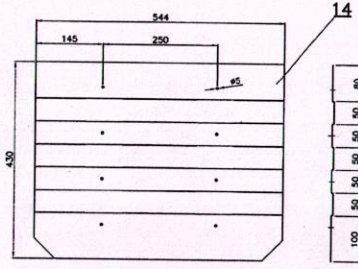
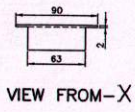
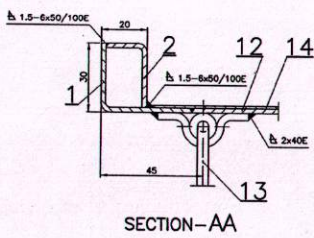
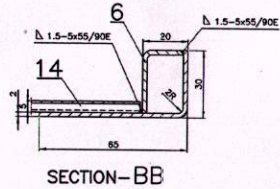
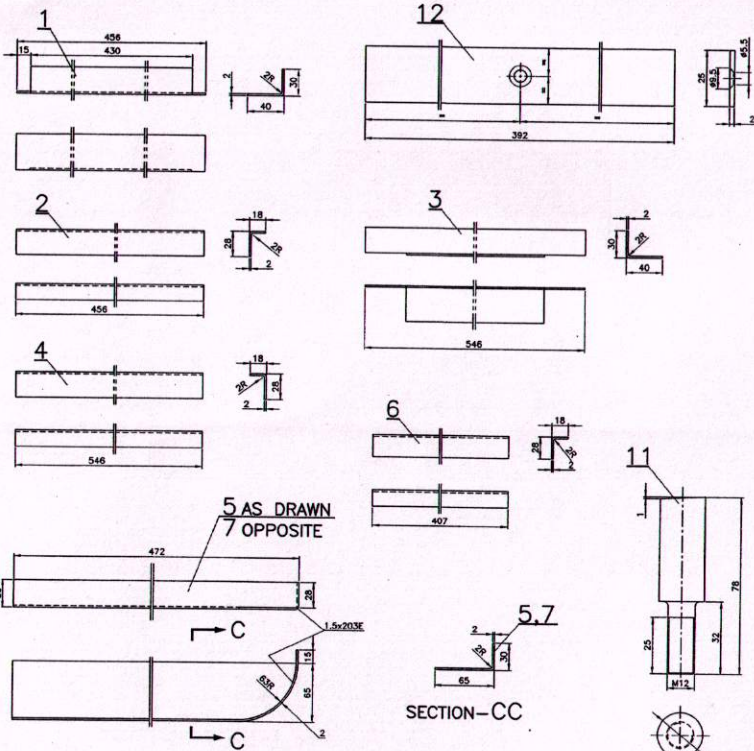
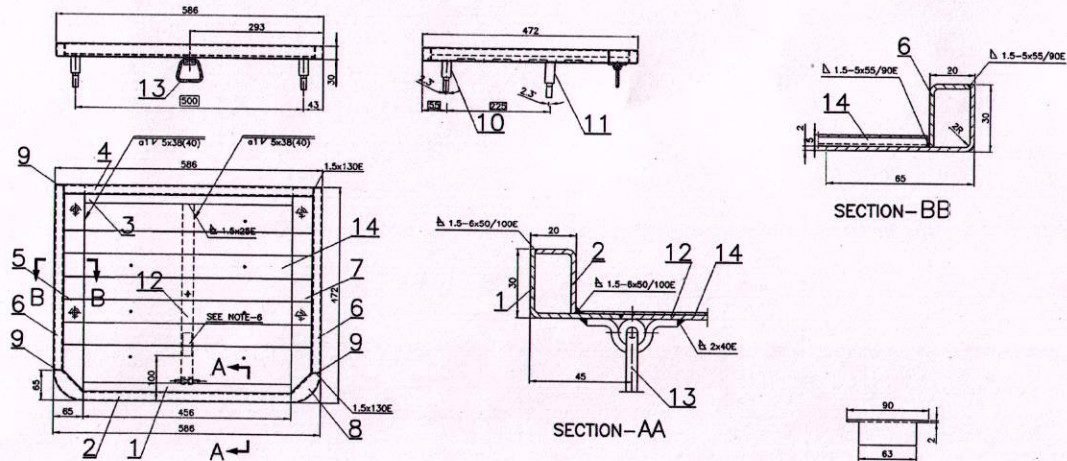


SCN6-6-1-609



**NOTE:**

- ALL SHARP CORNERS TO BE ROUNDED OFF.
- SUITABLE CHAMFERING TO BE DONE AT SITE BEFORE WELDING.
- DIMENSIONS MARKED  $\square$  THIS TO BE ENSURED.
- WELDING BURRS TO BE REMOVED AND GROUND.
- 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:2074-92.
- 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.
- 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-1
SCN No	18
WGACCN	16

NO	DESCRIPTION AND DIMENSIONS	ITEM	REF.DRG	MATL.&SPEC.	WEIGHT/LMT	REMARKS
1	CORRUGATED SHEET	1x448x544	4	IS:513-2008 CR-1		\$
1	RING BELOW SEAT		3	SCNG 6-1-819		
1	FLAT	2x25x382	2	IS:513-2008 CR-1		
2	PIN	#20x78	1	IS:2092-2011 E 280 A		
2	PIN	#20x68	1	IS:2092-2011 E 280 A		
4	CLOSING PIECE	2x18x26	9			
2	CORNER ANGLE	2x55x69	8			
1	ANGLE	2x91x472	7			
2	ANGLE	2x42x407	6			
1	ANGLE	2x91x472	5	IS:513-2008 CR-1		
1	ANGLE	2x42x546	4			
1	ANGLE	2x66x546	3			
1	ANGLE	2x42x456	2			
1	ANGLE	2x66x456	1			

NO OFF	DESCRIPTION AND DIMENSIONS	ITEM	REF.DRG	MATL.&SPEC.	WEIGHT/LMT	REMARKS
	GROUP: 6-1 SEATS BERTHS					

INDIAN RAILWAY STANDARDS

SCN6-6-1-609

FORM LR. A1 8402690

ROUGH MACHINED	ROUGH CLEANING	ALTERATIONS
✓	0	06/2004
✓	✓	LOCATION OF STUD ALTD. FROM 230 TO 225
✓	✓	09/2014
sd/-	sd/-	
SSE/D	SME/DSD	
0	10/2014	
0	10/2014	
sd/-	sd/-	
SSE/D	SME/DSD	
0	10/2014	
0	10/2014	
sd/-	sd/-	
SSE/D	SME/DSD	

15-10-2014	21-11-2002	
ALT	ONE OF LAST REVISION	ONE OF FIRST ISSUE
	Dy.CME/D	SME/DSD

ICF/SK3-6-1-090
ASSEMBLY DRAWING
CAD FILE: C:\MID-CAD\2014-1\609-SE00.DWG
DATA CODE NO: 201

NO. OF SHEETS	1
PER ASSY	1
SUPERSEDED BY:	SCN6-6-1-609 ALT 1
SCALE	1:1
CHKD	SKM/MSD
DRN	SKM/MSD
CAD	SKM/MSD
ALT	SKM/MSD
INTERNAL COACH FACTORY	CHENNAI-38
SHEET	1 OF 1