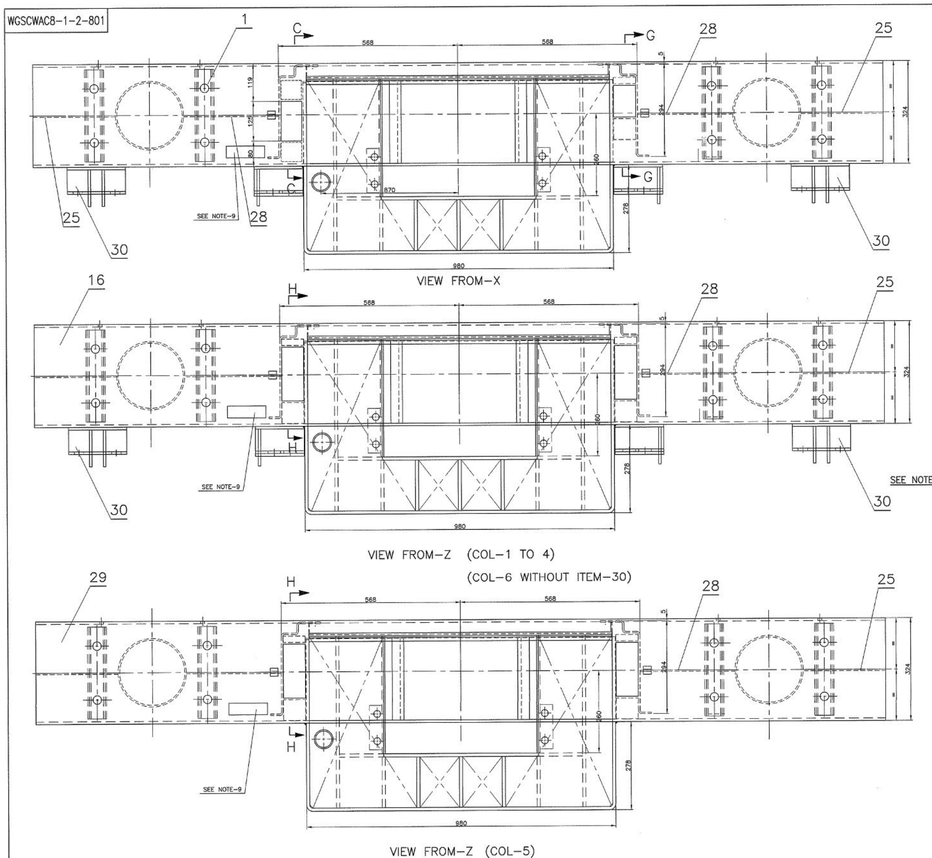
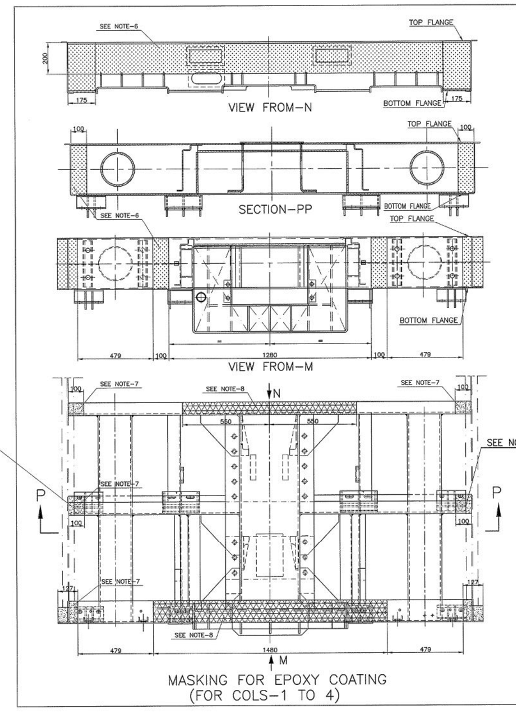
WGSCWAC8-1-2-801





MASKING FOR EPOXY COATING
(FOR COLS-1 TO 4)

▽	ROUGH MACHINED	(01) ROUGH CLEANING	
▽▽	FINISH MACHINED	(18) CHAMFERED	
▽▽▽	FINE FINISH MACHINED		

NOTE:-

1. ~~ITEM-3 TO BE MANUFACTURED IN SHELL AND SUPPLIED TO FUR DIVISION FOR WELDING IN THE COACH.~~
2. ITEMS-13,14&15 ARE TO BE WELDED AFTER WELDING THE ITEM-11&12.
3. COLS-3 & 4 ARE ALTERNATIVE DESIGN TO COLS-1 & 2
4. MACRO ETCH FOR FUSION OF FILLET WELD SHALL BE DONE ON RUNOUT PIECE AT RANDOM FOR ONE PERCENT OF BATCH PRODUCTION
5. FOR OUTSOURCED HEADSTOCK SUITABLE PLATE TREATMENT (OR) GRIT BLASTING (OR) SAND BLASTING (OR) PICKLING TO BE DONE AND EPOXY COATING TO RDSO/SPEC.NO. M&C/PCN/123/06 TO BE APPLIED TO A DFT OF MINIMUM 100 MICRONS.
6. THE AREA MARKED ▭ THUS, BOTH INNER AND OUTER SURFACES SHOULD NOT BE PAINTED WITH EPOXY COATING, IT SHOULD BE PAINTED WITH REDOXIDE ZINC CHROMATE PRIMER TO SPEC. IS:2074-92 TO A DFT OF MINIMUM 20 MICRONS WITH SMOOTH & MATT FINISH.
7. THE AREA MARKED ▭ THUS, TOP & BOTTOM FLANGE (BOTH INNER & OUTER SURFACE) SHOULD NOT BE PAINTED WITH EPOXY COATING, IT SHOULD BE PAINTED WITH REDOXIDE ZINC CHROMATE PRIMER TO SPEC. IS:2074-92 TO A DFT OF MINIMUM 20 MICRONS WITH SMOOTH & MATT FINISH.
8. THE AREA MARKED ▭ THUS, TOP FLANGE (INNER & OUTER SURFACES) SHOULD NOT BE PAINTED WITH EPOXY COATING,IT SHOULD BE PAINTED WITH REDOXIDE ZINC CHROMATE PRIMER TO SPEC. IS:2074-92 TO A DFT OF MINIMUM 20 MICRONS WITH SMOOTH & MATT FINISH.
9. MANUFACTURER'S NAME AND RUNNING SERIAL No. SHALL BE PUNCHED 1mm DEEP ON THE SPACE PROVIDED.
10. THIS SIDE OF BIOTOILET BRACKET TO BE WELDED AFTER WELDING OF HEADSTOCK WITH LONG. BEAM AT UNDERFRAME STAGE.
11. THE AREA MARKED ▭ THUS, BOTTOM FLANGE (BOTH INNER & OUTER SURFACE) SHOULD NOT BE PAINTED WITH EPOXY COATING, IT SHOULD BE PAINTED WITH REDOXIDE ZINC CHROMATE PRIMER TO SPEC. IS:2074-92 TO A DFT OF MINIMUM 20 MICRONS WITH SMOOTH & MATT FINISH.

ALTERATIONS

(d) 11/06
REMARKS COL. OF ITEMS-6, 20 & 23, ALTD FROM ITEM-7, 8&9 TO COL-IV ,V & VI RESPTLY. QTY. FOR ITEMS-14&15 IN COL-IV ALTD FROM 1 TO 2.
Sd/- SSE/D Sd/- SME/DSD

(e) 12/07
NOTE-5 ADDED.
Sd/- SSE/D Sd/- SME/DSD

(f) 05/2015
COL-5 & ITEM-29 ADDED.
Sd/- SSE/D Sd/- SME/DSD

(g) 11/2016
MASKING FOR EPOXY COATING, NOTE-6 TO 9 ADDED. DRG REVISED.
SSE/D SME/DSD

(h) 11/2016
ITEM-30,COL-6 & NOTE-10 ADDED. SECTIONS REVISED ACCORDLY. MASKING REVISED ACCORDLY.
Sd/- SSE/D Sd/- SME/DSD

(j) 12/2016
DESIGN OF ITEMS-6,7 & 18 TO 23 REVISED AS PER DETAIL. VIEWS REVISED ACCORDLY. MASKING FOR COLS-5&6 ADDED. DETAIL DIM. IN VIEWS X & Z DELETED. NOTE-11 ADDED.
SSE/D SME/DSD

QTY 6	5	4	3	2	1	DESCRIPTION & DIMENSION	ITEM	REF.DRGS	MAT.SPEC	WEIGHT/UNIT	REMARKS
–	–	1	1	1	1	MOUNTING BRACKETS FOR BIO TOILET SYSTEM	30	ICF/SK3 1-1-215			COL-4
–	1	–	–	–	–	OUTER HEADSTOCK COMPLETE	29	RAAC2 1-2-201			COL-1
2	2	2	2	2	2	RIB	28	ICF/STD 1-2-003			ITEM-11
2	2	2	2	2	2	GUSSET PLATE	27	T 1-2-524			ITEM-5
4	4	4	4	4	4	GUSSET PLATE	26	T 1-2-524			ITEM-4
2	2	2	2	2	2	RIB	25	ICF/STD 1-2-003			ITEM-10
1	1	1	1	–	–	CENTRE SILL ARRGT. COMPLETE	24	WGSCZAC5 1-2-518			
1	1	1	–	–	–	CHANNEL FOR LAV. CHUTE SUPPORT	23	WGSCWAC8 1-2-805			COL-6
1	1	1	–	–	–	CHANNEL FOR LAV. CHUTE SUPPORT	22	WGSCWAC8 1-2-805			COL-3
–	–	–	1	–	–	CHANNEL FOR LAV. CHUTE SUPPORT	21	WGSCWAC8 1-2-804			COL-4
–	–	–	1	–	–	CHANNEL FOR LAV. CHUTE SUPPORT	20	WGSCWAC8 1-2-805			COL-5
–	–	–	–	1	–	CHANNEL FOR LAV. CHUTE SUPPORT	19	WGSCWAC8 1-2-805			ITEM-1
–	–	–	–	1	–	CHANNEL FOR LAV. CHUTE SUPPORT	18	WGSCWAC8 1-2-805			COL-2
1	1	1	–	1	–	INNER HEADSTOCK BEAM	17	WGSCWAC8 1-2-804			COL-2
1	–	1	–	1	–	OUTER HEADSTOCK COMPLETE	16	WGSCWAC8 1-2-802			COL-2
2	2	2	1	1	1	PLATE	15	WGSCWAC8 1-2-805			ITEM-6
2	2	2	1	1	1	PLATE	14	WGSCWAC8 1-2-805			ITEM-5
–	–	–	2	–	2	PLATE	13	WGSCWAC8 1-2-805			ITEM-2
1	1	1	1	1	1	FLOOR STIFFENER	12	ICF/STD 1-2-003			COL-8
1	1	1	1	1	1	FLOOR STIFFENER	11	ICF/STD 1-2-003			COL-7
2	2	2	2	2	2	COLLAPASIBLE TUBE	10	WGSCZAC5 1-2-508			
2	2	2	2	2	2	COLLAPASIBLE TUBE	9	ICF/STD 1-2-003			COL-3
1	1	1	1	1	1	BUFFING CHANNEL	8	WGSCZAC5 1-2-506			ITEM-5
–	–	–	–	–	1	CHANNEL FOR LAV. CHUTE SUPPORT	7	WGSCWAC8 1-2-804			COL-3
–	–	–	–	–	1	CHANNEL FOR LAV. CHUTE SUPPORT	6	WGSCWAC8 1-2-805			COL-4
–	–	–	1	–	1	INNER HEAD STOCK BEAM	5	WGSCWAC8 1-2-804			COL-1
1	1	1	1	1	1	BUFFING CHANNEL	4	WGSCZAC5 1-2-506			ITEM-6
~~–~~	~~–~~	~~–~~	~~–~~	~~–~~	~~–~~	~~INLAY FOR LAV.CHUTE~~	3	F 1-2-009			
–	–	–	–	1	1	CENTRE SILL ARRGT. COMPLETE	2	WGSCZAC5 1-2-503			
–	–	–	1	–	1	OUTER HEADSTOCK COMPLETE	1	WGSCWAC8 1-2-802			COL-1
PER ASSY.	PER ASSY.	PER ASSY.	PER ASSY.	PER ASSY.	PER ASSY.	GROUP: 1-2					

$ COL-6 – HEAD STOCK ASSY WITHOUT BIOTOILET BRACKET

@ WGFSCWAC/J

ASSEMBLY DRAWINGS:
WGFSCWAC/J-1-1-001
WGFAC8-1-1-801
WGSCWAC8-1-1-801

Num. Alt.	DATE OF LATEST ALT	DATE OF FIRST ISSUE	AME/SME
0	16-12-2016	23-04-2013	

HEADSTOCK ARRGT. FOR CBC COUPLER

SUPERSEDED BY:
SUPERSEDES: WGSCWAC8-1-2-801, Alt: h/-

SCALE 1:10 1:5

SSE/D	
CHD	
ALTD	G.SURESH BABU
DRN	SHAIK MAHAMOOD

Alpha Alt:- j

INTEGRAL COACH FACTORY CHENNAI-38

DATA CODE NO. 291

INDIAN RAILWAY STANDARDS

SHEET 3 OF 3

WGSCWAC8-1-2-801

FORM:-IR.A1B-1260X600

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