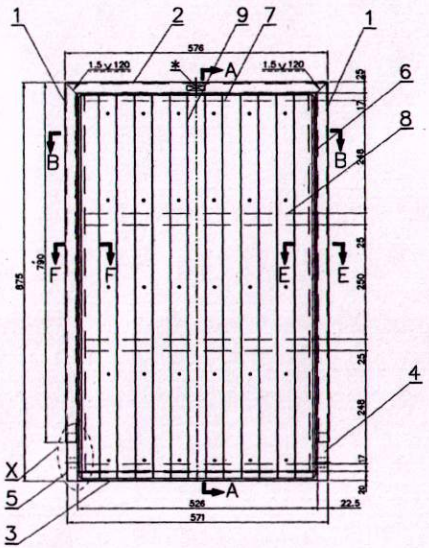
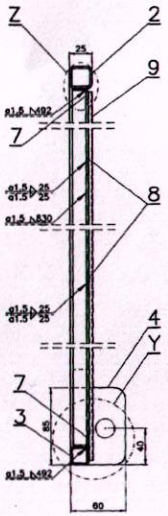
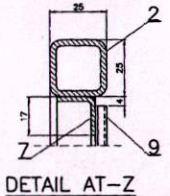
ICF/SK3-6-1-083

| ▽ ROUGH MACHINED | ROUGH CLEANING | ALTERATIONS |
|---|---|---|
| ▽▽ FINISH MACHINED | | |
| ▽▽▽FINE FINISH MACHINED | | |

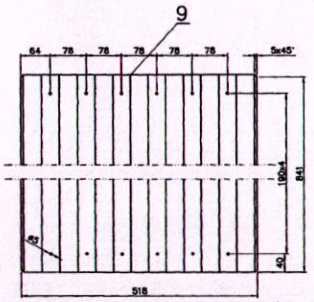


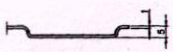


SECTION–AA

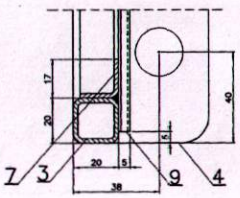


DETAIL AT–Z

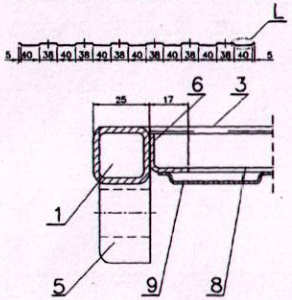




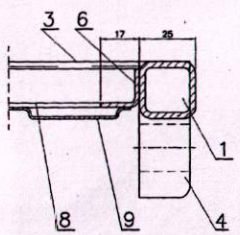
DETAIL AT–L



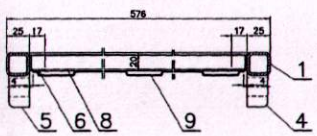
DETAIL AT–Y



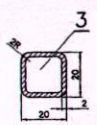
SECTION–FF



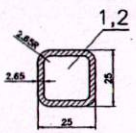
SECTION–EE



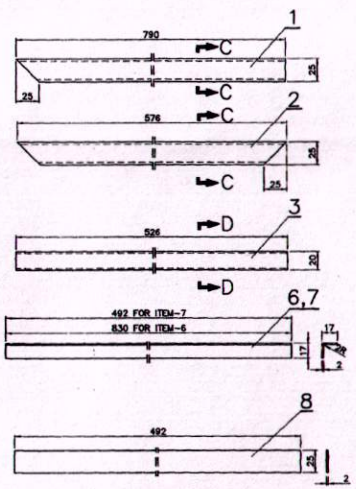
SECTION–BB

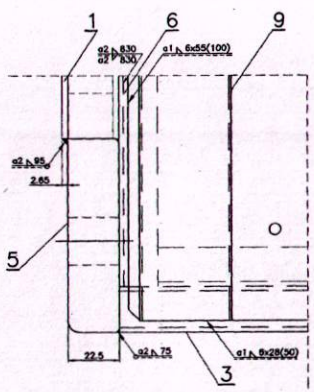


SECTION–DD

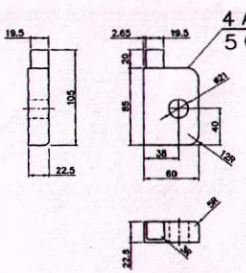


SECTION–CC





DETAIL AT–X



4 AS DRAWN
5 OPPOSITE

**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–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 MARPOL POWDER COATING OR SIMILAR.
6. METALLIC NAME PLATE OF THE MANUFACTURER WITH MONTH & YEAR OF MANUFACTURE OF SIZE NOT MORE THAN 225x50mm 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 1x550x841 | 9 | | IS:513–2008 Gr. CRI | | |
| 2 | FLAT 2x25x492 | 8 | | IS:513–2008 Gr. CRI | | |
| 2 | ANGLE 2x31x492 | 7 | | IS:513–2008 Gr. CRI | | |
| 2 | ANGLE 2x31x830 | 6 | | IS:513–2008 Gr. CRI | | |
| 1 | BEARING BLOCK 22.5x60x105 | 5 | | IS:3062–11 E 250 C | | |
| 1 | BEARING BLOCK 22.5x60x105 | 4 | | IS:3062–11 E 250 C | | |
| 1 | SQUARE TUBE 20x20x2x526 | 3 | | IS:4923–97 HF 345 YST–240 | | |
| 1 | SQUARE TUBE 25x25x2.65x576 | 2 | | IS:4923–97 HF 345 YST–240 | | |
| 2 | SQUARE TUBE 25x25x2.65x790 | 1 | | IS:4923–97 HF 345 YST–240 | | |

2 | 1 | GROUP: 6–1

FOR ASSY.

BACKREST FRAME

SUPERSEDED BY:
SUPERSEDES:
SCALE 1:5 1:2.5 1:1 | SSE/D | CHD | ALTD | DRN s.sivaselvakumar
Alpha Alt: –

INTEGRAL COACH FACTORY CHENNAI–38

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

| O Num. Alt. | DATE OF LATEST ALT | DATE OF FIRST ISSUE | AME/SME |
|---|---|---|---|

DATA CODE NO. 329

INDIAN RAILWAY STANDARDS

SHEET 1 OF 1

ICF/SK3–6–1–083

FORM: –IR.A1–840X600