

TABLE - 2

**MECHANICAL PROPERTIES OF COLD ROLLED PRODUCTS
(6 MM THICKNESS MAXIMUM)**

Designation/ Grade	Condition	Min. Yield Stress or 0.2% proof stress (N/mm ²) transverse	Tensile Strength (N/mm ²) Transverse	Min. Elongation at fracture (%) at 50 mm gauge length
FERRITIC STEELS				
X2 Cr Ti 12(409)	2D/2B	220	390 to 560	20
X2 Cr Ni 12(409M)	2D/2B	320	450 to 650	20
X6 Cr 17(430)	2D/2B	270	450 to 600	20
AUSTENITIC STEELS				
X5 Cr Ni 18 10(304)	2D/2B	235	550 to 750	40
	Work-hardened	350	700 min.	25
X2 Cr Ni N 18 7 (301)	2D/2B	350	600 to 900	40
	Work hardened	500	800 min.	20
X6 Cr Ni Ti 18 10 (321)	2D/2B	245	540 to 740	40
X5 Cr Ni Mo 17 12 2 (316)	2D/2B	255	550 to 700	40
Note : if the fracture of the tensile test piece is outside gauge length, the test shall be discarded and retest conducted. To facilitate this, sufficient number of test pieces shall be prepared.				

TABLE - 3

GUIDELINE INFORMATION ON FILLER METALS FOR ARC WELDING

Parent Metal A	Suitable filler metal (material No.) as specified in AWS	Parent Metal B					
		X2 Cr Ti 12 (409)	X2 Cr Ni 12 (409M)	X5 Cr Ni 18 10 (304)	X2 Cr Ni 18 7 (301)	X6 Cr Ni Ti 18 10 - (321)	X5 Cr Ni Mo 17 12 2 (316)
X2 Cr Ti 12 (409)	E 308L - 15	X	-	-	-	-	-
X2 Cr Ni 12 (409M)	E-308L-15	X	X	-	-	-	-
IRSM - 44							
X5 Cr Ni 18 10 (304)	E 308L - 15	X	X	X	-	-	-
X2 Cr Ni 18 7 (301)	E 308L - 15	X	X	X	X	-	-
X6 Cr Ni Ti 18 10 (321)	E 347 - 15	X	X	X	X	X	-
X5 Cr Ni Mo 17 12 2 (316)	E 316L - 15	X	X	X	X	X	X

Note that where grade x6 Cr 17 is to be welded, only the resistance welding process should be used. For welding any SS with M-41, use the corresponding SS electrode only as per table.

TABLE - 4

**RESISTANCE TO INTER CRYSTALLINE CORROSION
(FOR 2D & 2B FINISH MATERIAL)**

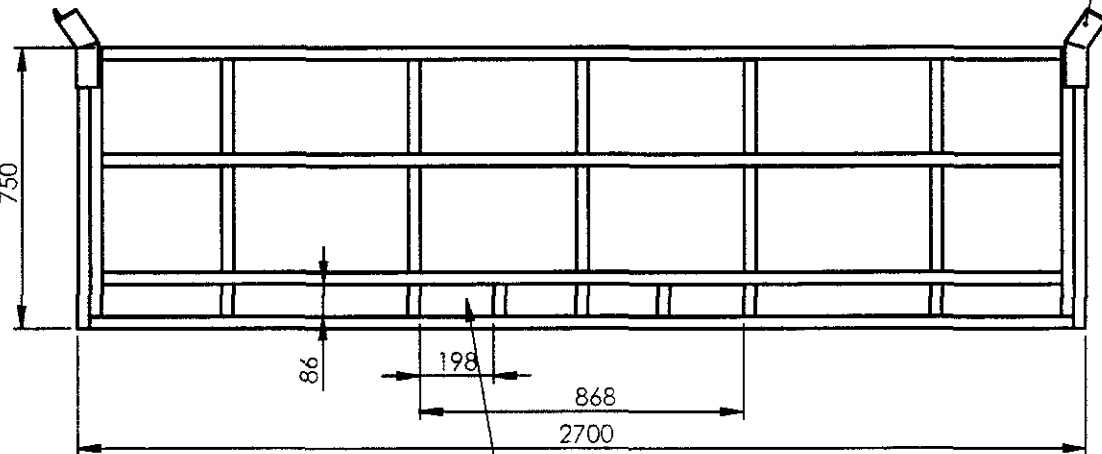
Material		Resistance to inter crystalline corrosion (tested as per ASTM A262 Practice E)	Smallest inside bending (180°) radius for a thickness, 't' not exceeding 6 mm
Designation	Grade	In the condition of supply	
X5 Cr Ni 18 10	304	Yes	1 t
X2 Cr Ni N 18 7	301	Yes	1 t
X6 Cr Ni Ti 18 10	321	Yes	1 t
X5 Cr Ni Mo 17 12 2	316	Yes	1 t

TABLE -5**HEAT TREATMENT CONDITION**

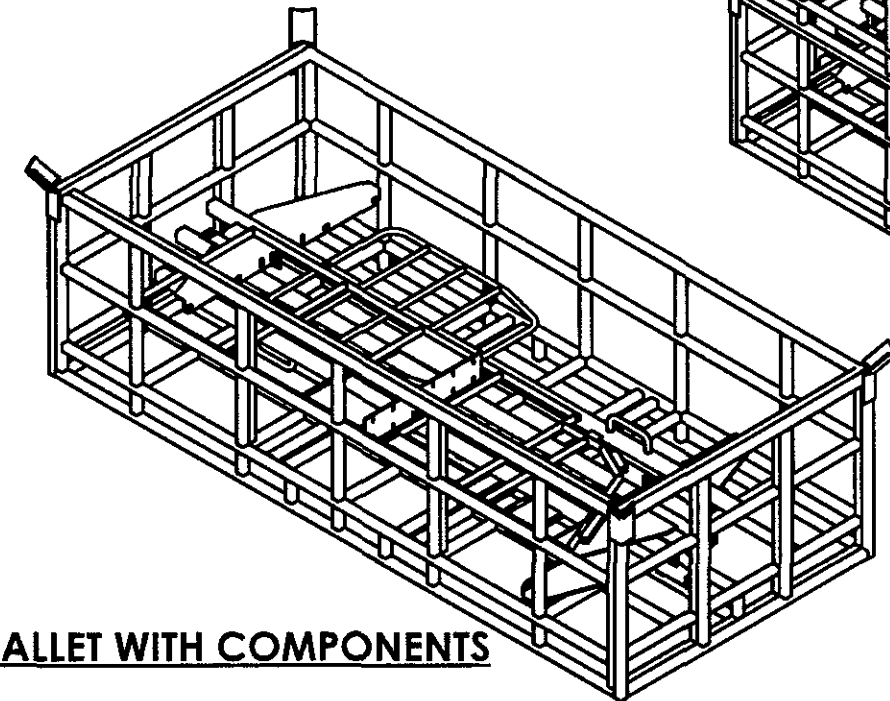
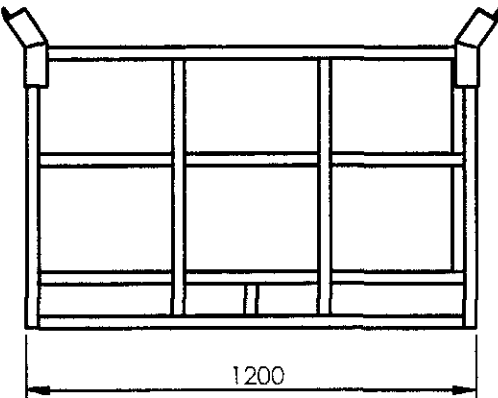
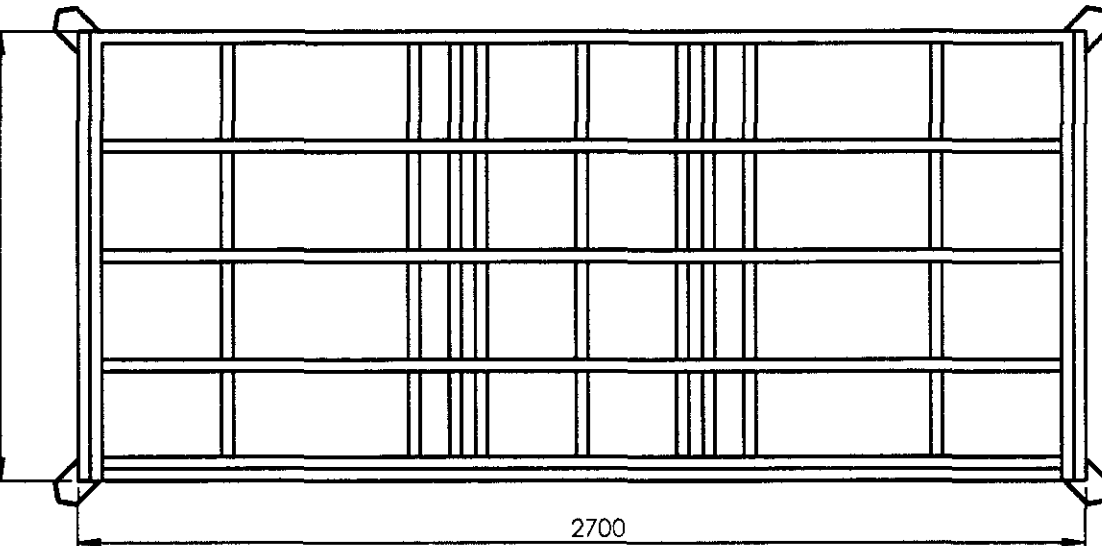
COLD ROLLED PRODUCTS		
2D	Cold rolled annealed and pickled.	Uniform Dull finish for thickness of 5 and 6 mm.
2B	Cold rolled annealed, pickled and skin passed.	Smoother finish and thickness upto and including 4 mm.
No.4	Cold rolled, annealed, pickled, and polished with 120-150 grit abrasive.	Decorative finish. For thickness of 1.00 to 2.5 mm.

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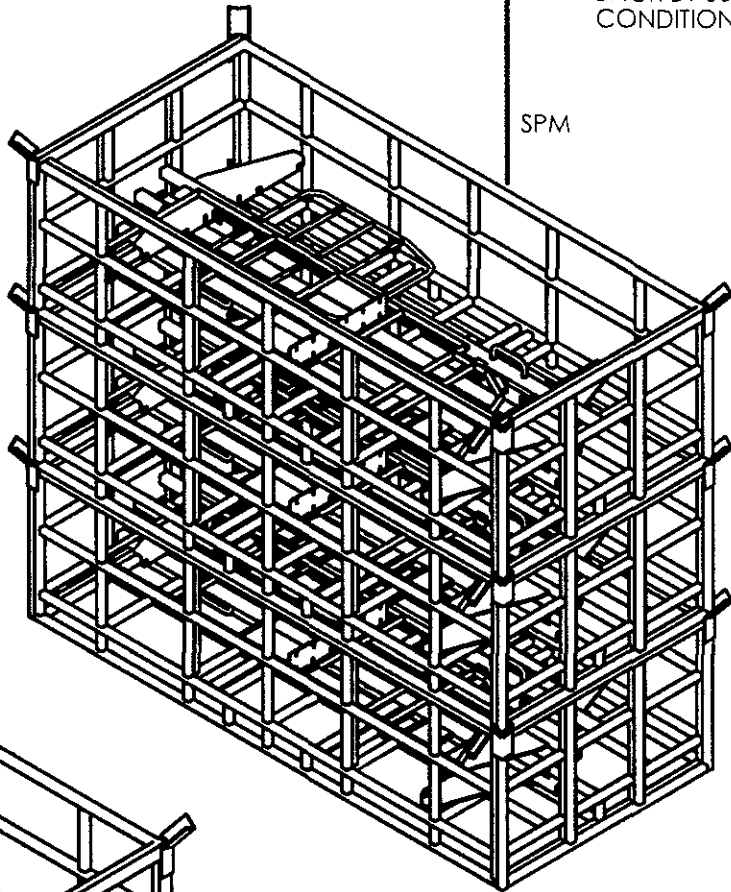
GUIDING ANGLE FOR SELF STACKING



POCKET FOR FORKLIFT FORK INSERTION



PALLET WITH COMPONENTS



STACKED PALLETS

NOTE:

1. THE PALLET TO BE USED FOR SUPPLYING SIDEWALL FRAME WORK DETAILS, BODY SHELL ITEMS, PARTITION FRAMES AND CHAIR PILLARS
2. THE LENGTH AND WIDTH DIMENSIONS OF THE PALLET TO BE MAINTAINED
3. HEIGHT MAY BE RAISED UPTO 150mm FROM THE HEIGHT GIVEN IN THE DRAWING.
4. THE POCKET FOR FORKLIFT TRUCK FORK INSERTION TO BE OF DIMENSION INDICATED IN THE DRAWING.
5. THE PALLET MAY BE MANUFACTURED USING 25mm SQUARE HOLLOW SECTIONS.
6. PALLET SHOULD HAVE ADEQUATE STRENGTH FOR TRANSPORTING AND HANDLING.
7. ALL THREE SIDES AND BOTTOM SIDE OF THE PALLET TO BE COVERED WITH SS MESH OF 50x50x2 mm
8. THE PALLETS SHOULD BE SELF STACKABLE. THE ANGLES AS SHOWN ON TOP CORNERS ARE FOR GUIDANCE WHILE STACKING.

▽	ROUGH MACHINED
▽▽	FINISH MACHINED
▽▽▽	FINE FINISH MACHINED

ALTERATIONS

- DATE: 11-11-2024
JOB NO: 592/2024-24
1. NOTE-9 DELETED
 2. "PALLET TO BE TAKEN BACK BY SUPPLIER" CONDITION REMOVED

SPM

SSE/J&T

THE PACKING FRAMES/STRUCTURES ARE TO BE TAKEN BACK BY THE SUPPLIER FROM ICF PREMISES AFTER THE COMPONENTS ARE TAKEN FOR PRODUCTION

PACKING CONDITION
FOR SIDEWALL FRAMEWORK DETAILS
BODY SHELL ITEMS AND PARTITION FRAMES

Weight (kg)	
SCALE	SSE/D
1:20	CHD
ALT	ALTD
α	DRN

INTEGRAL COACH FACTORY,
CHENNAI - 600038

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ASSEMBLY DRAWINGS		
11-11-2024	09-07-21	SME/AME
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	SME/AME