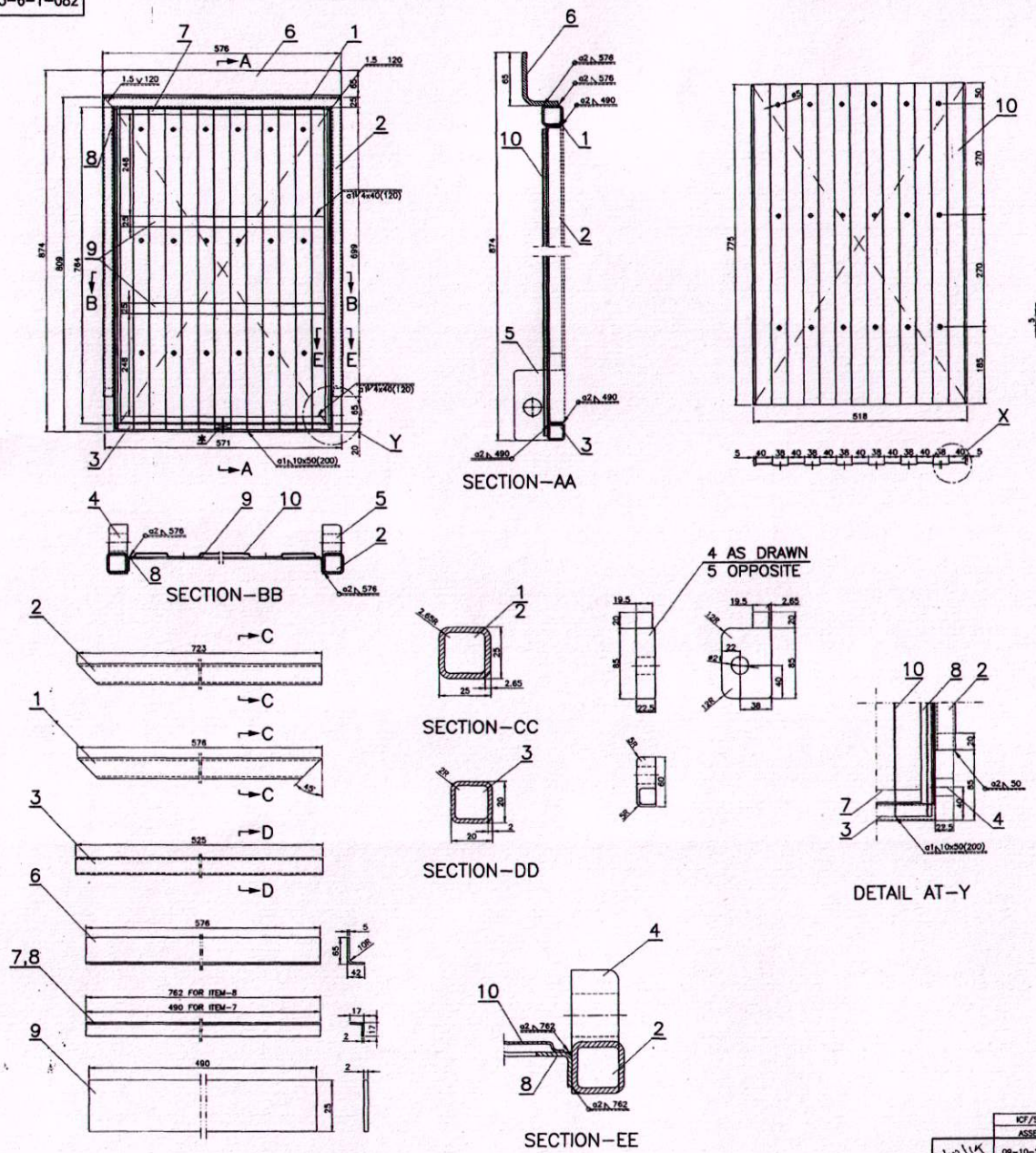
ICF/SK3-6-1-082

▽ ROUGH MACHINED	(R) ROUGH CLEANING	ALTERATIONS
▽▽ FINISH MACHINED		
▽▽▽ FINE FINISH MACHINED		



NOTE:

1. ALL SHARP CORNERS TO BE ROUNDED OFF.
2. SUITABLE END PREPARATION TO BE DONE BEFORE WELDING.
3. WELDING BURRS TO BE REMOVED AND GROUND.
4. BERTH FRAME TO BE HOT ZINC PHOSPATED TO SPEC. ICF/M/D SPEC. 046 FOLLOWED BY ONE COAT OF RED OXIDE ZINC CHROMATE PRIMER TO SPEC. IS:2074-92.

$ 5. ITEM-10 TO BE POWDER COATED TO ICF/M/D/SPEC.-091 WITH A MINIMUM THICK OF 50 MICRONS. COLOUR SHADE SILVER GREY TO SHADE NO.7508 OF MARPOL POWDER COATING OR SIMILAR.

* 6. METALLIC NAME PLATE OF THE MANUFACTURER WITH MONTH & YEAR OF MANUFACTURE OF SIZE NOT MORE THAN 25x50mm SHALL BE GLUED WITH WATER PROOF ADHESIVE AND SCREWED AS SHOWN IN THE DRG.

QTY	DESCRIPTION & DIMENSION	ITEM	REF.DRGS	MAT.SPEC	WEIGHT/UNIT	REMARKS
1	CORRUGATED SHEET 1x550x750	10		IS:513_2008 Gr.Cl1		$
2	FLAT 2x25x490	9		IS:513_2008 Gr.Cl1		
2	ANGLE 2x31x762	8		IS:513_2008 Gr.Cl1		
2	ANGLE 2x31x490	7		IS:513_2008 Gr.Cl1		
1	ANGLE 5x96x576	6		IS:513_2008 Gr.Cl1		
1	BEARING BLOCK 22.5x60x105	5		IS:2062-11 E 250 C		
1	BEARING BLOCK 22.5x60x105	4		IS:2062-11 E 250 C		
1	SQ. TUBE 20x20x2x525	3		IS:4923_97 HF SHS GR-YST-240		
2	SQ. TUBE 25x25x2.65x723	2		IS:4923_97 HF SHS GR-YST-240		
1	SQ. TUBE 25x25x2.65x576	1		IS:4923_97 HF SHS GR-YST-240		

2 1 GROUP: 6-1

SUPERSEDED BY:
SUPERSEDES:

PER ASSY.

FRAME FOR BACK REST

SCALE 1:5 1:2.5 1:1
SSE/D
CHD
ALTD
DRN S.KANNADASAN
Alpha Alt:- -

INTEGRAL COACH FACTORY CHENNAI-38

DATA CODE NO. 329

INDIAN RAILWAY STANDARDS

SHEET 1 OF 1

ICF/SK3-6-1-082

FORM:-IR.A1-840X600

ICF/SK3-6-1-081			
ASSEMBLY DRAWINGS			
09-10-2014			
DATE OF FIRST ISSUE	AME/SME	DATE OF LATEST ALT	0 Num. Alt.