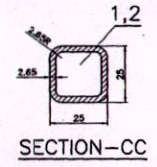
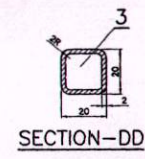
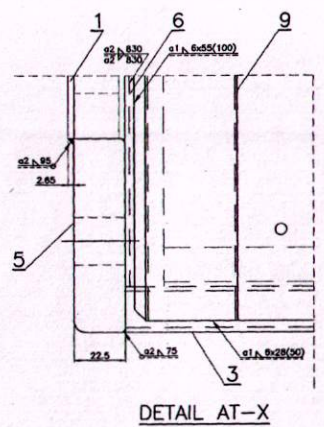
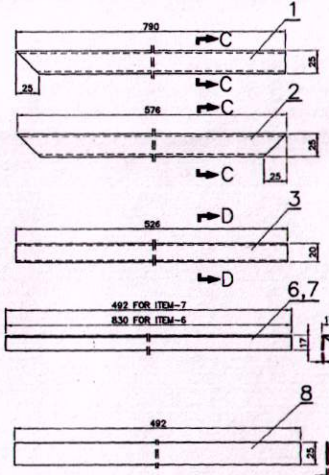
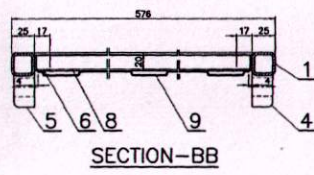
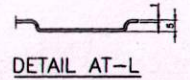
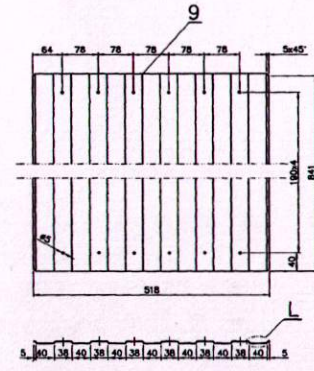
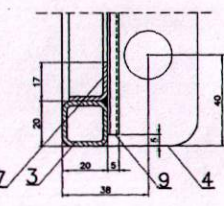
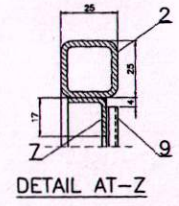
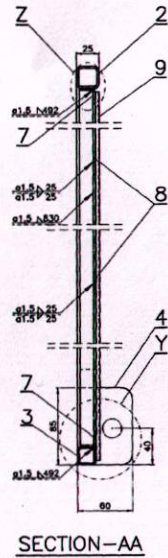
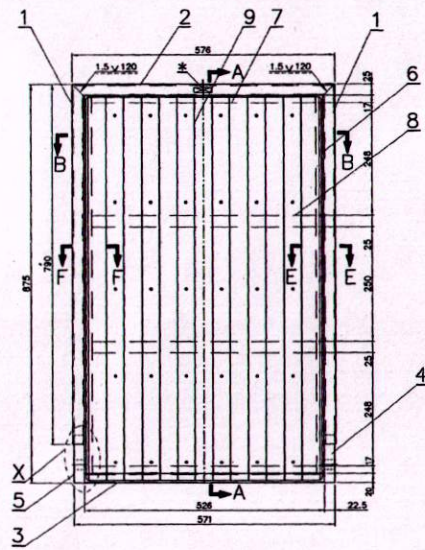


ICF/SK3-6-1-083

179 ROUGH MACHINED	61 ROUGH CLEANING	ALTERATIONS
177 FINE FINISH MACHINED		
1777 FINE FINISH MACHINED		



SECTION-FF

SECTION-EE

NOTE:

- ALL SHARP CORNERS TO BE ROUNDED OFF.
- SUITABLE END PREPARATION TO BE DONE BEFORE WELDING.
- WELDING BURRS TO BE REMOVED AND GROUNDED.
- 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:2074-82
- ITEM-9 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 MAPPOL POWDER COATINGS OR SIMILAR.
- METALLIC NAME PLATE OF THE MANUFACTURER WITH MONTH & YEAR OF MANUFACTURE OF SIZE NOT MORE THAN 25x50mm SHALL BE CLEED WITH WATER PROOF ADHESIVE AND SCREWED AS SHOWN IN THE DRG.

ITEM	DESCRIPTION & DIMENSION	ITEM	REF.DRGS	MAT.SPEC	WEIGHT/UNIT	REMARKS
1	CORRUGATED SHEET 1x550x841	9		IS 813-2008	67, 081	
2	FLAT 2x25x492	8		IS 813-2008	67, 081	
2	ANGLE 2x31x492	7		IS 813-2008	67, 081	
2	ANGLE 2x31x830	6		IS 813-2008	67, 081	
1	BEARING BLOCK 22.5x60x105	5		IS 5992-1 E 282 C		
1	BEARING BLOCK 22.5x60x105	4		IS 5992-1 E 282 C		
1	SQUARE TUBE 20x20x2x526	3		IS 4923-97 HP 816 T25-240		
1	SQUARE TUBE 25x25x2x65x576	2		IS 4923-97 HP 816 T25-240		
2	SQUARE TUBE 25x25x2x65x790	1		IS 4923-97 HP 816 T25-240		
OTY SUPERSEDED BY:						
1 GROUP: 6-1						

BACKREST FRAME

ICF/SK3-6-1-081
ASSEMBLY DRAWINGS
-10-2014

INDIAN RAILWAY
STANDARDS

INTEGRAL COACH FACTORY
CHENNAI-38
ICF/SK3-6-1-083