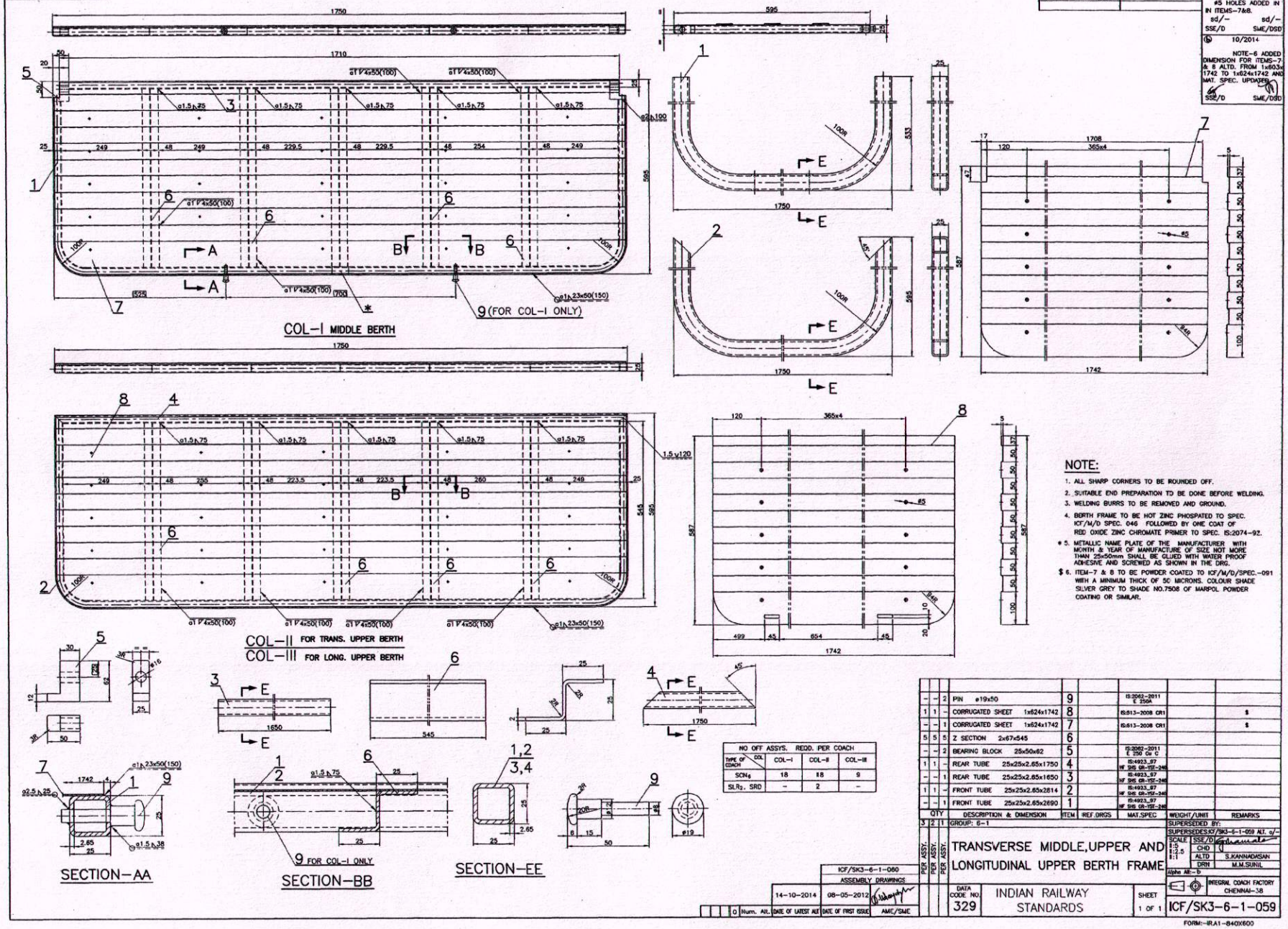
ICF/SK3-6-1-059

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

ALTERATIONS

ⓐ 09/2014
#5 HOLES ADDED IN IN ITEMS-7&8.
sd/- SSE/D sd/- SME/DSD

ⓑ 10/2014
NOTE-6 ADDED DIMENSION FOR ITEMS-7 & 8 ALTD. FROM 1x603x1742 TO 1x624x1742 AND MAT. SPEC. UPDATED
SSE/D SME/DSD



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. 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.

$ 6. ITEM-7 & 8 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	COL-II	COL-III
SCN_6	18	18	9
SLR_2, SRD	-	2	-

QTY			DESCRIPTION & DIMENSION	ITEM	REF.DRGS	MAT.SPEC	WEIGHT/UNIT	REMARKS
-	-	2	PIN ø19x50	9		IS:2062-2011 E 250A		
1	1	-	CORRUGATED SHEET 1x624x1742	8		IS:513-2008 CR1		$
-	-	1	CORRUGATED SHEET 1x624x1742	7		IS:513-2008 CR1		$
5	5	5	Z SECTION 2x67x545	6				
-	-	2	BEARING BLOCK 25x50x62	5		IS:2062-2011 E 250 Cu C		
1	1	-	REAR TUBE 25x25x2.65x1750	4		IS:4923_97 HF SHS GR-YST-240		
-	-	1	REAR TUBE 25x25x2.65x1650	3		IS:4923_97 HF SHS GR-YST-240		
1	1	-	FRONT TUBE 25x25x2.65x2814	2		IS:4923_97 HF SHS GR-YST-240		
-	-	1	FRONT TUBE 25x25x2.65x2690	1		IS:4923_97 HF SHS GR-YST-240		

3 2 1 GROUP: 6-1

PER ASSY. PER ASSY. PER ASSY.

TRANSVERSE MIDDLE, UPPER AND LONGITUDINAL UPPER BERTH FRAME

SUPERSEDED BY:
SUPERSEDES: ICF/SK3-6-1-059 ALT. a/-

SCALE		
1:5 / 1:2.5 / 1:1	SSE/D	
	CHD	
	ALTD	S.KANNADASAN
	DRN	M.M.SUNIL

Alpha Alt:- b

INTEGRAL COACH FACTORY CHENNAI-38

DATA CODE NO. 329 — INDIAN RAILWAY STANDARDS — SHEET 1 OF 1

ICF/SK3-6-1-059

ICF/SK3-6-1-060
ASSEMBLY DRAWINGS

Num. Alt.	DATE OF LATEST ALT	DATE OF FIRST ISSUE	AME/SME
0	14-10-2014	08-05-2012	

FORM:-IR.A1-840X600