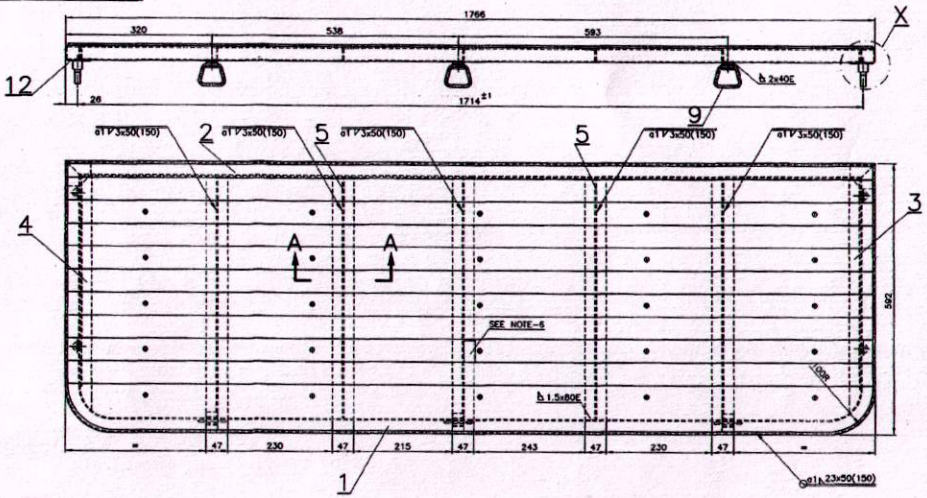
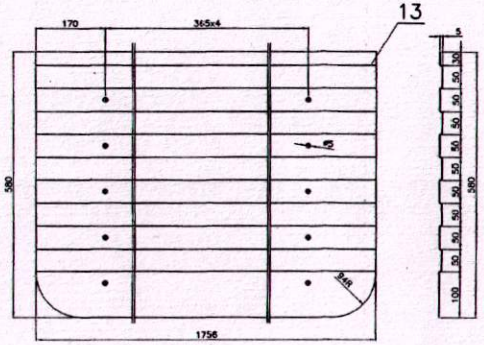
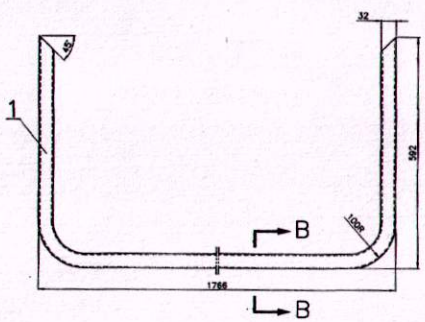
SCN6-6-1-603

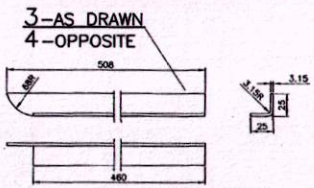
▽ ROUGH MACHINED	ROUGH CLEANING
▽▽ FINISH MACHINED	
▽▽▽ FINE FINISH MACHINED	

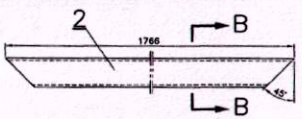
ALTERATIONS
(d) 08/2010
MAT. SPEC. UPDATED. PITCH DIM. FOR ITEM-9 ALTD. FROM 340,545,545 TO 320,538,593 RESPTLY. VIEWS CORRECTED ACCRDLY.
sd/- SSE/D
sd/- SME/DSD
(e) 09/2014
ITEM-13 ADDED IN LIEU OF COMPRED PLY LENGTH OF ITEMS-1,3,4& 5 ALTD. FROM 2800,515 515,530, TO 2794,508 508,528, RESPTLY. ITEMS 6,10 & 11 DELETED AND DRG. ALTD. ACCORDINGLY MAT. SPEC. UPDATED.
SSE/D
SME/DSD

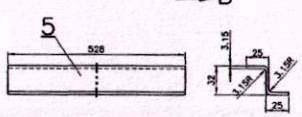


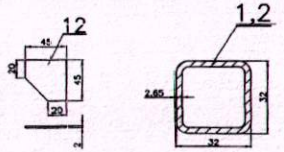




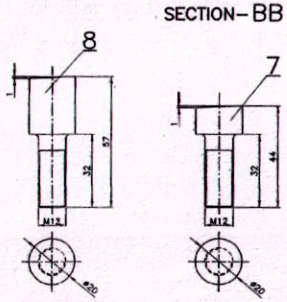






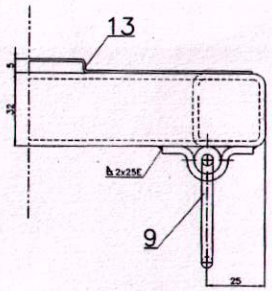


SECTION-BB

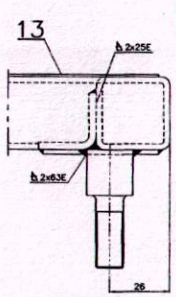


NOTE:

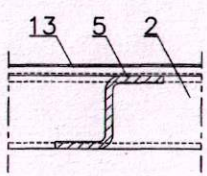
1. ALL SHARP CORNERS TO BE ROUNDED OFF..
2. SUITABLE CHAMFERING TO BE DONE BEFORE WELDING.
3. ~~DIMENSIONS MARKED ——— THUS TO BE ENSURED.~~
4. WELDING BURRS TO BE REMOVED AND GROUND.
5. BERTH FRAME TO BE HOT ZINC PHOSPATED TO SPEC. ICF/M/D SPEC. 046 FOLLOWED BY ONE COAT OF RED OXIDE ZINC CHROMATE PRIMER TO SPEC. IS:2074-92.
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.
7. $ ITEM-13 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.



DETAIL AT-Y



DETAIL AT-X



SECTION-AA

NO OFF ASSEMBLIES REQUIRED PER COACH

TYPE OF COACH	COL	COL-I			
SCN6		18			

NO.	NO.OFF	DESCRIPTION AND DIMENSIONS	ITEM	REF.DRG	MATL.&SPEC.	WEIGHT/UNIT	REMARKS
13	1	CORRUGATED SHEET 1x615x1760			IS:513-2008 CR-1		$
12	2	CORNER SUPPORT 2x45x45					
11	2	FIXING PLATE 3.15x67x87			IS:1079-2008 Gr.HR1		
10	2	FIXING PLATE 3.15x50x75					
9	3	RING BELOW SEAT		SCN6 6-1-519			
8	2	PIN ø20x57			IS:2062-2011 E 250 A		
7	2	PIN ø20x44			IS:2062-2011 E 250 A		
6	1	Z-SECTION 3.15x73x530					
5	5	Z-SECTION 3.15x70x528					
4	1	ANGLE 3.15x44x508			IS:1079-2009 Gr.HR1		
3	1	ANGLE 3.15x44x508					
2	1	REAR TUBE 32x32x2.65x1770			IS:4923-97 HF 345 Y28-240		
1	1	FRONT TUBE 32x32x2.65x2794			IS:4923-97 HF 345 Y28-240		

IV III II I PER ASSY

GROUP: 6-1 SEATS BERTHS

FRAME FOR TRANSVERSE SEAT

CAD FILE: C:\MD-CAD\201\6-1\603-SE00.DWG

DATA CODE NO: 201

INDIAN RAILWAY STANDARDS

SHEET 1 OF 1

SCN6-6-1-603

SUPERSEDED BY:	
SUPERSEDES: SCN6-6-1-603 ALT d/-	
SCALE	SSE/D
1:5	CHD
1:1	ALT
	CHD
ALT	e

S.KANNADASAN

O.K.Kabilan

INTEGRAL COACH FACTORY CHENNAI-38

ICF/SK3-6-1-079			
ASSEMBLY DRAWING			
25-09-2014	07-09-2002		
ALT	DATE OF LATEST ALTERATION	DATE OF FIRST ISSUE	SME/AME

FORM I.R. A1 840X600