SCN$_5$-6-1-505

④ 10/2001 QTY. FOR SLR$_2$ ADDED IN COL 5	③ 12/2000 QTY. FOR DETC/US ADDED IN COL 3	② 7/2000 QTY. FOR WCBAC$_6$ ADDED IN COL 5	DESCRIPTION OF JIG OR TOOL	JIG OR TOOL NO.	▽ ROUGH MACHINED ▽▽ FINISH MACHINED ▽▽▽ FINE FINISH MACHINED	⑤ ROUGH CLEANING
SSE/D SME/DSD	SSE/D SME/DSD	SSE/D SME/DSD				

ALTERATIONS

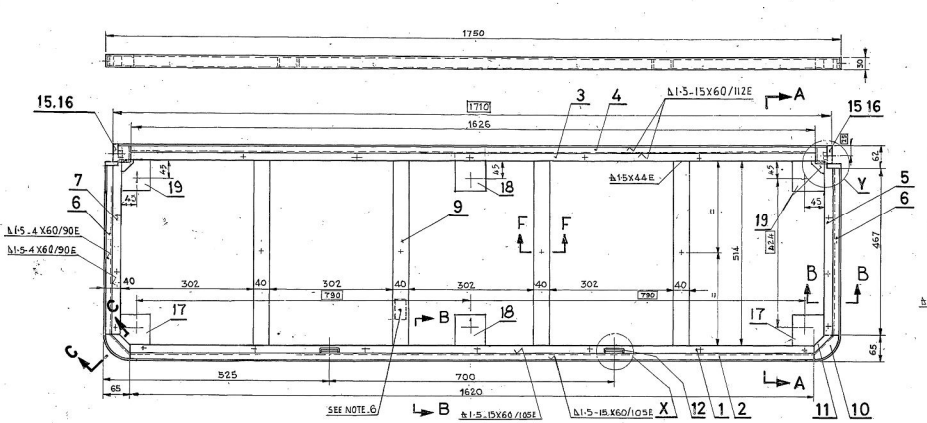
ⓐ 7/98
SECTION FF ADDED DIMENSION FOR ITEM 16 IN DETAIL AT 'Y' ALTD FROM 457050.
SSE/D SME/DSD

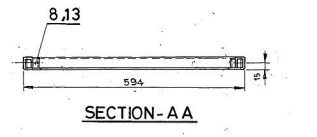
ⓑ 3/2000
NOTE. 6 ADDED.
SSE/D SME/DSD

ⓒ 4/2000
MAT. SPEC. UPDATED.
SSE/D SME/DSD

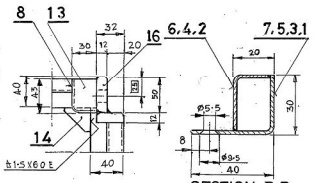
ⓓ 01/01
ITEMS 17,18,19 AND COL 11 ADDED FOR MODULAR BERTH. WITH ASSY. DRG. NO ICF/SK-6-1-373
SSE/D SME/DSD

ⓔ 04/02
HOLE PITCH FOR ITEM-3 ALTD FROM 36 & 269 x 6 = 1614 TO 57 & 250 x 6 = 1500 AND MAT. SPEC. UPDATED.
SSE/D SME/D



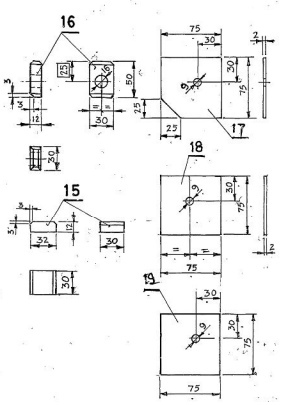


SECTION-AA



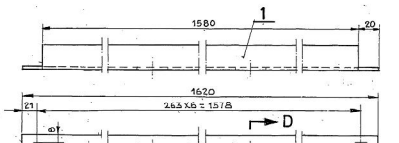
DETAIL AT Y

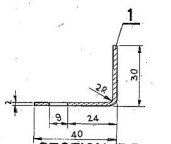
SECTION B B



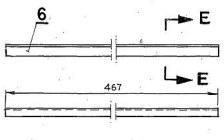
NOTE

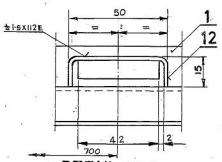
1. FRAME TO BE SUPPLIED IN PRIMED CONDITION (ie) WITH ONE COAT OF RED OXIDE ZINC CHROMATE PRIMER TO SPEC. IS: 2074-62
2. ALL SHARP CORNERS TO BE ROUNDED OFF
3. DIMENSIONS ENCLOSED BY RECTANGLES TO BE ENSURED BY USE OF JIG.
4. SUITABLE CHAMFERING TO BE PROVIDED FOR WELDING IN ALL ITEMS.
5. WELDING BURRS TO BE REMOVED AND GROUND.
6. METALIC NAME PLATE OF THE MANUFACTURER WITH MONTH & YEAR OF MANUFACTURE OF SIZE NOT MORE THAN 25 X 50 SHALL BE RIVETED AS SHOWN IN THE DRG.



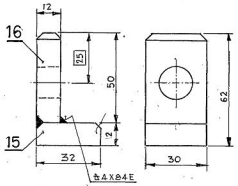


SECTION-DD

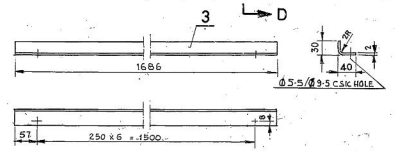


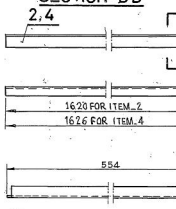


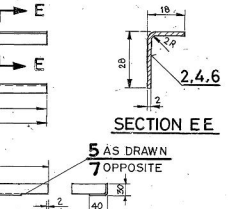
DETAIL AT-X



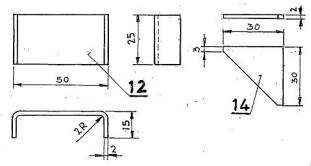
ASSEMBLY OF BEARING BLOCK





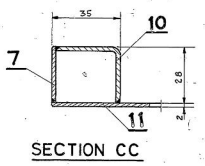


SECTION E E

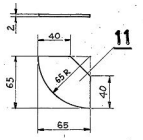


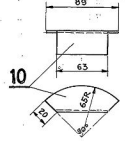
COL-II MODULAR BERTH

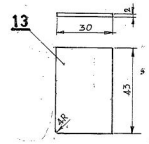
NO OFF ASSYS REQUIRED PER COACH				
TYPE OF COACH	I	II	III	IV
SCN	45	45		
WCBAC$_6$	15			
DETC/US	3			
SLR$_2$	2			

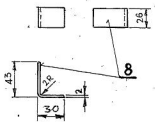


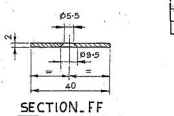
SECTION CC











SECTION FF

NO. OFF	DESCRIPTION & DIMENSION.	ITEM	REF. DRG	MAT-SPEC.	REMARKS.
	GROUP:-6.1. SEATS AND BERTHS			SUPERSEDED BY	
				SUPERSEDES:-	
2	- FLAT 2 X 75 X 75	19			
2	- FLAT 2 X 75 X 75	18		IS:513-94 Gr. D-SK	
2	- FLAT 2 X 75 X 75	17			
2 2	BEARING BLOCK 12 X 30 X 50	16		IS:2062-99 Fe.410.WA	
2 2	BEARING BLOCK 12 X 30 X 32	15		IS:2062-99 Fe.410.WA	
– 2	SUPPORT 2 X 30 X 50	14			
2 2	CLOSING PIECE 2 X 30 X 45	13			
2 2	CHANNEL 2 X 25 X 72	12			
2 2	CORNER PIECE 2 X 65 X 65	11			
2 2	CORNER ANGLE 2 X 56 X 88	10			
4 4	FLAT 2 X 40 X 514	9		IS:513-94 Gr. D-SK	
2 2	ANGLE 2 X 26 X 63	8			
1 1	ANGLE 2 X 66 X 609	7			
2 2	ANGLE 2 X 42 X 467	6			
1 1	ANGLE 2 X 66 X 609	5			
1 1	ANGLE 2 X 42 X 1626	4			
1 1	ANGLE 2 X 66 X 1686	3			
1 1	ANGLE 2 X 42 X 1620	2			
1 1	ANGLE 2 X 66 X 1620	1			

IV	III	II	I
PER ASSY	PER ASSY	PER ASSY	

ICF/SK-6-1-373
SCN-6-1-504
ASSEMBLY DRAWINGS

FRAME FOR TRANSVERSE MIDDLE UPPER & LONG. UPPER BERTH

DATA CODE NO 171

INDIAN RAILWAY STANDARDS

SCALE 1:5 1:2·5 1:1

SD	
CHD	
DRN	
TRD	

ALT a b c d e

INTEGRAL COACH FACTORY MADRAS.38.

SCN$_5$-6-1-505

FORM IR A1a. 600X1050.

4	3	2	ALT	DATE	SME/DSD	AME/D