

- NOTE**
- UPHOLSTERY SHALL BE PASTED TO COMPRES PLYWOOD BASE WITH NON FLAMMABLE SOLVENT BASED ADHESIVE TO REF/IND/ SPEC.-003
 - TRIMS 9&13 TO BE WELDED TOGETHER.
 - METALIC NAME PLATE OF THE MANUFACTURER WITH YEAR OF MANUFACTURE TO BE NOT MORE THAN 2500 SHALL BE SCREWED AS SHOWN IN THE DRG.
 - COL-1&II WITH S.S FRAME FOR LUG COACHES.
 - COL-1&II WITH U.S FRAME FOR CONVENTIONAL COACHES.

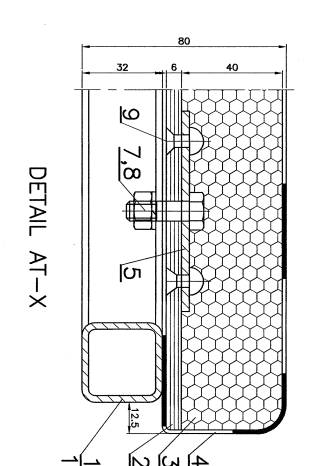
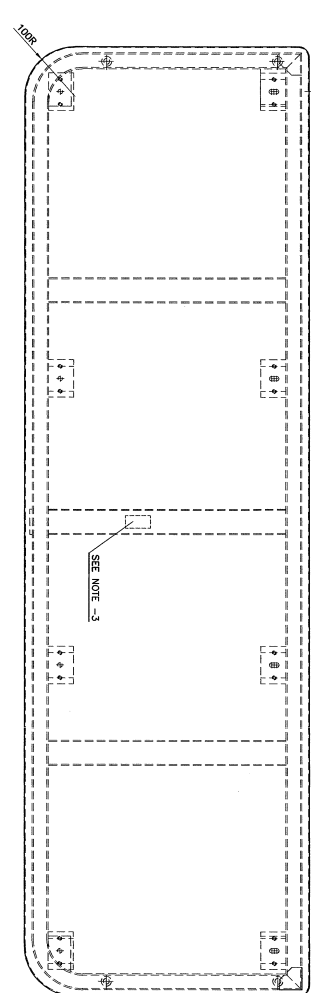
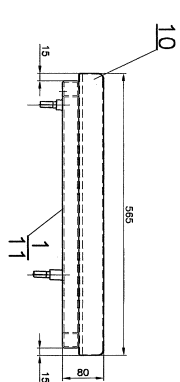
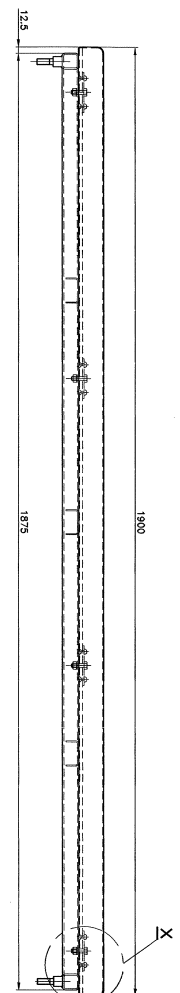
NO OF ASSEMBLERS REQUIRED PER COACH	TYPE OF COACH	QTY	SMO	SLR	LSRD
18	COL-I	18	12	4	14
18	COL-II	18	12	4	13
18	COL-III	18	12	4	14
18	COL-IV	18	12	4	13

NO	DESCRIPTION & DIMENSIONS	ITEM REF. DRWG	MAT. SPEC.	WEIGHT/JUNT	REMARKS
15	BACK REST FRAME (SINGLE)	6-1-300	COL-II		
14	BACK REST FRAME	6-1-300	COL-II		
13	FRONT PLATE	AS-104			
12	SPRING LOCK WASHER	18-12-4			
11	HEX. NUT	18-12-4			
10	HEX. HD SCREW	18-12-4			
9	UPHOLSTERY	RS57/RS58/RS59/RS60/RS61/RS62/RS63/RS64/RS65/RS66/RS67/RS68/RS69/RS70/RS71/RS72/RS73/RS74/RS75/RS76/RS77/RS78/RS79/RS80/RS81/RS82/RS83/RS84/RS85/RS86/RS87/RS88/RS89/RS90/RS91/RS92/RS93/RS94/RS95/RS96/RS97/RS98/RS99/RS100			
8	UPHOLSTERY	RS57/RS58/RS59/RS60/RS61/RS62/RS63/RS64/RS65/RS66/RS67/RS68/RS69/RS70/RS71/RS72/RS73/RS74/RS75/RS76/RS77/RS78/RS79/RS80/RS81/RS82/RS83/RS84/RS85/RS86/RS87/RS88/RS89/RS90/RS91/RS92/RS93/RS94/RS95/RS96/RS97/RS98/RS99/RS100			
7	CUSHION	RS50-2X607			
6	CUSHION	RS50-2X607			
5	COMPRES PLYWOOD	RS50-2X607			
4	COMPRES PLYWOOD	RS50-2X607			
3	BACK REST FRAME (SINGLE)	6-1-300	COL-II		
2	BACK REST FRAME	6-1-300	COL-II		
1	BACK REST FRAME	6-1-300	COL-II		

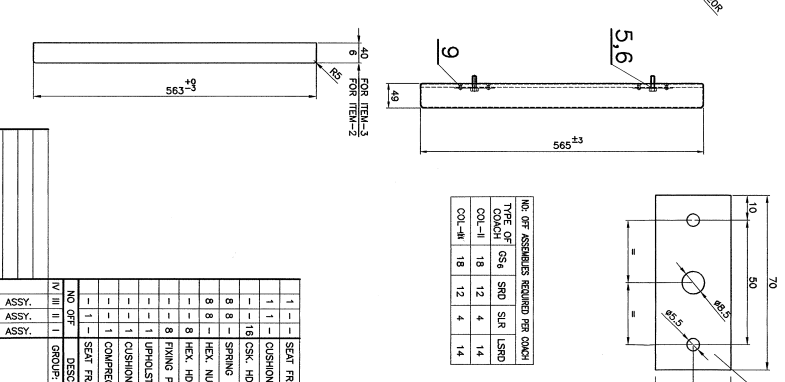
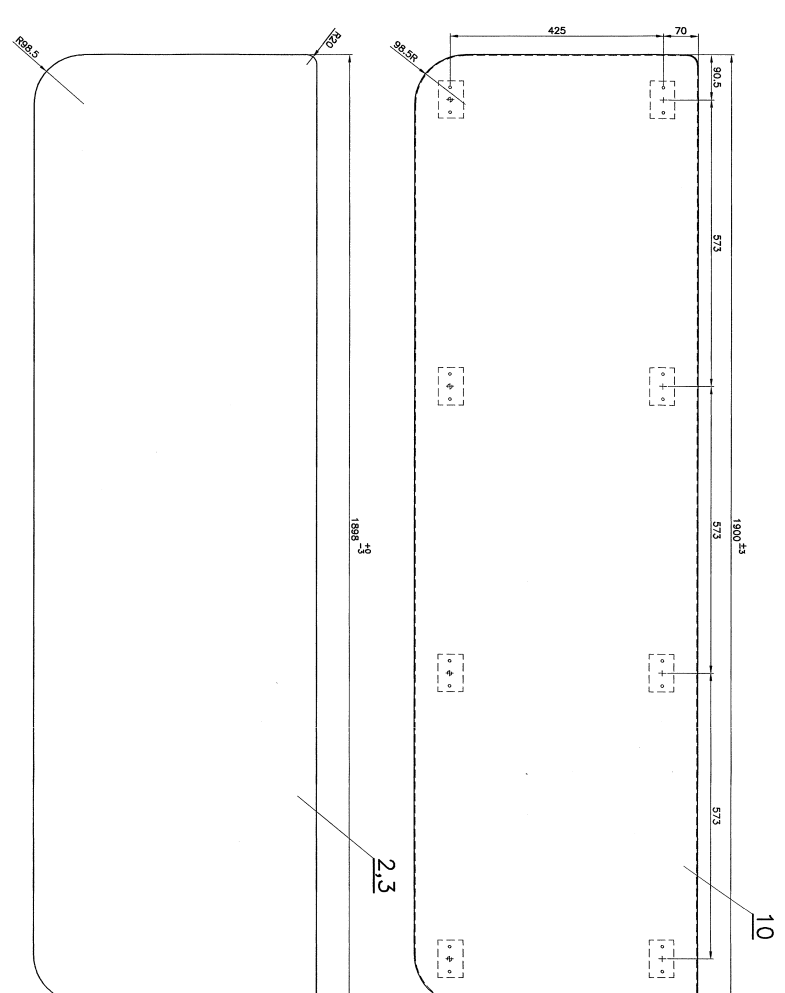
CUSHIONED BACK REST FOR FOUR SEATER & SINGLE SEAT

CAD FILE: VMC-CAD\2581\F-1\08-3000.DWG
 DATA CODE NO: 285
 INDIAN RAILWAY STANDARDS
 SHEET 1 OF 1
 GS 4-6-1-408
 INTERNAL CONTROL FACTORY CHURNAN, SR.

APPROVED BY: [Signature]
 DATE: 08/2009



DETAIL AT-X



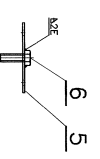
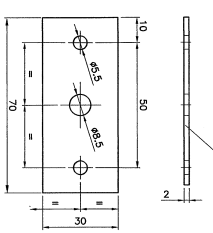
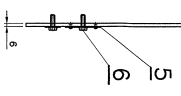
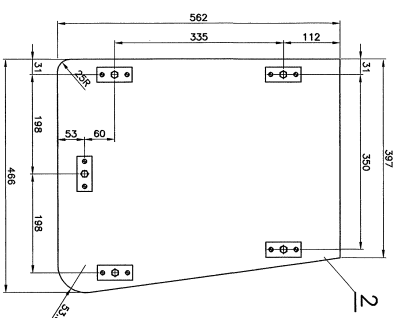
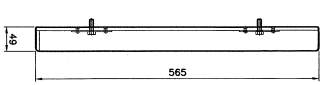
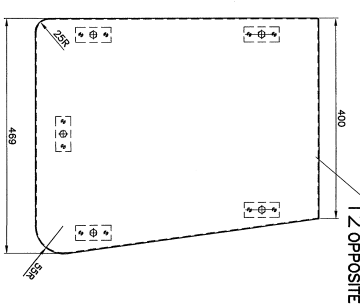
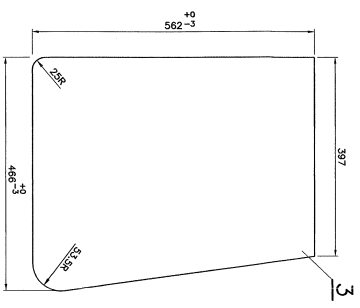
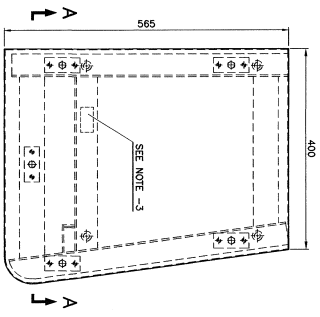
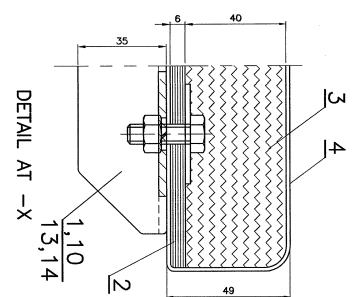
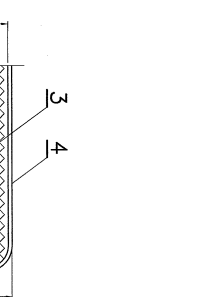
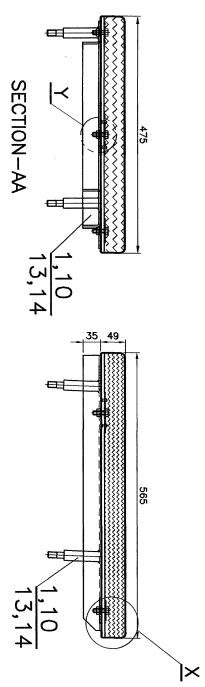
NO. OF ASSEMBLES REQUIRED PER COACH	NO. OF COACHES	NO. OF COACHES	NO. OF COACHES	NO. OF COACHES
11	12	13	14	15

- NOTE**
- UPHOLSTERY (ITEM 4) SHALL BE FASTENED TO CORRUGATED PLUMWOOD BASE WITH NON FLAMMABLE SOLVENT BASED ADHESIVE TO 67/AD/SPEC.093.
 - ITEMS 5&6 TO BE WELDED TOGETHER.
 - METALIC NAME PLATE OF THE MANUFACTURER WITH YEAR OF MANUFACTURE TO SIZE NOT MORE THAN 25x50 SHALL BE SCREWED AS SHOWN IN THE DRG.
 - COL-III WITH S.S FRAME FOR LHB COACHES.
 - COL-III WITH M.S FRAME FOR CONVENTIONAL COACHES.

ITEM NO.	DESCRIPTION	QTY	UNIT	REMARKS
1	SEAT FRAME	11	EA	COL-I
2	CUSHION COMPLETE	10	EA	COL-I
3	CSK. HD RIVET	9	EA	
4	SPRING LOCK WASHER	8	EA	
5	HEX. NUT	7	EA	
6	HEX. HD SCREW	6	EA	
7	FINING PLATE	5	EA	
8	UPHOLSTERY	4	EA	
9	CUSHION	3	EA	
10	CORRUGATED PLUMWOOD	2	EA	
11	SEAT FRAME	1	EA	
12	DESCRIPTION & DIMENSIONS	1	EA	

FOUR SEATER COMPLETE WITH CUSHION

GROUP	INDIAN RAILWAY STANDARDS
CODE NO.	285
DATE	10-03-07
REVISED BY	Y.S.
DATE	20-08-2009
SCALE	AS SHOWN



NO. OF ASSEMBLIES REQUIRED PER COACH	TYPE OF COACH	SHO	SUR	SLR	SLRD
9	COL-III	6	2	7	
9	COL-IV	6	2	7	
9	COL-V	6	2	7	
9	COL-VI	6	2	7	

NO. OF	DESCRIPTION & DIMENSIONS	ITEM REF. DRG.	MAT. ASPEC.	REMARKS
14	SEAT FRAME	6-1-303		COL-III
13	SEAT FRAME	6-1-303		COL-III
12	CUSHION COMPLETE	6-5-307		COL-III
11	CUSHION COMPLETE	6-5-307		COL-III
10	SEAT FRAME	6-1-303		COL-III
9	CSK. HD RIVET	SI740-17		
5	SPRING LOCK WASHER	SI156(15-14)		
5	HEX. NUT	SI136(13-14)		
5	HEX. HD SCREW	M&ZS-4/8		
5	FRING PLATE	2430/70		
4	UPHOLSTERY	600/670		
3	CUSHION	4046&452		
2	COMPREG PLYWOOD	6446&452		
1	SEAT FRAME	6-1-302		COL-IV

DATE	BY	DATE OF LATEST REV.	DATE OF REVISION	DATE OF ISSUE
10-05-07	10-05-07	10-05-07	10-05-07	10-05-07
26-08-2009	26-08-2009	26-08-2009	26-08-2009	26-08-2009

INDIAN RAILWAY STANDARDS	285	INDIAN RAILWAY STANDARDS	1 OF 1
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CS4-6-1-407	CS4-6-1-407
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