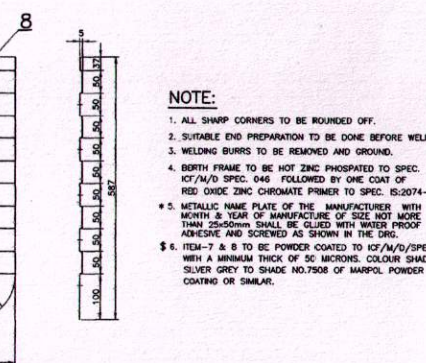
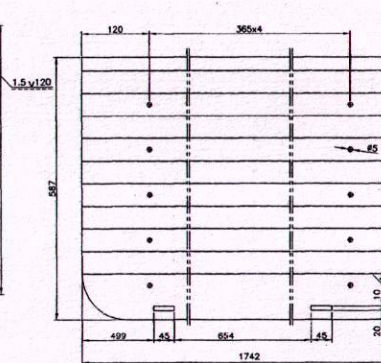
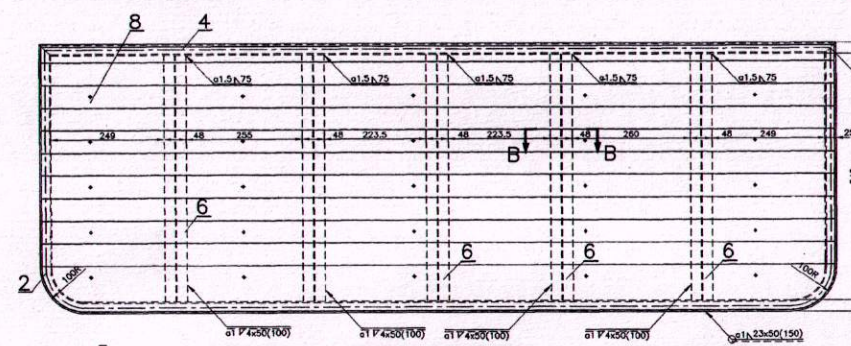
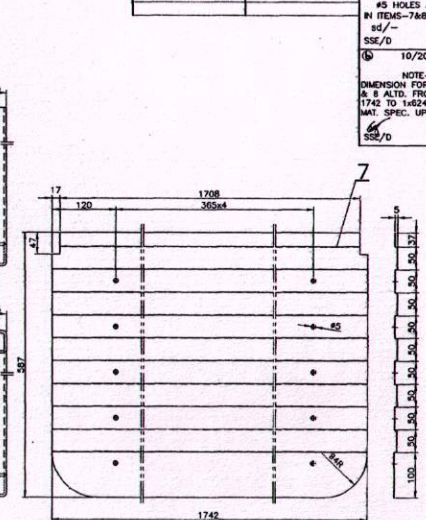
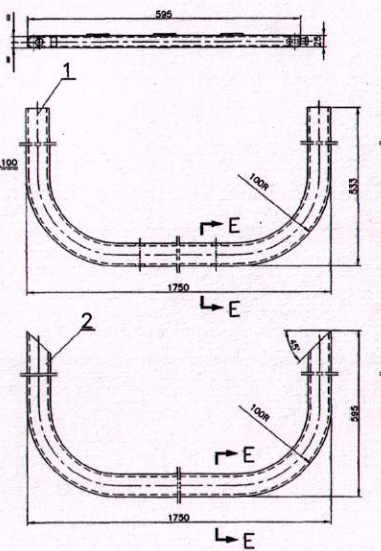
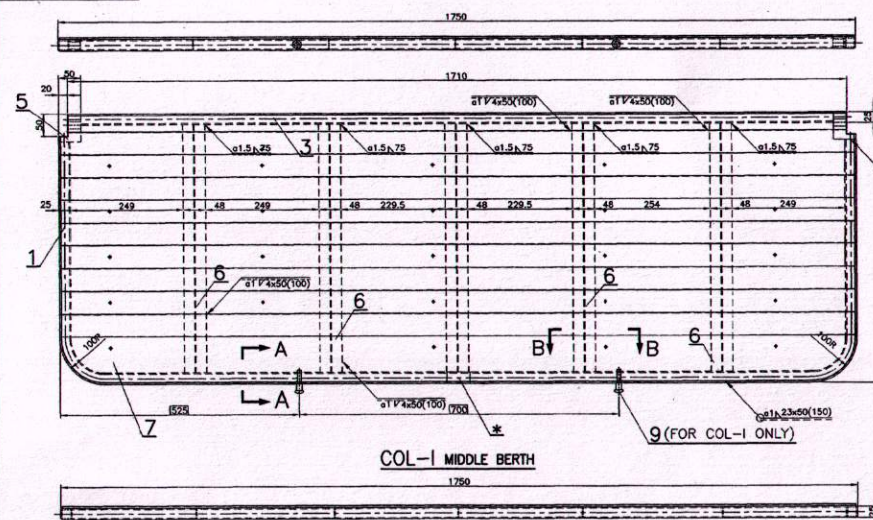
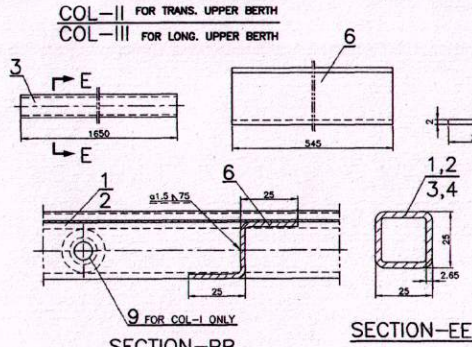
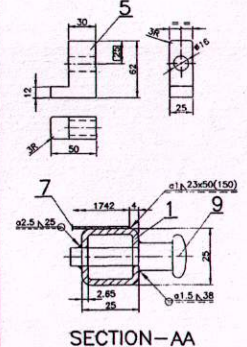


ICF/SK3-6-1-059

▽	ROUGH MACHINED	⑥	ROUGH CLEANING	ALTERATIONS	
▽▽	FINISH MACHINED			① 09/2014	
▽▽▽	FINE FINISH MACHINED			#5 HOLES ADDED IN ITEMS-7&8.	
				sd/-	SME/DSD
				SSE/D	SME/DSD
				② 10/2014	
				NOTE-6 ADDED DIMENSION FOR ITEMS-7 & 8 ALTD. FROM 1x624x1742 TO 1x624x1742 AND MAT. SPEC. UPDROUNDED.	
				SSE/D	SME/DSD



- NOTE:**
- ALL SHARP CORNERS TO BE ROUNDED OFF.
 - SUITABLE END PREPARATION TO BE DONE BEFORE WELDING.
 - WELDING BURRS TO BE REMOVED AND GROUND.
 - BERTH FRAME TO BE HOT ZINC PHOSPHATED TO SPEC. ICF/M/D SPEC. 046 FOLLOWED BY ONE COAT OF RED OXIDE ZINC CHROMATE PRIMER TO SPEC. IS:2074-92.
 - METALLIC NAME PLATE OF THE MANUFACTURER WITH MONTH & YEAR OF MANUFACTURE OF SIZE NOT MORE THAN 25x50mm SHALL BE GLED WITH WATER PROOF ADHESIVE AND SCREWED AS SHOWN IN THE DRG.
 - ITEM-7 & 8 TO BE POWDER COATED TO ICF/M/D/SPEC.-091 WITH A MINIMUM THICK OF 30 MICRONS. COLOUR SHADE SILVER GREY TO SHADE NO.7508 OF HARPOL POWDER COATING OR SIMILAR.



NO	OFF ASSYS.	REQD.	PER COACH
TYPE OF COACH	COL-I	COL-II	COL-III
SCN2	18	18	9
SILR2, SIRD	-	2	-

QTY	DESCRIPTION & DIMENSION	ITEM	REF.DRGS	MAT.SPEC	WEIGHT/UNIT	REMARKS
9	PIN #19x50				IS:2062-2011	
8	CORRUGATED SHEET 1x624x1742				IS:813-2008 CR1	\$
7	CORRUGATED SHEET 1x624x1742				IS:813-2008 CR1	\$
6	Z SECTION 2x67x545					
5	BEARING BLOCK 25x50x82				IS:2062-2011	
4	REAR TUBE 25x25x2.65x1750				IS:2062-2011	
3	REAR TUBE 25x25x2.65x1650				IS:2062-2011	
2	FRONT TUBE 25x25x2.65x2614				IS:2062-2011	
1	FRONT TUBE 25x25x2.65x2690				IS:2062-2011	

ICF/SK3-6-1-060
 ASSEMBLY DRAWINGS

PER. ASST.	PER. ASST.	DATE	INDIAN RAILWAY STANDARDS	SHEET
		14-10-2014		1 OF 1
		08-05-2012		