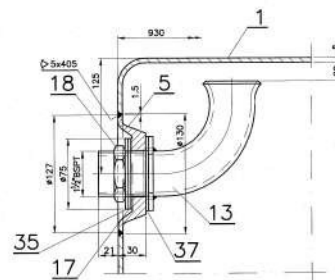
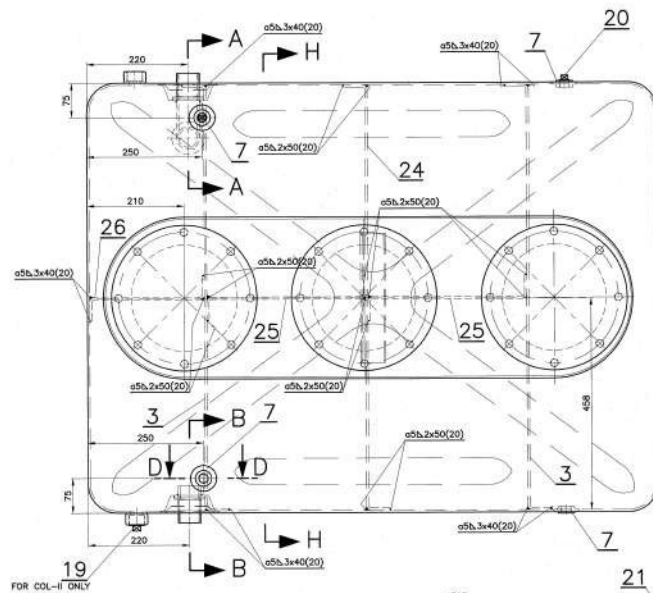
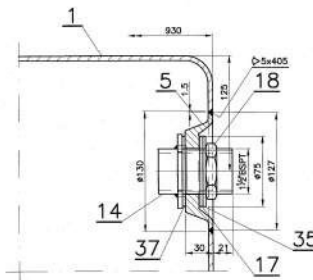


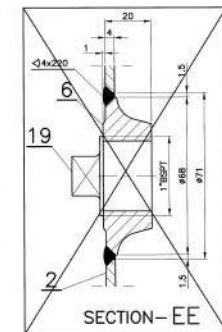
SECTION-HH



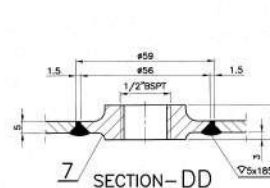
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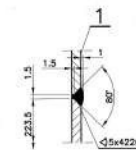
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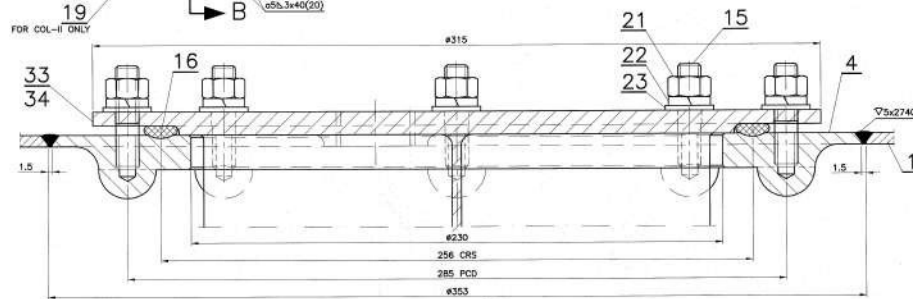
SECTION-EE



SECTION-DD

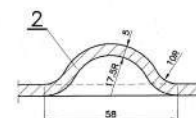
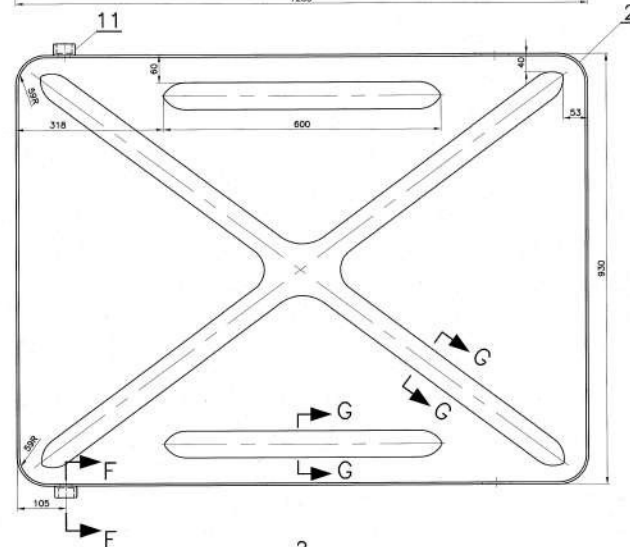
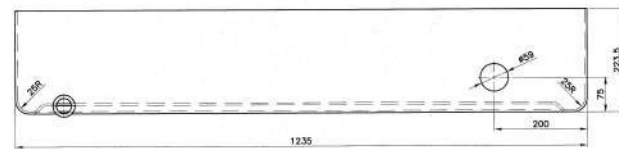
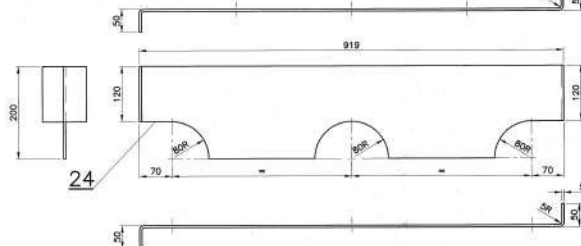
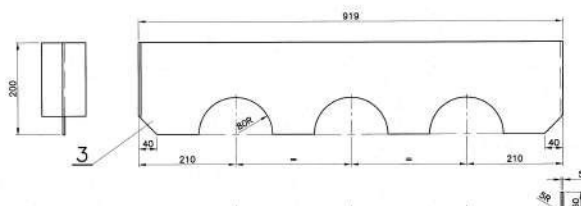
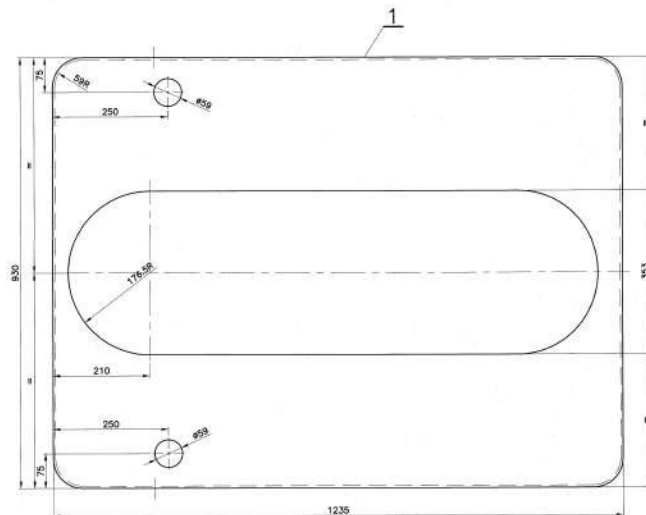


DETAIL AT-X
(GENERAL WELDING DETAILS)

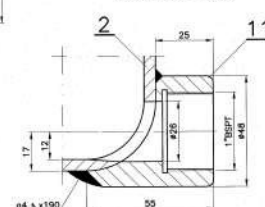


SECTION-CC

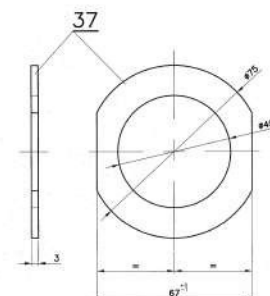
[illegible]



SECTION- GG



SECTION—FF



			V			GROUP: 8-3 LAVORARY			SUPERVISOR: 8-3					
OS: -6-3-203			<div>WATER TANK ASSEMBLY</div> <div>(MSB LTR)</div> <div>TWO PIECE DESIGN</div>						SUPERVISOR: KF/MS-6-3-444 ALT: m/-					
WOSGL2-6-3-005									1-0.5 SHED CND			1-0.5 SHED CND		
WOSGL2-6-3-005									1-1.5 ALT			1-1.5 ALT		
WOSGL2-6-3-005									1-1 ALT			1-1 ALT		
WOSGL2-6-3-005									1-1 ALT			1-1 ALT		
ASSEMBLY DRAWING			CAD FILE: MS-CAD/07/16-3-4442900.080						SHEET 2 OF 3					
15-10-2018			INDIAN RAILWAY STANDARDS						ICF/SK-6-3-444					
DATE OF LASTEST ALT			DATE OF FIRST ISSUE			DATE OF FIRST ISSUE			DATE OF FIRST ISSUE					
ALT			ALT			ALT			ALT					

FORM IR-A1 840x500

NOTE:

- 1. SEALING RING FOR SEALING SURGE DAMPERS (ITEMS-33,34 &36) SHOULD BE CONTINUOUS AND TO BE PASTED TO THE GROOVE ON WATER TANK WITH SUITABLE WATER PROOF ADHESIVE.
- 2. STUDS (ITEM-15) SHOULD BE PROPERLY FASTENED TO THE TANK WITH LOCK TIE SOLUTION OR ARALDITE.
- 3. POSITION OF ITEMS-13,14,19 & 20 SHOWN IN THIS DRG. TO BE RE-ARRANGED TO SUIT WATER TANK PIPE CONNECTIONS IN DIFFERENT TYPES OF COACHES BEFORE MOUNTING THE TANK.
- 4. FABRICATION TO BE DONE BY ARCON AND WELDING.
- 5. TANK SHOULD BE FABRICATED WITH FILLER RESIN W-100 SPEC-156607-85-5-A-43000.
- 6. AFTER FABRICATION THE TANK INTERIOR TO BE SLUSHED WITH BLACK DRINKING WATER SOLUTION TO IS-8862-81, THE COATING THICKNESS SHALL BE MINIMUM 35 MICRONS.
- 7. EACH TANK SHOULD BE TESTED WITH WATER FROM DOMESTIC SUPPLY TO A PRESSURE OF 0.35 Kg/cm² FOR 10 MIN. FOR LEAKAGE.
- 8. THE APPROX. WEIGHT OF THE EMPTY WATER TANK SHALL BE 15 Kg.
- 9. WATER TANK ASSEMBLIES MANUFACTURED ACCORDING TO THIS DRAWING SHALL BE PRESSURE TESTED INTERCONNECTING TWO SIMILAR TANKS AS THEY ARE FITTED INSIDE THE COACH (AS PER THE WORKING CONDITION i.e. KEEPING OVER FLOW OPEN) WITH WATER FROM DOMESTIC SUPPLY TO A PRESSURE OF 0.35 Kg/cm² (5 PSI) FOR LEAKAGE.
- 10. HOLES IN DRG. TO BE DRILLED AND TAPPED AS FOLLOWS FOR ITEMS-1 & 27.
- 11. HOLES IN DRG. TO BE DRILLED ON ITEMS-8 & 29.
- 12. ALTERNATIVELY SURGE DAMPERS TO DRG. OF/ FORs 6-3-014 ITEMS-1 & 25.
- 13. ALTERNATIVELY MANUFACTURE DAMPERS AS FOLLOWS WITH ITEMS-0-10-10-29,30,31,32, RESPLY.
- 14. FOR FABRICATION OF WATER TANKS OF DIFFERENT TECHNICAL REQUIREMENTS FOR ALUMINUM WELDING TO ICR/WD/SPEC-182 SHALL BE FOLLOWED.
- 15. GALVANIZING SHALL BE DONE ACCORDING TO SPECIFICATION
- 16. OPEN TOLERANCE TO DRG. NO. ICR/STD-9-0-001 SHALL GENERALLY BE FOLLOWED WHEREVER TOLERANCE IS NOT MENTIONED FOR DIMENSIONS.
- 17. ALTERNATIVELY SPECIAL WASHER ITEM-35 CAN BE MANUFACTURED OUT OF CUTS FROM ITEM-1.

No. OF ASSEMBLIES REQUIRED PER COACH			
	*		
COL-I	2		
COL-II	1		

* WGSRJ, WGSZJ

2	2	PACKING	3x975/49	37	IS-1149-'84				
1	1	SURGE DAMPER		36	IS-579	TYPE-1 CLASS-C			
2	2	SPECIAL WASHER	3.15x975/50	35	IS-5096-'02		COL-III		
1	1	SURGE DAMPER		34	IS-579	Fe 350		GALVD ★	
1	1	SURGE DAMPER		33	IS-579			COL-I	
1	1	SURGE DAMPER		32	IS-579			COL-II	
2	2	ANTI-SURGE-SHEET	4x167x260	31					
1	1	ANTI-SURGE-SHEET	4x219x500	30					
1	1	PLATE	5x79x79	29	IS-737-'86	31000-12			
1	1	CLEANING-HOLE-COVER	10x3x15	28					
1	1	SEALING-RING	#15B05	27				HARDNESS	
1	1	BOSS	20x3x16	26	RUBBER	IS-1147-'84	35 TO 40 SHORE		
1	1	STIFFENER	5x200x330	25	4200-M			TO BE CHEL-CHK	
2	2	STIFFENER	5x200x427	24					
1	1	STIFFENER	5x200x1002	23					
24	24	PLAIN WASHER	A11	22	IS-2016-'67	IS-1977-'96			
24	24	SPRING LOCK WASHER	B10	21	IS-2016-'67	IS-1977-'96			
24	24	HEX. NUT	M10-S	20	IS-2016-'67	IS-1977-'96			
2	2	SOLID PLUG	1/2" TB	19					
1	1	SOLID PLUG	1" TB	18					
2	2	HEX. PIPE NUT	G 1/2"	17					
2	2	PACKING	3x875/49	16					
3	3	SEALING RING	#15B05	15					
24	24	STUD		14					
-	-	EQUALISING CONNECTION		13					
1	1	FILLING CONNECTION		12					
2	2	NAME PLATE		11					
2	2	SOCKET		10					
2	2	ANTI-SURGE-SHEET	4x130x212	9					
1	1	ANTI-SURGE-SHEET	4x200x244	8					
1	1	CLEANING-HOLE-COVER		7					
4	4	BOSS		6					
1	1	BOSS		5					
2	2	BOSS		4					
1	1	BOSS		3					
2	2	STIFFENER	5x200x1002	2					
1	1	BOTTOM PRESSING	5mm WALL THICKNESS	1					
1	1	TOP PRESSING	5mm WALL THICKNESS	1					
NO OFF	NO OFF	DESCRIPTION & DIMENSIONS	ITEM	REF. DES.	MAT & SPEC.	WEIGHT/UNIT	REMARKS		
IV	IV	GROUP-6-3 LANTORY							
FOR ASSY	FOR ASSY								
PER ASSY	PER ASSY								
<p style="text-align: center;">WATER TANK ASSEMBLY (455 LTS) TWO PIECE DESIGN</p>									
<p>CDX FILE: NO-CDX077V6-3, 44439005 DWG</p>									
<p>DATA CDX NO 077</p>									
<p style="text-align: center;">INDIAN RAILWAY STANDARDS</p>									
<p>SHEET 3 OF 3</p>						<p>ICF/SK-6-3-444</p>			
<p>INTEGRAL COACH FACTORY CHENNAI-38</p>						<p>ICF/SK-6-3-444</p>			