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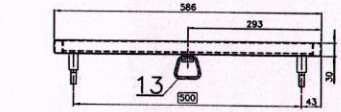
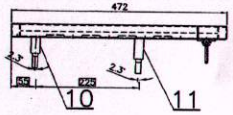
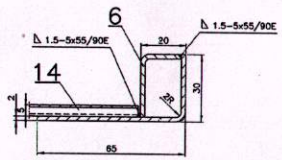
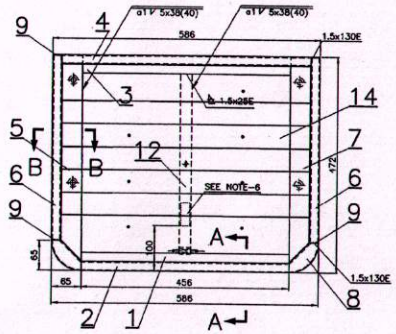
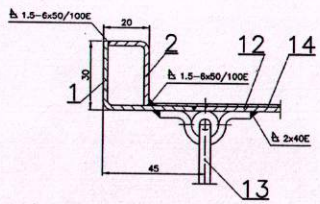






SECTION-BB





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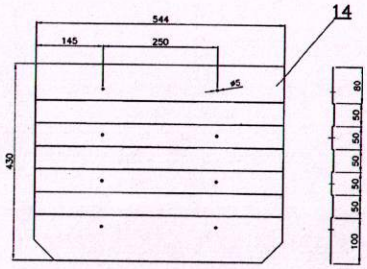
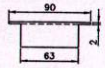
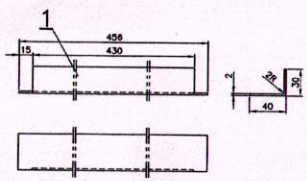
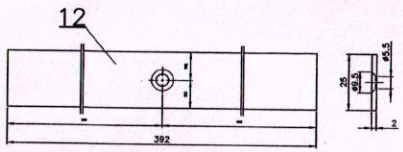
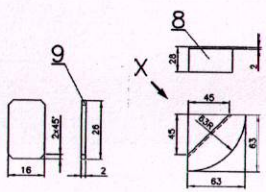


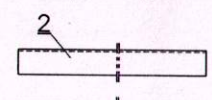


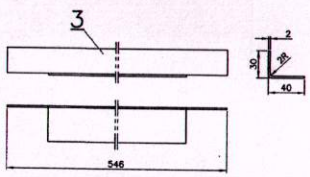
VIEW FROM-X

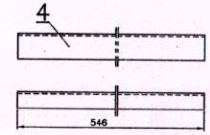


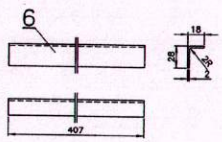


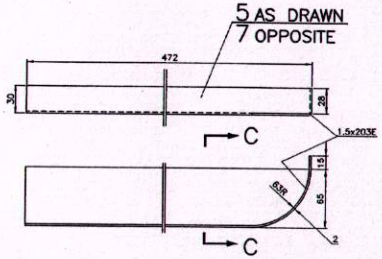


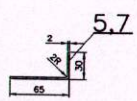




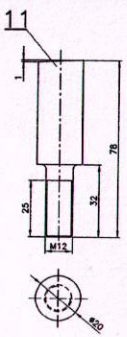


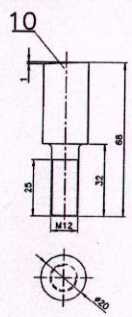






SECTION-CC





NOTE:

1. ALL SHARP CORNERS TO BE ROUNDED OFF..
2. SUITABLE CHAMFERING TO BE DONE AT SITE 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 & SCREWED HERE.
7. $ ITEM-14 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.

NO OFF ASSYs. REQD. PER COACH				
TYPE OF COACH \ COL	COL-I			
SCN6	18			
WGACCN	16			

NO.OFF	ITEM	DESCRIPTION AND DIMENSIONS	REF.DRG	MATL.&SPEC.	WEIGHT/UNIT	REMARKS
		GROUP: 6-1 SEATS BERTHS				SUPERSEDED BY:
						SUPERSEDES: SCN6-6-1-608 ALT d/-
1	1	CORRUGATED SHEET 1x448x544	SCN6 6-1-519	IS:513-2008 CR-4		$
1	13	RING BELOW SEAT				
1	12	FLAT 2x25x392		IS:513-2008 CR-4		
2	11	PIN ø20x78		IS:2062-2011 E 250 A		
2	10	PIN ø20x68		IS:2062-2011 E 250 A		
4	9	CLOSING PIECE 2x16x26				
2	8	CORNER ANGLE 2x55x69				
1	7	ANGLE 2x91x472				
2	6	ANGLE 2x42x407		IS:513-2008 CR-1		
1	5	ANGLE 2x91x472				
1	4	ANGLE 2x42x546				
1	3	ANGLE 2x66x546				
1	2	ANGLE 2x42x456				
1	1	ANGLE 2x66x456				

PER ASSY: IV III II I

FRAME FOR SINGLE SEAT

ICF/SK3-6-1-080 ASSEMBLY DRAWING

CAD FILE: C:\MD-CAD\201\6-1\609-SE00.DWG

SCALE	SSE/D	
1:5 1:1	CND	
	DRN	S.KANNADASAN
	CAD	Jayakumar & Kabilaraj
ALT	e	

INTEGRAL COACH FACTORY CHENNAI-38

DATA CODE NO: 201

INDIAN RAILWAY STANDARDS

SHEET 1 OF 1

SCN6-6-1-609

ALT	DATE OF LATEST ALTERATION	DATE OF FIRST ISSUE	Dy.CME/D	SME/DSD
	15-10-2014	21-11-2002		

FORM I.R. A1 840X600

ROUGH MACHINED	ROUGH CLEANING
FINISH MACHINED	
FINE FINISH MACHINED	

ALTERATIONS

(c) 08/2004
LOCATION OF STUD ALTD. FROM 230 TO 225
sd/- SSE/D sd/- SME/DSD

(d) 09/2014
CORRUGATED SHEET INTRODUCED IN LIEU OF COMPRED PLY LENGTH FOR ITEMS-1,2,3,4,5,6,7 & 12 ALTD. FROM 460,460,550,550,474,409,474 & 394 TO 456,456,546,546,472,407,472 & 392 RESPTLY DRG. ALTD. ACCORDINGLY MAT. SPEC. UPDATED.
sd/- SSE/D sd/- SME/DSD

(e) 10/2014
DIMENSION FOR ITEMS-5,6,7 & 9 ALTD. FROM 2x115x472,2x66x407 2x115x472 & 2x16x50 TO 2x91x472,2x42x407,2x91x 472 & 2x16x26 AND DRG ALTD. ACCORDINGLY
SSE/D SME/DSD