

NO. OF ASSEMBLY REQUIRED PER COACH				
TYPE OF COACH	COL-I	COL-II	COL-III	COL-IV
⊙ ALL BG AC & NON AC COACHES	4	-	-	-
◆ ALL EMU TRAILER & MEMU TRAILER COACHES	-	4	-	-
■ ALL MG & MG/EMU TRAILER COACHES	-	-	4	-
⊠ MG/EMU/M2	-	-	-	4

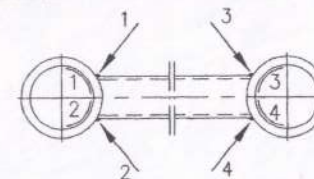
T-0-7-612
EMU-0-7-001
T-0-7-608
ASSEMBLY DRAWINGS

15-10-02
02-12-98
SME/SPV

15	12/98	▽ ROUGH MACHINED	16	ROUGH CLEANED	ALTERATIONS
DRG. REDRAWN IN CAD		▽▽ FINISH MACHINED	17	CHAMFERED	⊗ 02/2007
SD -5d-	SME/BD	▽▽ FINE FINISH MACHINED	18	BURRS REMOVED	WELDING SYMBOL ALTD FROM 5x191E TO 5x191E AND STAMPING PARTICULARS ADDED. -sd- 22-02-2007
					SSE/D AME/D
					⊙ 11/2007
					QTY IN COLS-I TO IV ALTD FROM PER COACH TO PER ASSY. NO. OF ASSY/COACH ADDED. FOR ITEMS- 1,3,4, 5 IN REMARKS. COL-I,III & IV ALTD TO ITEM-1,2,3 & 4 RESPECTIVELY. NOTE-2 ADDED. -sd- 09-11-2007
					SSE/D AME/D
					⊙ 10/2008
					NOTE-3, SKETCH FOR X-RAY DIRECTIONS & ASSY. DRG. NO. T-0-7-612 ADDED.
					SSE/D SME/SPV

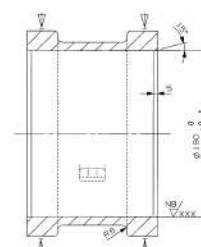
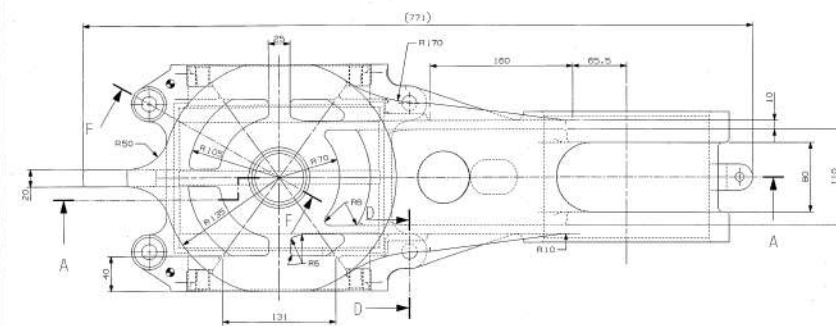
NOTE:

- CARE IS TO BE TAKEN WHILE WELDING ITEM-2 WITH ITEMS-1,3,4 OR 5 FOR THEIR CENTRE DISTANCE, AXES SQUARE & TRUE.
- FINISHED ASSEMBLY SHALL BE THOROUGHLY CLEANED AND APPLIED WITH ONE COAT OF RED OXIDE ZINC CHROMATE PRIMER TO IS:2074/92 OF THICKNESS OF 15-20 MICRONS AND FOLLOWED BY ONE COAT OF SYNTHETIC ENAMEL FINISHING TO IS:8662/93(BLACK) AND CUMULATIVE DFT SHOULD BE 35 MICRONS MINIMUM WITH SMOOTH & GLOSSY FINISH. MACHINED SURFACES - $\phi 90.5$ BORE SHALL BE APPLIED WITH RUST PREVENTION OIL.
- WELD SHALL BE FREE FROM WELD DEFECTS. WELD QUALITY SHALL CONFORM TO RADIOGRAPHIC STANDARD LEVEL-II OF ASTM E390 VOL.II. NO LINEAR DEFECT IS PERMISSIBLE. TWO PERCENT OR A MINIMUM OF TWO NUMBERS FROM EACH LOT SHALL BE SUBJECTED TO RADIOGRAPHIC EXAMINATION.

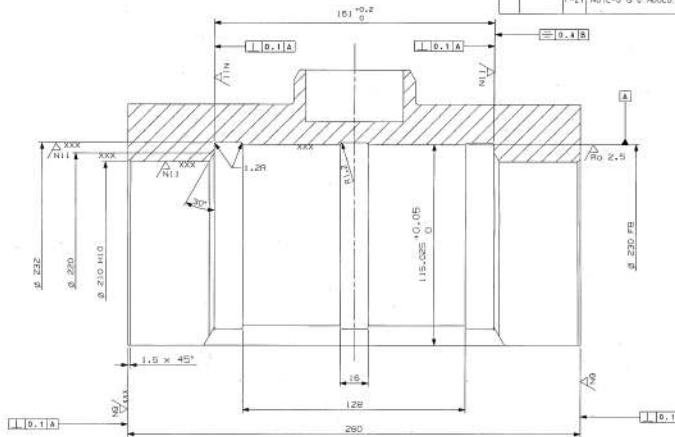


SKETCH SHOWING THE DIRECTIONS OF RADIATION BEAM TO BE FOCUSED

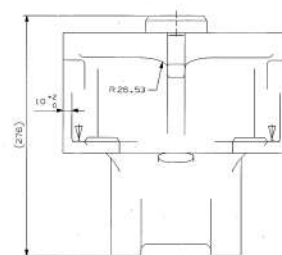
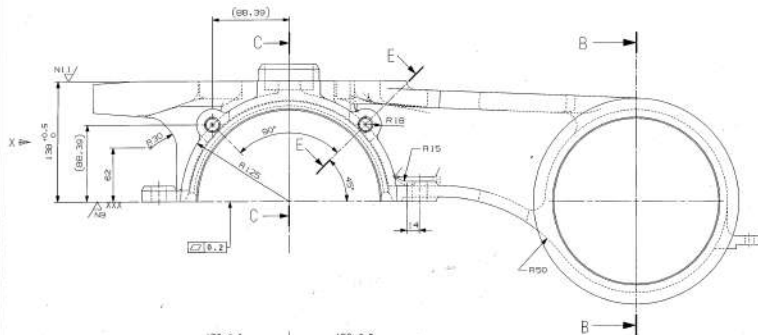
No.	OFF	DESCRIPTION & DIMENSIONS	ITEM	REF. DRG	MATL. SPEC.	WEIGHT/UNIT	REMARKS
1	-	CONNECTING PIPE	5	T-0-7-604		1.28 kg	ITEM-4
-	1	CONNECTING PIPE	4	T-0-7-604		1.55 kg	ITEM-3
-	-	CONNECTING PIPE	3	T-0-7-604		2.23 kg	ITEM-2
2	2	HOUSING	2	T-0-7-605		2.104 kg	
-	-	CONNECTING PIPE	1	T-0-7-604		2.07 kg	ITEM-1
GROUP: ANCHOR LINK ARRGT.							
ANCHOR LINK							
SUPERSEDED BY: T-0-7-603 ALT. y/15							
SCALE 1:2.5							
SSE/D R. Aravind							
CHD R. Muralidhar							
ALT B. Jureash							
DRN							
ALT z							
INTEGRAL COACH FACTORY CHENNAI - 600 038							
T-0-7-603							



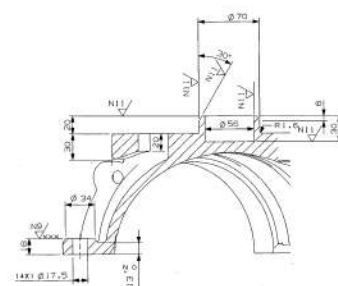
SECTION B-B



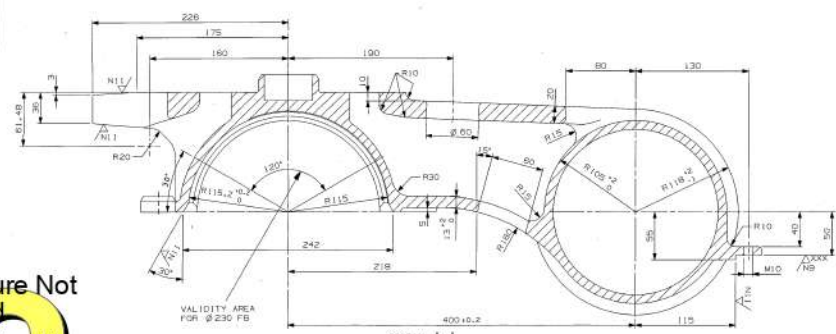
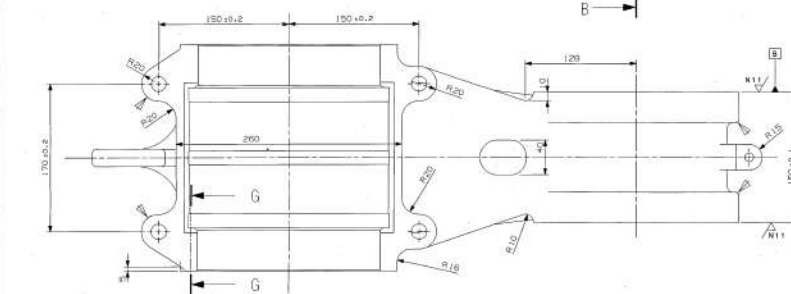
SECTION C-C
(SCALE 1:1)



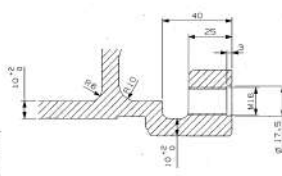
VIEW FROM -X



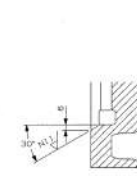
SECTION F-F



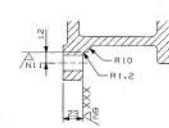
SECTION A-A



SECTION E-E
(SCALE 1:1)



SECTION G-G



SECTION D-D

NOTE:-

- NOTES:-
1. UNDIMENSIONED RADII R4.
 2. XX SURFACE ONLY WITH PRIMING COAT.
 3. XXX SURFACE WITHOUT ANY PAINTING.
 4.  = ADAPTATION BASE.
 5. SURFACE PROTECTION AS PER MDS-166 REV 02 OR LATEST.
 6. OTHER APPLICABLE SPECIFICATION No. MDS-241 REV 02 OR LATEST.

ENTERED
INTO
DATA BASE
12 FEB 2000

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Signature Not
Verified

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TULSHIDAS

ANNUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID.

DETAIL ORGS STARTING WITH "LI" ARE INTERNAL REFERENCE LISTS ONLY AND ARE NOT FOR ISSUE.

DATE OF FIRST ISSUE

14/02/2019

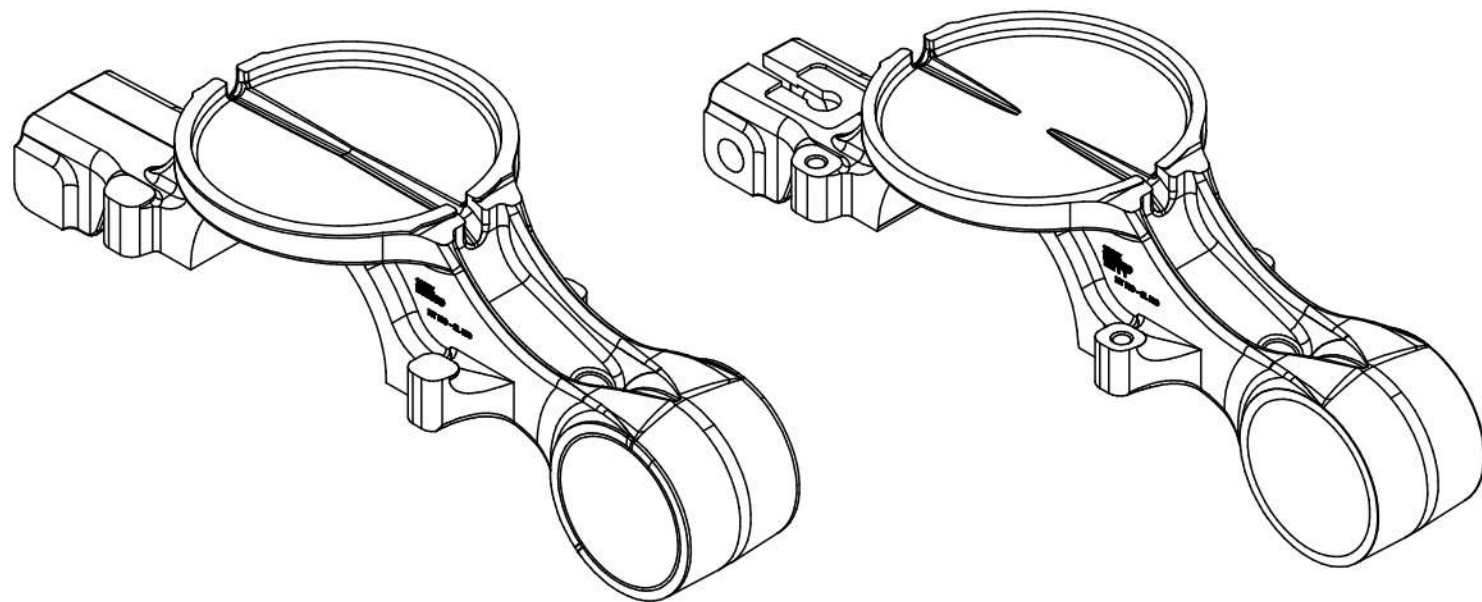
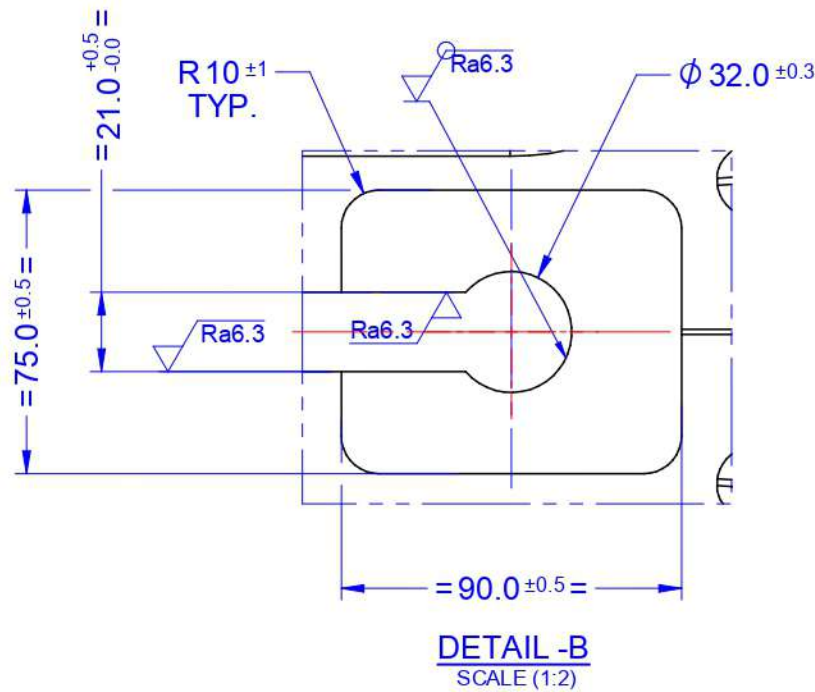
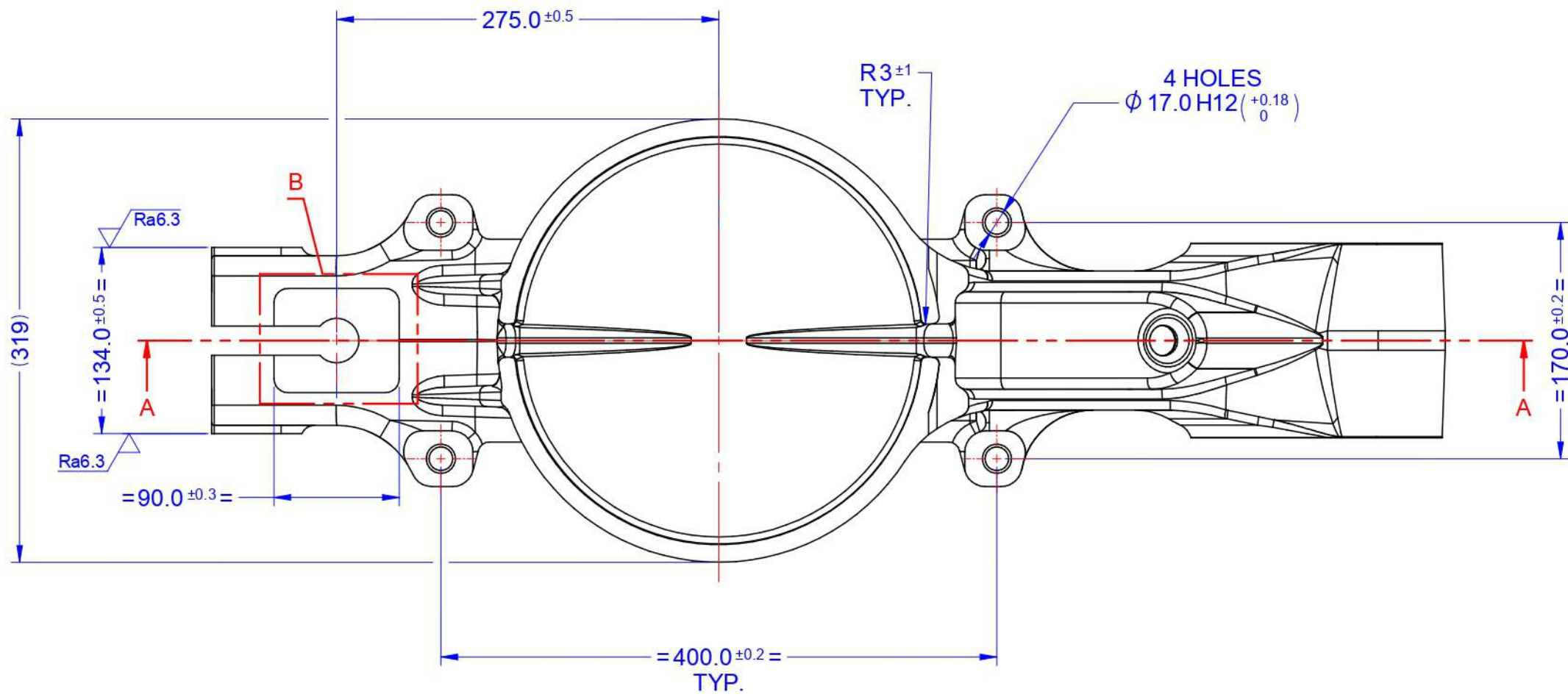
CGM BY

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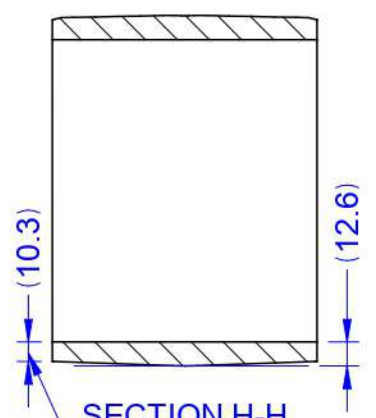
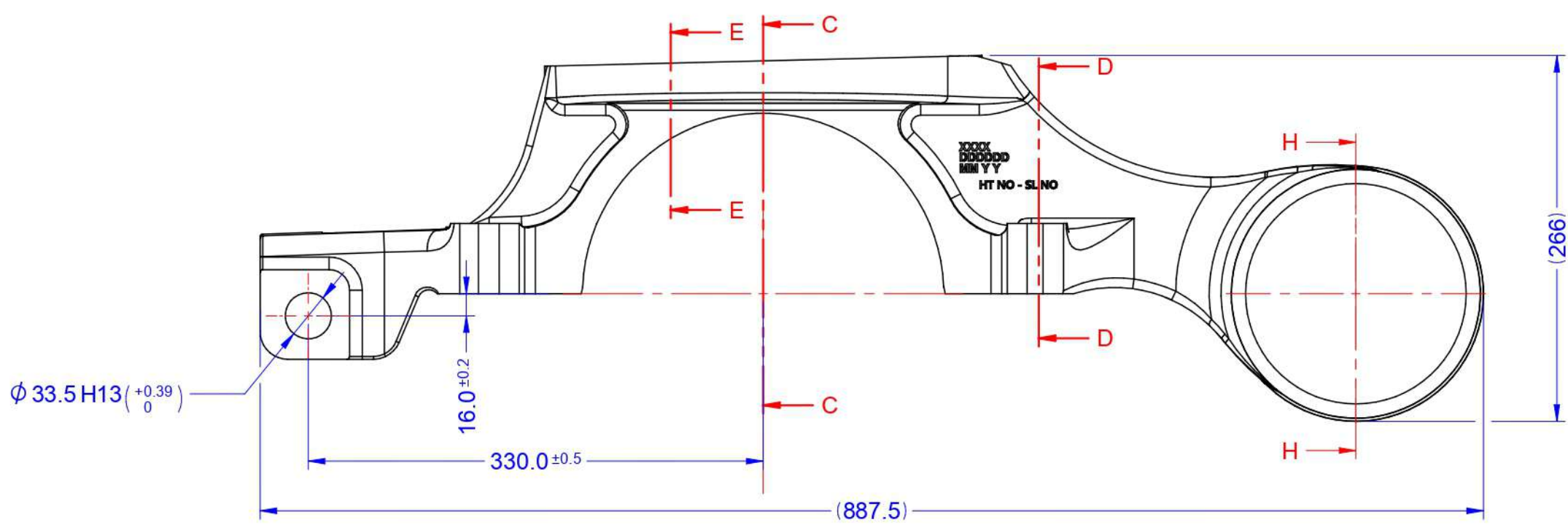
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Location: New Delhi

Location: New Delhi

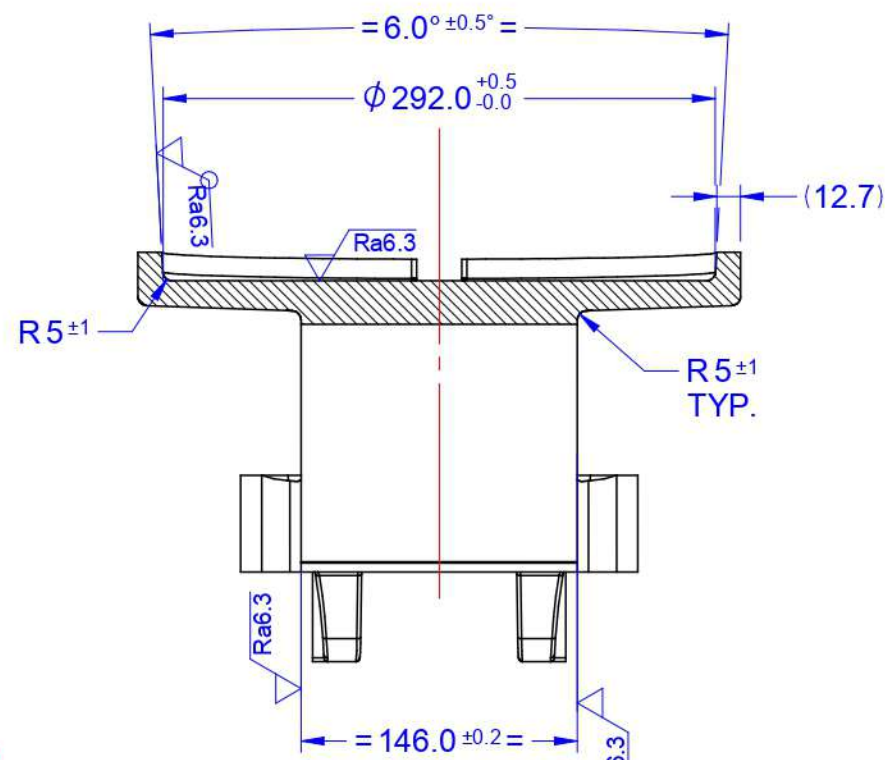
REV	ECR.NO.	ZONE	REVISION	DATE	REVISED	CHKD.	APPD.
02	0522-044424-M	---	FINISH CHANGED.	06.05.2022	MOHAN.J	SRKANTH.P	BOCR
03	0922-046160-M	F14, F15,K7	INSTRUCTIONS ABOUT PAINTING, SEE NOTES	17.08.2022	AJAY.D	SRKANTH.P	BOCR
04	1122-046906-M	F8,H15	SECTION H-H ADDED. INSTRUCTIONS ABOUT WALL THICKNESS AND PAINTING INSTRUCTIONS UPDATED.	28.10.2022	AJAY.D	SRKANTH.P	BOCR



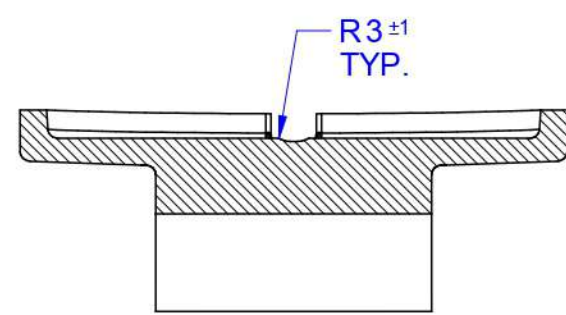
3D VIEW



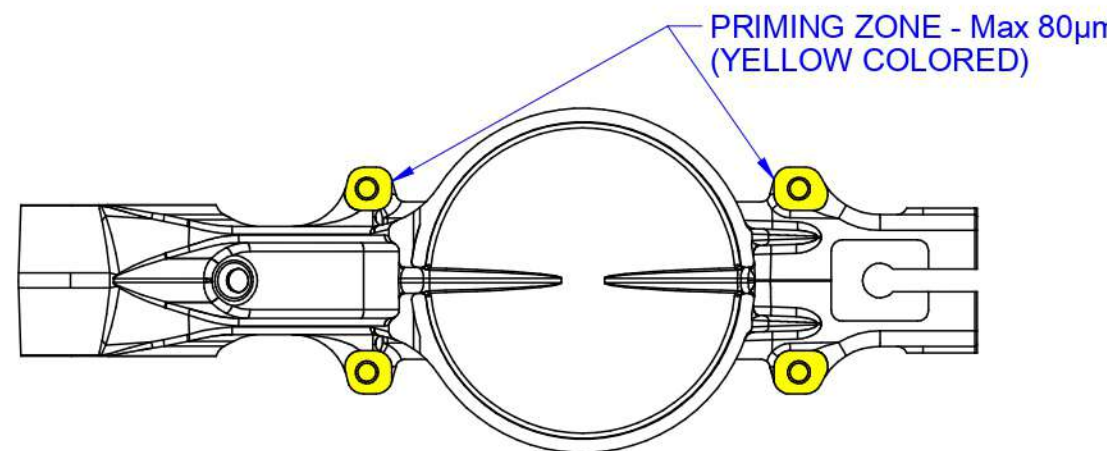
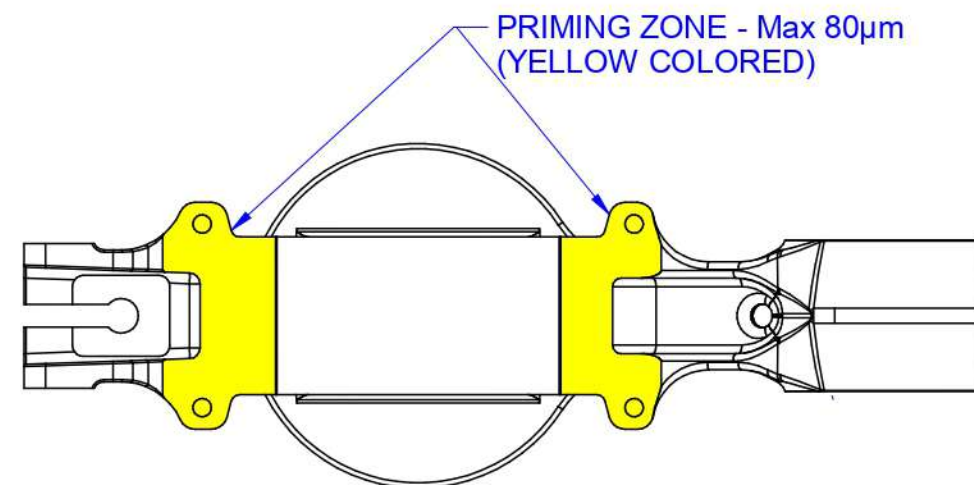
CHECK FOR WALL THICKNESS BEFORE MACHINING & SHOULD BE VERIFIED BY QC



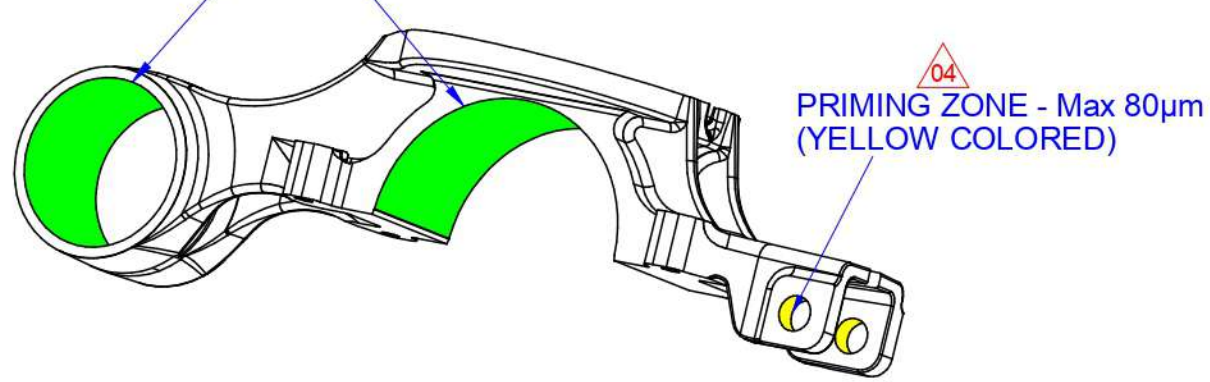
SECTION C-C SCALE (1:4)



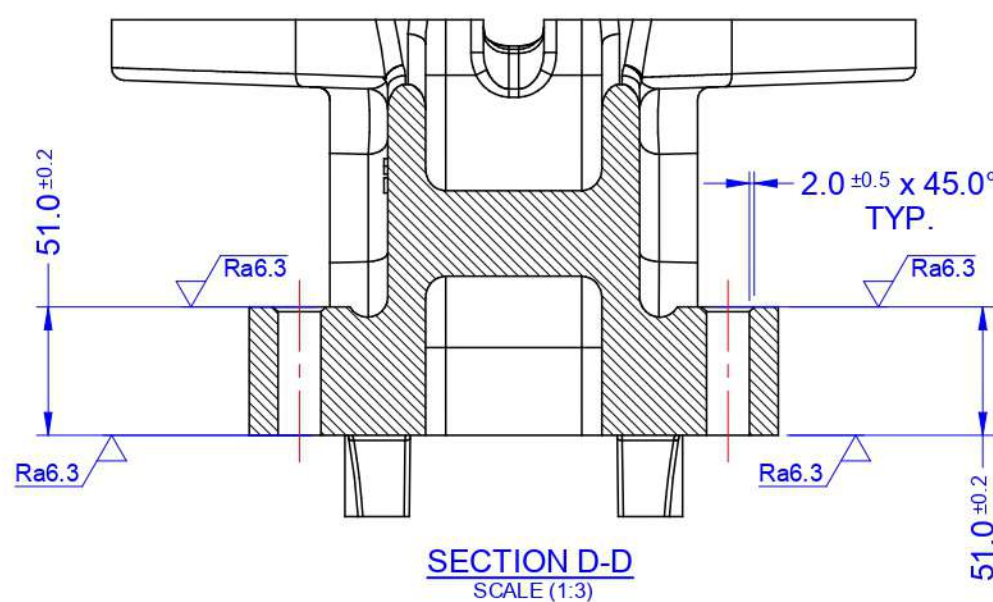
SECTION E-E SCALE (1:4)



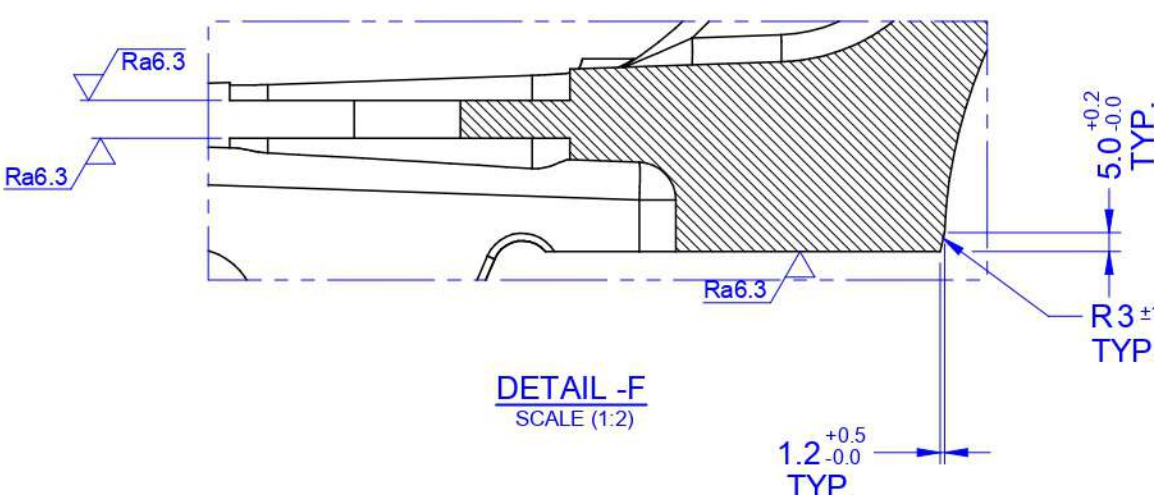
MASKING ZONE (GREEN COLORED)



"PAINTING INSTRUCTIONS"



SECTION D-D SCALE (1:3)

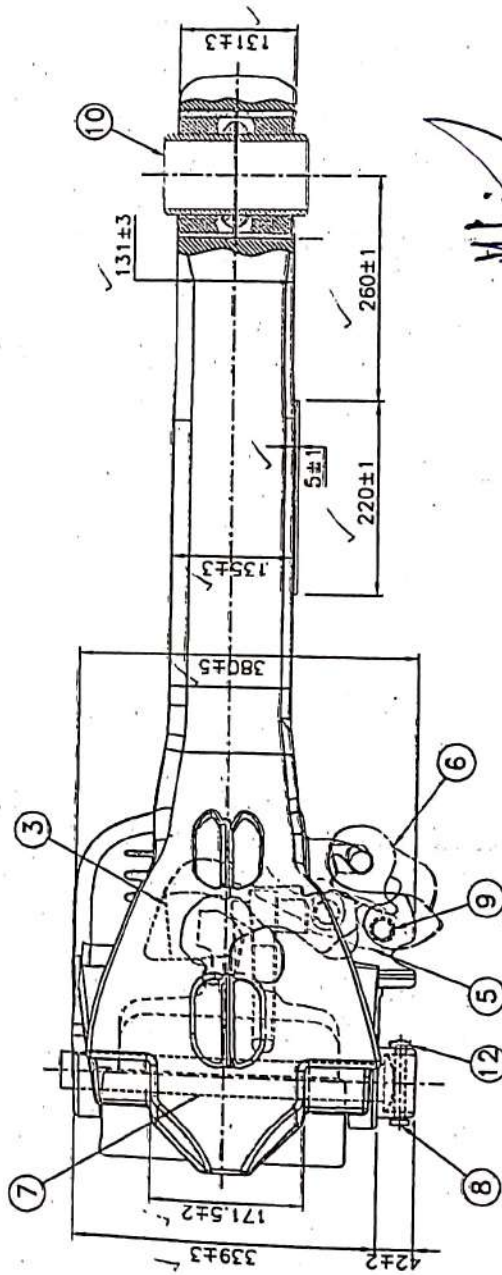
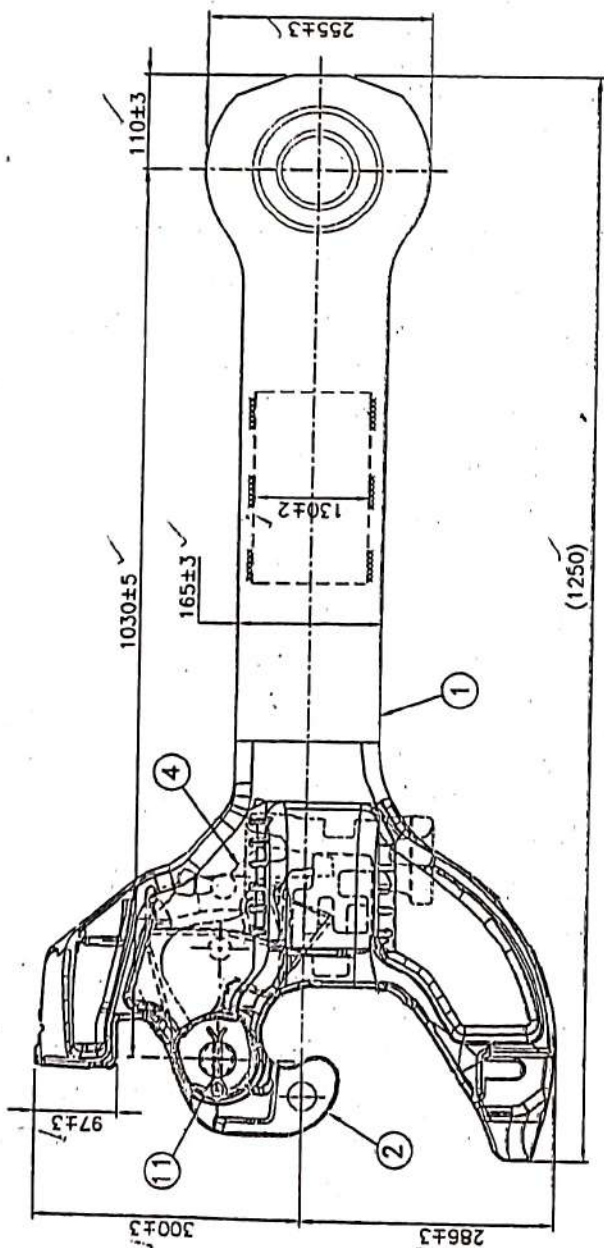


DETAIL-F SCALE (1:2)

- NOTES :
01. MATERIAL : REFER TO THE RESPECTIVE DRAWING IN THE TABLE
 02. INTERNAL SURFACE ROUGHNESS OF ALL DRILLED HOLES : Ra12.5
 03. FOLLOWING IDENTIFICATION DETAILS SHELL BE SUITABLY ENGRAVED ON OUTER SURFACE AS SHOWN IN 6mm HEIGHT LETTERS.
MM YY - MONTH AND YEAR OF MANUFACTURE (LAST TWO DIGITS ONLY)
 04. REMOVE ALL SHARP EDGES AND BURRS
 05. FINISH :
A) PROPER MASKING SHOULD BE DONE ACCORDING TO PAINTING INSTRUCTIONS
B) PRETREATMENT: SHOT/GRIT/SAND BLASTING ACCORDING TO ISO:8501, Sa 2.5 AS PER ICF/MD/SPEC-299
C) PRIMER: HIGH PERFORMANCE ANTI CORROSION EPOXY COATING(TWO PACK) HAVING COLOUR GREEN WITH DFT OF 125⁺²⁰₀ MICRONS TO BE DONE AS PER RD50 SPEC NO.M&C/PCN/123/2018
D) PRIMER, INTERMEDIATE & TOP COATS MUST BE COMPLY TO FIRE SAFETY STANDARD EN 45545 - HL3-R7
E) INTERMEDIATE COAT : FLUOROPOLYMER (FLUOROETHYLENE) WITH DFT OF 30⁺¹⁰₀ MICRONS TO BE DONE AS PER JAPANESE INDUSTRIAL STANDARD JIS K 5659:2008
F) TOP COAT : FLUOROPOLYMER (FLUOROETHYLENE) WITH DFT OF 25⁺¹⁰₀ MICRONS WITH SHADE TO RAL-7012(BASALT GREY) TO BE DONE AS PER JAPANESE INDUSTRIAL STANDARD JIS K 5659:2008-CLASS-1
G) MACHINED AREAS/MACHINED COMPONENTS, WHICH DON'T REQUIRE PRIMER OR PAINT, SHOULD BE PROTECTED AGAINST CORROSION WITH SUITABLE CORROSION PREVENTIVE COATING, WHICH IS REMOVABLE EASILY AND SUITABLE PACKING SHOULD BE DONE SO AS TO AVOID ANY POSSIBILITY OF DAMAGE DURING TRANSIT
 06. PRESERVATION MEASURES : COMPONENT SHOULD BE PRESERVED IN THE MOISTURE FREE AND DUST LESS ZONE
 07. ENSURE ALL THREADED / TAPPED PORTION ARE MASKED

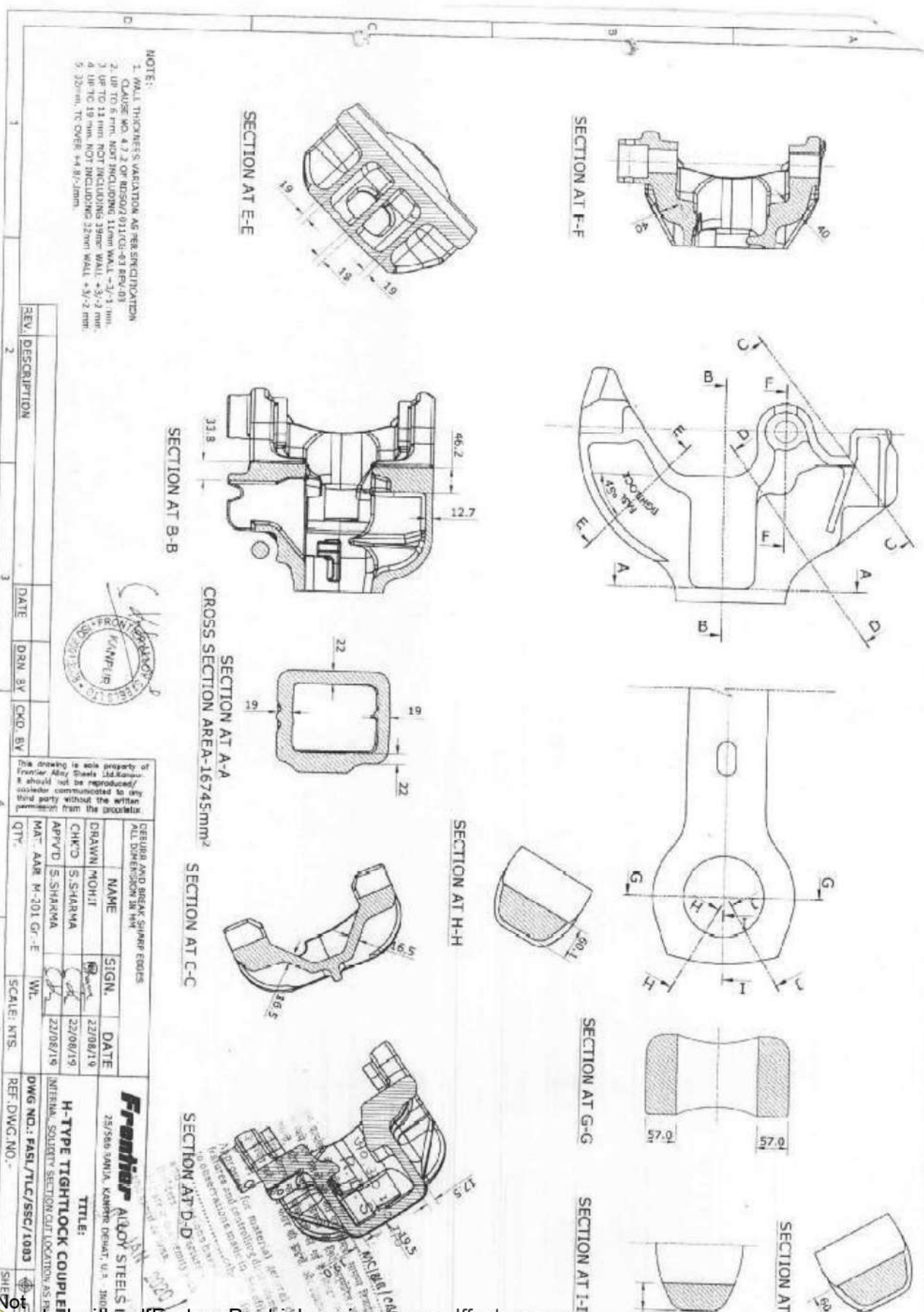
1	D-A675UV2-137345	CONTROL ARM UPPER COVER CASTING-A675UV2	G24Mn6+QT2	1	65.202 kg
S.NO	DRG.NO / SAP CODE	DESCRIPTION	MATERIAL	QTY	MASS (QTY)
TITLE: CONTROL ARM UPPER COVER MACHINED-A675UV2					DRAWING NO: D-A675UV2-135408
UNLESS SPECIFIED: - ALL DIMENSIONS ARE IN mm - ALL MASSES ARE IN kg - AREA IN cm ² - DO NOT MEASURE DIMENSIONS FOR MFG - AREA & MASS VALUES ARE FOR REF ONLY - DRAWING MUST BE MODIFIED IN 3D ONLY		DRAWN: MOHAN.J CHECKED: SRKANTH.P APPROVED: BOCR	MOHAN.J SRKANTH.P BOCR	13.10.2021 13.10.2021 13.10.2021	REV: 04 PROJECTION:
AREA: 6952cm ² MASS: 56.707 kg		SCALE: 1:4 SHEET: 1 / 1	MEDHA SERVO DRIVES PVT. LTD., P-4/SB, IDA, NACHARAM, HYDERABAD - 500 076, INDIA.		

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सहायक मंडल यांत्रिक अभियंता (सवारी)
Asst. Divl. Mech. Engineer (Chg.)
सवारी डिपो, भुवनेश्वर पूर्व तट रेलवे
Coaching Depot. BBS. E.Co.Rly.

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