINGS

Field of the Invention

5 This invention relates to the field of railroad freight cars, and, in particular to railroad freight cars such as may employ bottom unloading doors.

Background

10 There are many kinds of railroad cars for carrying particulate material, be it sand or gravel aggregate, plastic pellets, grains, ores, potash, coal or other granular materials. These materials are not liquid, yet may in some ways tend to flow in a somewhat liquid-like manner. Many of those cars have an upper opening, or accessway of some kind, by which the particulate is loaded, and a lower opening, accessway, or door, by which the particulate material exits the
15 car under the influence of gravity. Clearly, while the inlet opening need not necessarily have a movable door (but may include a cover to discourage contamination of the lading or exposure of the lading to the wind, rain or snow), the outlet opening requires a governor of some kind that is movable between a closed position for retaining the lading while the lading is being transported, and an open position for releasing the lading at the destination. The terminology “flow through”
20 or “flow through railroad car” or “center flow” car, or the like, may sometimes be used for cars of this nature where lading is introduced at the top, and flows out at the bottom.

 Consider, for example, a hopper car for transporting sand or gravel aggregate. It may have a converging hopper discharge section that has the shape, generally speaking, of an inverted
25 four sided, truncated pyramid. At the truncated bottom end, there may be a stationary plate and a moving plate, or door. When the moving plate and the stationary plate are brought together, the door is closed. The car is filled with lading, and is hauled to its destination. At the destination, the door or gate is opened, and the lading is allowed to escape from the hopper. The doors are driven by actuators connected to the doors by mechanical transmission elements.

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Summary of the Invention

 In an aspect of the invention, there is a railroad hopper car having a hopper car body carried on railroad car trucks for rolling motion in a longitudinal direction. The railroad hopper
35 car has a center sill. It also has a first hopper. The first hopper has a bottom discharge. The bottom discharge has a movable door mounted to govern egress of lading from the first hopper.

The movable door being driven by a door actuator. The door actuator being located at the center sill. The door actuator is predominantly upstandingly oriented.

5 In a feature of that aspect of the invention, the door is a transverse door. In another feature, the railroad hopper car has first and second spaced apart sidewalls extending therealong. The first hopper has a first slope sheet extending obliquely upwardly away from the bottom discharge. The actuator is mounted in the lee of the first slope sheet. In another feature at least a portion of the actuator is mounted within the center sill. In another feature the actuator acts amidst the center sill. In still another feature, the actuator has a line of action that acts through
10 the center sill. In a further feature, the center sill extends through the first hopper. In a still further feature, the door of the first hopper is split into first and second portions lying laterally to either side of the center sill. In another feature, the actuator is connected to the door by a mechanical transmission, and the mechanical transmission is bifurcated to drive the first and second portions. In another feature, the first and second portions are yoked to sweep through a
15 common arc together.

In another aspect of the invention there is a railroad hopper car having a hopper car body supported by railroad car trucks for rolling motion in a longitudinal direction. The railroad hopper car has a center sill. It includes a first hopper, the first hopper having a bottom discharge.
20 The bottom discharge has a movable door mounted to govern egress of lading from the first hopper. An actuator is connected to drive the movable door. The door actuator is predominantly upstandingly oriented. At least part of the door actuator being mounted within the center sill.

In a feature of that aspect of the invention, the center sill has a pair of spaced apart webs
25 and a bottom flange. The bottom flange has a first portion having a first width adjacent the door, and a second portion having a second width adjacent the actuator. The first width is narrower than the second width. The door is mounted to swing beside the center sill alongside the first portion. The second portion has an aperture formed therein to permit the actuator to work therethrough. The actuator is connected to the door by a linkage that folds at least partially into
30 the center sill. In another feature the actuator is connected to the door by mechanical linkages, and one of the linkages has a fulcrum mounted under the center sill. In a further feature, the actuator has a reaction mounted on top of the center sill. In another feature, the door is a transverse hopper door having first and second portions to either side of the center sill. In a further feature, the actuator is connected by a bifurcated linkage to drive the first and second
35 portions of the door. In a still further feature, the first and second portions of the door are yoked to sweep together. In another feature, in a closed position of the door, the door has a free edge

most distant from the actuator. The free edge has a backing beam extending thereacross. The backing beam yokes the first and second portions of the door together. The actuator is connected to the door by a mechanical transmission that includes a linkage mounted to the backing beam.

5 In another feature, the door is movable between an open position and a closed position. The actuator is connected to the door by linkages. The linkages are movable to an over center condition when the door is in the closed position. The linkages have a secondary lock operable to discourage movement out of the over-center condition when the actuator is passive.

10 In another aspect of the invention there is a secondary lock for a railroad hopper car door transmission, the secondary lock being mounted to body structure of the hopper car.

15 In a feature of that aspect of the invention, the secondary lock includes a base mounted to the body structure of the hopper car and a movable member that is biased toward engagement with the door transmission. The movable member has a first position in which it intercepts the door transmission, and a second position in which it is disengaged from the door transmission. In another feature, the movable member has a pawl operable to interact with a catch of the door transmission. In a further feature, the secondary lock includes a follower engagable with the door transmission, the follower being operable to release the secondary lock from the door
20 transmission.

25 In still another feature there is a combination of the secondary lock and the door transmission more generally. The door transmission includes a catch, and the secondary lock includes a pawl. The pawl and the catch are mutually engaged when the door transmission is in a primary lock configuration. In another feature the secondary lock includes a follower and the door transmission includes a moving member. The moving member is operable in motion to engage the follower and thereby to release the secondary lock. In yet another feature the door transmission includes a sequencing member, and, when the sequencing member is moved, the secondary lock is released during a first portion of motion of the sequencing member. The
30 transmission is released from a primary lock configuration during a second portion of motion of the sequencing member.

35 In another feature there is a linkage mounted to drive a door of a hopper, and an actuator mounted to drive the linkage. The linkage is drivable by the actuator to a primary lock configuration in which the linkage is in an over-center condition. There is a sequencing member, a catch, and a release member. The secondary lock is biased to engage the linkage. The

secondary lock includes a pawl. The pawl is biased to engage the catch when the linkage is driven to the over-center condition. When so engaged, engagement of the pawl with the catch prevents the linkage from moving out of the over-center condition. The secondary lock includes a follower for engagement with the release member. The sequencing member is a lost motion fitting driven by the actuator. The actuator is operable to drive the lost motion fitting through a first portion of motion. During the first portion of motion the actuator also drives the release member in engagement with the follower to release the secondary lock. The actuator is operable to drive the lost motion fitting through a second portion of motion after the first portion of motion; and, during the second portion of motion the actuator also drives the linkage out of the over-center condition. In another feature, the sequencing member is mounted between the actuator and the linkages, whereby the actuator is operable to drive the linkage through the sequencing member. In still another feature, the lost motion fitting is an elongate slot in the sequencing member, and the release member is a cam that co-operates with the follower.

In another aspect of the invention there is a railroad hopper car door operating mechanism. It has an actuator, a primary lock, a secondary lock, a sequencing member, and a manual release operable when the actuator is inactive to release the secondary lock and the primary lock.

In a feature of that aspect, the manual release is operable to disengage the secondary lock prior to disengagement of the primary lock. In another feature, the manual release is mounted to the sequencing member. In another feature, the manual release member is movable. A first stationary member is mounted to the hopper car. The first stationary member functions as a fulcrum to permit a person standing at trackside to engage the release member with a lever, using the first stationary member as a fulcrum. In another feature, a second stationary member is mounted to the railcar. The second stationary member defines a lever guide by which a person standing at trackside may feed a first end of a lever to engage the manual release. In another feature the door operating mechanism includes a linkage mounted to drive a hopper door. The linkage is drivable to an over-center condition when the door is closed. The over-center condition defines the primary lock. The sequencing member is a lost motion member mounted between the actuator and the linkage. The linkage has a catch that is engaged by a pawl when the linkage is in the over-center condition, thereby preventing the linkage from moving out of the over-center condition, the catch and pawl defining the secondary lock. The lost motion member is movable when the manual release is driven first to release the secondary lock while taking up lost motion therein, and then to release the primary lock after lost motion therein is exhausted.

These and other aspects and features of the invention may be understood with reference to the description which follows, and with the aid of the illustrations of a number of examples.

Brief Description of the Figures

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The description is accompanied by a set of illustrative Figures in which:

Figure **1a** is a general arrangement, isometric view of a railroad freight car;

Figure **1b** is a top view of the railroad freight car of Figure **1a**;

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Figure **1c** is a bottom view of the railroad freight car of Figure **1a**;

Figure **1d** is side view of the railroad freight car of Figure **1a**;

Figure **1e** is an enlarged view of a detail of Figure **1d**, showing the door and door actuator layout of the freight car of Figure **1a**;

Figure **1f** is an enlarged detail of Figure **1c**;

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Figure **2a** is an isometric general arrangement view of a discharge door and actuator assembly of the freight car of Figure **1a**;

Figure **2b** is a projected bottom view of the door of Figure **2a**;

Figure **2c** shows a transverse cross-section of the freight car of Figure **1c** showing installation of an actuator within the center sill;

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Figure **3a** is an enlarged side view of a door assembly and actuator of the railroad freight car of Figure **1e** with the near-side web of the center sill removed to reveal internal details of the actuator installation;

Figure **3b** shows the same view as Figure **3a**, with the door linkage partially open;

Figure **3c** shows the view of Figure **3a** with the door linkage fully open;

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Figure **4** is a perspective view of the actuator assembly of Figure **3a**;

Figure **5a** shows an enlarged side view of detail of a secondary lock mechanism of the door linkage of Figures **3a** to **3c** in a disengaged position or condition;

Figure **5b** shows the secondary lock of Figure **5a** in an engaged position or condition;

Figure **6a** shows a general arrangement perspective view of an alternate layout of actuator assembly to that of Figure **3a**;

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Figure **6b** shows a detail of the assembly of Figure **6a** from the opposite side and below;

Figure **7** shows an isometric view of an alternate door installation having a bifurcated transmission; and

Figure **8** shows an isometric view of a manual release for the assembly of Figure **6a**.

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Detailed Description

The description that follows, and the embodiments described therein, are provided by way of illustration of an example, or examples, of particular embodiments of the principles, aspects or features of the present invention. These examples are provided for the purposes of explanation, and not of limitation, of those principles and of the invention. In the description, like parts are marked throughout the specification and the drawings with the same respective reference numerals. The drawings are not necessarily to scale and in some instances proportions may have been exaggerated in order more clearly to depict certain features of the invention.

The terminology used herein is thought to be consistent with the customary and ordinary meanings of those terms as they would be understood by a person of ordinary skill in the railroad industry in North America. Following from *Phillips v. AWH Corp.*, the Applicant expressly excludes all interpretations that are inconsistent with this specification, and, in particular, expressly excludes any interpretation of the claims or the language used in this specification such as may be made in the USPTO, or in any other Patent Office, other than those interpretations for which express support can be demonstrated in this specification or in objective evidence of record in accordance with *In re Lee*, (for example, earlier publications by persons not employed by the USPTO or any other Patent Office), demonstrating how the terms are used and understood by persons of ordinary skill in the art, or by way of expert evidence of a person or persons of at least 10 years experience in the railroad industry in North America or in other former territories of the British Empire and Commonwealth.

In terms of general orientation and directional nomenclature, for railroad cars described herein the longitudinal direction is defined as being coincident with the rolling direction of the railroad car, or railroad car unit, when located on tangent (that is, straight) track. In the case of a railroad car having a center sill, the longitudinal direction is parallel to the center sill, and parallel to the top chords. Unless otherwise noted, vertical, or upward and downward, are terms that use top of rail, **TOR**, as a datum. In the context of the car as a whole, the term lateral, or laterally outboard, or transverse, or transversely outboard refer to a distance or orientation relative to the longitudinal centerline of the railroad car, or car unit, or of the centerline of a centerplate at a truck center. The term “longitudinally inboard”, or “longitudinally outboard” is a distance taken relative to a mid-span lateral section of the car, or car unit. Pitching motion is angular motion of a railcar unit about a horizontal axis perpendicular to the longitudinal direction. Yawing is angular motion about a vertical axis. Roll is angular motion about the longitudinal axis. Given that the railroad car described herein may tend to have both

longitudinal and transverse axes of symmetry, a description of one half of the car may generally also be intended to describe the other half as well, allowing for differences between right hand and left hand parts. To the extent that this specification or the illustrations may refer to standards of the Association of American Railroads (AAR), such as to AAR plate sizes, those references are to be understood as at the earliest priority date to which this application is entitled.

Figure 1a shows an isometric view of an example of a railroad freight car 20 that is intended to be representative of a wide range of railroad cars in which the present invention may be incorporated. While car 20 may be suitable for a variety of general purpose uses, it may be taken as being symbolic of, and in some ways a generic example of, a flow through car, in which lading is introduced by gravity flow from above, and removed by gravity discharge through gated or valved outlets below. Flow through, or center flow cars may include open topped hopper cars, grain cars, plastic pellet cars, potash cars, ore cars, and so on. In one embodiment car 20 may be a hopper car such as may be used for the carriage of bulk commodities in the form of a granular particulate, be it in the nature of relatively coarse gravel or fine aggregate in the nature of fine gravel or sand or various ores or concentrate or coal. Car 20 may be symmetrical about both its longitudinal and transverse, or lateral, centreline axes. Consequently, it will be understood that the car has first and second, left and right hand side beams, bolsters and so on.

By way of a general overview, car 20 may have a car body 22 that is carried on trucks 24 for rolling operation along railroad tracks. Car 20 may be a single unit car, or it may be a multi-unit car having two or more car body units, where the multiple car body units may be connected at an articulated connector, or by draw bars. Car body 22 may have a lading containment vessel or shell 26 such as may include an upstanding wall structure 28 which may have a pair of opposed first and second end walls 30, 32, that extend cross-wise, and a pair of first and second side walls 34, 36 that extend lengthwise. The end walls 30, 32 and side walls 34, 36 co-operate to define a generally rectangular form of peripheral wall structure 28. Wall structure 28 may include top chords 38 running along the top of the walls, and side sills 40 running fore-and-aft along lower portions the side sheets of side walls 34, 36. In some instances car 20 may have stub center sills at either end, in which case side walls 34, 36 may act as deep beams, and may carry vertical loads to main bolsters that extend laterally from the centerplates. Alternatively, or in addition to deep side beams, car 20 may include a center sill 42, which may be a straight-through center sill, running from one end of the car body to the other. In the case of a single, stand alone car unit, draft gear and releaseable couplers may be mounted at either end of the center sill. In a center flow, or flow through car, the upper portion of the car may typically include means by which to admit lading under a gravity drop system. Such an intake, or

entryway, may be a large rectangular opening such as bounded by top chords **38**, or the car may have one or more hatches, whether covered or uncovered.

The interior of car body **22** may include end slope sheets **44** and lateral partitions such as may be identified as intermediate slope sheets **46** that may extend between the sidewalls of the car, in a manner such as may tend to divide the internal space **48** of car body **22** into two or more sub-compartments, sub-volumes or subspaces indicated generally as **50**, **52** and **54** in this example, and which may be referred to as first, second, and third hoppers. Clearly, in some embodiments there may be one single hopper, in others two hoppers and in others three, four, or more hoppers. The hoppers are bounded on their sides by side sheets **56** of side walls **34** and **36** that run between side sills **40** and top chords **38**.

Car **20** may have relatively large slope sheets, be they **44** or **46**, that extend cross-wise between sidewalls **34**, **36**, and which may tend to extend to a height relatively close to top chords **38**. As may be noted, end sheets **44** may be slope sheets, and internal partition sheets **46** may also be slope sheets. Not atypically, each pair of fore-and aft opposed slope sheets, be they end sheets or internal partitions, may be inclined at equal and opposite angles, and the angles of those sheets may be selected to be somewhat steeper than the free slope angle, or natural talus slope angle, or angle of repose, of the lading for which the car is designed, such that, when the gates are opened, the lading may tend to flow out, rather than sit at rest. That is, taking either the coupler centerline height or the center sill cover plate upper surface as a datum, slope sheets **46** may terminate at a height that is at least half way to top chord **38**, and which may, in some embodiments, extend more than $\frac{2}{3}$, $\frac{3}{4}$ or $\frac{4}{5}$ of that distance, as may be.

Car **20** may include a fitting mounted at the apex where two adjacent slope sheets **46** meet. It be termed a partition, or a divider, or reinforcement, and may be referred to as a ridge plate **58**. Ridge plate **58** may include a central portion, and end portions mated to the side walls.

The lower regions of car body **22** may include gate or discharge assemblies **60**, for the various hoppers, however many there may be, by which one or more members that are movable between closed and open positions may be used as a flow control to govern the egress of lading from that hopper. Discharge assemblies **60** may include the lower portion of, or a continuation of, one or both of the fore-and-aft slope sheets defining the fore and aft walls of that hopper. For example, hopper **50** (it being chosen arbitrarily, and generically) may include a first fore-and-aft hopper slope sheet extension **62**, mounted to one slope sheet, e.g., item **44**, and a second fore-and-aft slope sheet extension **64** mounted to an opposed slope sheet, e.g., be it item **46**.

Discharge assemblies **60** may also include a pair of opposed inboard and outboard side sheet members, **66**, **68**. Side sheet members **66**, **68** may be steel plates, and may be positioned to co-operate with slope sheet extension **62** to define a converging, or funnel-like passageway, or conduit, leading to a throat, or opening, indicated generally as **80**, at which an exit, or port, or gate, however it may be termed, is defined. Each of hoppers **50**, **52**, **54** has a respective door or door assembly **70**, **72**, **74**, each mounted at a respective pivot or hinge fitting **78**. In the embodiment shown, all of these door assemblies are the same. Consequently only one such door will be described. It may also be noted that the presence of center sill **42** divides the opening into two portions, a first, or left-hand portion **102** lying to one side of center sill **42**, and a second, or right-hand portion **104** lying to the other side of center sill **42**. From one point of view, each corresponding door may therefore be considered as being a pair of two doors **112**, **114**; from another point of view each door may be considered to be a single door having two portions or halves, *i.e.*, **112**, **114**. In a stub sill car, the opening could be uninterrupted, and could form a single continuous gate across the width of the car. Given that it is customary to discharge lading on both sides of the center sill at the same time to avoid asymmetric load distribution (as might tend to encourage the car to lean to one side, or tip), the right and left hand door portions are driven together. In the embodiments shown and described herein, the doors are yoked together by physical structure to compel them to sweep through the same arc at the same time. Accordingly, the choice of terminology of items **102**, **104**, **112** and **114** is somewhat arbitrary.

Looking at a single door portion, the sides of the periphery of any one left-hand or right-hand discharge opening **80** may be defined by the margins **82** of side sheet members **66** and **68** that angle upwardly and away from slope sheet extension **62**. The bottom edge, or sill, of the discharge opening may be defined by the lowest margin or extremity of slope sheet extension **62**, or such fittings or assemblies as may be mounted thereto. First slope sheet extension **62** may be a panel that is rigidly fixed relative to the first slope sheet, and may be made from a metal, such as a steel, that may serve as a wear plate, and which may be hardened or alloyed for such a purpose. Slope sheet extension **62** may be reinforced along its lower lateral margin by a lip stiffening member **86**, which may be a U-pressing, or channel, mounted to the outside face of extension **62** and forming a hollow section therewith, capped by the wings, or tabs **76** of side sheet members **66**, **68**.

Slope sheet extension **64** may be a movable slope sheet extension, and may be, or may be part of, a moveable closure member or closure assembly **84** that is mounted to move between a closed position (Figure **1e**) obstructing flow through throat **80**, and an open position (Figure **3d**) in which flow through throat **80** is less obstructed, such that lading may be discharged. In Figure

3d, the open position corresponds, roughly to a vertical orientation of the lading-facing surface of the door. To that end, slope sheet extension 64 may be connected to the rest of body 22 at a hinged or pivoted member, such as a pivot pin or hinge 78, such as may tend to constrain slope sheet extension 64 to a single degree of motion relative to opening 80, which, in one embodiment, may be angular displacement (i.e., rocking or pivoting motion, about an axis, such as the axis of hinge 78). By virtue of its motion, slope sheet extension 64 may be considered to be, or to be part of, the door or door assembly, or closure, or closure assembly or sub-assembly, such as may be referred to generally as 90.

Where car 20 includes a straight through center sill, such as item 42, rather than having a single full width hopper discharge door assembly 90, such as might tend to be centered on the longitudinal centerline of the car, there may be two such discharge assemblies 90, one mounted to either side of center sill 42, in car 20. In this latter case, the center sill may tend to be protected from abrasion or other damage by one or more shrouds 88. Shroud 88 may, in cross-section, have the form of an inverted V, whose arms may extend on an incline upwardly from the upper, laterally inboard margin of inboard side sheet members 96, to meet at an apex above center sill 42 along the centerline of the car. In the illustrated embodiments, the closure assemblies include transverse doors. As suggested by the name, a transverse door extends cross-wise relative to the car body underframe, and the door motion is in a fore-and-aft swinging direction parallel to the center sill.

Door assembly 90 may include motion accommodating, or motion permitting, fittings, such as hinge 78. Hinge 78 may be received in a pivoting arm member, 94. Arm member 94 as may run along the back of the door pan sheet, or wing, defined by extension 64. Arm member 94 may extend generally radially away from hinge 78 toward the distal margin of extension 64, and may be a substantially planar member lying in a plane perpendicular to the axis of hinge 78. Given that hopper doors seem to be prone to abuse in service, extension sheet 64 may have a laterally extending reinforcement 96 that may run across the back of extension 64. Reinforcement 96 may have the general form of a flange or lateral reinforcement 98 running across the front lip of door assembly 90, bent to lie across the back of the webs defined by arm members 94, and inside edge reinforcement webs 92, thus forming an open box section, which, in effect, is a cross-wise extending beam. Once again, member 98 may provide a certain robustness of structure, such as may tend to discourage distortion of the distal margin of sheet 64 when the car moves with the door acting as something of a plow while the discharge section is still obstructed by the lading being discharged. Reinforcement member 98 may extend not only across the back of door assembly 90, but also across the back of the adjacent opposite handed

door assembly **90** mounted on the opposite side of the car such that the two door assemblies may be yoked together, as shown in Figure **2b**. Door assembly **90** may also include end webs or end gussets, namely stiffeners **96**, such as may tend to run predominantly radially along the back of extension **64**, and being angled axially to match the profile of outside edge of opening **80** when in the closed position.

The front or forward facing surface **108**, or face of the panel, or pan defined by extension **64**, may, in one context, be defined in terms of facing toward the interior of the hopper, or in a direction facing toward the lading, or toward the opposed members of the hopper discharge assembly in either the closed or the open position. The front, or upward, or inward facing surface **108**, however, will tend, in general, to face inwardly toward the lading. Door assembly **90** may include upstanding lips, or cheeks, or legs, such as side wall members that stand proud of the inwardly facing surface of the door. The roots may lie directly over the mating webs of the gussets. When the mating moving and stationary portions of the discharge assembly come together, the edge members may tend to seat against the opposed lateral cheek, rim or lip, such as may be defined by a backing plate, or bar welded to one or the other of items **66**, **68**. The door assembly **90** is driveable between open and closed positions or conditions by an operating mechanism, indicated generally as **120**. Operating mechanism **120** may include an actuator **122** and a mechanical transmission **124** linking the output of actuator **122** to door assembly **90**. In one context, the actuator is a drive that operates the mechanical transmission. In another context the actuator can be considered part of the mechanical transmission as being an element of operating mechanism **120**, more generally.

Considering Figures **2a – 2c** and **3a – 3c**, in the embodiment shown, actuator **122** is a pneumatic actuator having a generally cylindrical body **126** and an axially reciprocating output shaft **128**. Actuator **122** is mounted in the lee of either an end slope sheet **44** or an internal slope sheet, or sheets **46**, and so may tend to be somewhat protected from precipitation and damage. As discussed below, actuator **122** may also be mounted to pass at least partially within center sill **42**, and may have fitting accessibly from above or below center sill **42**, or both. Mechanical transmission **124** includes a first member in the nature of a driven crank, or arm, or lever **130**, and a second member in the nature of a slave, or connecting link, or drag link, or follower, **132**. The output of actuator **122** can have an end, or tip, or indexing member or extension **134**. In terms of general operation, in one context indexing member **134** and output shaft **128** combine to function as a piston rod or pushrod. The output of that pushrod is connected at a pivotal connection **136** that is the input interface of lever **130**. Lever **130** is effectively a bell crank, having an input arm **138**; a central axis or pivot point or fulcrum **140**; and an output arm **142**, the

output interface of lever **130** in this embodiment being another pivot, or pin joint **144**. Pin joint **144** is likewise the input interface of drag link **132**. Link **132** is a strut having a first pivot at its input interface, and a second pivot at its output interface, namely a second pin connection **146**, at which it is pivotally connected to door panel assembly **90** at a radial distance from hinge fitting **78**. Drag link **132** can have a pair of parallel, spaced apart webs, as seen in Figure **2a**, such that the connection with output arm **142** at pin connection **144** is effectively a clevis in double shear. As can be seen, output lever arm **142**, drag link **132**, door panel assembly **90**, and the stationary structure of the car body form a four bar linkage. The input of force and displacement to this four bar linkage is delivered through the media of output shaft **128**, extension **134** and input arm **138**. This transmission carries force; displacement; and information, i.e., it is a mechanical door-opening signal device as well as being the means by which force and displacement are imparted to the door to implement that signal.

When the transmission is fully extended, the pivot points or pin connections **140**, **144** and **146** are positioned in an over-center condition. That is to say, the force of gravity against door panel assembly **90**, and particularly so if augmented by the weight of lading bearing on door panel assembly **90**, may tend to want to drive lever **130** in the clockwise direction – i.e., the direction of closing, not of opening. It is prevented from further angular displacement in the clockwise direction by the over-travel range of motion limiting obstruction presented by the stop, or abutment, or dog, or catch, or pawl, or over-travel prevention pin or lug **150** that projects laterally from horn **148** of drag link **132**. While the weight is on the door, pin **150** will bind against the upper margin of output arm **142**. Drag link **132** can have a length adjustment, or length adjustor **152**, which may typically be in the nature of a threaded rod and securement nut, which may be a wired or otherwise locked nut to prevent loosening. On assembly, adjustor **152** is set to fit the door to the door opening, with the over-travel lug in contact.

Fulcrum **140** is, or has, a pin joint formed at the apex of a fulcrum mounting fitting, or fulcrum stand, or fulcrum base, or footing **154**. Base **154** has a foot or anchor or main mounting identified at flanges **156** that are rigidly attached to center sill **42**. Footing **154** may have a generally triangular profile when seen in side view, and may have radial webs that extend along its edges to flanges at mounting **156** at which it is bolted to the flange, or flanges **158**, of bottom cover plate **160** of center sill **42**. As seen in the figures, the inboard face of footing **154**, i.e., facing toward the centerline of the car, has stiffening ribs. In some contexts the entire structure may be referred to collectively as the fulcum.

Transmission **124** also has a secondary lock or secondary lock assembly, indicated generally as **162**. It includes a suspended arm **164** that is pivotally mounted to the stationary structure of the car body underframe by a rigidly mounted bracket **168**, in this case to bottom cover plate **160** of center sill **42**. Suspended arm **164** may be biased toward engagement of transmission **124**. It could be biased by gravity or other means. In the embodiment shown in Figure **3d** it is biased by a spring **166**, which is shown as a leaf spring jointly mounted with arm **164** to a mounting bracket **168** bolted to the underside of flange **158**.

The distal end of arm **164** includes a pawl, abutment, catch, dog, lug, or pin **170**. The back side of the elbow of input arm **138** has a corresponding seat, or catch, or notch **172** formed therein. When transmission **124** moves to the over center position, notch **172** will be presented to pawl **170**, and, under the biasing influence of spring **166** as input arm **138** rotates clockwise pawl **170** will ride along the back face of the elbow of arm **138** until notch **172** is exposed and pawl **170** springs into place, thus capturing arm **138** and preventing return rotation in the counter-clockwise direction. Thus, even if car **20** should experience a vertical bounce that might otherwise tend to cause the over-center mechanism to jump and disengage, pawl **170** may tend to prevent such an occurrence from happening.

Indexing member **134** includes an information transmitting member in the form of a cam **174**, and a lost motion element, identified as slot **176**. The combination of items **174** and **176** permit indexing member **134** to function as a motion sequencing member, or information transmitting member that sets the order or schedule or sequence of steps of operation. That is, when actuator **122** operates to extend output shaft **128**, the first portion of that motion takes up the slack in the linkage provided by slot **176**. During the time period of this motion, cam **174** is delivering the message to secondary lock assembly **162** that it is time to permit release of pawl **170**. Mechanism **120** delivers this message by causing cam **174** to bear against the near side of suspended arm **164**, which acts as a cam follower. As this engagement occurs, spring **166** is compressed, and pawl **170** is disengaged from notch **172**. By the time slot **176** reaches its end of travel on pin joint **136**, pawl **170** is fully disengaged, and transmission **124** is ready for the next step in the sequence, namely the transmission of force and displacement from output shaft **128** to move pin joint **136**, and therefore lever **130**, in the counter-clockwise direction in Figure **3d**. When this occurs, over-travel prevention pin **150** is lifted off output arm **142** and output pin connection moves out of the over-center condition, and through the aligned position or condition. Once the mechanism has reached the aligned condition, any further motion will be aided by the weight of the door and lading, tending to move lever **130** counter-clockwise and tending to open door panel assembly **90**. When it is desired to close door panel assembly **90**,

actuator **122** is operated in the opposite direction, and the action is reversed to close the door.

As best seen in the cross-sectional view of Figure **2c**, actuator **122** is mounted to work through center sill **42**. As seen in Figure **3d**, the back end of cylindrical body **126** (i.e., the end facing away from output shaft **128**) is pivotally mounted at pin **178** to a reaction, or reaction member, or stationary mounting, or fitting, or footing, or bracket **180**, however it may be termed. It is the mounting fitting at which the reaction force provided by the structure of car **20** generally passes into, or is provided to, actuator **122**. Bracket **180** has a corresponding fitting, or eye to receive pin **178**, and feet **182**, **184** that are rigidly secured to center sill **42**, as by bolting to top cover plate **186** of center sill **42**. Body **126** is suspended from pin **178** to hang predominantly vertically between webs **188** of center sill **42**. In the embodiment shown, actuator **122** is located on the centerline of car **20**, as is mechanical transmission **124**. Body **126** swings fore-and-aft longitudinally relative to center sill **42** on pin **178** during motion, the angle varying with the moving position of pin joint **136** as it moves about fulcrum **140**. Throughout this motion, actuator **122** remains predominantly upright or upstanding or vertical, (i.e., that is, a predominantly upstanding actuator is one that has a line of action of the piston being more vertical than horizontal. In the embodiments herein, the line of action is generally less than 30 degrees from vertical), with the back end being secured above the center sill top cover plate, and the output being connected below the center sill bottom cover plate. Car **20** can include “elephant ears”, or shear web reinforcements **190** of slope sheets **44** and **46** that have a first, lower, edge welded to the outboard edge of the top cover plate flange of center sill **42** in line with center sill webs **188**, and an upper obliquely outboard edge welded to the underside of the respective slope sheets. Actuator **122** is mounted between the roots of elephant ears **190**.

In the sequence of Figures **3a**, **3b** and **3c**, during motion of mechanical transmission **124**, the output arm of lever **130** and the double webs of drag link **132** fold together upwardly in a scissor, or scissor-like action. In this motion, the distal region of output arm **142**, pin connection **146**, and the distal portion of drag link **132** including horn **148** protrude upwardly beyond the height of bottom cover plate **160** of center sill **42**. To accommodate actuator **122**, bottom cover plate **160** of center sill **42** splits and deviates around actuator, such that an opening **200** is formed in bottom cover plate **160**. A corresponding opening **198** is formed in top cover plate **186**. Similarly, an opening is formed in bottom cover plate **160** to accommodate the motion of mechanical transmission **124**. In this case, it is convenient for opening **200** to extend sufficiently far along center sill **42** to serve both functions. However, there could be two separate apertures defining the accommodation for actuator **122** and the accommodation for actuator **124**.

Placing actuator **122** in a substantially vertical orientation tends to permit the actuator installation to have a relatively short extent in the x-direction along the center sill. This, in turn, may permit two such actuators **122** to be mounted more closely together, and may permit transmission **124** to fold upward and to be generally more compact than might otherwise be the case. Where the installation is more compact, it tends to be possible for the space between adjacent hoppers to be smaller, such that the hopper discharge slope sheets can be closer together. “Closer together” can imply that the longitudinal size of the hopper discharge can be larger than before. If the discharge opening is larger, discharge may tend to be more rapid.

Vertical installation, or predominantly vertical installation, rather than horizontal installation along the inside of the center sill, may also tend to encourage use of shorter-stroke cylinders, such as may be smaller. While a single cylinder may be used to drive two longitudinally adjacent door sets at one time, the squat vertical installation may also tend to encourage the use of one actuator per door set, such that individual door pairs can be opened one-at-a-time. That is, each of hoppers **50**, **52** and **54** can have its left and right hand doors controlled separately from the doors of the adjacent hopper, allowing partial discharge, separate discharge, or sequenced discharge.

The doors tend to require a high volume of air due to the cylinder size used. Using a squat, vertical cylinder in the center sill may tend to permit a reduction in the length of cylinder stroke required to open and close the doors. For cars with on-board reservoirs, in particular, using less air for each operation may tend to decrease the required frequency of refilling the reservoirs, and the time required to refill the reservoirs.

The shortening of the length of the center sill bottom cover plate flange deviations may tend also to permit the cover plate to return to its normal width abreast of each of the discharge doors. Effectively, this permits the inboard edge of each of the left-hand and right-hand doors to be located a few inches closer to the centerline of the car, thus increasing the effective door opening width. This is shown in Figure **1f**. Bottom cover plate **160** has a normal, narrow width as indicated at **202**, that width prevailing abreast of the region of swing of the doors in the neighborhood of inboard side sheet extension **66**, almost to the hinge point. It then widens on a smooth angled, tapered transition at **204** to its broader width at **206**. That broader width prevails until past the end of opening **200**, where there is again another transition **204** to return to the normal width **202**. Over the widened portion the bottom cover plate flange is split into left hand and right hand flange portions **208**, **210** running along either side of the opening. Where there are two hopper actuators located back-to-back, as at **212**, opening **200** is longer, as at **214**.

Where there is only a single actuator, as at **216**, opening **200** is shorter, as at **218**. As shown in Figure **6a**, the upper flange, or upper cover plate, **186** of center sill **42** also has narrow, or normal width portion **222**, transition **224**, and wide portion **226** with split flange halves **228**.

5 In Figure **4**, fulcrum base **154** has a shallower sloped side facing the door, and a more steeply sloped side facing the actuator. Also visible in Figure **4**, Figures **5b** and **5c**, and in Figure **8** is an auxiliary manual release arrangement. In the manual release arrangement, extension **134** has a socket, or seat, or prying lug **242**. A prying wing, or abutment, or fulcrum **244** is formed as an extension or lug on the adjacent steeper flange **246** of fulcrum base **154**. A
10 guide, or shield or vane **238** extends from flange **246** lower down the side thereof, there being an open space, effectively a notch, between vane **238** and wing **244** of a size to admit entry of a lever or pry rod **250**. The slope on vane **238** may aid in placement of rod **250**. In operation, the insertion of a lever, such as manual pry rod **250** by an operator standing well clear of the car at trackside permits lug **242** to be pried downward, using wing **244** as a fulcrum. When this
15 happens, cam **174** releases secondary lock assembly **162**, and then sequentially permits transmission **124** to be forced out of the over-center condition. A person standing at track side can see whether mechanical transmission **124** is in the over-center condition by virtue of an annunciator in the form of a painted arrow or an indicator arrow **248** that is fastened to output arm **142** and that points toward a corresponding marking on the back of drag link **132**. In this
20 embodiment, the operator is able to release the secondary lock and the over-center condition of the transmission with a single tool, in a single motion.

As described above there is a secondary lock assembly **162** mounted to body structure of hopper car **20**. The movable member, arm **164**, has a first position in which it intercepts the door
25 transmission, and a second position in which it is disengaged from the door transmission. Pawl **170** is operable to interact with a catch, notch **172**. In a further feature, the secondary lock includes a follower, the face of arm **164**, that is biased to engage the cam defined by follower **174**, and is operable to release secondary lock **162**. The door transmission includes a sequencing member, namely extension **134**, which is mounted between actuator **122** and the mechanical
30 linkage of transmission **124**. When extension **134** is moved, secondary lock **162** is released during a first portion of motion, as the lost motion of slot **176** is taken up. In this first portion of motion, neither force nor displacement is imparted to the over-center linkage. The transmission is released from a primary lock configuration, *i.e.*, from the over-center condition, during a second portion of motion of the sequencing member after the lost motion has been exhausted.
35 Actuator **122** then operates to drive the linkage through the sequencing member.

As described, secondary lock **162** stops the main lever from rotating without the cylinder being pressurized or activated. The “lost motion” (the amount of travel of shaft **128** before force is applied to the actuating lever) is provided in the clevis, *i.e.*, extension **134**, that attaches the cylinder rod, output shaft **128** to main lever **130**. The clevis moves the secondary lock lever arm **164** clear of main lever **130** before applying force to the actuating lever when the cylinder is pressurized. The secondary lock lever is anchored to the car body. Alternatively, in other embodiments the secondary lock lever arm may be anchored to the cylinder body.

Mechanical transmission **124** has an actuator **122**, a primary lock, a secondary lock, and a sequencing member, namely extension **134**; and a manual release operable when actuator **122** is inactive, to release the secondary lock and the primary lock. The manual release is operable to disengage the secondary lock prior to disengagement of the primary lock. The manual release, namely prying lug **242**, is mounted to extension **134**. Being part of mechanical transmission **124**, the manual release member is movable, while fulcrum **244** is mounted to the stationary, or datum, structure of the underframe of hopper car **20**. This permits a person standing at trackside to engage the release member with a lever using the stationary member as a fulcrum. A second stationary member, namely wing **238** is mounted to car **20**, thereby defining a lever guide by which to feed a first end of a lever or pry rod to engage the manual release. The mechanism is designed such that the door may be opened manually if a source of pressurized air is not available. In other mechanisms, a first action must be taken to release the secondary locking prior to a second action of rotating the main lever. The new design has both actions performed by a single operator input. A pry bar moves the cylinder clevis such that the secondary lock is disengaged and the main lever is rotated with a single motion. This provides a means of opening the door in the event that no pneumatic supply is available.

The assembly described above may also be used, whether by retrofit or otherwise, with cars having left and right hand doors with split force inputs, as shown in Figure 7. Here, a door assembly **260** has left hand and right hand halves, each of which has a force input fitting **262**, **264** mounted to the back of a cross-beam or yoke **266** that ties the two door halve portions together. In this case, drag link **270** is substantially the same as drag link **132** on the input end, but the output is split into first and second arms **272**, **274** that are connected to the door assembly at fittings **262**, **264** respectively. This fittings may be all-welded assemblies having parallel doubled webs and a pin connection in double shear.

The mechanisms described above are for the operation of bottom discharge doors on railroad hopper cars, whether covered or open top. Each mechanism uses a single cylinder for

each pair of doors (i.e., a left-hand door, and a right hand door, yoked together). Each cylindrical actuator is oriented in a near vertical position or a position such that it does not extend between the doors, causing the area of the doors to be reduced, i.e., because the center sill flanges would otherwise have to extend to a greater width). The cylinder orientation is such that it protrudes up through the center sill. The cylinder **126** is connected to one end of a lever **130** that is located at the center line of the car. The lever fulcrum **140** is at a location below center sill **42** and is connected to support-brackets, namely of mounting base **154**, that are suspended from center sill **42**. The end of the lever opposite the cylinder, i.e., output arm **142**, is connected to a linkage member **132**. Linkage member **132** is connected to door assembly **90**. Door assembly **90** has a pair of transverse doors **112**, **114** on opposite sides of center sill **42**. The doors are connected by a rigid beam such that the doors operate in unison. The linkage member connects at the center point of the rigid beam, as seen in Figure 4 or Figure 6.

In another iteration of the new design, a different method was used to connect the lever to the door. The linkage that connects to the door was generally triangular, which provided two locations for two eye bolts to connect to the door assembly. While this design was found to be heavier than the single connection, it may be used on cars already built with doors that accommodate two points of connection to the mechanism. The mechanism operates in a manner such that when in the closed position, the lever and linkage members lock the door by resting in an over-toggle position. This over-toggle position (shown in Figure 4) causes any force on the door to rotate the lever against a rigid stop on the linkage member that prevents further rotation of either member. When the cylinder is pressurized, it causes rotation of the lever that breaks this over-toggle and causes the door to open.

The cylinder is locked by way of a secondary locking mechanism in addition to the main lever locking in over-toggle position. This mechanism uses a small locking lever that holds the main lever in the closed position until the cylinder is actuated. Lost motion in the cylinder moves the locking lever such that it disengages from the main lever prior to applying any force to the main lever. Once the locking lever is clear of the main lever, it is free to rotate in response to the cylinder applying force.

As described above, the apparatus has a substantially linear single actuating lever **130** that connects to the cylinder, i.e., actuator **122**, at one end, a door linkage **132** at the other end and pivots about a central fulcrum **140**. Lever **130** is approximately horizontal when reacting the forces on the door. In other embodiments, lever **130** may be at some angle other than horizontal. Lever **130** may itself form an angle, or dog leg, or curve, such that the cylinder and door linkage

connection points are at less than 180 degrees from one another (could be at 90 degrees, or L shaped for example).

5 The apparatus described above has a cylinder (i.e., actuator **122**) that extends
predominantly upward from the mechanism of mechanical transmission **124** such that it is
substantially out of the plane of bottom cover **160** of center sill **42**. This allows the profile of the
center sill to be narrower at the location of the doors, and allows the door openings to be larger.
The cylinder extends up through the top cover plate **186** of center sill **42**. In an alternate
embodiment, the angle of the cylinder may be slightly less vertical in order to decrease the height
10 of the top cylinder hinge point at pin **178**, removing the need for an opening in the center sill top
cover. That is, the mounting for pin **178** can be on the underside of cover plate **186**, rather than
above it. In another alternative embodiment, in the case of a car with no center sill (a stub sill
design), the cylinder is oriented in a way that it does not interfere with the motion of the door or
required a reduction in the door size. In this case, rather than two side-by-side door openings,
15 there may be one continuous door that extends laterally across the car.

In each of the embodiments described the transmission includes a linkage, or assembly of
linkages that connect to the door assembly at a center location, *i.e.*, along the centerline of car
20. The connection to the door is near the bottom, or distal, edge of the door. The door
connections may also be a plurality of connections that may be laterally away from the center of
the door assembly. In some embodiments the linkage may connect to the door at some different
location with respect to the distance from the bottom edge of the door, *i.e.*, not quite as close to
the distal margin.

25 Various embodiments have been described in detail. Since changes in and or additions to
the above-described examples may be made without departing from the nature, spirit or scope of the
invention, the invention is not to be limited to those details.

Claims

We Claim:

1. A railroad hopper car having a hopper car body carried on railroad car trucks for rolling
5 motion in a longitudinal direction, said railroad hopper car having a center sill, said railroad
hopper car comprising:
a first hopper;
said first hopper having a bottom discharge;
said bottom discharge having a movable door mounted to govern egress of lading from
10 said first hopper;
said movable door being driven by a door actuator;
said door actuator being located at the center sill; and
said door actuator being predominantly upstandingly oriented.
- 15 2. The railroad hopper car of claim 1 wherein said door is a transverse door.
3. The railroad hopper car of any one of claims 1 and 2 wherein said railroad hopper car has
first and second spaced apart sidewalls extending therealong, and said first hopper has a first
slope sheet extending obliquely upwardly away from said bottom discharge, and said actuator is
20 mounted in the lee of said first slope sheet.
4. The railroad hopper car of any one of claims 1 to 3 wherein at least a portion of said
actuator is mounted within said center sill.
- 25 5. The railroad hopper car of any one of claims 1 to 4 wherein said actuator acts amidst said
center sill.
6. The railroad hopper car of any one of claims 1 to 5 wherein said actuator has a line of
action that acts through said center sill.
30
7. The railroad hopper car of any one of claims 1 to 6 wherein said actuator is mounted on
the longitudinal centerline of the hopper car
7. The railroad hopper car of any one of claims 4 to 7 wherein said center sill extends
35 through said first hopper.

8. The railroad hopper car of claim 7 wherein said door of said first hopper is split into first and second portions lying laterally to either side of said center sill.

5 9. The railroad hopper car of claim 8 wherein said actuator is connected to said door by a mechanical transmission, and said mechanical transmission is bifurcated to drive said first and second portions.

10 10. The railroad hopper car of claim 9 wherein said first and second portions are yoked to sweep through a common arc together.

11. A railroad hopper car having a hopper car body supported by railroad car trucks for rolling motion in a longitudinal direction, said railroad hopper car having a center sill, said railroad hopper car comprising:

15 a first hopper, said first hopper having a bottom discharge;

said bottom discharge having a movable door mounted to govern egress of lading from said first hopper;

an actuator connected to drive said movable door;

said door actuator being predominantly upstandingly oriented; and

at least part of said door actuator being mounted within said center sill.

20 12. The railroad hopper car of claim 11 wherein said center sill has a pair of spaced apart webs and a bottom flange, said bottom flange having a first portion having a first width adjacent said door, and a second portion having a second width adjacent said actuator; said first width being narrower than said second width; said door being mounted to swing beside said center sill
25 alongside said first portion; said second portion having an aperture formed therein to permit said actuator to work therethrough.

30 13. The railroad hopper car of any one of claims 11 and 12 wherein said actuator is connected to said door by a linkage that folds at least partially into said center sill.

14. The railroad hopper car of any one of claims 11 to 13 wherein said actuator is connected to said door by mechanical linkages, and one of said linkages has a fulcrum mounted under said center sill.

35 15. The railroad hopper car of any one of claims 11 to 14 wherein said actuator has a reaction mounted on top of said center sill.

16. The railroad hopper car of any one of claims 11 to 15 wherein said door is a transverse hopper door having first and second portions to either side of said center sill.

5 17. The railroad hopper car of claim 16 wherein said actuator is connected by a bifurcated linkage to drive said first and second portions of said door.

18. The railroad hopper car of claim 16 wherein said first and second portions of said door are yoked to sweep together.

10 19. The railroad hopper car of claim 16 wherein, in a closed position of said door, said door has a free edge most distant from said actuator; said free edge has a backing beam extending thereacross, said backing beam yoking said first and second portions of said door together; and said actuator is connected to said door by a mechanical transmission that includes a linkage mounted to said backing beam.

15 20. The railroad hopper car of any one of claims 16 to 19 wherein said door is movable between an open position and a closed position; said actuator is connected to said door by linkages; said linkages are movable to an over center condition when said door is in said closed position; and said linkages have a secondary lock operable to discourage movement out of said over-center condition when said actuator is passive.

20 21. A secondary lock for a railroad hopper car door transmission, said secondary lock being mounted to body structure of said hopper car.

25 22. The secondary lock of claim 21 wherein said secondary lock includes a base mounted to the body structure of the hopper car and a movable member that is biased toward engagement with the door transmission, the movable member having a first position in which it intercepts the door transmission, and a second position in which it is disengaged from the door transmission.

30 23. The secondary lock of claim 21 wherein said movable member has a pawl operable to interact with a catch of the door transmission.

35 24. The secondary lock of claim 21 wherein said secondary lock includes a follower engagable with the door transmission, the follower being operable to release said secondary lock from the door transmission.

25. A combination of the secondary lock of claim 21 and the door transmission, the door transmission including a catch, and the secondary lock including a pawl, said pawl and said catch being mutually engaged when said door transmission is in a primary lock configuration.

5 26. The combination of claim 25 wherein said secondary lock includes a follower and said door transmission includes a moving member, said moving member being operable in motion to engage said follower and thereby to release said secondary lock.

10 27. A combination of the secondary lock of claim 21 and the door transmission, wherein said door transmission includes a sequencing member, and, when said sequencing member is moved, said secondary lock is released during a first portion of motion of said sequencing member, and said transmission is released from a primary lock configuration during a second portion of motion of said sequencing member.

15 28. A combination of the secondary lock of claim 21, a linkage mounted to drive a door of a hopper, and an actuator mounted to drive said linkage, wherein:

said linkage is drivable by said actuator to a primary lock configuration in which said linkage is in an over-center condition;

there is a sequencing member, a catch, and a release member;

20 said secondary lock is biased to engage said linkage;

said secondary lock includes a pawl, said pawl being biased to engage said catch when said linkage is driven to said over-center condition, and, when so engaged, engagement of said pawl with said catch preventing said linkage from moving out of said over-center condition;

25 said secondary lock includes a follower for engagement with said release member; and said sequencing member is a lost motion fitting driven by said actuator;

said actuator is operable to drive said lost motion fitting through a first portion of motion, and, during said first portion of motion said actuator also drives said release member in engagement with said follower to release said secondary lock;

30 said actuator is operable to drive said lost motion fitting through a second portion of motion after said first portion of motion; and, during said second portion of motion said actuator also drives said linkage out of said over-center condition.

35 29. The combination of claim 28 wherein said sequencing member is mounted between said actuator and said linkages, whereby said actuator is operable to drive said linkage through said sequencing member.

30. The combination of claim 29 wherein said lost motion fitting is an elongate slot in said sequencing member, and said release member is a cam that co-operates with said follower.

5 31. A railroad hopper car door operating mechanism comprising: an actuator, a primary lock, a secondary lock, a sequencing member, and a manual release operable when said actuator is inactive to release said secondary lock and said primary lock.

32. The railroad hopper car of claim 31 wherein said manual release is operable to disengage said secondary lock prior to disengagement of said primary lock.

10 33. The railroad hopper car door operating mechanism of claim 31 wherein said manual release is mounted to said sequencing member.

15 34. The railroad hopper car door operating mechanism of claim 31 wherein said manual release member is movable; a first stationary member is mounted to the hopper car; and, said first stationary member functions as a fulcrum, permitting a person standing at trackside to engage said release member with a lever, using said first stationary member as a fulcrum.

20 35. The railroad hopper car door operating mechanism of claim 34 wherein a second stationary member is mounted to said railcar, said second stationary member defining a lever guide by which a person standing at trackside may feed a first end of a lever to engage said manual release.

25 36. The railroad hopper car door-operating mechanism of claim 35 wherein:
said door operating mechanism includes a linkage mounted to drive a hopper door, said linkage being drivable to an over-center condition when said door is closed, said over-center condition defining said primary lock;
said sequencing member is a lost motion member mounted between said actuator and said linkage;
30 said linkage has a catch that is engaged by a pawl when said linkage is in said over-center condition, thereby preventing said linkage from moving out of said over-center condition, said catch and pawl defining said secondary lock;
and said lost motion member being movable when said manual release is driven first to release said secondary lock while taking up lost motion therein, and then to
35 release said primary lock after lost motion therein is exhausted.

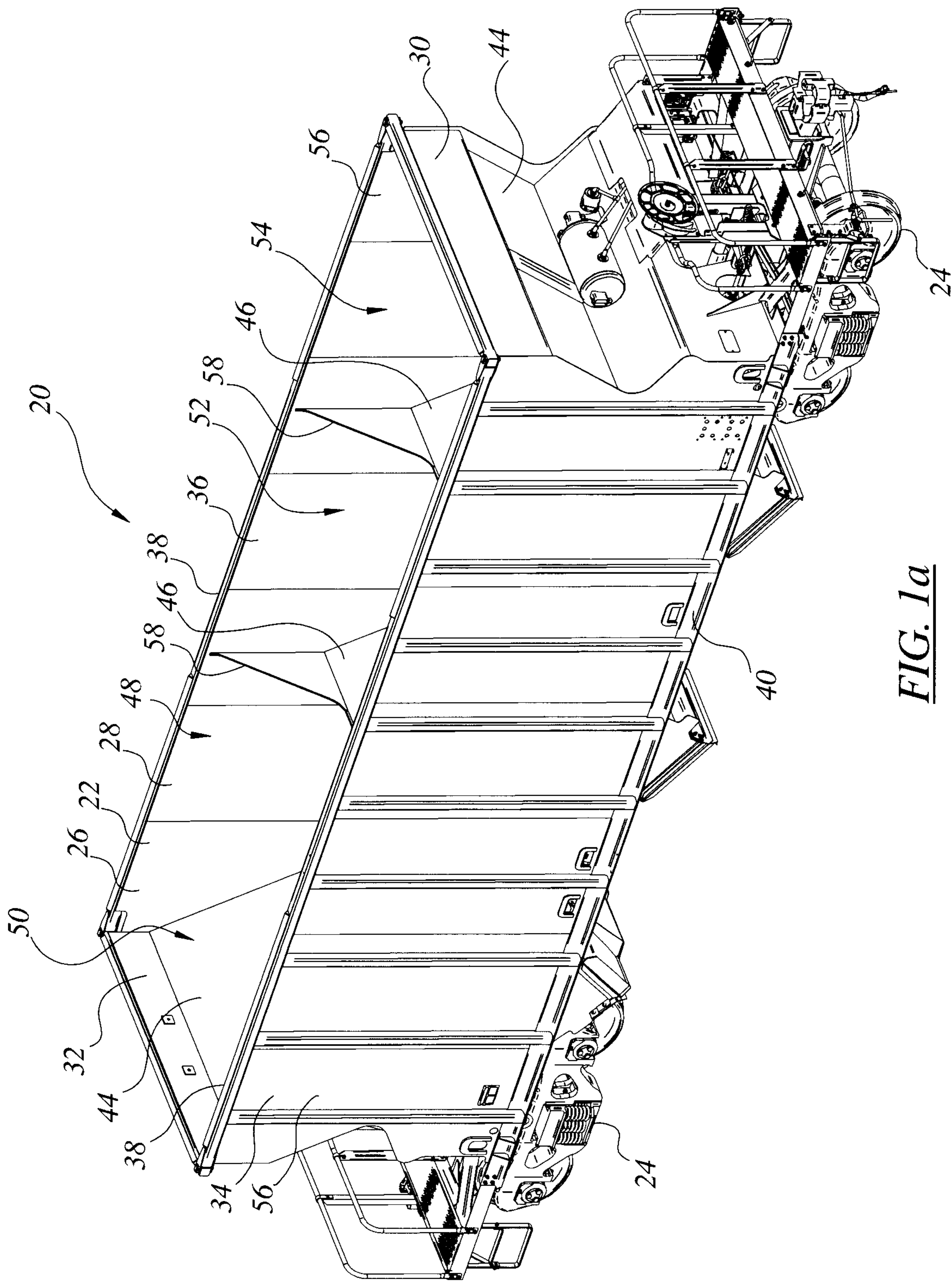
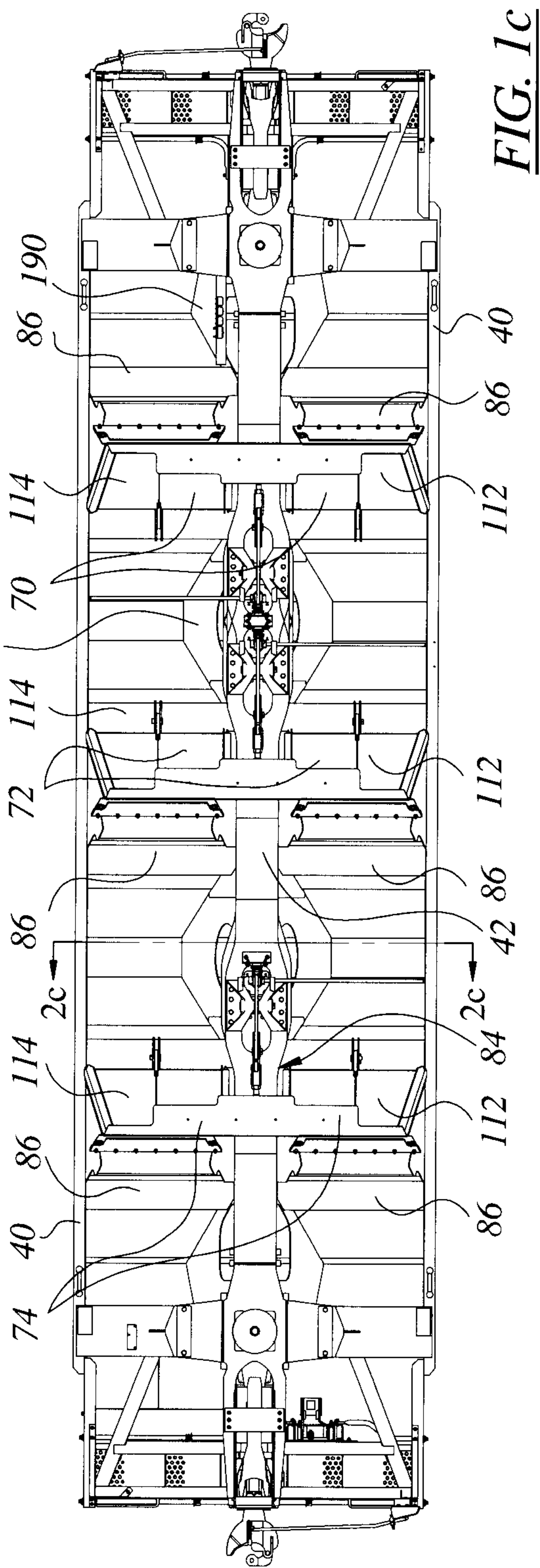
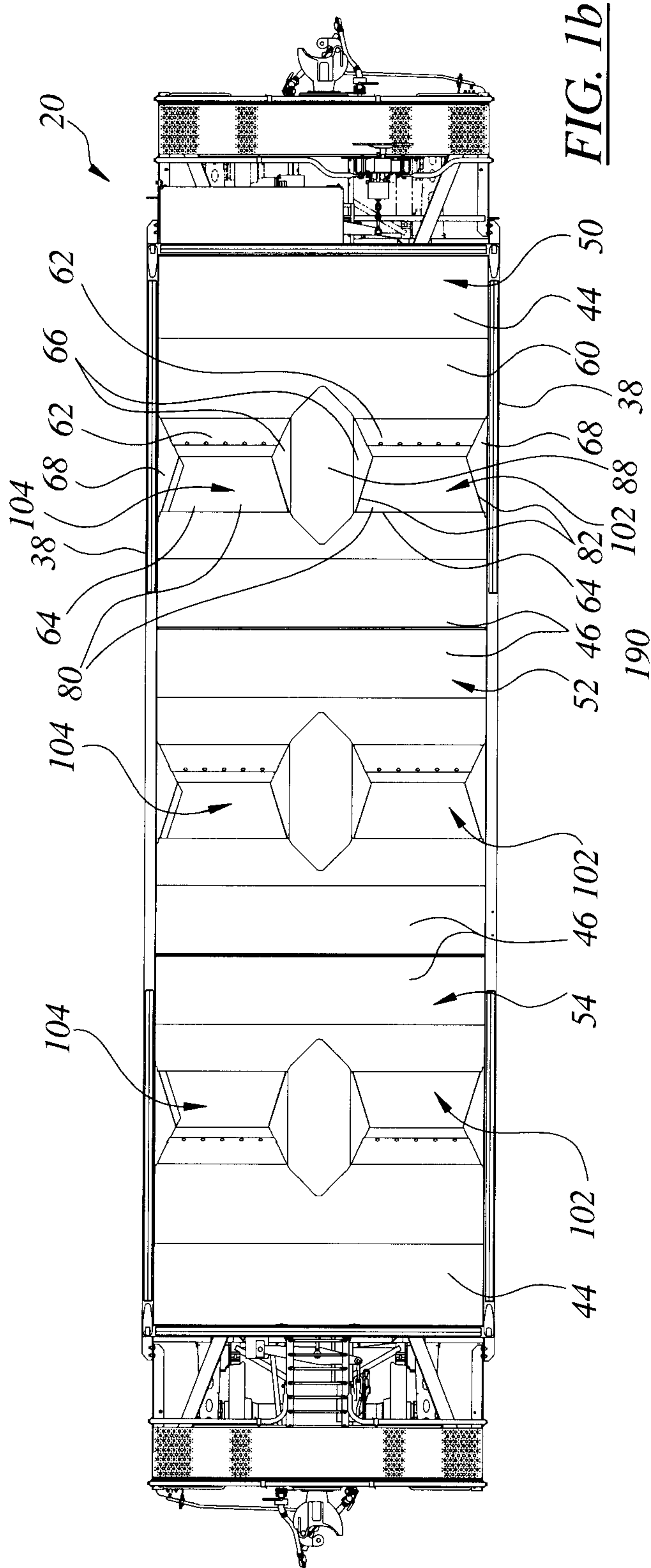


FIG. 1a



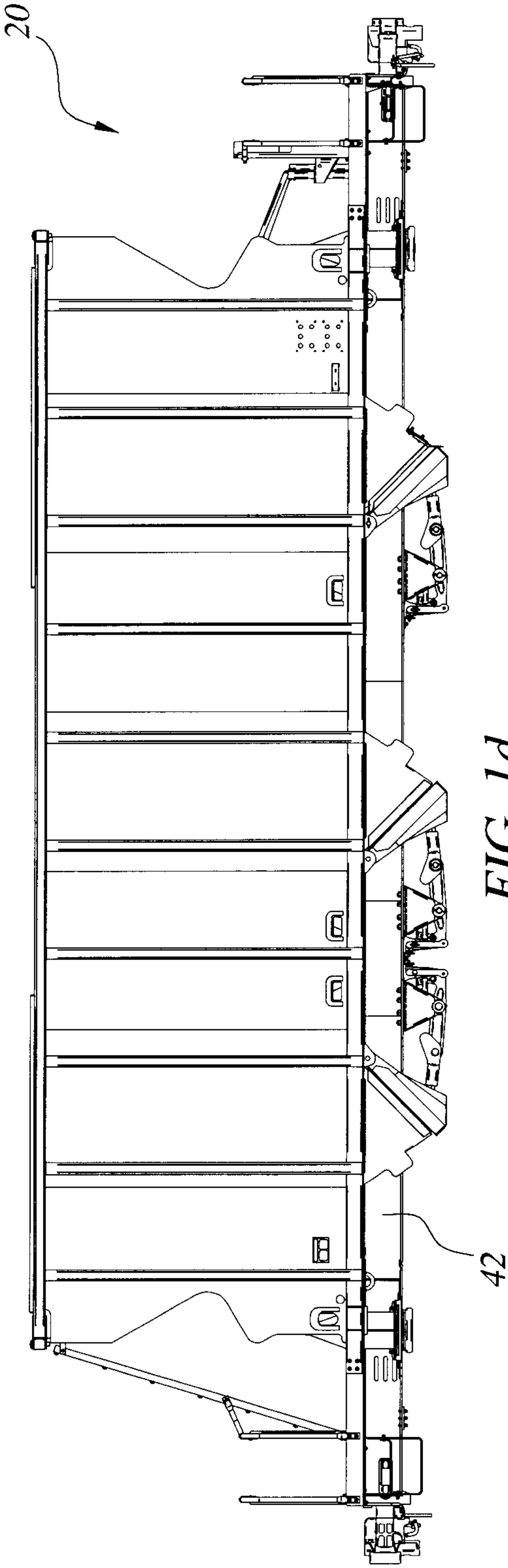


FIG. 1d

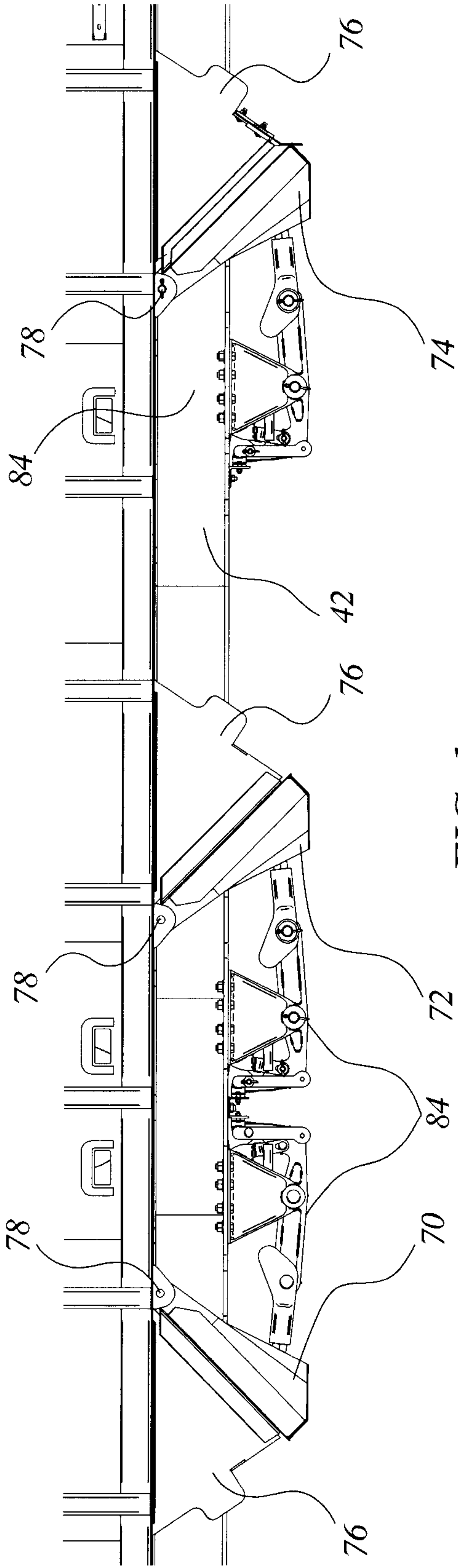


FIG. 1e

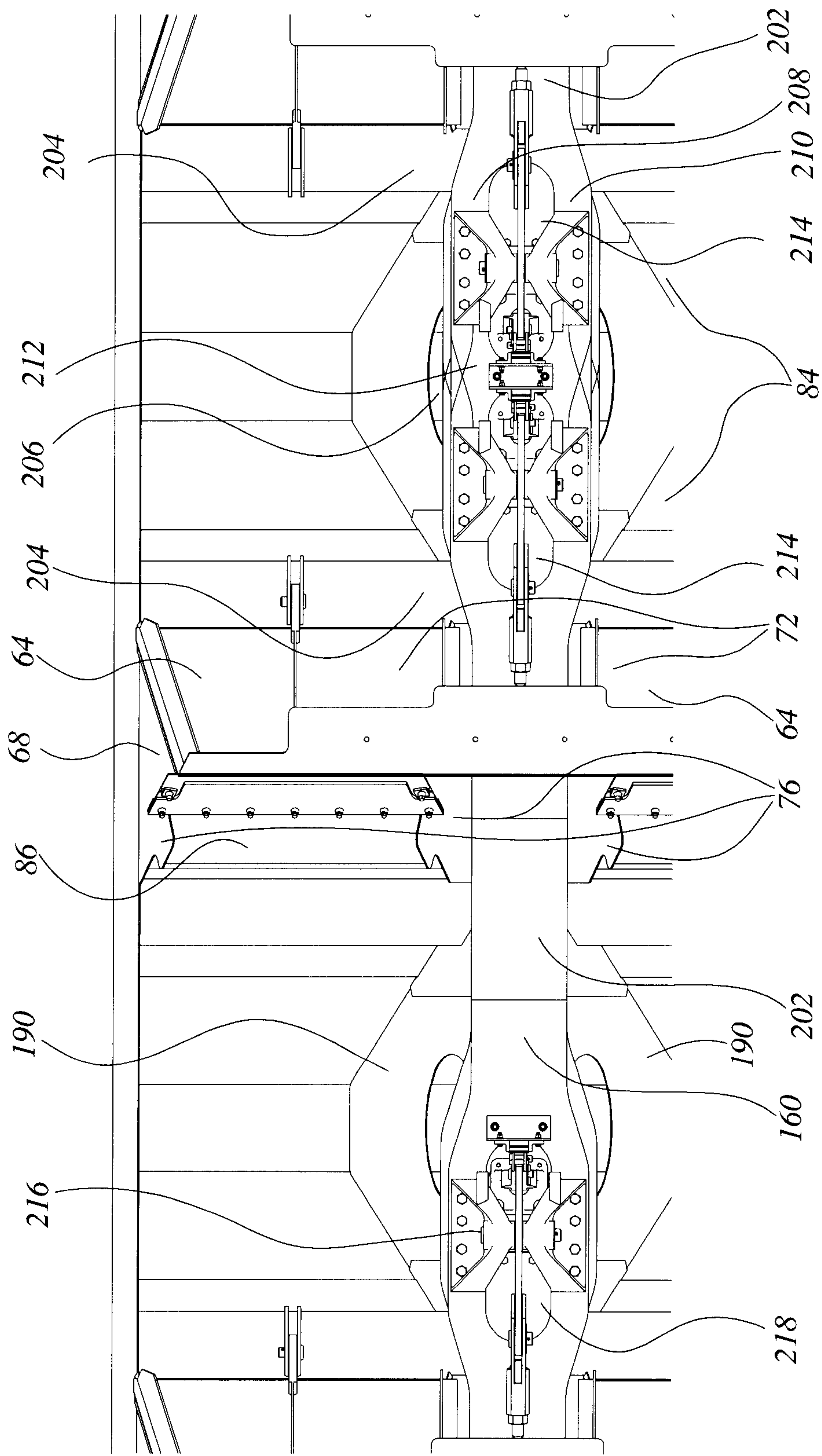


FIG. 1f

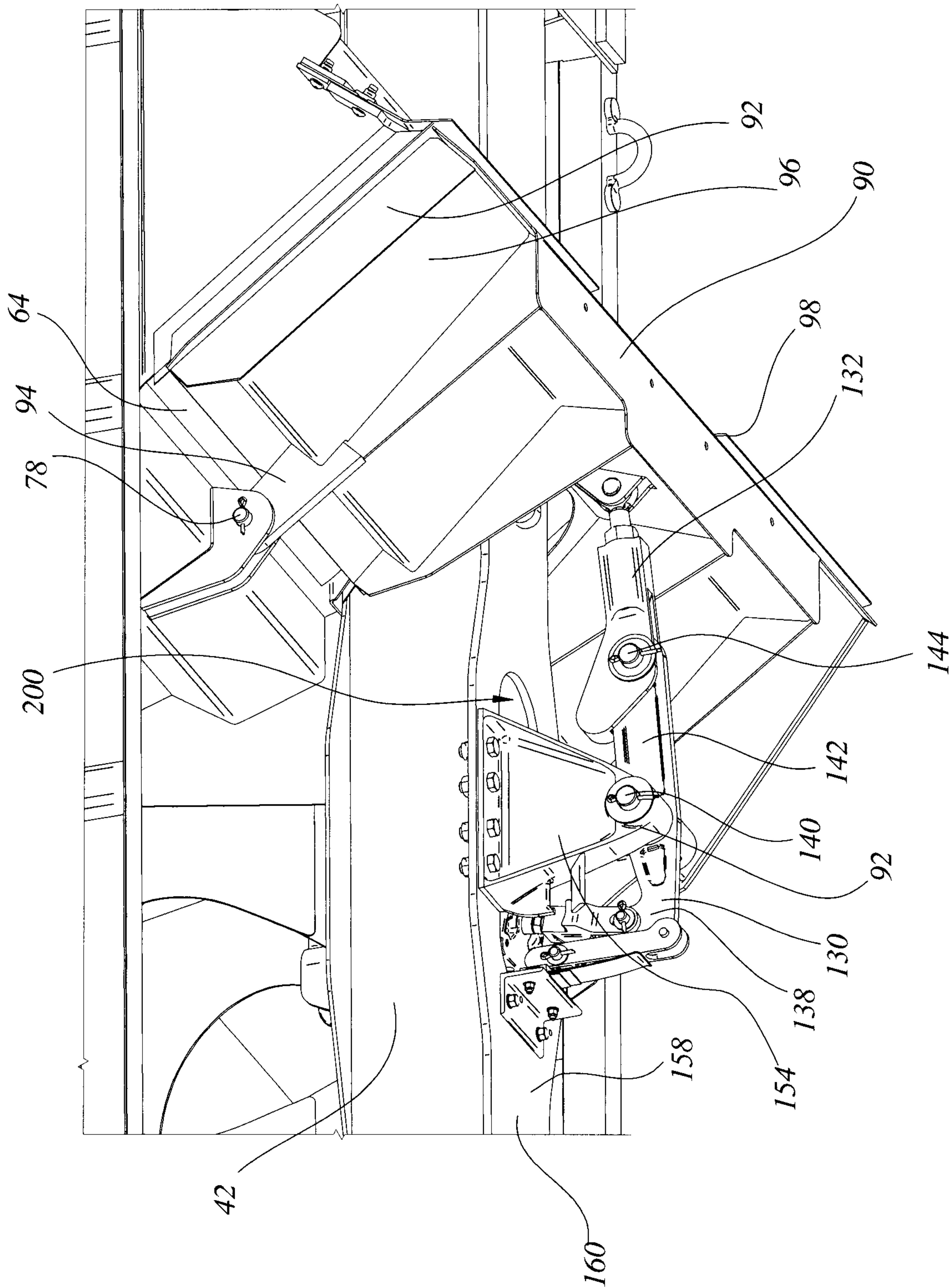


FIG. 2a

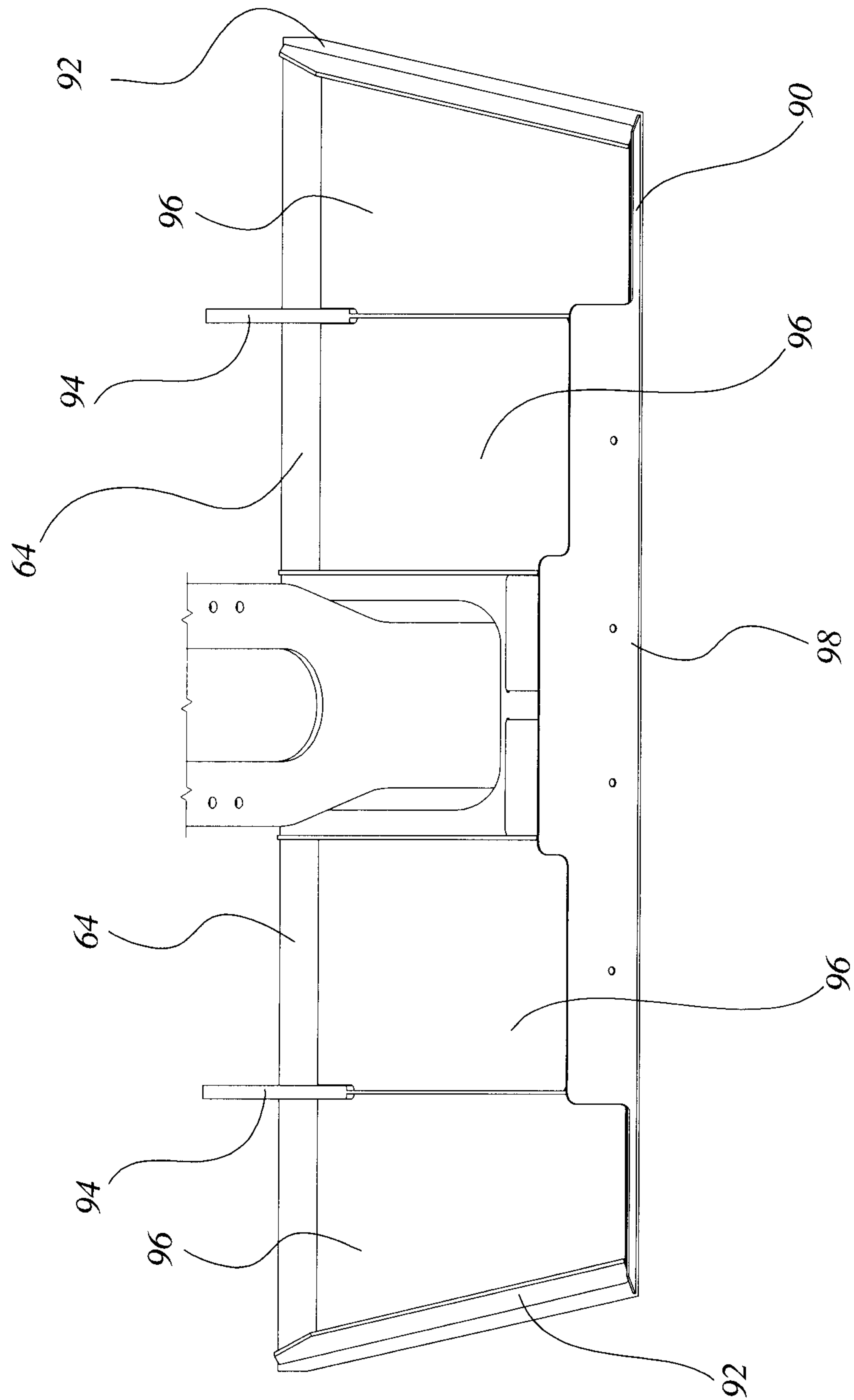


FIG. 2b

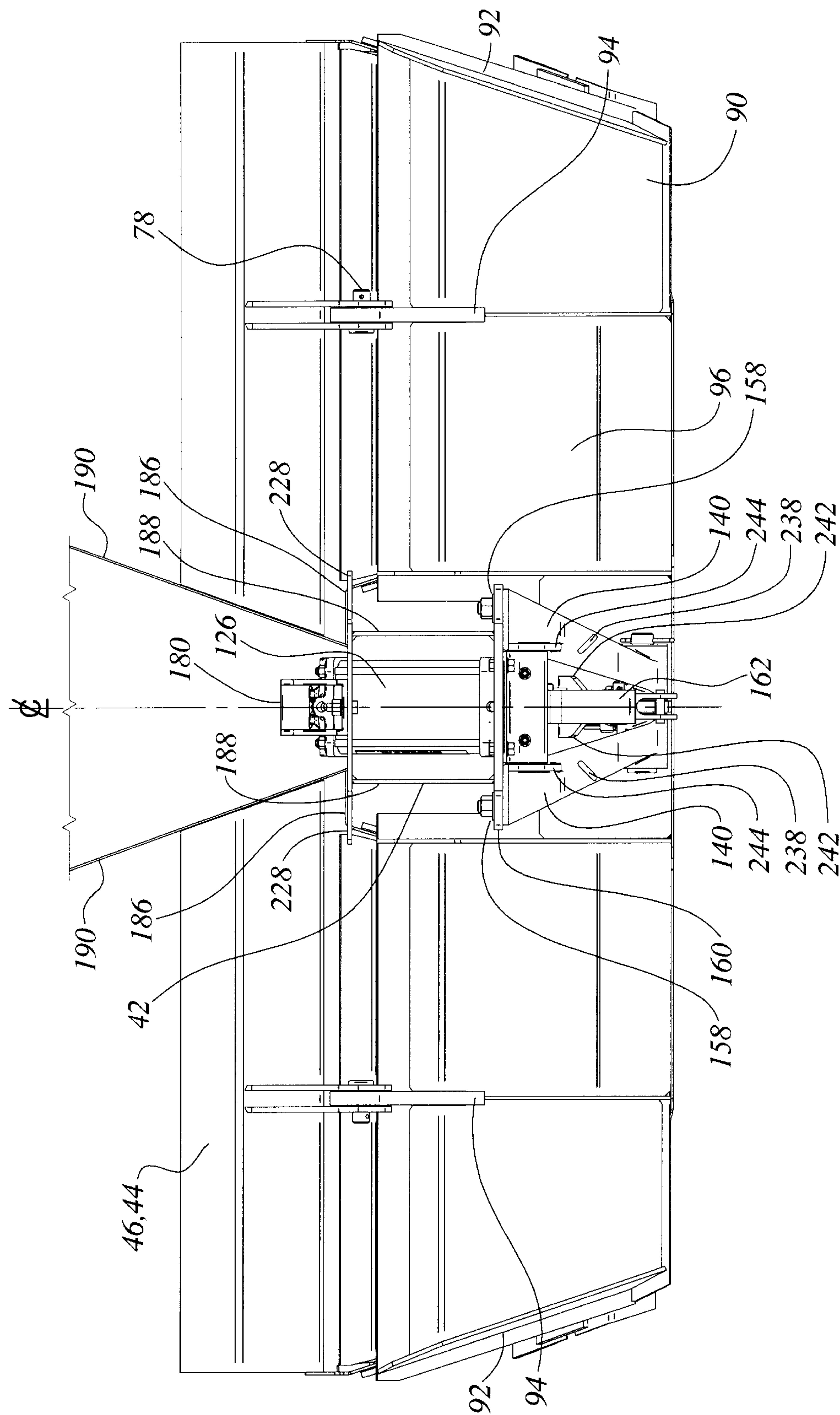
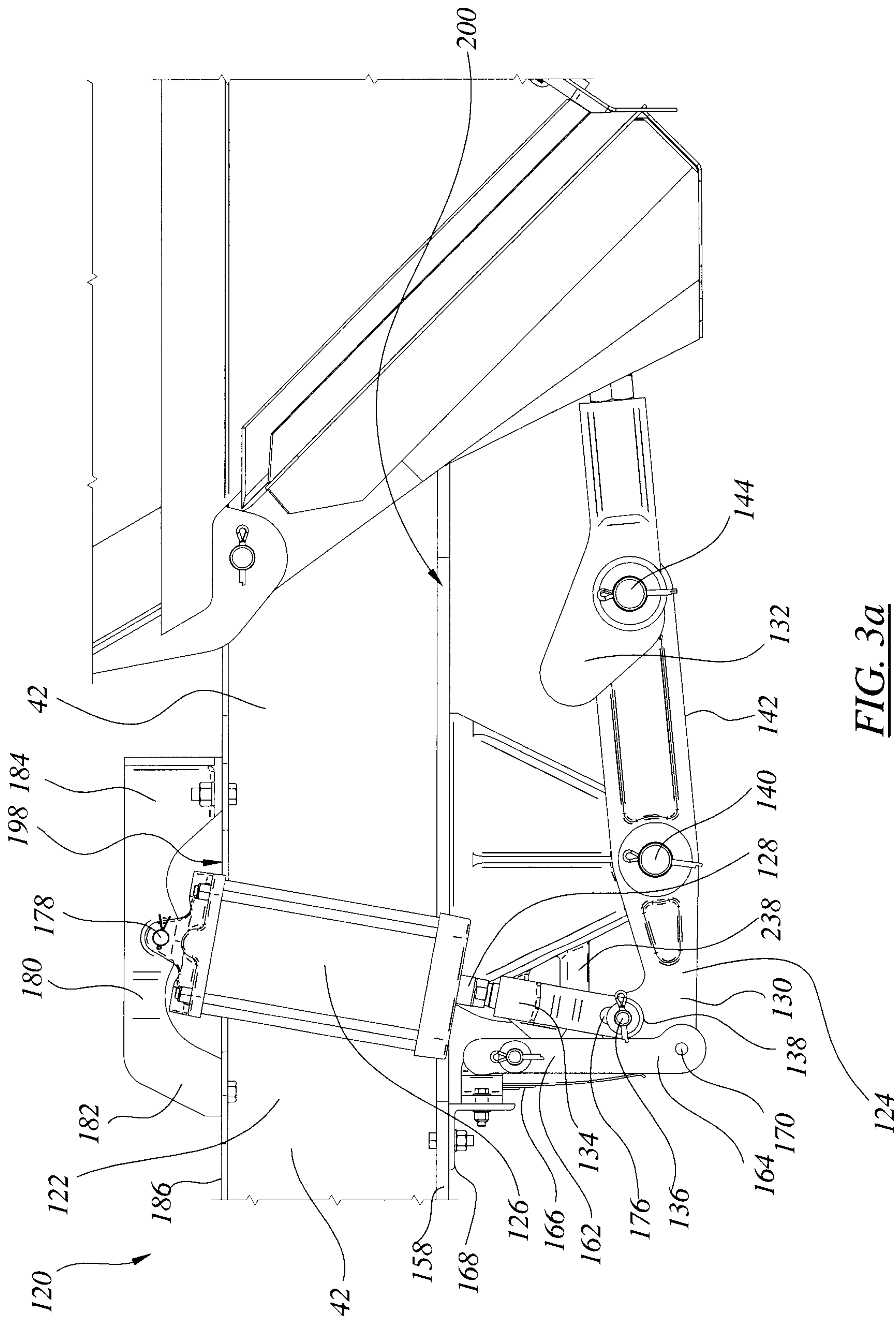


FIG. 2c



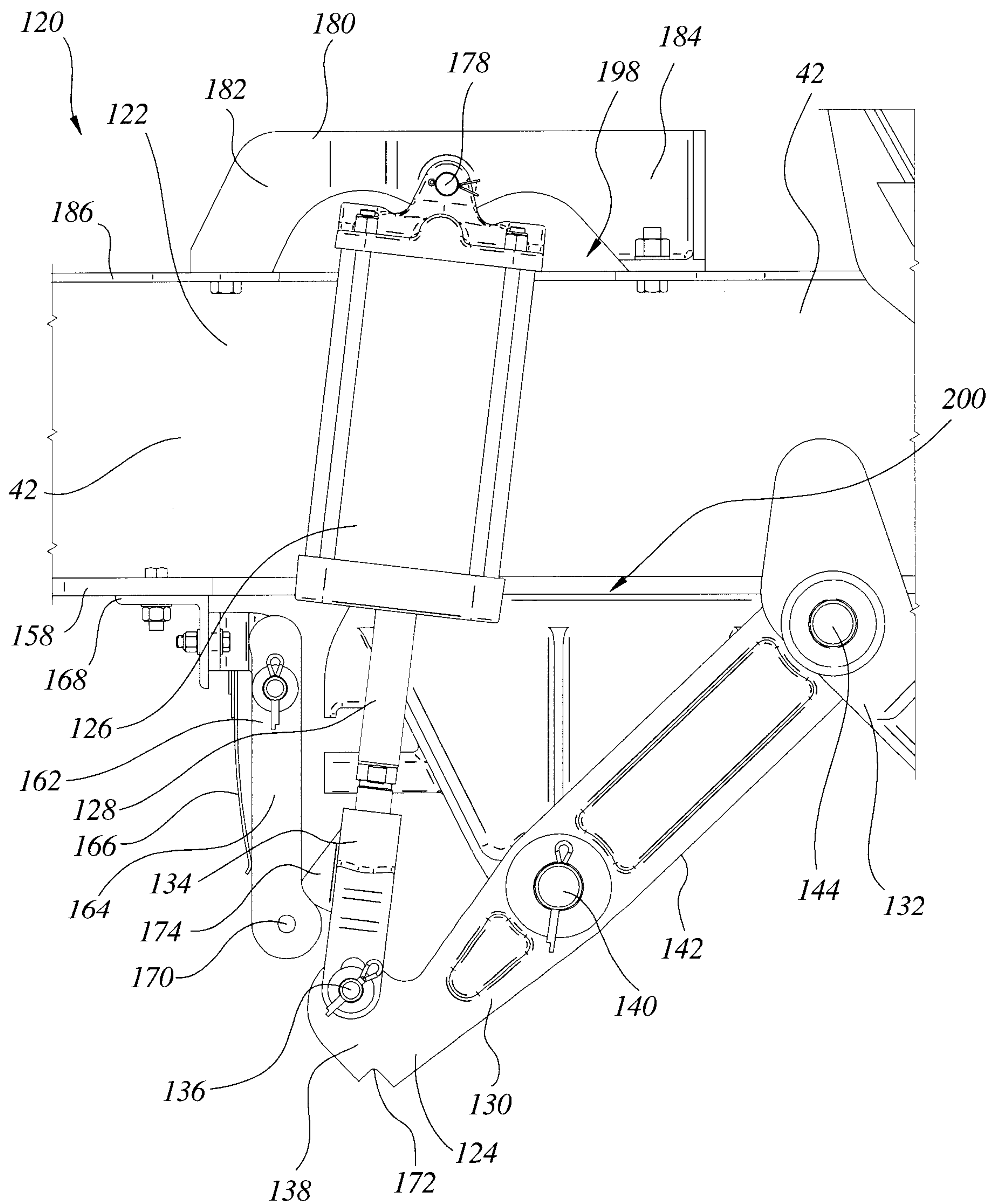
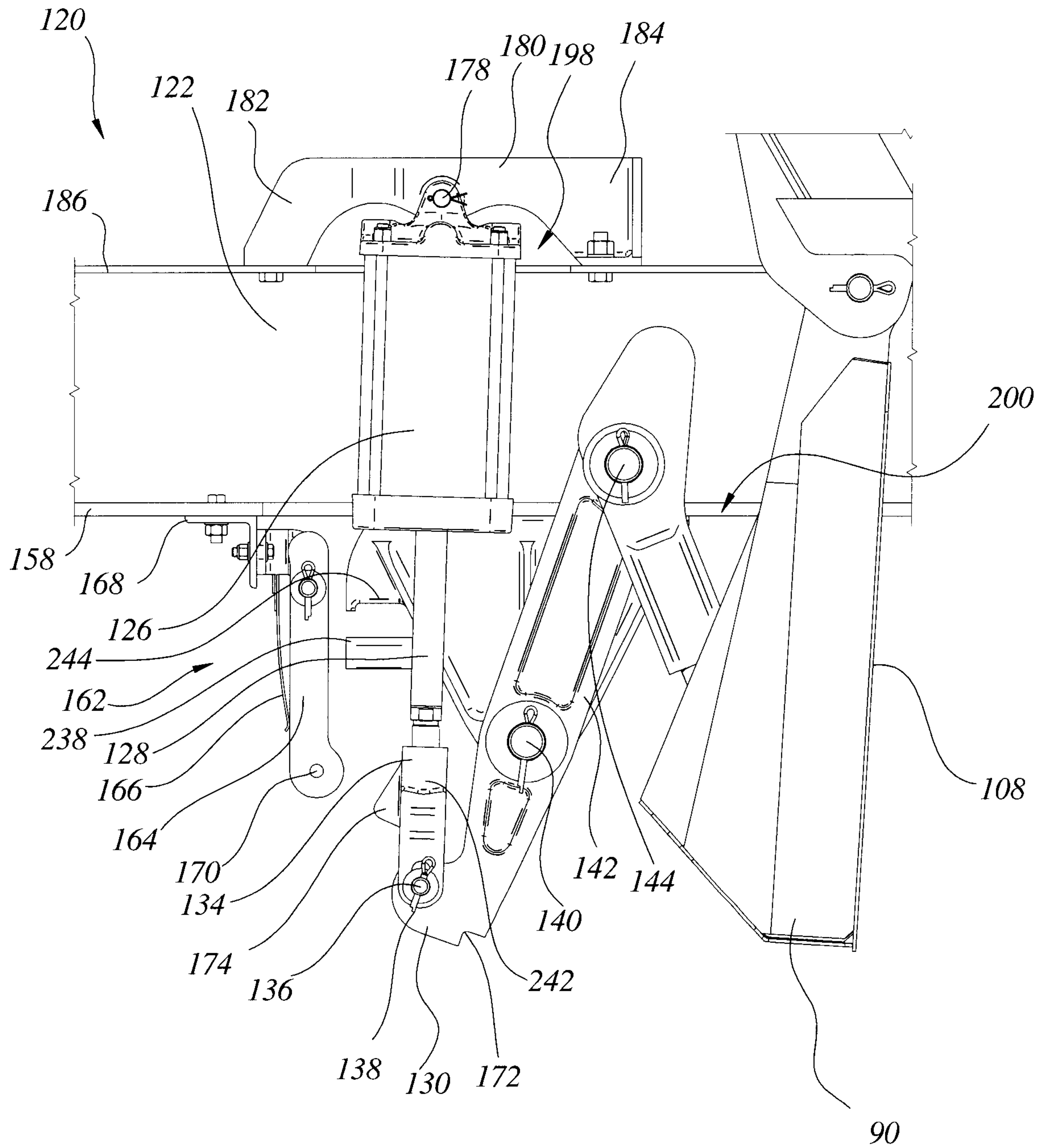


FIG. 3b

FIG. 3c

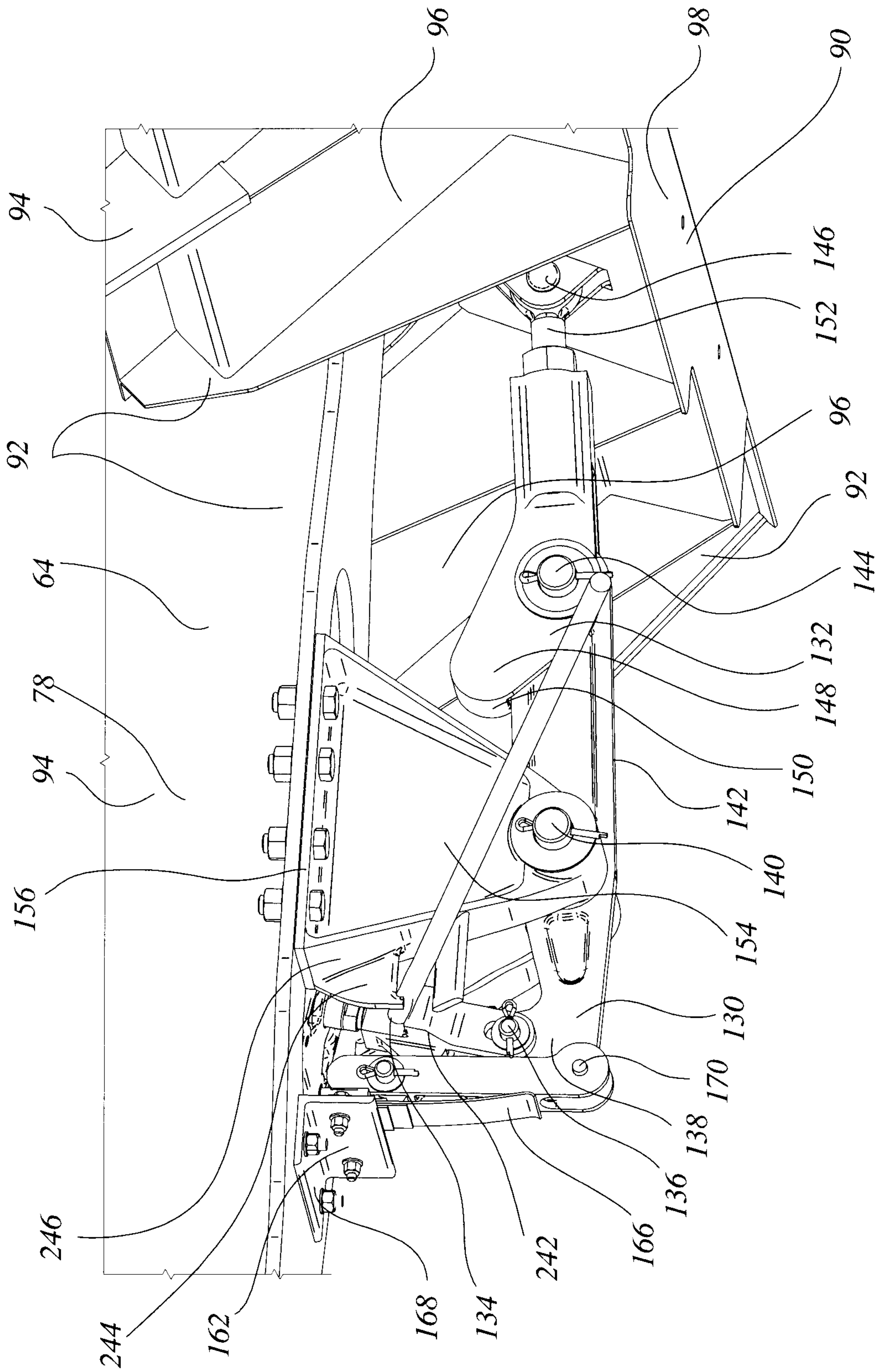
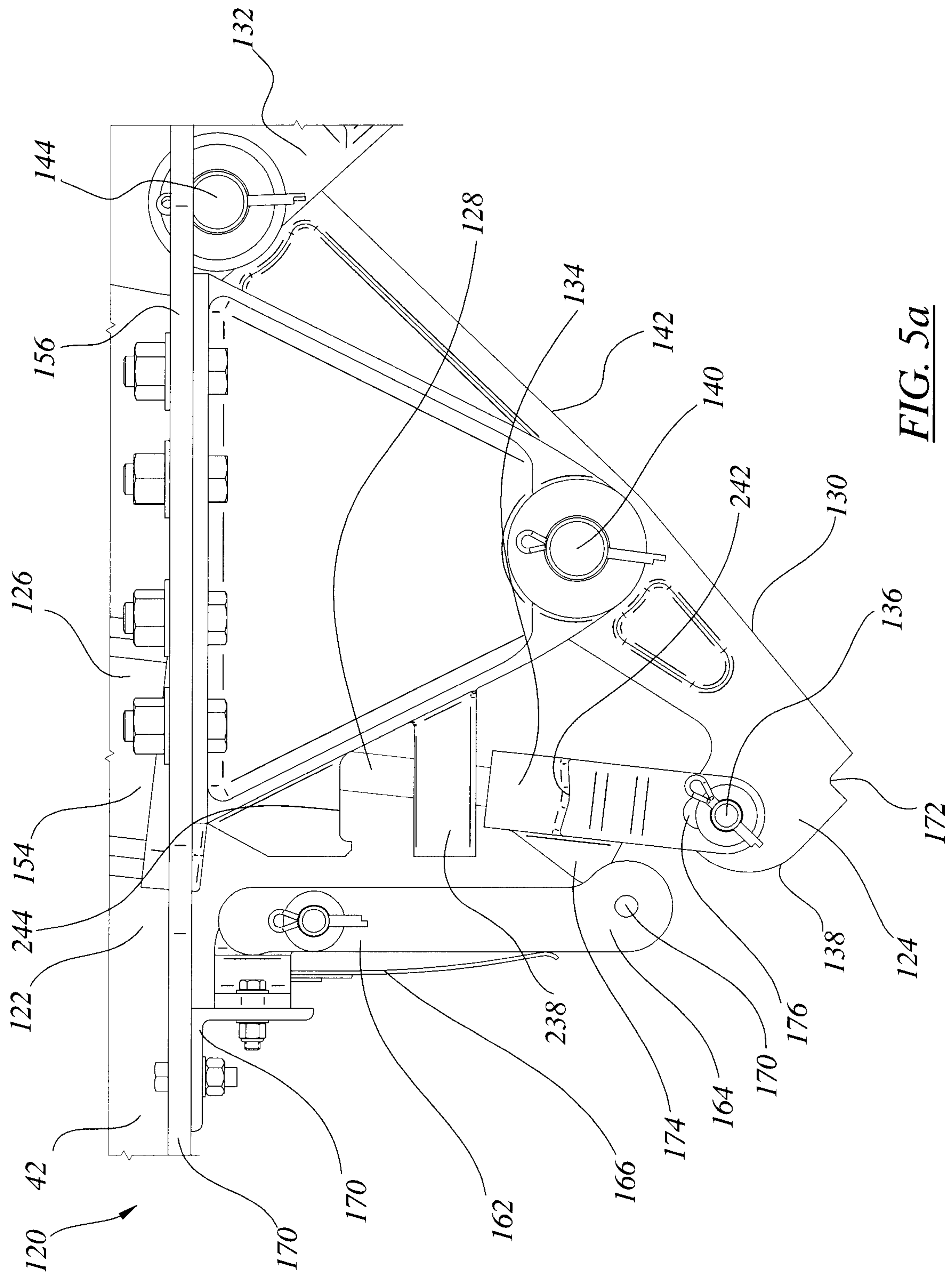


FIG. 4



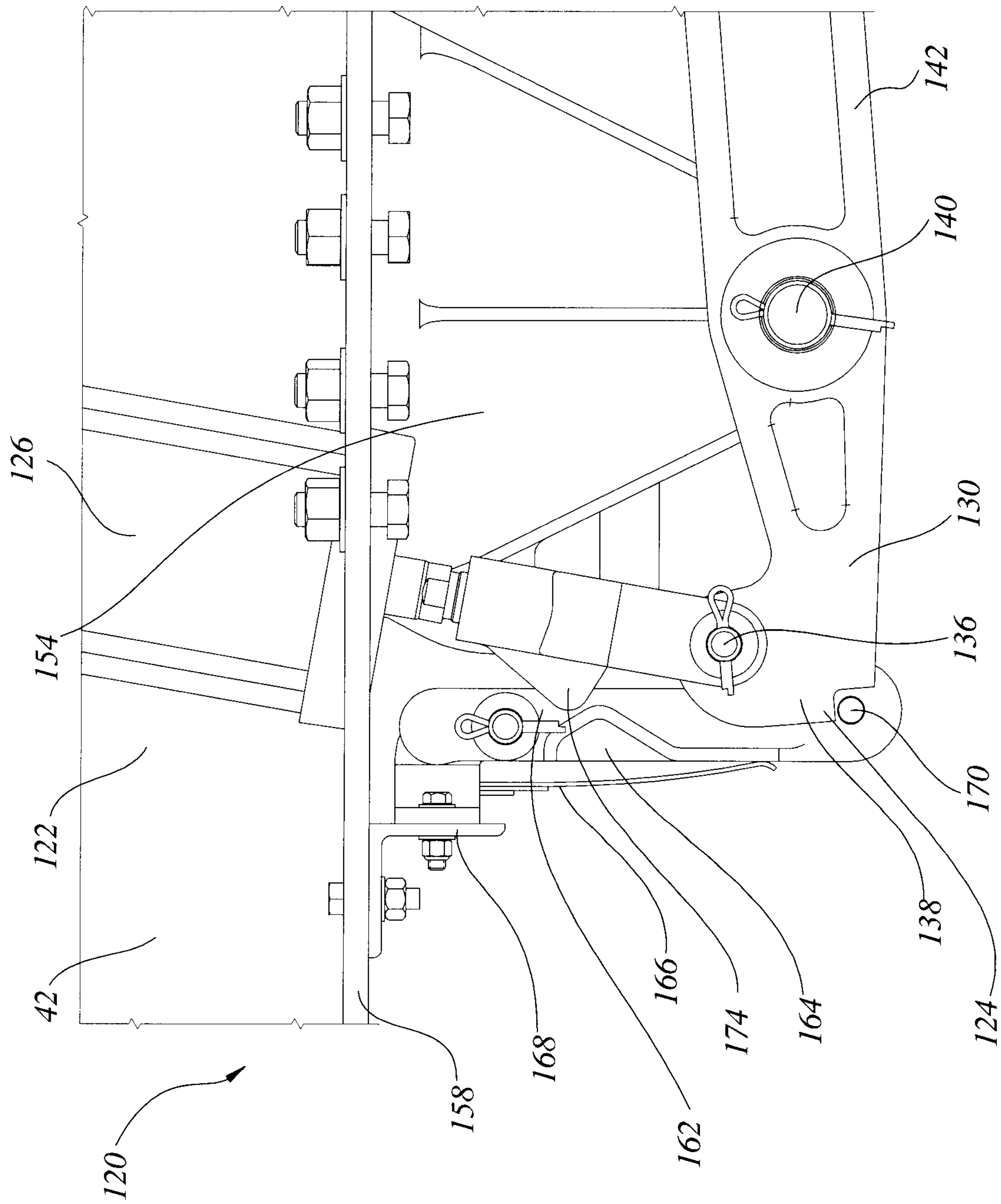


FIG. 5b

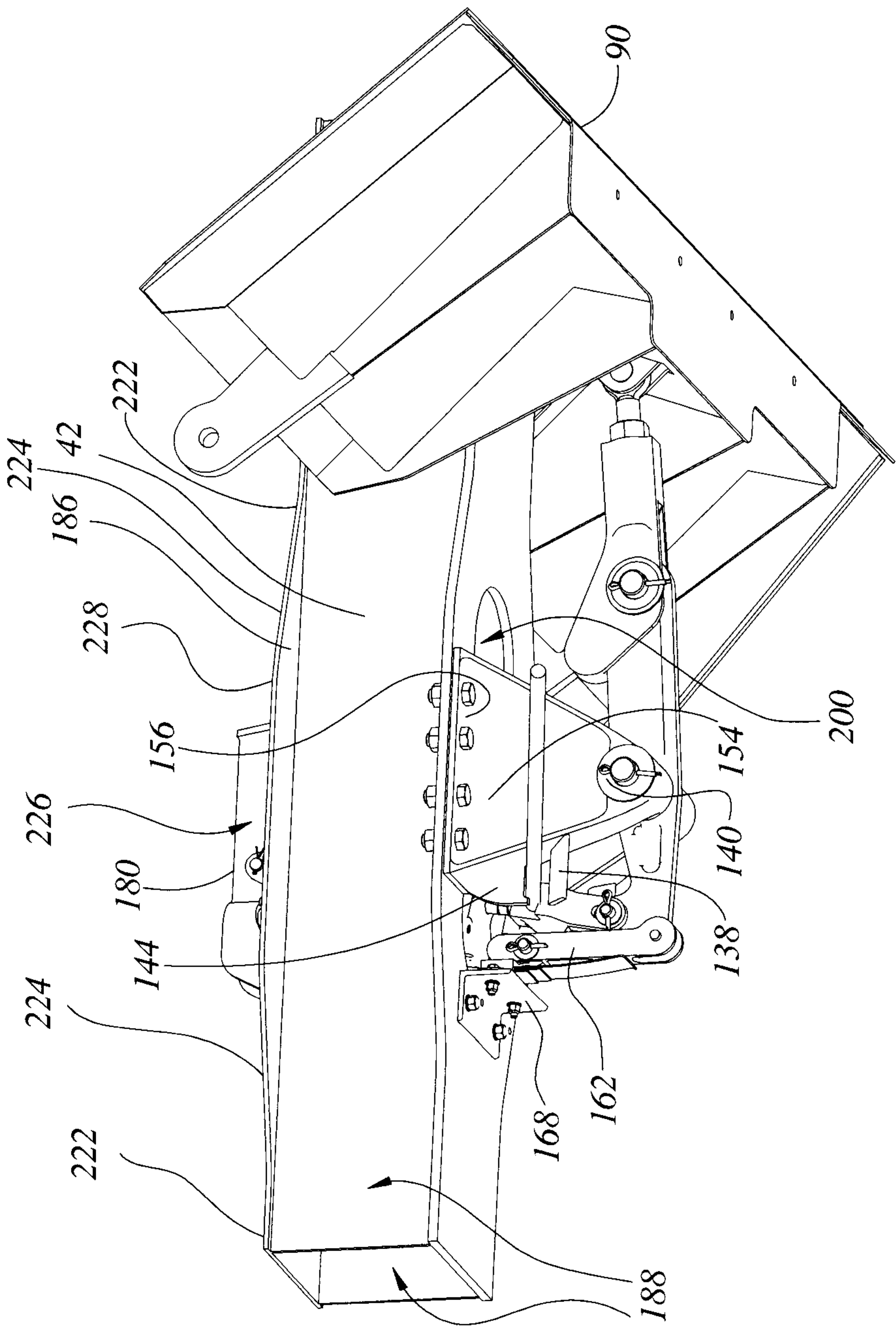


FIG. 6a

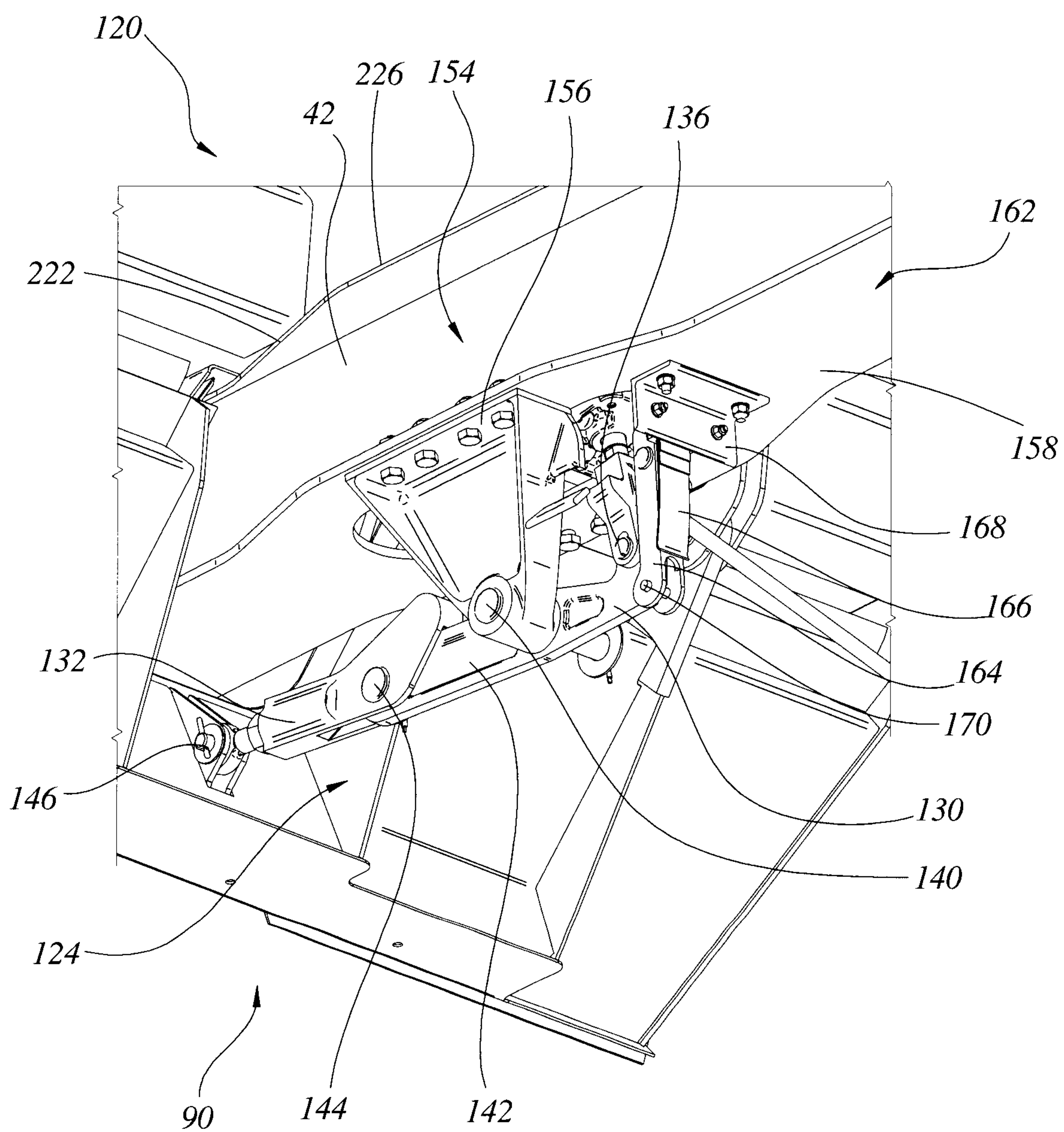


FIG. 6b

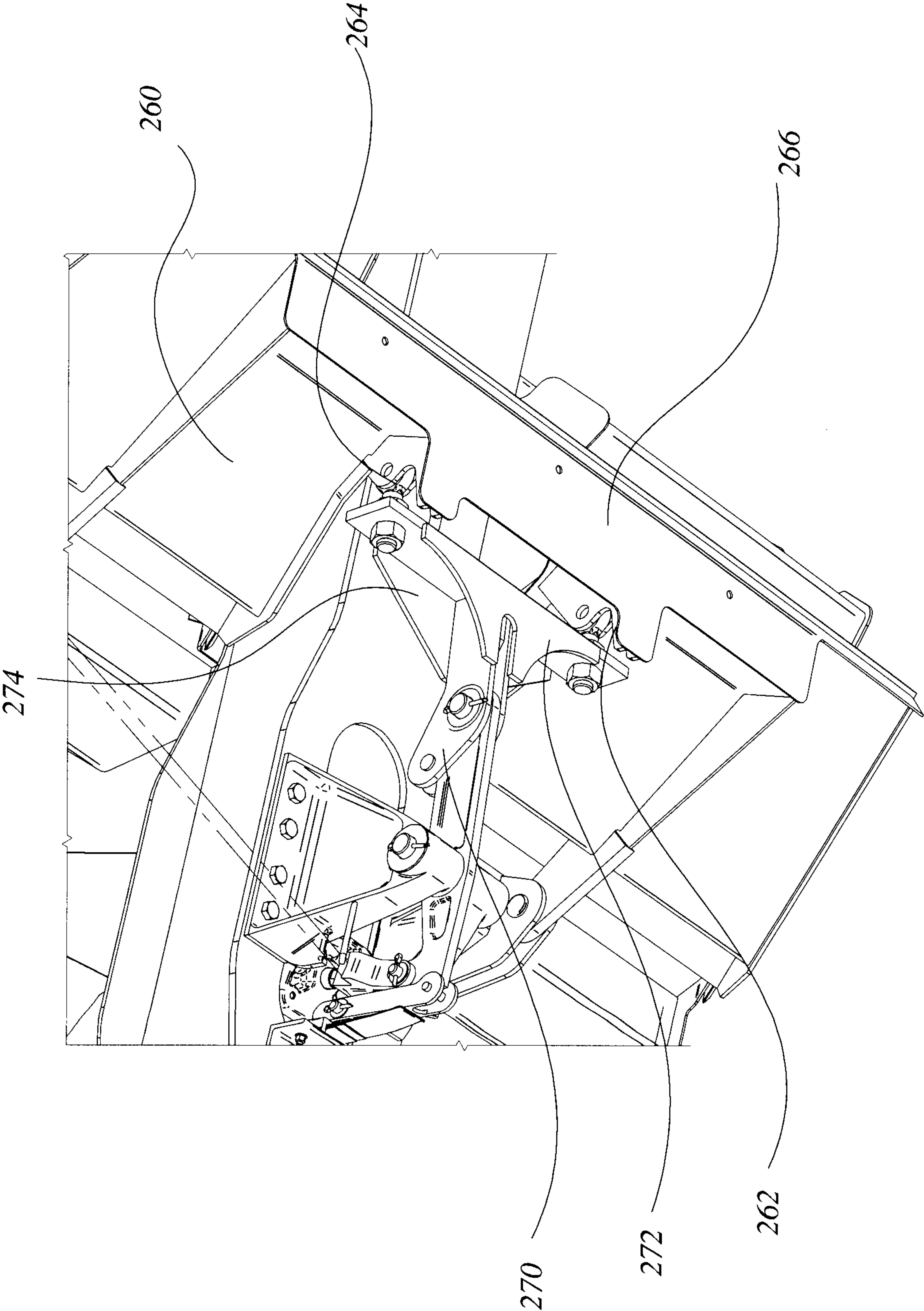


FIG. 7

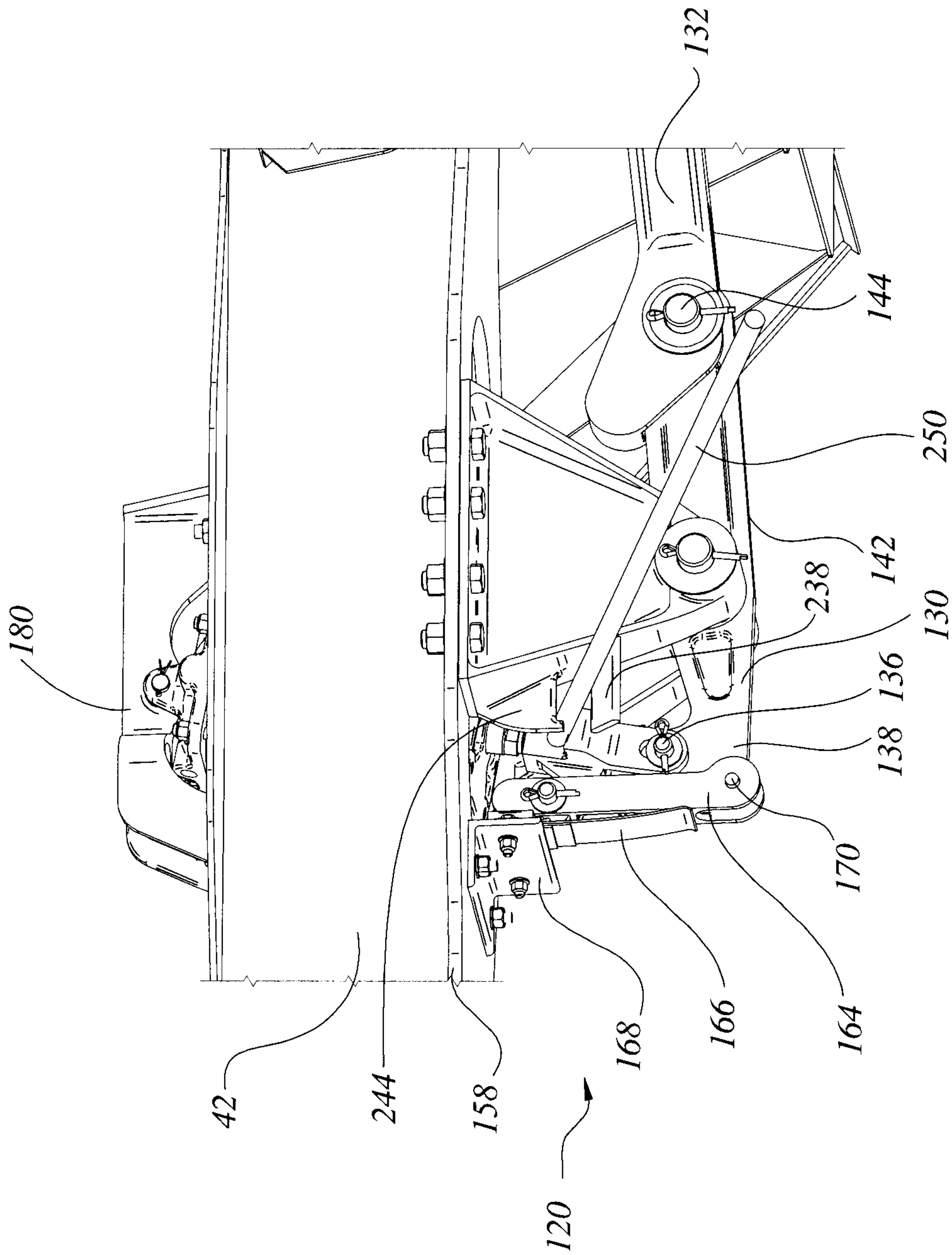


FIG. 8

