

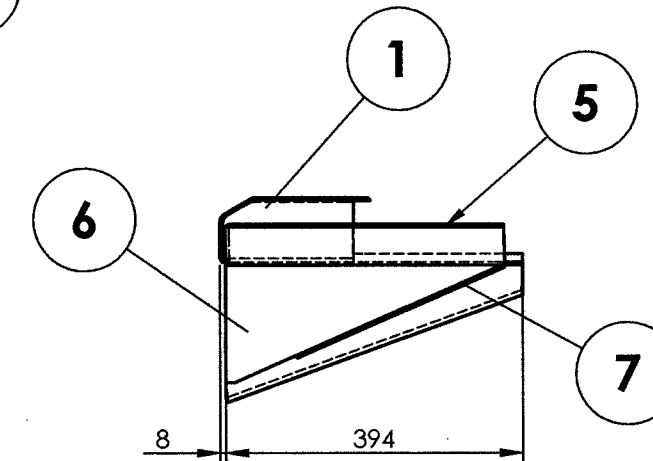
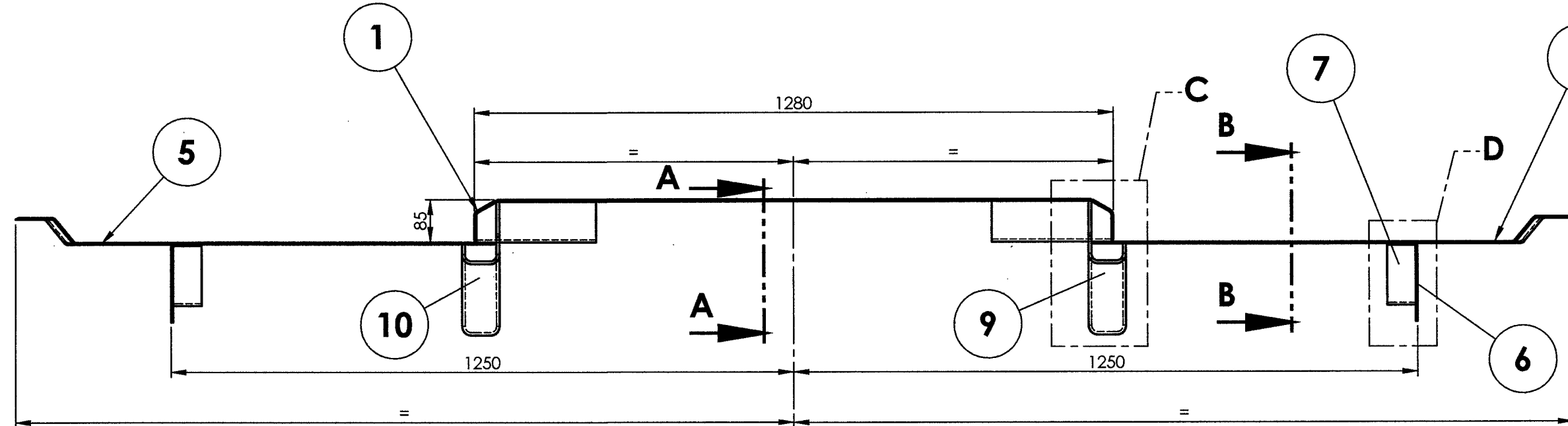
49515003

▽ ROUGH MACHINED	01 ROUGH CLEANED
▽▽ FINISH MACHINED	01b BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	018 CHAMFERED

01 ROUGH CLEANED
01b BURRS REMOVED
018 CHAMFERED

REVISIONS

ALT.	ZONE	DESCRIPTION	APPROVED & DATE
a		ITEM-4 DELETED AND ITEM-8 ADDED.	Sd..06-09-2014
b		ITEMS-9&10 ADDED. ITEMS-2&3 DELETED. WELDING NOTE & GENERAL NOTE ADDED.	



WELD TESTING PREFERENCES AS PER EN 15085-3:2007(E) TABLE-4

WELD PERFORMANCE CLASS	QUALITY LEVEL FOR IMPERFECTIONS EN ISO 5817 €	INSPECTION CLASS	VOLUMETRIC TEST RT or UT	SURFACE TEST MPT or DPT	VISUAL EXAMINATION VT
CP C2	B	CT2 §	NOT REQUIRED	NOT REQUIRED	100%

THE TEST METHODS INDICATED IN THIS TABLE SHALL BE THE MINIMUM CAPABLE OF ENSURING COMPLIANCE OF THE WELDED JOINTS. ADDITIONAL TESTS DEPENDING ON THE MATERIAL, THE DESIGN OR CUSTOMER REQUIREMENTS MAY BE NECESSARY.

§ FOR INSPECTION CLASS CT2, THE VISUAL EXAMINATION SHALL BE PERFORMED BY PERSONNEL CERTIFIED ACCORDING TO ISO-9712 AND SHALL BE DOCUMENTED.

€ ALL APPLICABLE CLAUSES FOR VISUAL INSPECTION SHALL BE CARRIED OUT.

FOR APPLICABLE WELDING PROCEDURE SPECIFICATION (WPS) REFER DRAWING NO ICF/STD-9-0-999

NOTE:

1. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC C-K201 SHALL BE USED FOR WELDING.
2. ALL WELDINGS SHALL BE TIG WELDING UNLESS OTHERWISE SPECIFIED.
3. ALL WELD SPATTERS SHALL BE GROUND.
4. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
5. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.

1	CONSOLE		10	AAA15250		0.75	
1	CONSOLE		9	AAA15249		5.906	
1	FLANGE L.H		8	AAA15412		11.391	
2	SHEET		7	AAA15264		0.543	
2	WEB		6	AAA15263		0.935	
1	FLANGE R.H		5	AAA15244		11.394	
1	FLANGE L.H		4	AAA15243		11.403	
1	CONSOLE COMPLETE		3	49515005		0.877	
1	CONSOLE COMPLETE		2	49515004		6.031	
1	SILL COMPLETE		1	49515006		7.542	

QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS
GROUP: 1-5 END CONSTRUCTION				SURFACE AREA IN Sq.m.: 2.706		WT/ASSY IN Kgs:	
SILL ARRANGEMENT				SCALE 1:10	SSE/D CHD	Sd..Pandurangas	
				ALT b	ALTD DRN	H. Irshath Ahamed	
						A.Palanichamy	
INDIAN RAILWAY STANDARDS				SHEET 1 OF 1		LWGSCWAC2	
INTEGRAL COACH FACTORY, CHENNAI - 600038				49515003		A2	

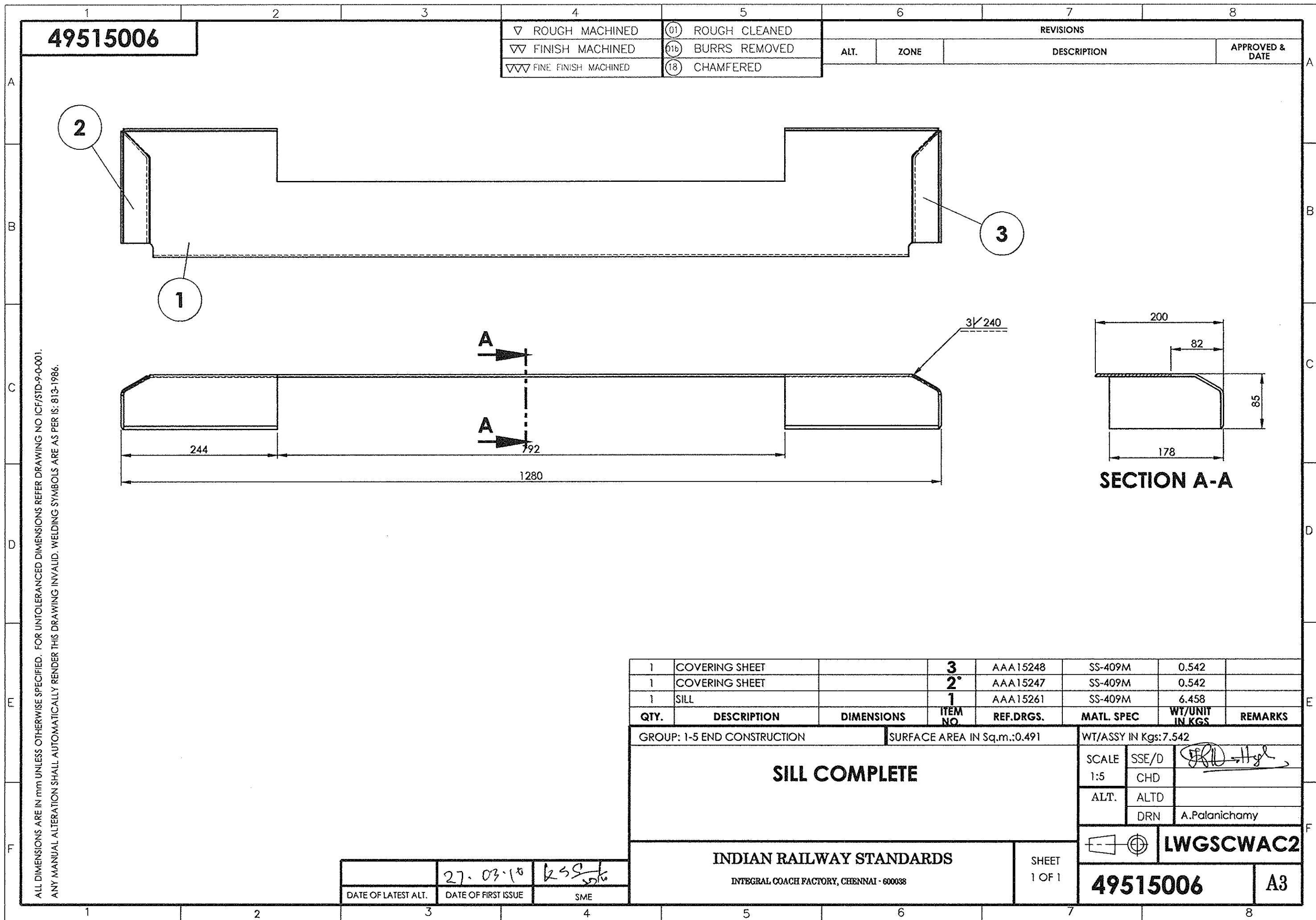
SECTION A-A

SECTION B-B

DETAIL C
SCALE 1 : 5DETAIL D
SCALE 1 : 5

REF.DRG.NO.

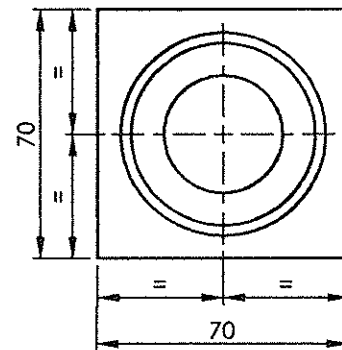
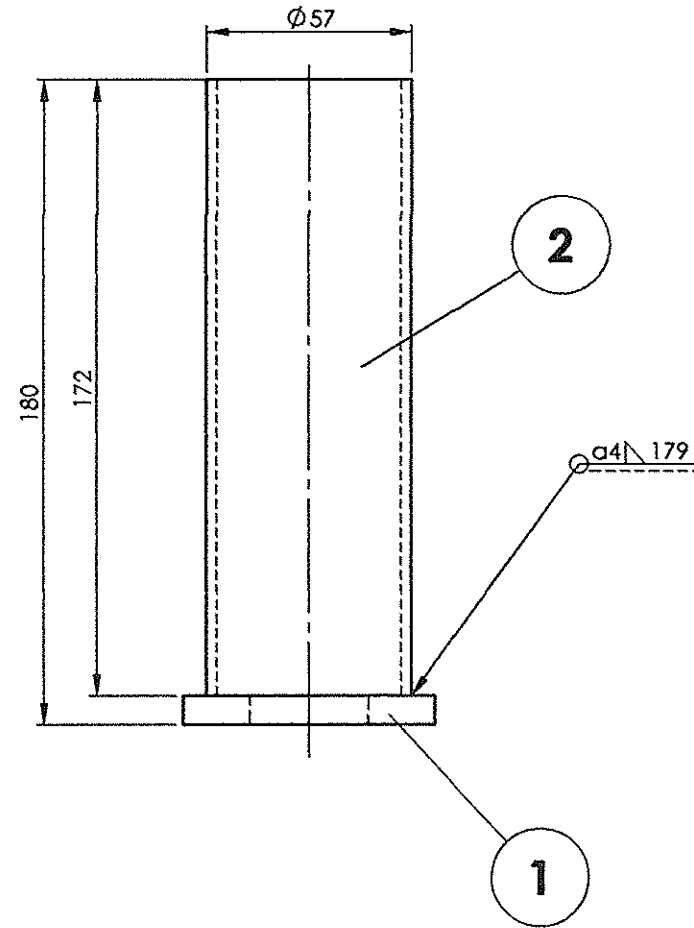
07-04-19	27-03-2010	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME



49515018

▽ ROUGH MACHINED	① ROUGH CLEANED
▽▽ FINISH MACHINED	② BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	③ CHAMFERED

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE

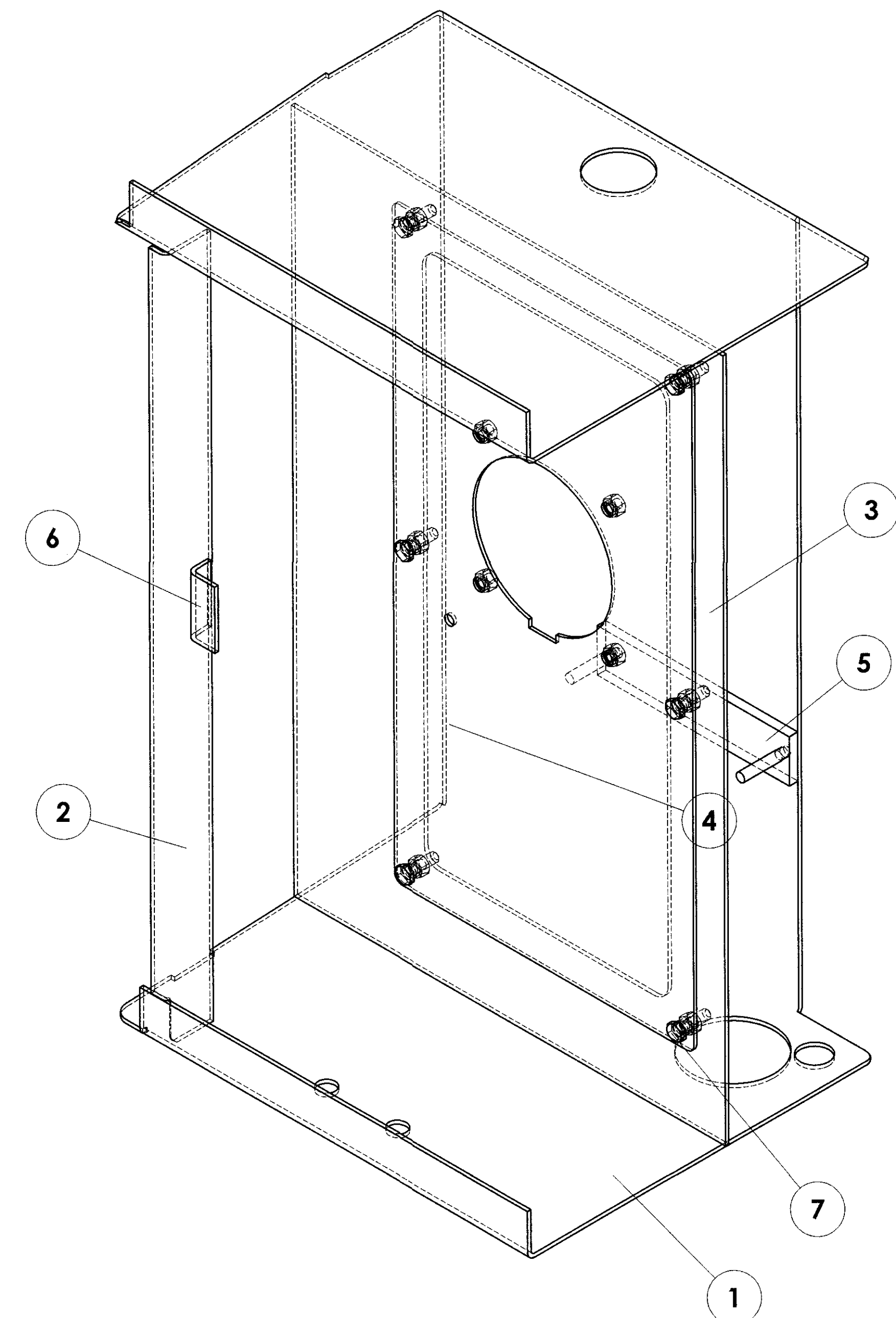
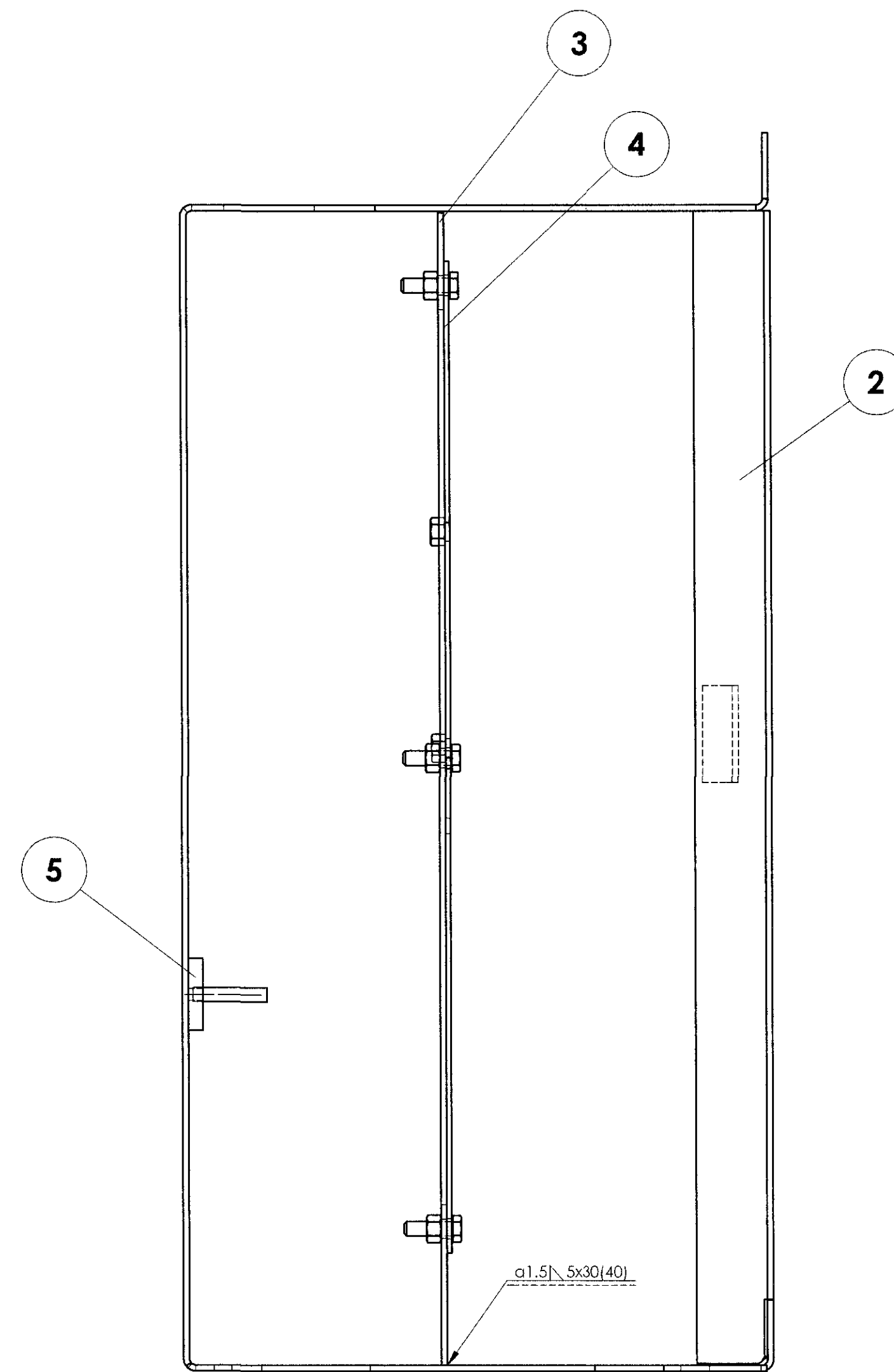


1	PIPE		2	AAA15287		0.670	
1	PLATE		1	AAA15203		0.259	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-5				SURFACE AREA IN Sq.m.:0.071		WT/ASSY IN Kgs:0.929	
PIPE COMPLETE					SCALE	SSE/D	[Signature]
					1:2	CHD	
					ALT.	ALTD	
						DRN	D.MOSES
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038					SHEET 1 OF 1		
					49515018		A3

	27.03.10	KSL
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	SME/AME

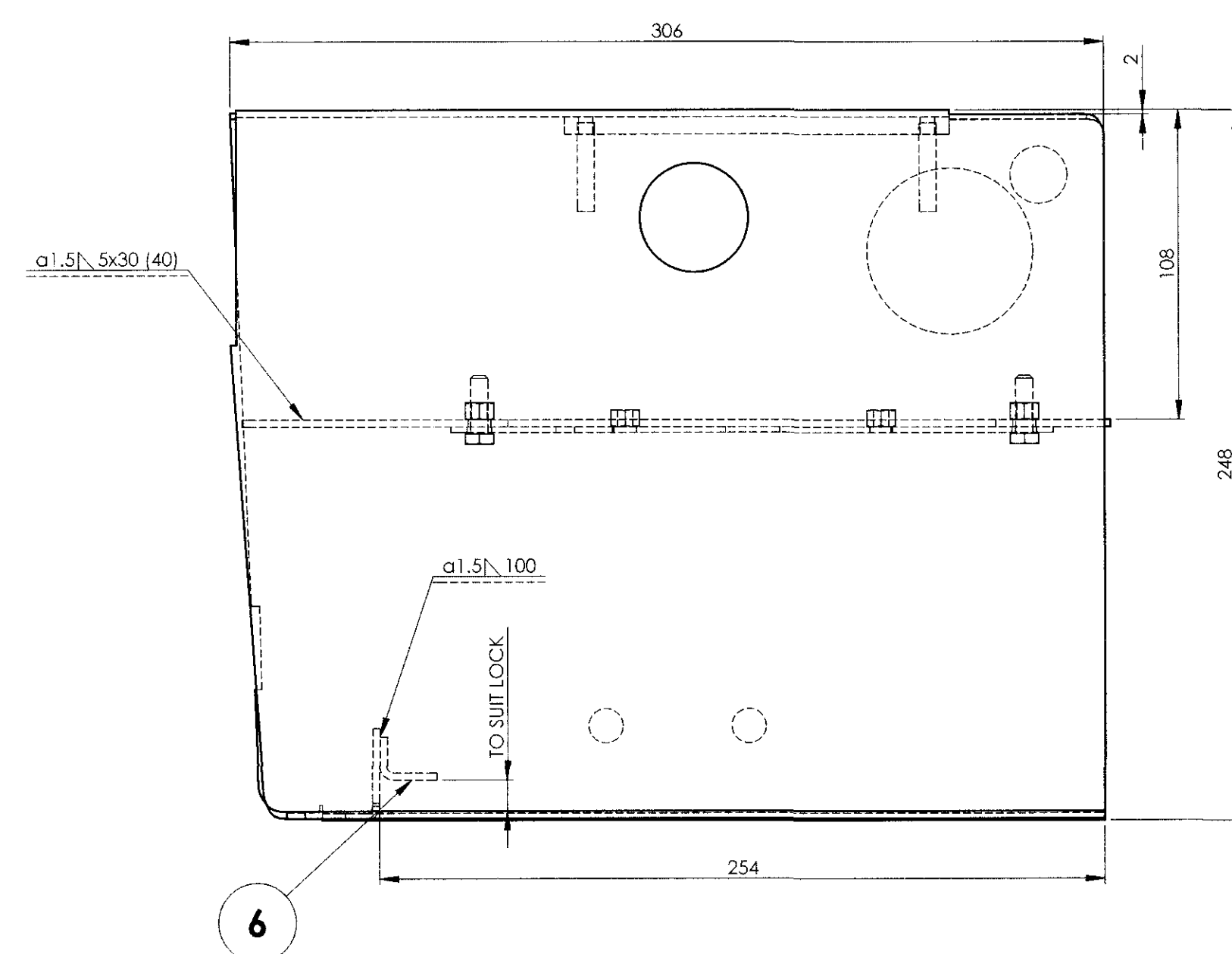
ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS REFER DRAWING NO ICF/STD-9-0-001.
ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER IS: 813-1986.

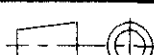
▽ ROUGH MACHINED	(01) ROUGH CLEANED	REVISIONS			
▽▽ FINISH MACHINED	(11b) B.JRRS REMOVED	ALT.	ZONE	DESCRIPTION	APPROVED & DATE
▽▽▽ FINE FINISH MACHINED	(18) CHAMFERED	a		ITEM-6 LOCATION REVISED.	N F-X 2/11/12



NOTE:

1. ALL WELD SPATTERS SHALL BE GROUND.
2. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
3. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
4. ALL WELDINGS SHALL BE TIG WELDING UNLESS OTHERWISE SPECIFIED.
5. FINISHED ASSEMBLY SHALL BE APPLIED WITH (AIRLESS SPRAY) ECO FRIENDLY WATER BASED MODIFIED EPOXY ZINC PHOSPHATE ETCH PRIMER TO ICF/MD/SPEC-231.



6	HEXAGON HEAD SCREW	IS 1364 (Part-2)/ISO 4017 - M6 x 20-A2-70	7	IS:1364 (PART-2)	IS:1367 (P-14) A2-70			
1	STOP		6	AAA15193			0.025	
1	FIXING BRACKET		5	58115006			0.194	
1	COVERING SHEET COMPLETE		4	58115005			1.271	
1	BRACKET COMPLETE.		3	58115014			1.654	
1	ANGLE SUPPORT		2	AAA15431			0.377	
1	BRACKET		1	AAA15428			5.568	
Default	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DGS.	MATL	WT/UNIT IN KGS	REMARKS	
GROUP: 1-5 End Construction		SURFACE AREA IN Sq.m.: 0.960			WT/ASSY IN Kgs: 9.449			
BRACKET COMPLETE					SCALE	SSE/D	Handwritten signature	
					1:2	CHD		
					ALT. a	ALTD	H. Ishath Ahamed	
						DRN	B.SARAVANAN	
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038						LGS/EOG		
					SHEET 1 OF 1	58115004		A1

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO CF/STD-9-0-001. ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER BS 813-1986.

REF.DRG.NO.

58115005

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

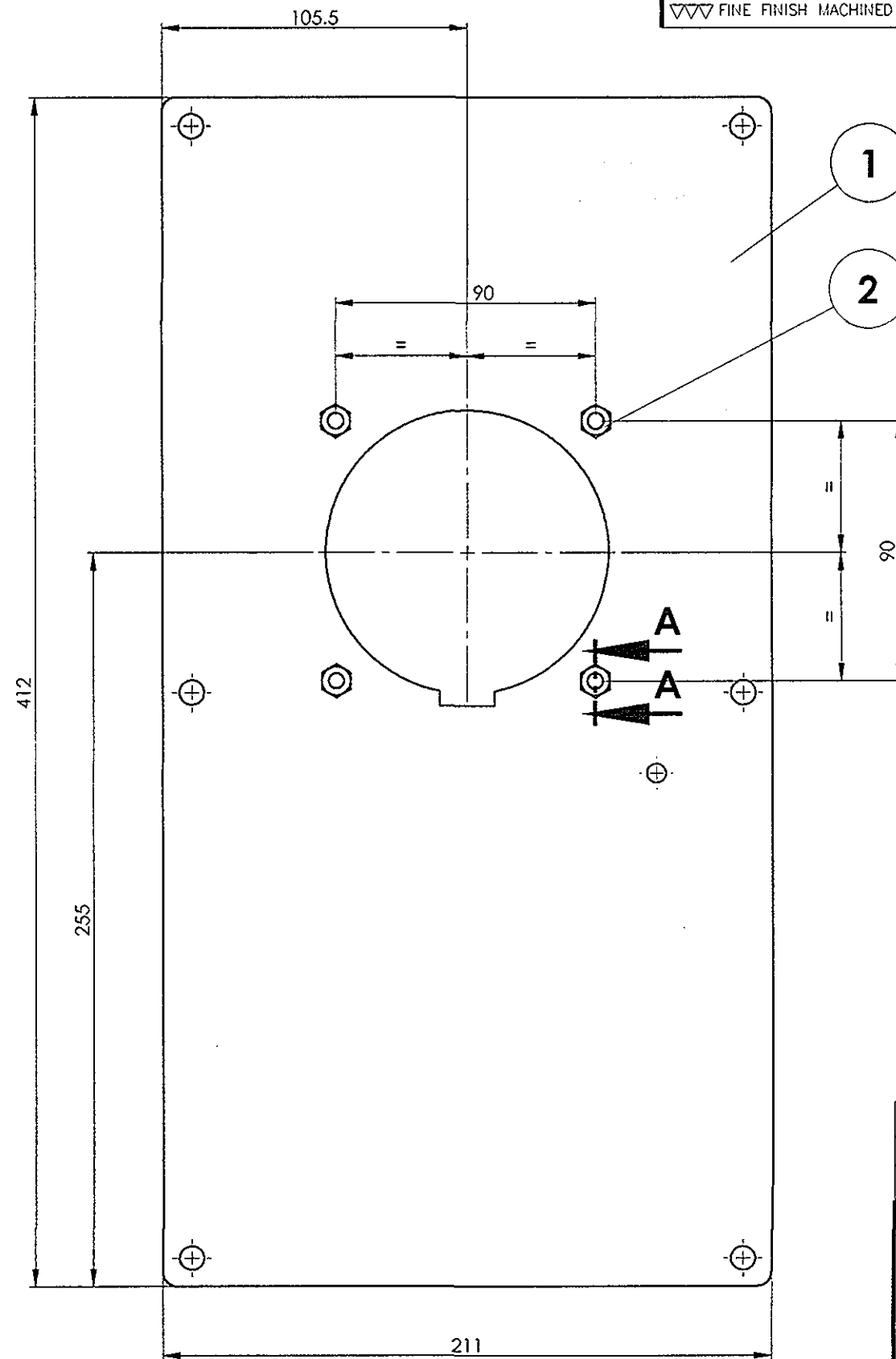
① ROUGH CLEANED
② BURRS REMOVED
③ CHAMFERED

REVISIONS

ALT.

ZONE

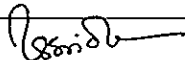

DESCRIPTION

APPROVED &
DATE

SECTION A-A SCALE 1 : 1

NOTE:

1. ALL WELD SPATTERS SHALL BE GROUND.
2. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
3. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
4. ALL WELDINGS SHALL BE TIG WELDING UNLESS OTHERWISE SPECIFIED.
5. FINISHED ASSEMBLY SHALL BE APPLIED WITH (AIRLESS SPRAY) ECO FRIENDLY WATER BASED MODIFIED EPOXY ZINC PHOSPHATE ETCH PRIMER TO ICF/MD/SPEC-231.

4	HEXAGON NUT	IS:1364(PART-3)/ISO 4032-M6-A2-70	2	IS:1364	IS:1367 (P-14) A2- 70			
1	SHEET		1	AAA15429		1.259		
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS	
GROUP: 1-5 END CONSTRUCTION			SURFACE AREA IN Sq.m.:0.164			WT/ASSY IN Kgs:1.587		
COVERING SHEET COMPLETE FOR BULK SUPPLY MOUNTING ON LHB/EOG COACHES.						SCALE	SSE/D	
						1:2	CHD	
						ALT.	ALTD	
							DRN	B.SARAVANAN
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038								LGS/EOG
						SHEET 1 OF 1		58115005

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICF/STD-9-0-001.
ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER IS: 813-1986.

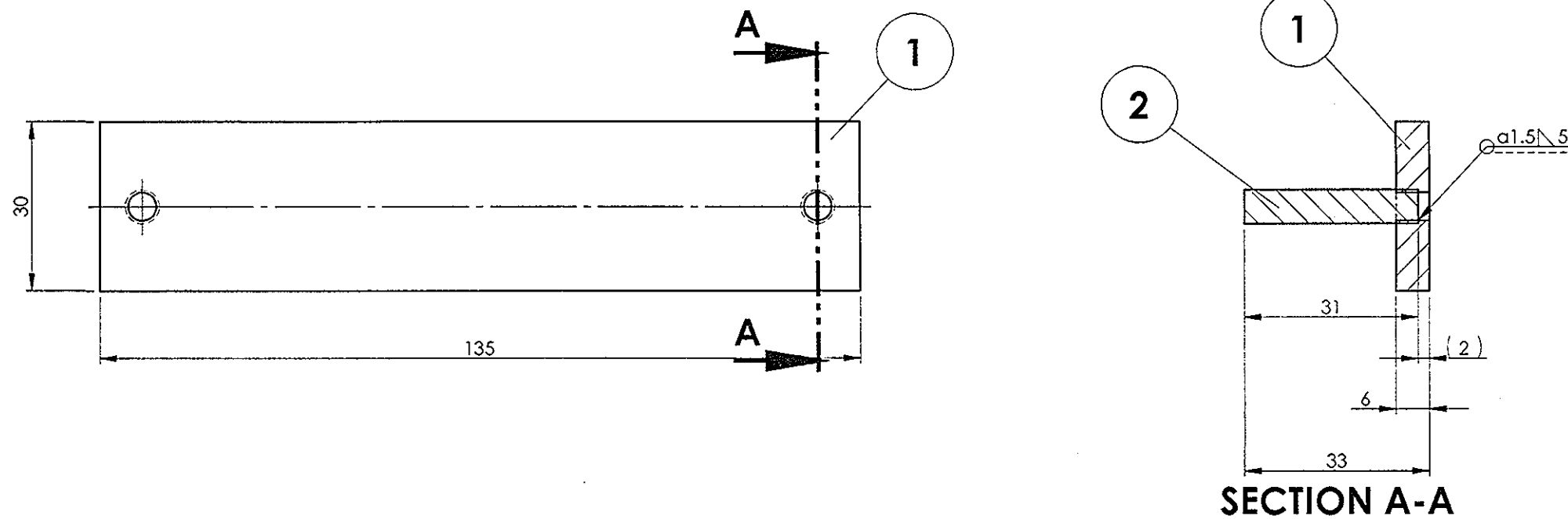
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DATE OF LATEST ALT.	28 -03-2013	AME/SME
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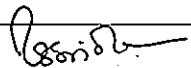
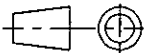
58115006

▽ ROUGH MACHINED	⊖ ROUGH CLEANED
▽▽ FINISH MACHINED	⊖⊖ BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	⊖⊖⊖ CHAMFERED

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE

**NOTE:**

1. ALL WELD SPATTERS SHALL BE GROUND.
2. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
3. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
4. ALL WELDINGS SHALL BE TIG WELDING UNLESS OTHERWISE SPECIFIED.
5. FINISHED ASSEMBLY SHALL BE APPLIED WITH (AIRLESS SPRAY) ECO FRIENDLY WATER BASED MODIFIED EPOXY ZINC PHOSPHATE ETCH PRIMER TO ICF/MD/SPEC-231.

2	STUD	A M6x25 IS:1862 P-8.8	2	IS 1862			
1	BRACKET		1	AAA15430		0.193	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS
GROUP: 1-5		SURFACE AREA IN Sq.m.:0.011			WT/ASSY IN Kgs:0.193		
FIXING BRACKET (RH)					SCALE	SSE/D	
					1:1	CHD	
					ALT.	ALTD	
						DRN	B.SARAVANAN
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038							LGS/EOG
					SHEET 1 OF 1		

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICF/STD-9-0-001.
ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER IS: 813-1986.

REF.DRG.NO. 3 10113.0.20.120.035

	28 -03-2013	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

58115014

4		5		6		7		8	
▽ ROUGH MACHINED		① ROUGH CLEANED		REVISIONS					
▽▽ FINISH MACHINED		①① BURRS REMOVED		ALT.	ZONE	DESCRIPTION		APPROVED & DATE	
▽▽▽ FINE FINISH MACHINED		①①① CHAMFERED							

1

2

30

196 ±0.2

196 ±0.2

83

191 ±0.2

A

A

1

2

α1.5 3x7

SECTION A-A
SCALE 1 : 2

NOTE:

1. ALL WELD SPATTERS SHALL BE GROUND.
2. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
3. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
4. ALL WELDINGS SHALL BE TIG WELDING UNLESS OTHERWISE SPECIFIED.
5. FINISHED ASSEMBLY SHALL BE APPLIED WITH (AIRLESS SPRAY) ECO FRIENDLY WATER BASED MODIFIED EPOXY ZINC PHOSPHATE ETCH PRIMER TO ICF/MD/SPEC-231.

6	HEXAGON NUT	IS:1364(PART-3)/ISO 4032-M6-A2-70	2	IS:1364	IS:1367 (P-14) A2-70		
1	BRACKET		1	AAA15433		1.636	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS
GROUP: 1-5 END CONSTRUCTION				SURFACE AREA IN Sq.m.:0.173		WT/ASSY IN Kgs:1.654	
BRACKET COMPLETE.						SCALE	SSE/D
						1:5	CHD
						ALT.	ALTD
						DRN	B.SARAVANAN
INDIAN RAILWAY STANDARDS						SHEET 1 OF 1	
INTEGRAL COACH FACTORY, CHENNAI - 600038						58115014	
						A3	

REF.DRG.NO.3 10113.0.20.120.032_A

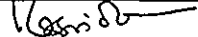
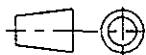
28 -03-2013

AME/SME

DATE OF LATEST ALT.

DATE OF FIRST ISSUE

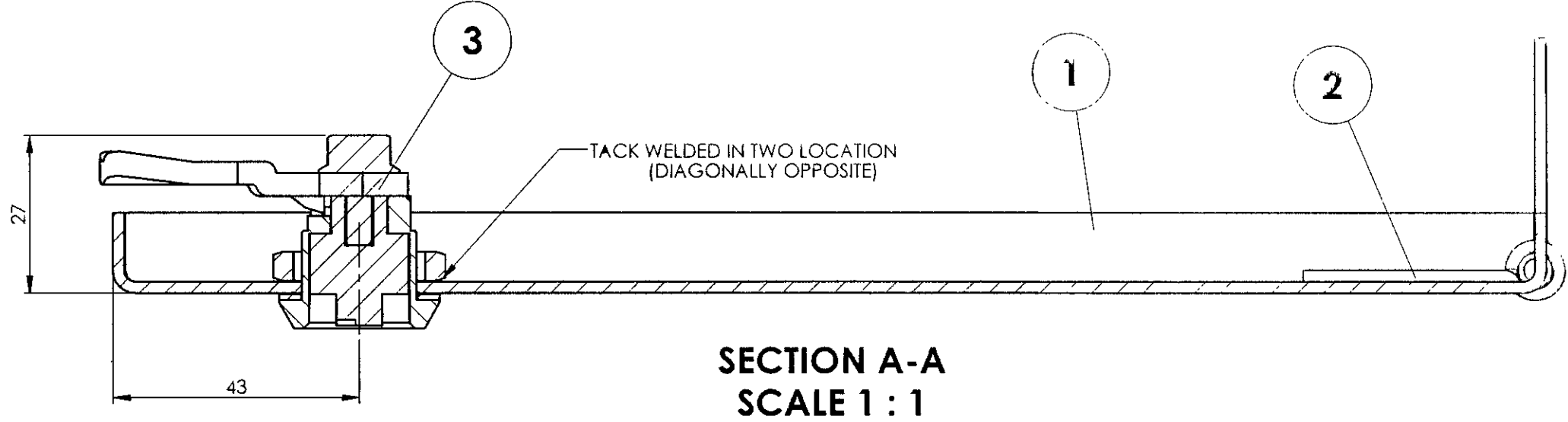
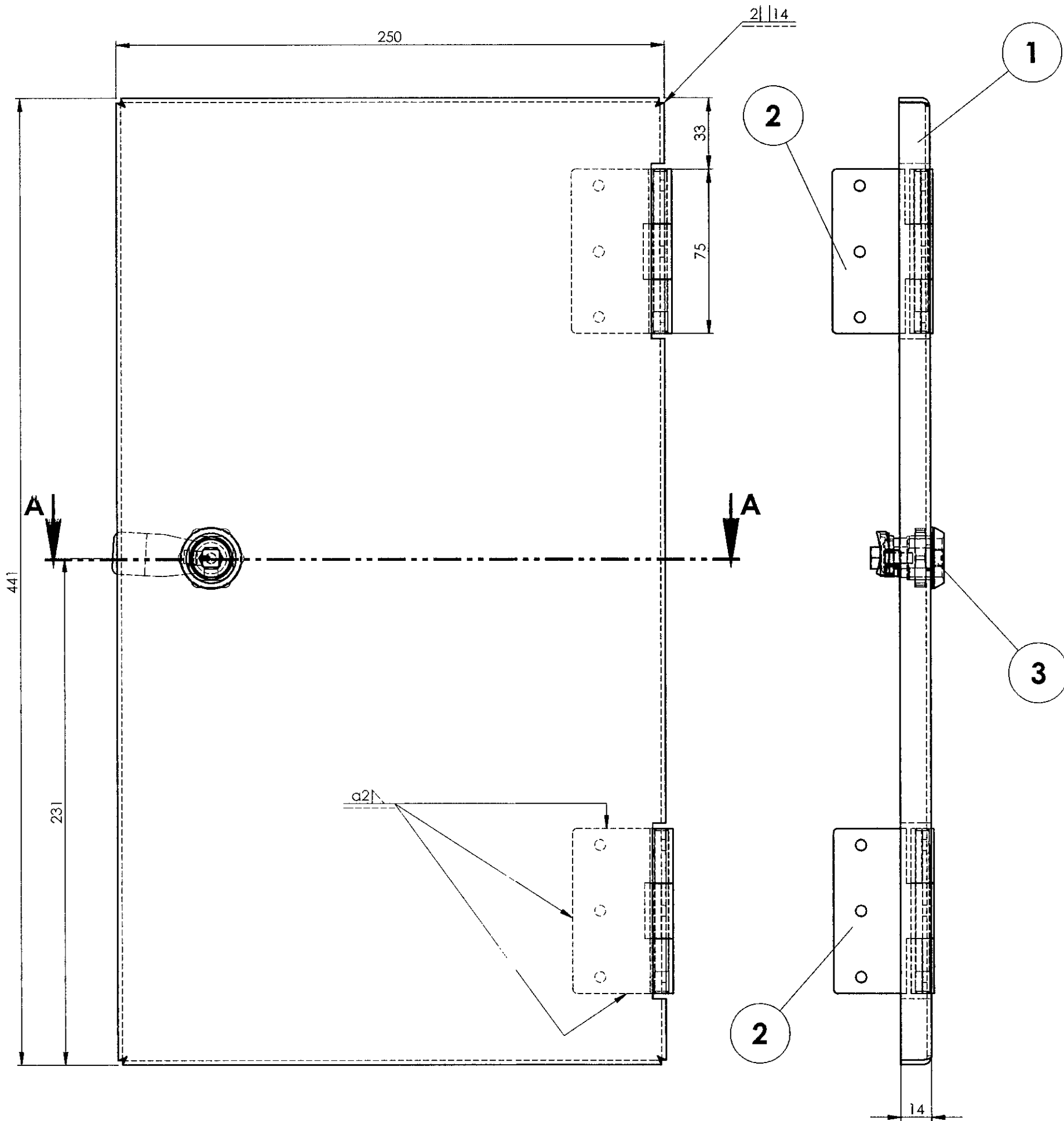
1. ALL WELD SPATTERS SHALL BE GROUND.
2. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
3. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
4. ALL WELDINGS SHALL BE TIG WELDING UNLESS OTHERWISE SPECIFIED.
5. FINISHED ASSEMBLY SHALL BE APPLIED WITH (AIRLESS SPRAY) ECO FRIENDLY WATER BASED MODIFIED EPOXY ZINC PHOSPHATE ETCH PRIMER TO ICF/MD/SPEC-231.

6	HEXAGON NUT	IS:1364(PART-3)/ISO 4032-M6-A2-70	2	IS:1364	IS:1367 (P-14) A2- 70		
1	BRACKET		1	AAA15433		1.636	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS.	REMARKS
GROUP: 1-5 END CONSTRUCTION		SURFACE AREA IN Sq.m.:0.173			WT/ASSY IN Kgs:1.654		
BRACKET COMPLETE.					SCALE	SSE/D	
					1:5	CHD	
					ALT.	ALTD	
						DRN	B.SARAVANAN
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1	 LGS/EOG		
					58115014		A3

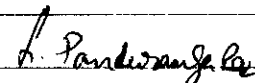
58115015

▽ ROUGH MACHINED	⊖1 ROUGH CLEANED
▽▽ FINISH MACHINED	⊖2 BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	⊖3 CHAMFERED

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE
a		REF. DRG. DELETED AND REMARK ALTD FOR ITEM-3.	SA. 04-2019
b		ITEM-4 AND NOTE-7&8 ADDED. ITEMS-1,2,3 & NOTE-6 REVISED.	SA. 25-06-2020
c		ITEM-4 & NOTE-8 DELETED. NOTE-6 & 7 REVISED.	11/2/24



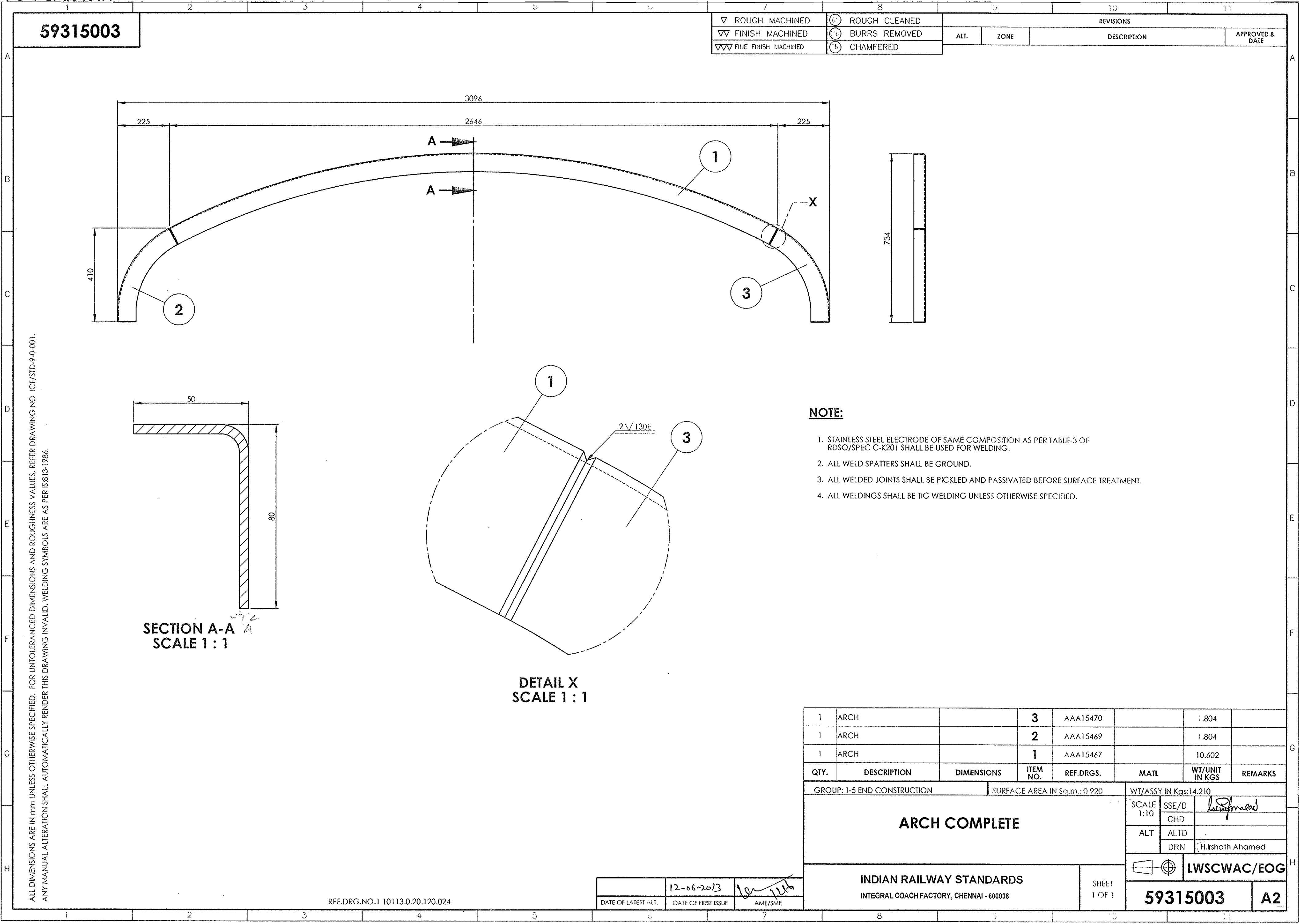
- NOTE:**
- 1. ALL WELD SPATTERS SHALL BE GROUND.
 - 2. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT
 - 3. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
 - 4. ALL WELDINGS SHALL BE TIG WELDING UNLESS OTHERWISE SPECIFIED.
 - 5. FINISHED ASSEMBLY SHALL BE APPLIED WITH (AIRLESS SPRAY) ECO FRIENDLY WATER BASED MODIFIED EPOXY ZINC PHOSPHATE ETCH PRIMER TO ICF/MD/SPEC-231.
 - 6. # CAM LATCH TO PART NUMBER -E5-32-0524-111 OF M/S. SOUTHCO (OR) CAM LATCH TO PART NUMBER 379-0065.07-30326 AND PART NUMBER 200-0520 OF M/S DIRAK TO BE USED.
 - 7. \$ - HINGE TO PART NUMBER EH-99-314 OF M/S. SOUTHCO (OR) HINGE TO PART NUMBER 378-0007.07-07550 OF M/S DIRAK TO BE USED.
 - 8. @ - LATCH NUT TO PART NUMBER E3-0-64136 OF M/S. SOUTHCO TO BE USED TO PREVENT UNAUTHORISED REMOVAL OF LOCK.

1	LATCH NUT(WELDABLE)		4	-		0.00	@
1	LOCK ASSEMBLY		3			0.009	#
2	HINGE		2			0.02	\$
1	SHUTTER		1	AAA15432		1.949	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS
GROUP: (1-5) END CONSTRUCTI			SURFACE AREA IN Sq.m.: 0.293		WT/ASSY IN Kgs:		
SHUTTER ASSEMBLY FOR EFT SOCKET					SCALE 1:2	SSE/Li	
						CHD	
					ALT c	ALTD	VIJAYAKUMAR
						DPII	B.SARAVATHI
					INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038		
58115015							
SHEET 1 OF 1							

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICF/STD-9-0-001. ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER IS:813-1986. WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY.

REF.DRG.NO.

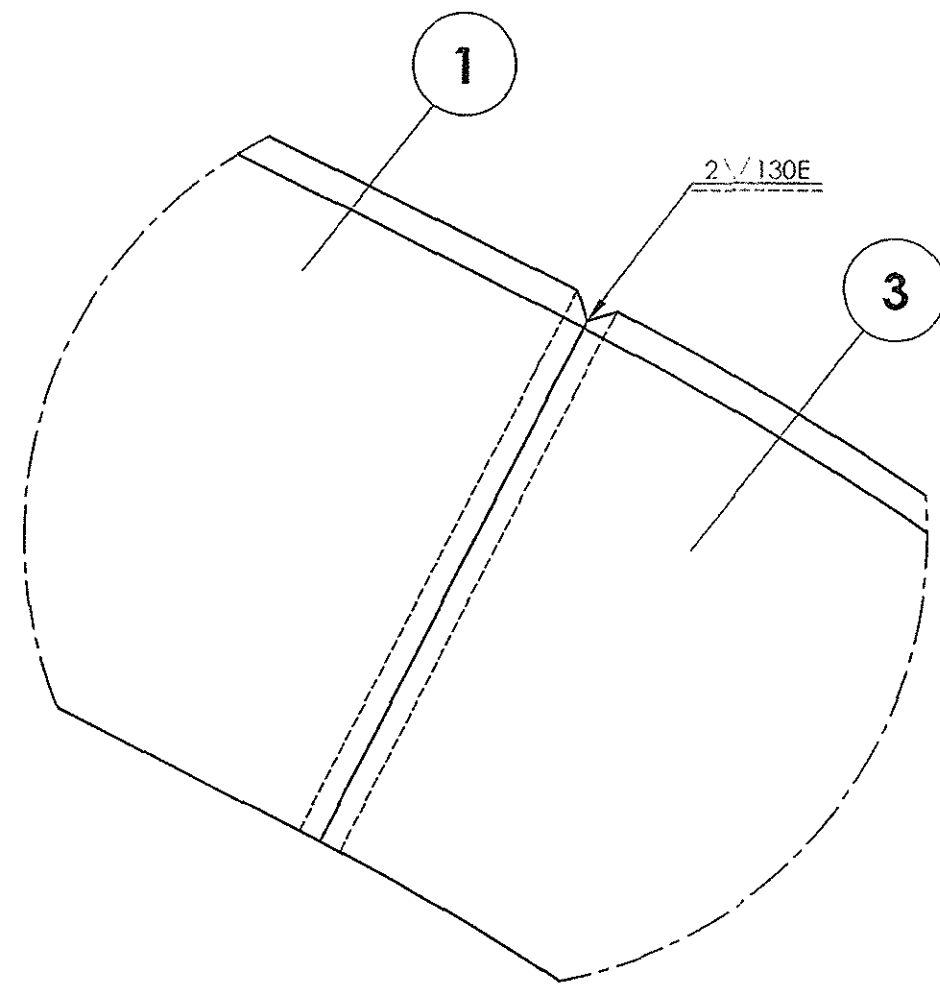
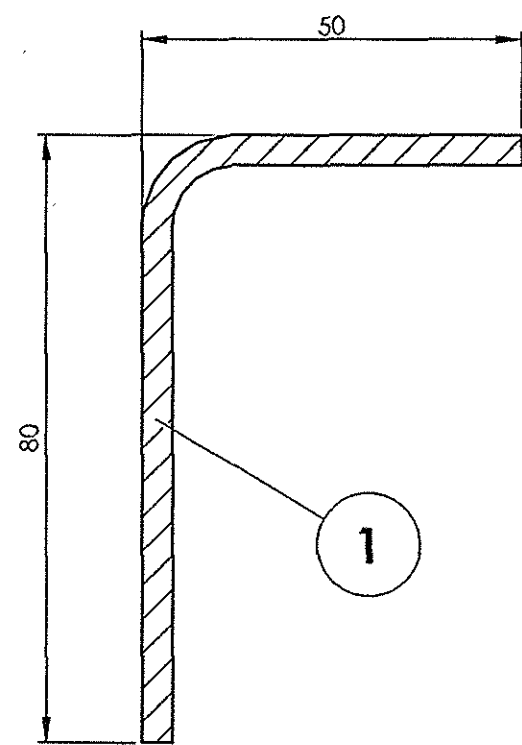
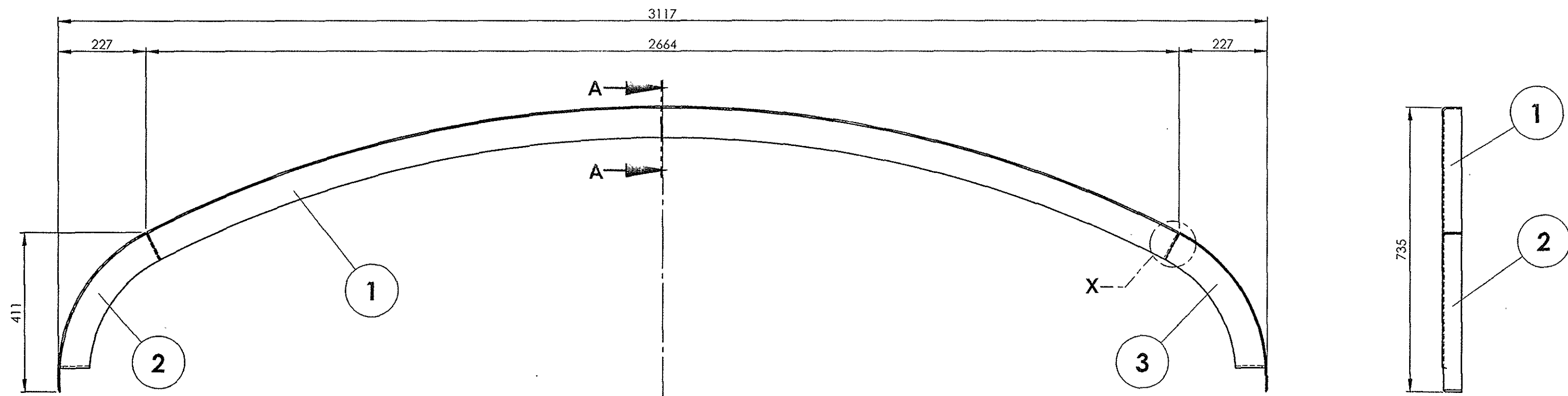
01-02-2024	28-03-2013	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME



59315004

▽ ROUGH MACHINED	⊙ ROUGH CLEANED
▽▽ FINISH MACHINED	⊙ BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	⊙ CHAMFERED

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



NOTE:

1. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC C-K201 SHALL BE USED FOR WELDING.
2. ALL WELD SPATTERS SHALL BE GROUND.
3. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
4. ALL WELDINGS SHALL BE TIG WELDING UNLESS OTHERWISE SPECIFIED.

1	ARCH		3	AAA15472		1.660	
1	ARCH		2	AAA15471		1.660	
1	ARCH		1	AAA15468		10.669	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS
GROUP: 1-5 END CONSTRUCTION				SURFACE AREA IN Sq.m.: 0.907		WT/ASSY IN Kgs: 13.990	
ARCH COMPLETE					SCALE 1:10	SSE/D CHD	<i>H. Irshath</i>
					ALT	ALTD	
					DRN	DRN	H. Irshath Ahamed
					LWSCWAC/EOG		
INDIAN RAILWAY STANDARDS				SHEET 1 OF 1		59315004	
INTEGRAL COACH FACTORY, CHENNAI - 600038						A2	

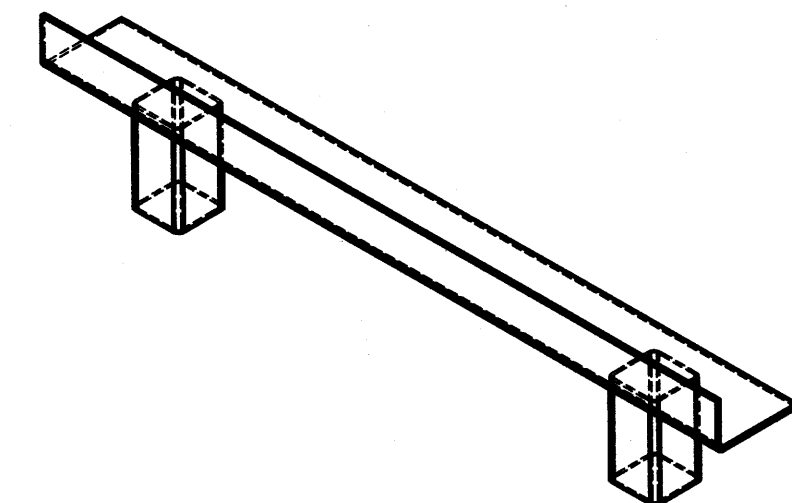
	12-06-2013	<i>12/06</i>
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

REF.DRG.NO.1 10113.0.20.120.025

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO. ICF/STD-9-0-001. ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER IS813:1986.

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO. ICF/STD-9-0-001. ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER S813-1986. WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY.

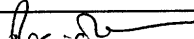


▽	ROUGH MACHINED
▽▽	FINISH MACHINED
▽▽▽	FINE FINISH MACHINED




NOTE:

1. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC C-K201 SHALL BE USED FOR WELDING.
2. ALL WELDINGS SHALL BE TIG WELDING UNLESS OTHERWISE SPECIFIED.
3. ALL WELD SPATTERS SHALL BE GROUND.
4. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
5. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
6. ALL WELD PERFORMANCE CLASS SHALL BE **CP C2** UNLESS OTHERWISE SPECIFIED.
7. FOR WELD TESTING PREFERENCES REFER DRG. No. ICF/STD-9-Q-998.
8. FOR WELD PROCEDURE SPECIFICATION REFER DRG. No. ICF/STD-9-Q-999.

2	SQ. TUBE 2.5x45x45	L=83.5	2		SS-409M	0.27	
1	ANGLE		1	AAB15888		1.71	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS

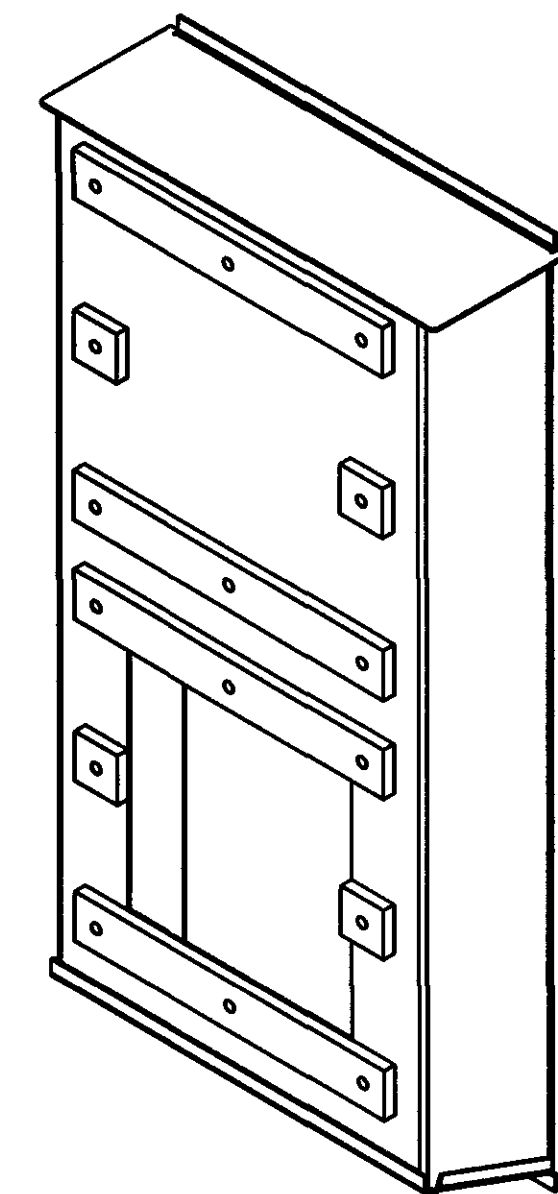
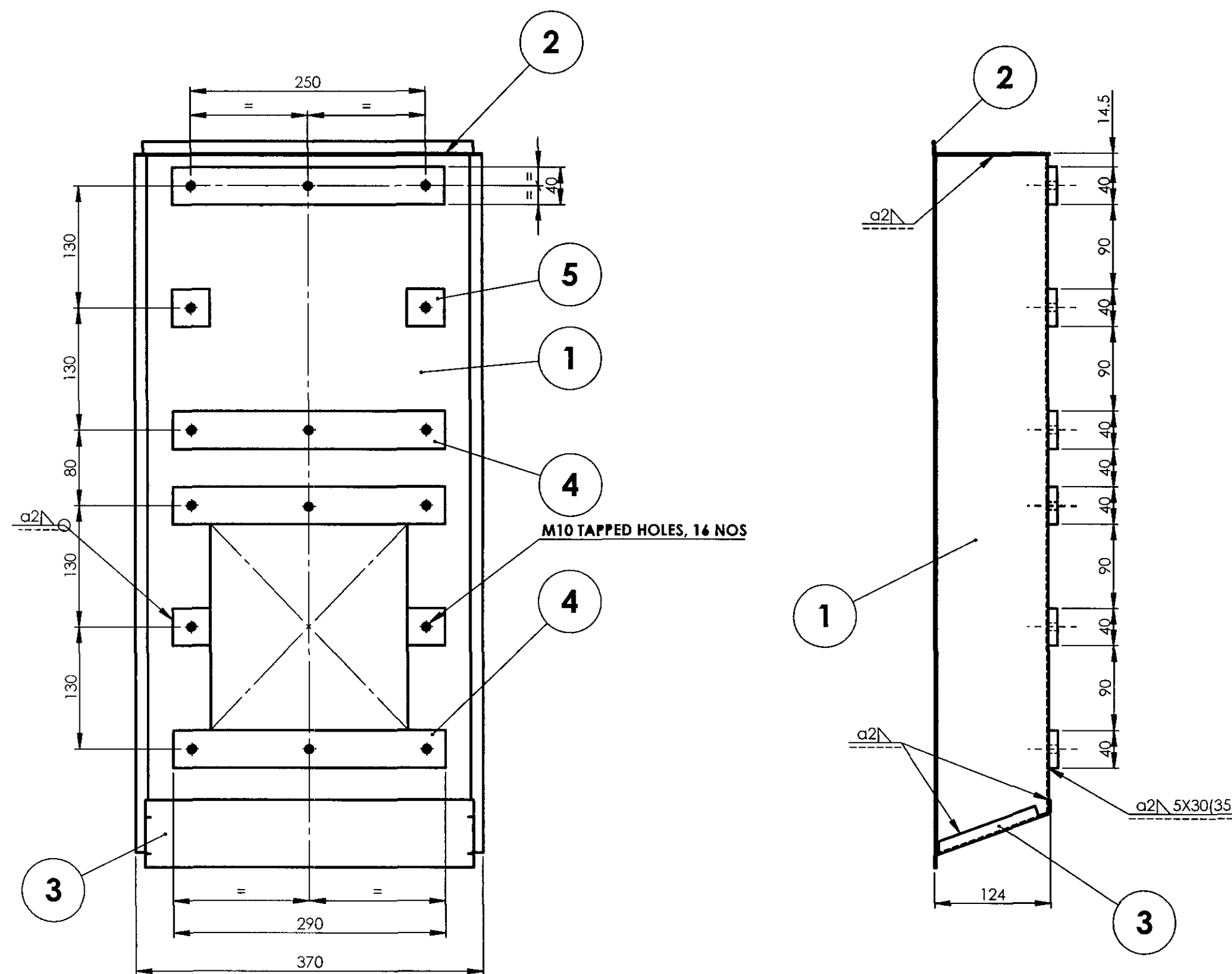
203190.14	WT/ASSY IN Kgs: 		
	SCALE 1:5	SSE/D	
		CHD	
	ALTD -	ALTD	
		DRN	B.Suresh
 	LSLRD		
	<div> <div>SHEET 1 OF 1</div> <div>74115007</div> </div> <div>A2</div>		

	27-11-2020	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

75415006

▽ ROUGH MACHINED	⓪1 ROUGH CLEANED
▽▽ FINISH MACHINED	⓪1b BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	⓪1c CHAMFERED

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE

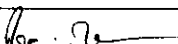


ISOMETRIC VIEW

NOTE:-

1. ALL WELDING SHALL BE OF TIG- UNLESS OTHERWISE SPECIFIED.
2. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC. CK-201 SHALL BE USED FOR WELDING.
3. ALL WELDED JOINTS SPATTERS SHALL BE GROUND.
4. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
5. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
6. ALL WELD PERFORMANCE CLASS SHALL BE CP C2 UNLESS OTHERWISE SPECIFIED.
7. FOR WELD TESTING PREFERANCES REFER DRG. No. ICF/STD-9-0-998.
8. FOR WELD PROCEDURE SPECIFICATION REFER DRG. No. ICF/STD-9-0-999.

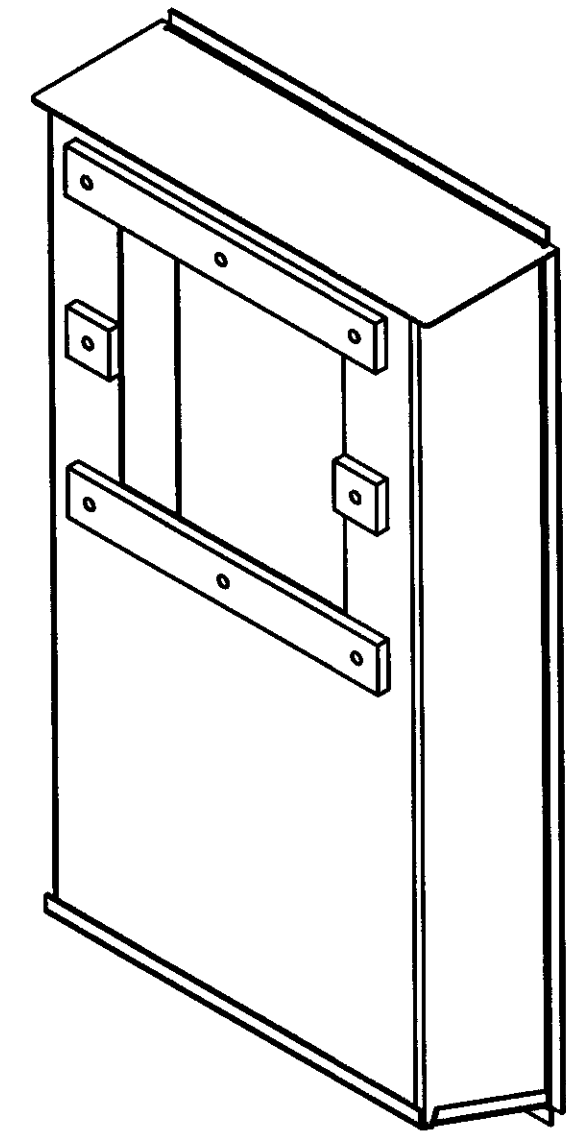
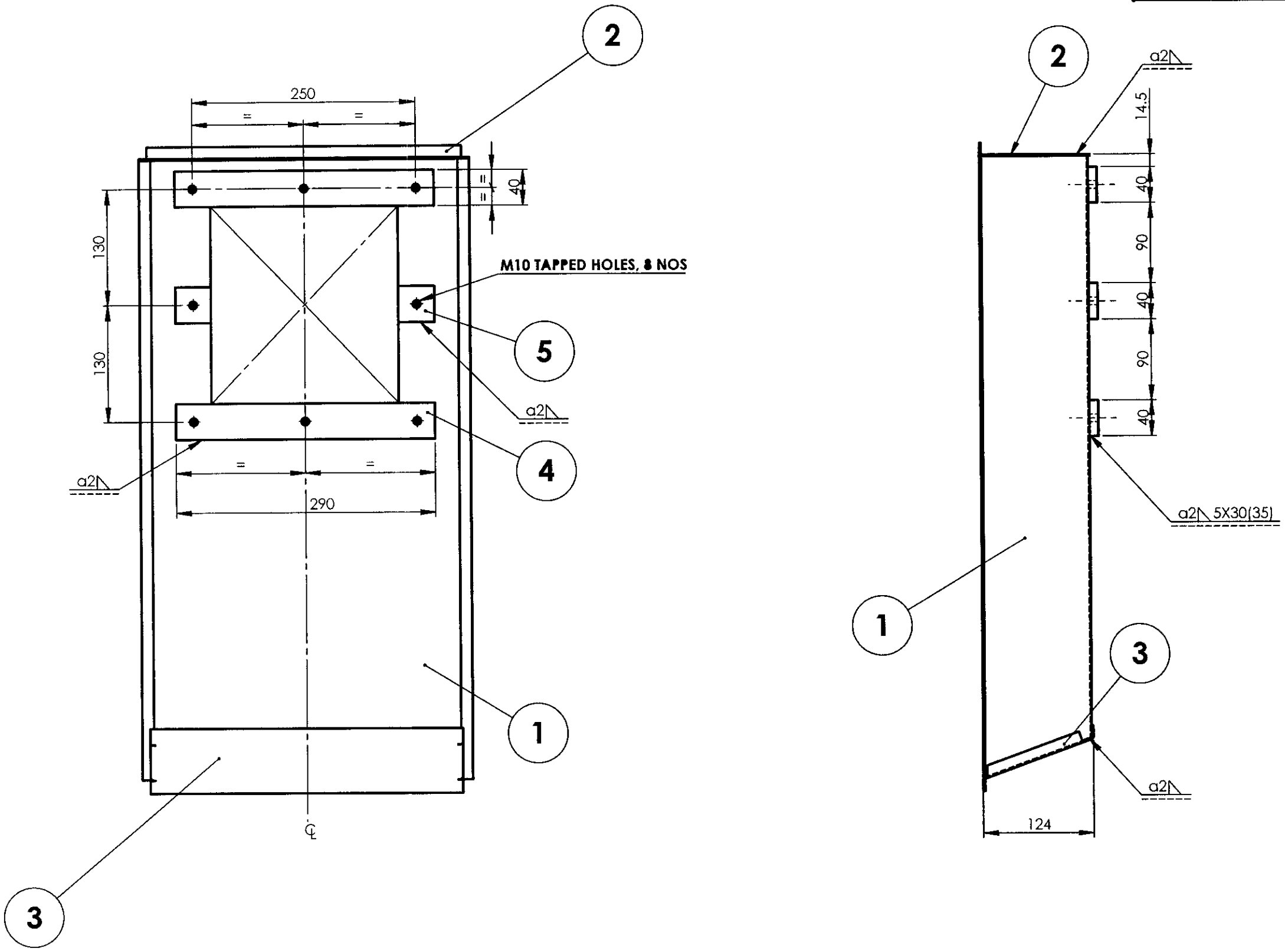
4	BACK PIECE	10x40x40	5		RDSO SPEC C-K201 X2 Cr Ni 12	0.13	
4	FLAT	10x40x290	4		RDSO SPEC C-K201 X2 Cr Ni 12	0.93	
1	CLOSING ANGLE		3	AAD15845		0.912	
1	CLOSING ANGLE		2	AAD15844		0.800	
1	BASE PLATE FOR COUPLER SOCKET		1	AAD15843		4.123	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGs.	MATL	WT/UNIT IN KGS	REMARKS

GROUP: 1-5 End Construction		SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:		
BRACKET ASSEMBLY FOR EFT AND PARKING				SCALE 1:5	SSE/D CHD	
				ALT -	ALTD	
					DRN	3D: MAHESH 2D: KUNTI THAKUR
				INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038		
75415006						
					A2	

75415007

▽ ROUGH MACHINED	01 ROUGH CLEANED
▽▽ FINISH MACHINED	01b BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	01B CHAMFERED

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



ISOMETRIC VIEW

NOTE:-

- ALL WELDING SHALL BE OF TIG UNLESS OTHERWISE SPECIFIED.
- STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC. CK-201 SHALL BE USED FOR WELDING.
- ALL WELDED JOINTS SPATTERS SHALL BE GROUND.
- ALL SHARP CORNERS SHALL BE ROUNDED OFF.
- ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
- ALL WELD PERFORMANCE CLASS SHALL BE CP C2 UNLESS OTHERWISE SPECIFIED.
- FOR WELD TESTING PREFERANCES REFER DRG. No. ICF/STD-9-0-998.
- FOR WELD PROCEDURE SPECIFICATION REFER DRG. No. ICF/STD-9-0-999.

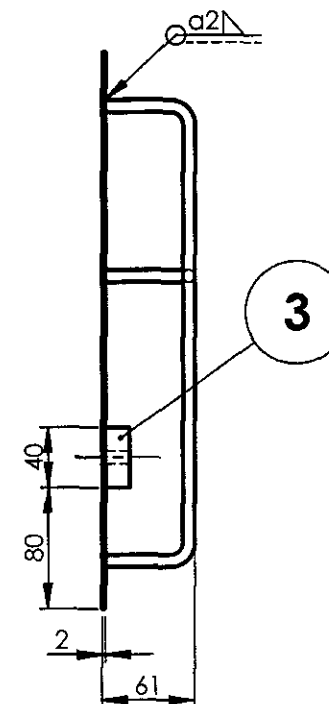
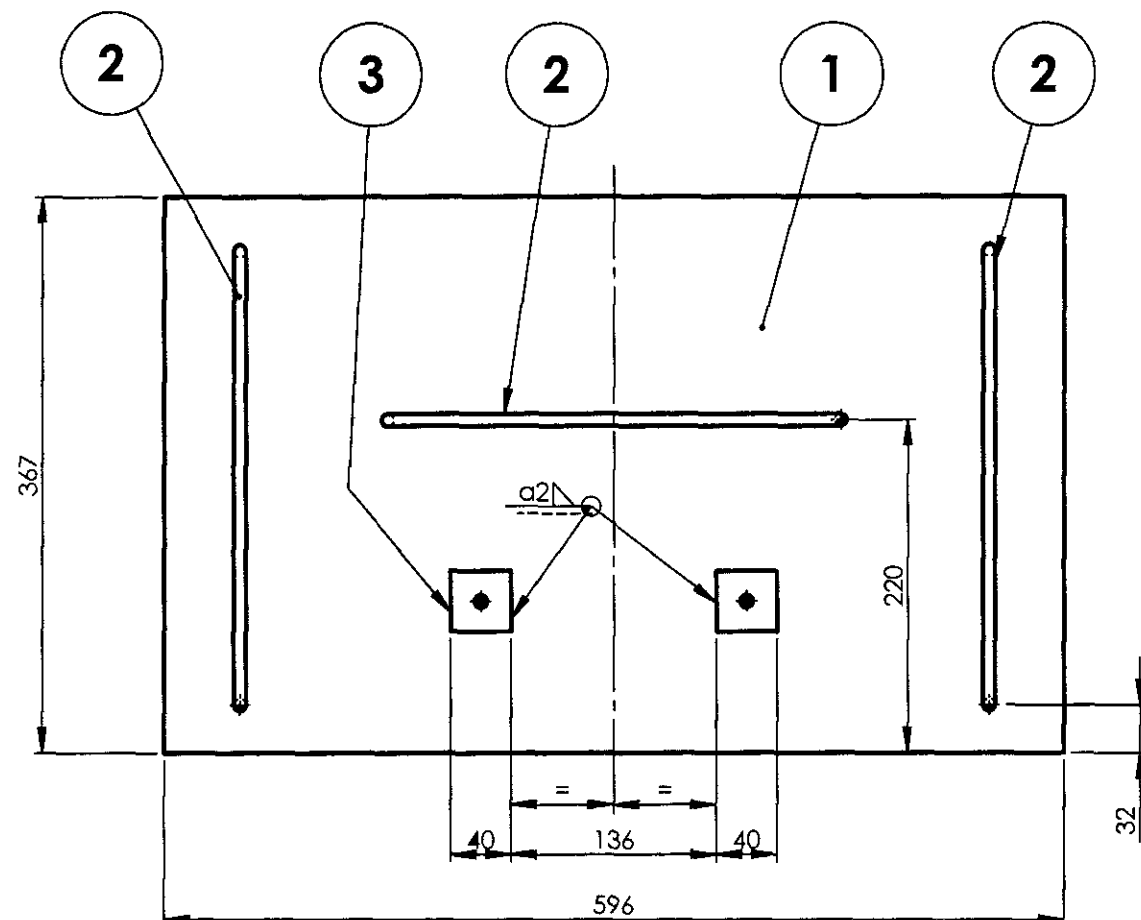
2	BACK PIECE	10x40x40	5		RDSO SPEC C-K201 X2 Cr Ni 12	0.13	
2	FLAT	10x40x290	4		RDSO SPEC C-K201 X2 Cr Ni 12	0.93	
1	CLOSING ANGLE		3	AAD15845		0.912	
1	CLOSING ANGLE		2	AAD15844		0.800	
1	BASE PLATE FOR COUPLER SOCKET		1	AAD15848		5.451	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS
GROUP: 1-5 End Construction				SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:	
BRACKET ASSEMBLY FOR EFT AND PARKING				SCALE 1:5	SSE/D CHD	3D: MAHESH 2D: KUNITHAKUR	
				ALT	ALTD DRN	LWS/PP2	
				INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600035		SHEET 1 OF 1	75415007 A2

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO. ICF/STD-9-0-001. ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER EN ISO 2553. WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY.

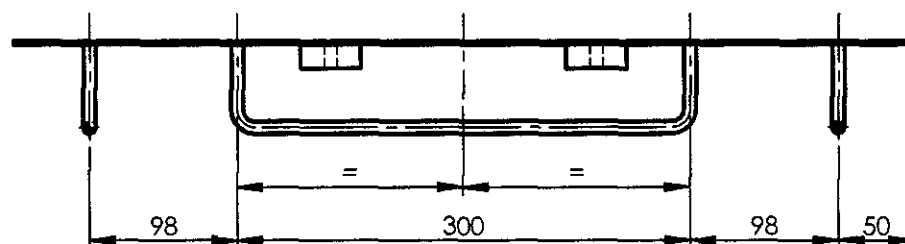
75415010

▽ ROUGH MACHINED	① ROUGH CLEANED
▽▽ FINISH MACHINED	①b BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	①8 CHAMFERED

REVISIONS				APPROVED & DATE
ALT.	ZONE	DESCRIPTION		

**NOTE:-**

1. ALL WELDING SHALL BE OF TIG UNLESS OTHERWISE SPECIFIED.
2. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC. CK-201 SHALL BE USED FOR WELDING.
3. ALL WELDED JOINTS SPATTERS SHALL BE GROUND.
4. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
5. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
6. ALL WELD PERFORMANCE CLASS SHALL BE CP C2 UNLESS OTHERWISE SPECIFIED.
7. FOR WELD TESTING PREFERENCES REFER DRG. No. ICF/STD-9-0-998.
8. FOR WELD PROCEDURE SPECIFICATION REFER DRG. No. ICF/STD-9-0-999.



2	EARTHING BLOCK		3	AAD15485		0.20	
3	ELEC CABLE TIE ROD		2	AAB15177		0.14	
1	ELEC COUPLER COVER SHEET	2x367 x596	1		RDSO SPEC C-K201 X2 Cr Ni 12	3.50	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS

GROUP: 1-5 End Construction

SURFACE AREA IN Sq.m.:

WT/ASSY IN Kgs:

ELEC COUPLER CLOSING PLATE

SCALE	SSE/D	3D: MAHESH
1:5	CHD	2D: KUNTI THAKUR
ALT.	ALTD	
	DRN	

LWS/PP2

INDIAN RAILWAY STANDARDS

INTEGRAL COACH FACTORY, CHENNAI - 600038

SHEET
1 OF 1**75415010****A3**

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICF/STD-9-0-001.
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WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY

REF.DRG.NO.

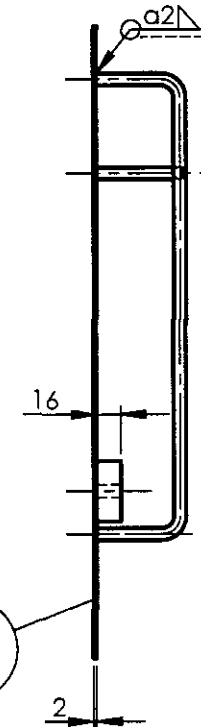
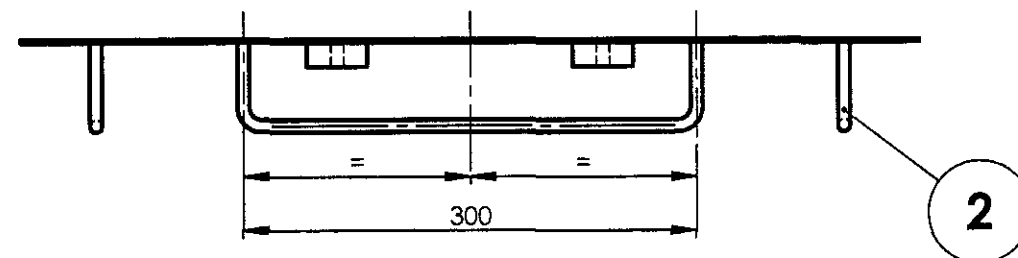
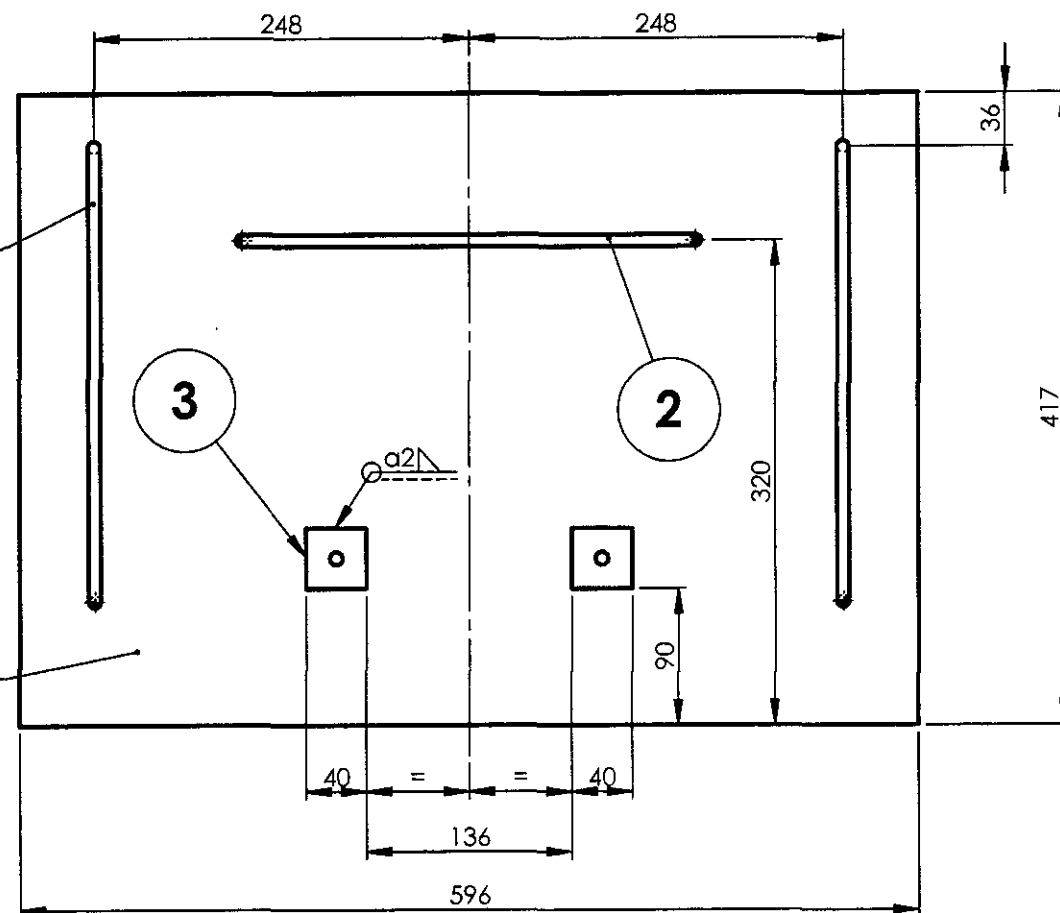
	17 -05-2024	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

75415011

▽ ROUGH MACHINED	01 ROUGH CLEANED
▽▽ FINISH MACHINED	01b BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	18 CHAMFERED

REVISIONS

ALT.	ZONE	DESCRIPTION	APPROVED & DATE
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**NOTE:-**

1. ALL WELDING SHALL BE OF TIG UNLESS OTHERWISE SPECIFIED.
2. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC. CK-201 SHALL BE USED FOR WELDING.
3. ALL WELDED JOINTS SPATTERS SHALL BE GROUND.
4. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
5. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
6. ALL WELD PERFORMANCE CLASS SHALL BE CP C2 UNLESS OTHERWISE SPECIFIED.
7. FOR WELD TESTING PREFERENCES REFER DRG. No. ICF/STD-9-0-998.
8. FOR WELD PROCEDURE SPECIFICATION REFER DRG. No. ICF/STD-9-0-999.

2	EARTHING BLOCK		3	AAD15485		0.20	
3	ELEC CABLE TIE ROD		2	AAB15177		0.16	
1	ELEC COUPLER COVER SHEET	2x417 x596	1		RDSO SPEC C-K201 X2 Cr Ni 12	3.98	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS
GROUP: 1-5 End Construction				SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:	
ELEC COUPLER CLOSING PLATE					SCALE	SSE/D	1:5
					ALT.	CHD	
					DRN	3D: MAHESH 2D: KUNTI THAKUR	
INDIAN RAILWAY STANDARDS					LWS/PP2		
INTEGRAL COACH FACTORY, CHENNAI - 600038					75415011		
SHEET 1 OF 1					A3		

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICF/STD-9-0-001.
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REF.DRG.NO.

17-05-2024

DATE OF LATEST ALT.

DATE OF FIRST ISSUE

AME/SME

75415013

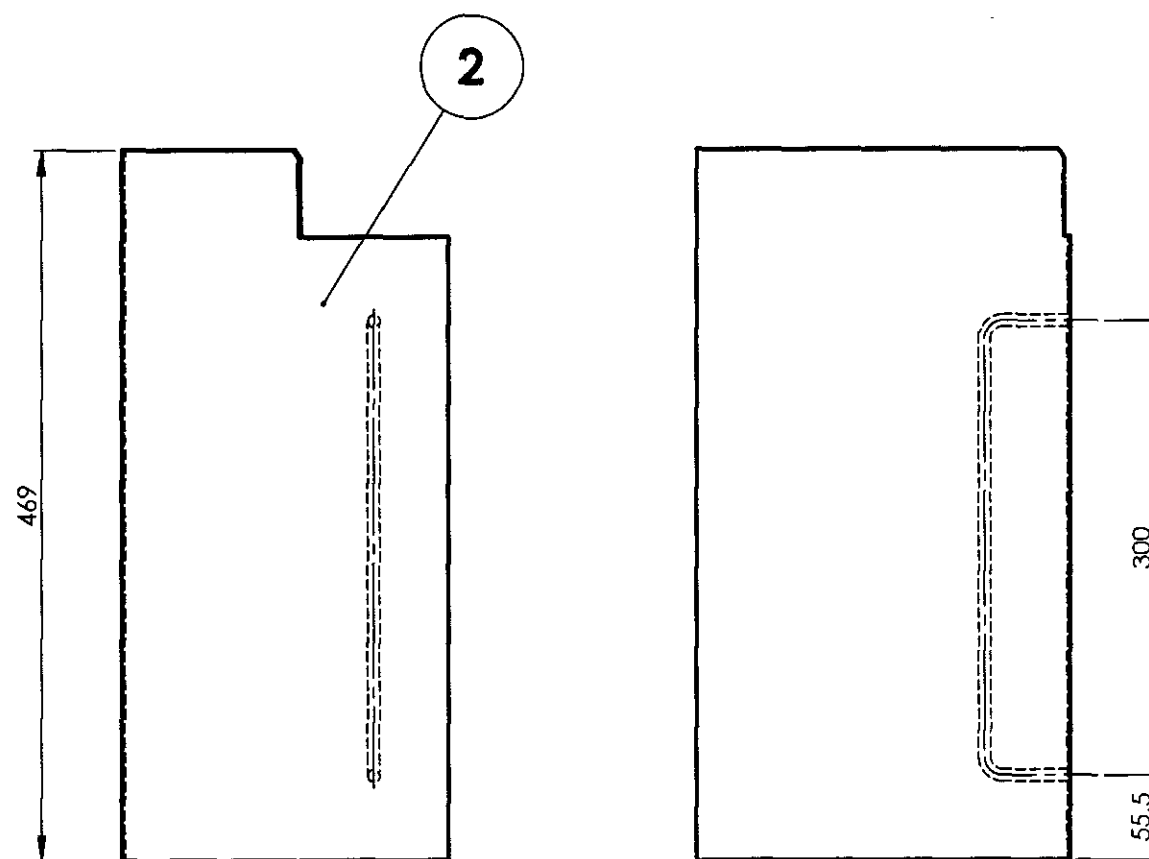
▽ ROUGH MACHINED	① ROUGH CLEANED
▽▽ FINISH MACHINED	② BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	③ CHAMFERED

REVISIONS

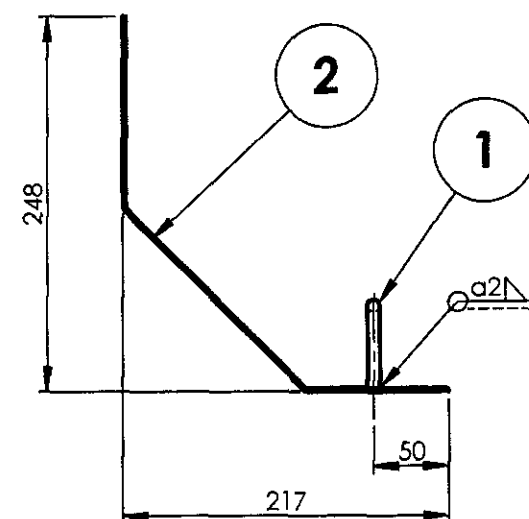
ALT.

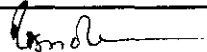

ZONE

DESCRIPTION

APPROVED &
DATE**NOTE:-**

1. ALL WELDING SHALL BE OF TIG UNLESS OTHERWISE SPECIFIED.
2. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC. CK-201 SHALL BE USED FOR WELDING.
3. ALL WELDED JOINTS SPATTERS SHALL BE GROUND.
4. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
5. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
6. ALL WELD PERFORMANCE CLASS SHALL BE CP C2 UNLESS OTHERWISE SPECIFIED.
7. FOR WELD TESTING PREFERANCES REFER DRG. No. ICF/STD-9-0-998.
8. FOR WELD PROCEDURE SPECIFICATION REFER DRG. No. ICF/STD-9-0-999.



1	ELEC COUPLER COVER		2	AAD15876		2.85	
1	ELEC CABLE TIE ROD		1	AAB15177		0.16	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS
GROUP: 1-5 End Construction		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
ELEC COUPLER COVER COMPLETE					SCALE	SSE/D	
					1:5	CHD	
					ALT.	ALTD	3D: MAHESH 2D: KUNTI THAKUR
						DRN	
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038					LWS/PP2		
					SHEET 1 OF 1		
					75415013		A3

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICF/STD-9-0-001.
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WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY

REF.DRG.NO.

17-05-2024

DATE OF LATEST ALT.

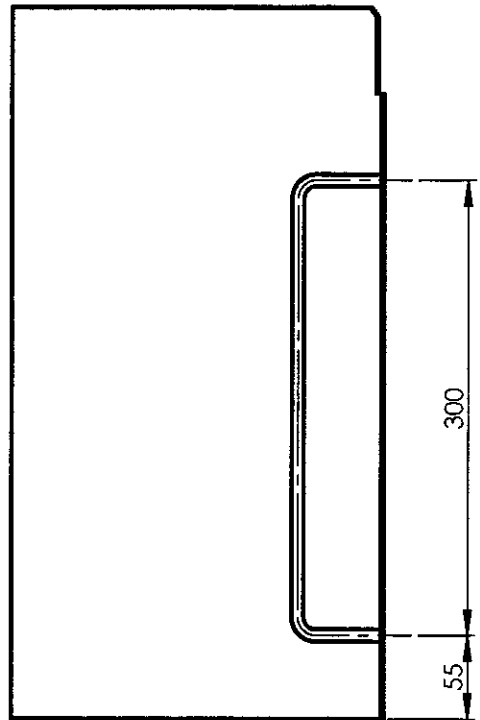
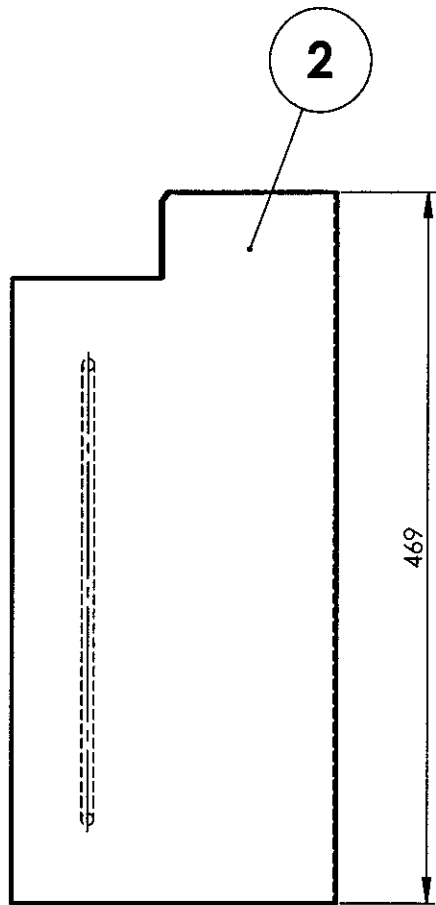
DATE OF FIRST ISSUE

AME/SME

75415014

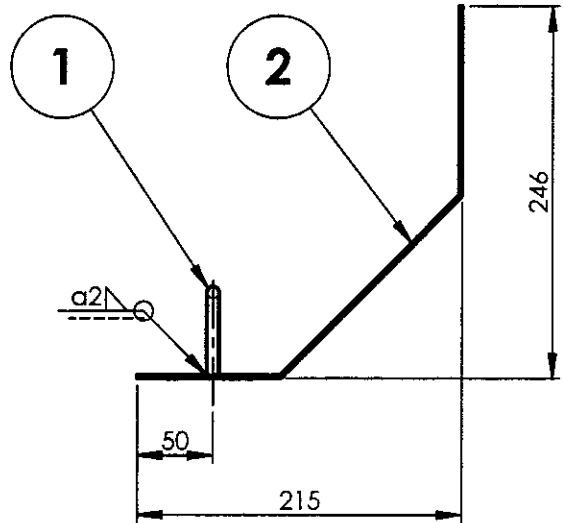
▽ ROUGH MACHINED	① ROUGH CLEANED
▽▽ FINISH MACHINED	①b BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	①8 CHAMFERED

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



NOTE:-

1. ALL WELDING SHALL BE OF TIG UNLESS OTHERWISE SPECIFIED.
2. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC. CK-201 SHALL BE USED FOR WELDING.
3. ALL WELDED JOINTS SPATTERS SHALL BE GROUND.
4. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
5. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
6. ALL WELD PERFORMANCE CLASS SHALL BE CP C2 UNLESS OTHERWISE SPECIFIED.
7. FOR WELD TESTING PREFERANCES REFER DRG. No. ICF/STD-9-0-998.
8. FOR WELD PROCEDURE SPECIFICATION REFER DRG. No. ICF/STD-9-0-999.



1	ELEC COUPLER COVER		2	AAD15877		2.83	
1	ELEC CABLE TIE ROD		1	AAB15177		0.16	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS


GROUP: 1-5 End Construction		SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:		
ELEC COUPLER COVER COMPLETE				SCALE	SSE/D	
				1:5	CHD	
				ALT.	ALTD	3D: MAHESH 2D: KUNTI THAKUR
				-	DRN	
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038		SHEET 1 OF 1			LWS/PP2	
				75415014		A3

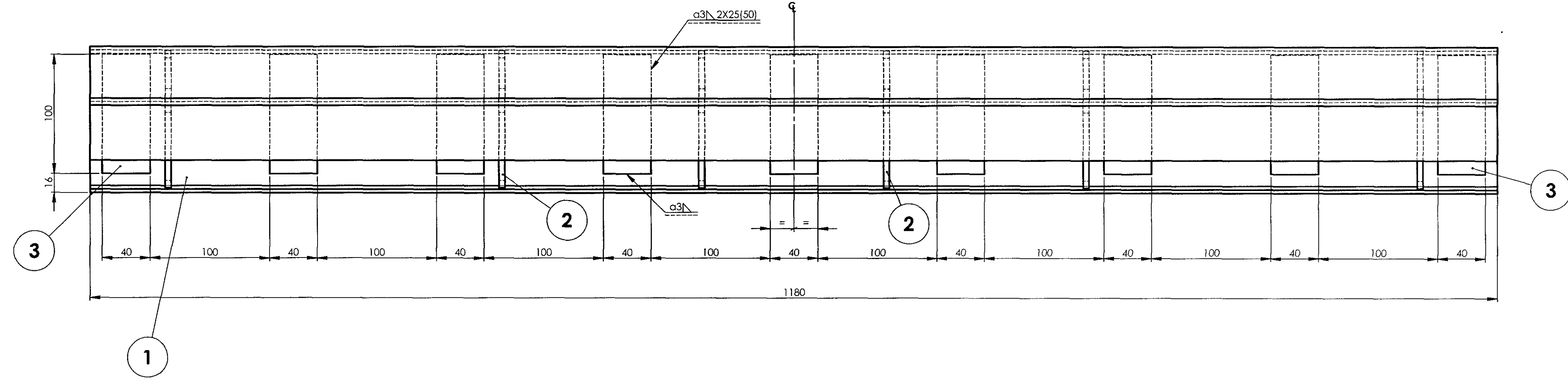
ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICF/STD-9-0-001.
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REF.DRG.NO.

	17-05-2024	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

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	30-07-2025	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME



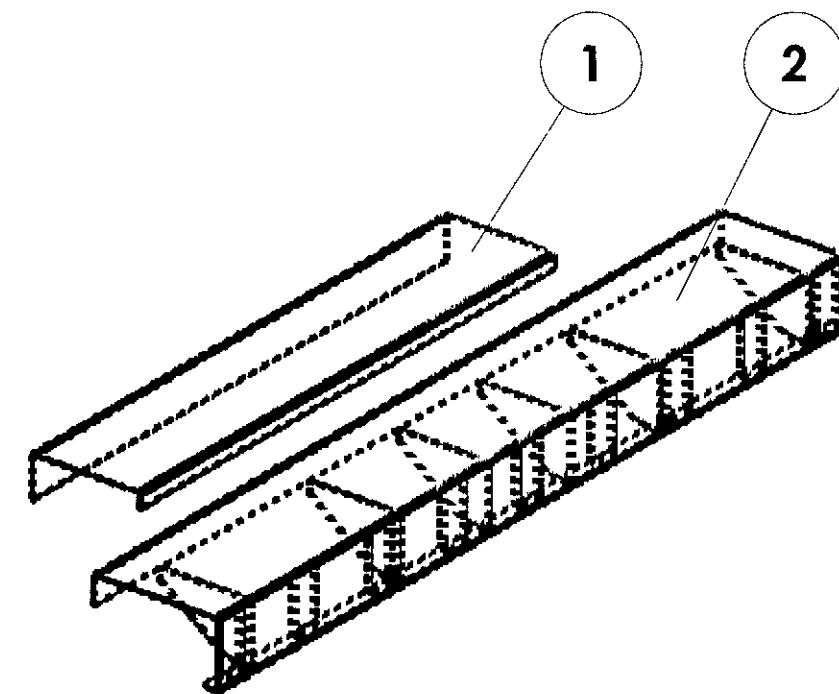
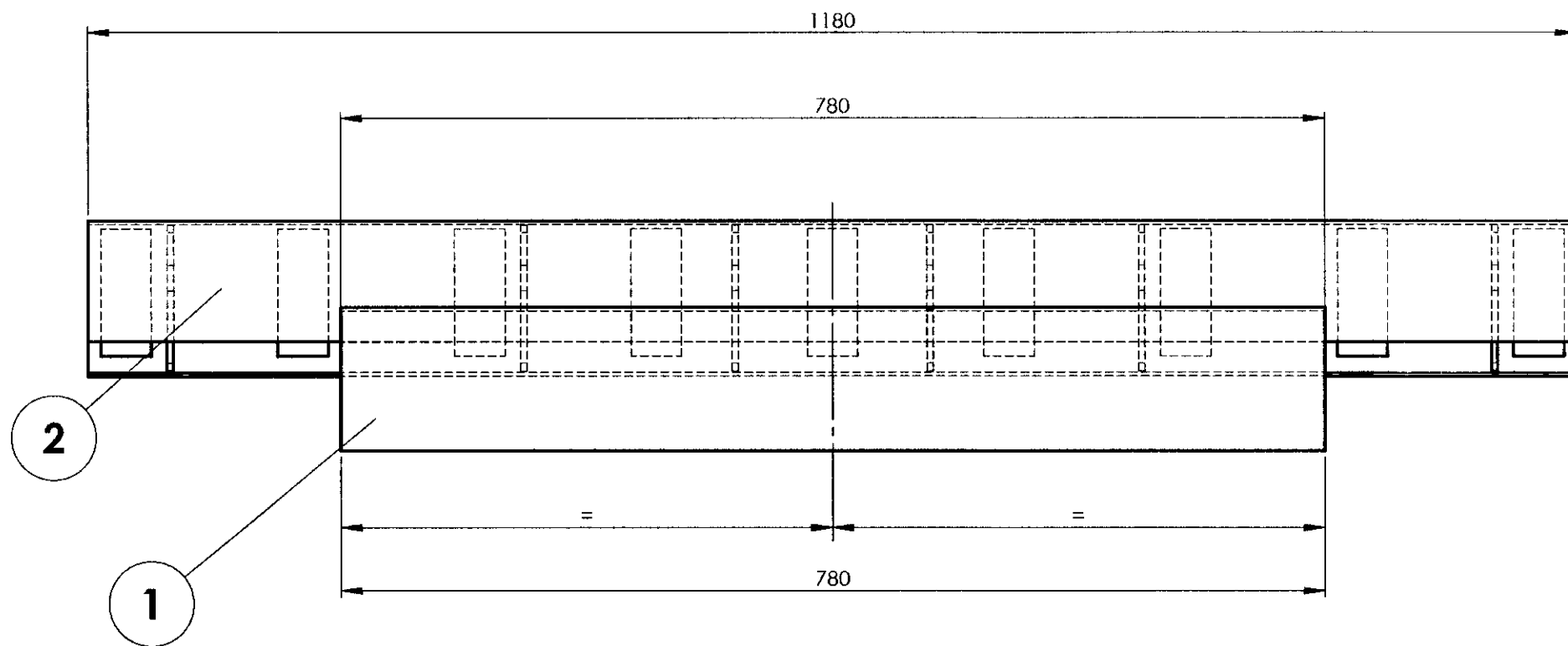
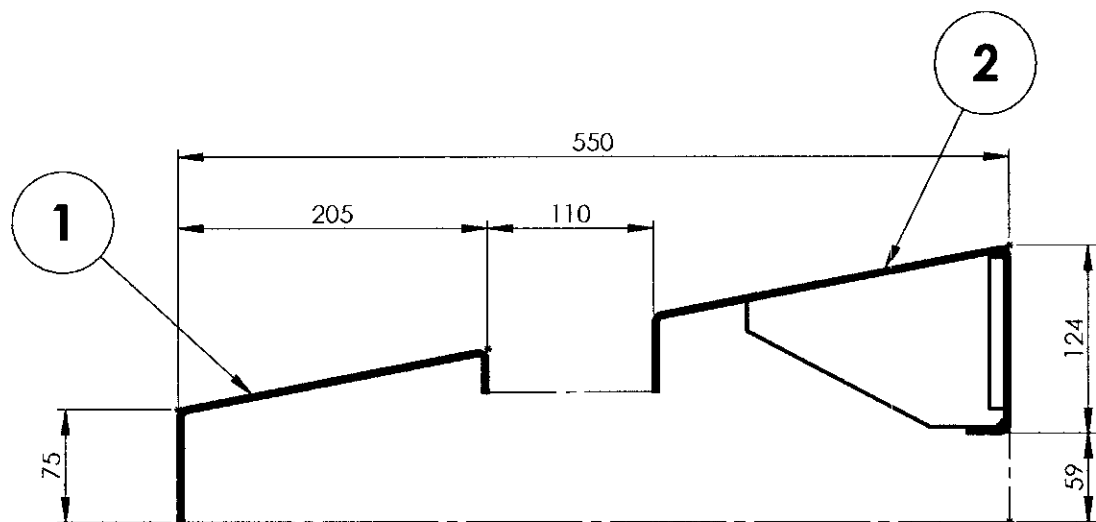
1. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC C-K201 SHALL BE USED FOR WELDING.
2. ALL WELDINGS SHALL BE TIG WELDING UNLESS OTHERWISE SPECIFIED.
3. ALL WELD SPATTERS SHALL BE GROUND.
4. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
5. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
6. ALL WELD PERFORMANCE CLASS SHALL BE **CF C2** UNLESS OTHERWISE SPECIFIED.
7. FOR WELD TESTING PREFERENCES REFER DRG. No. ICF/STD-9-0-998.
8. FOR WELD PROCEDURE SPECIFICATION REFER DRG. No. ICF/STD-9-0-999.
9. FINISHED ASSEMBLY SHALL BE APPLIED WITH (AIRLESS SPRAY)ECO FRIENDLY WATER BASED MODIFIED EPOXY ZINC PHOSPHATE ETCH PRIMER TO ICF/MD/SPEC-231.

INDIAN RAILWAY STANDARDS
INTEGRAL COACH FACTORY, CHENNAI - 600038

75415022

▽ ROUGH MACHINED	① ROUGH CLEANED
▽▽ FINISH MACHINED	② BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	③ CHAMFERED

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



ISOMETRIC VIEW

NOTE:

1. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC C-K201 SHALL BE USED FOR WELDING.
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8. FOR WELD PROCEDURE SPECIFICATION REFER DRG. No. ICF/STD-9-0-999.
9. FINISHED ASSEMBLY SHALL BE APPLIED WITH (AIRLESS SPRAY) ECO FRIENDLY WATER BASED MODIFIED EPOXY ZINC PHOSPHATE ETCH PRIMER TO ICF/MD/SPEC-231.
10. ITEM-1 SHALL BE SUPPLIED LOOSE AND WELDED AFTER BODY SHELL INTEGRATION.

1	RAMP ARRANGEMENT		2	75415015		18.124	
1	CHANNEL		1	AAB15841		5.44	\$
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS
GROUP: 1-5 End Construction				SURFACE AREA IN Sq.m.: 1.765		WT/ASSY IN Kgs:	
RAMP ARRANGEMENT					SCALE 1:10	SSE: CHD	B-Suresh
					ALT	ALTD	
					DRN	DRN	B.Suresh
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038					SHEET 1 OF 1	LWS/PP2	
					75415022		A2

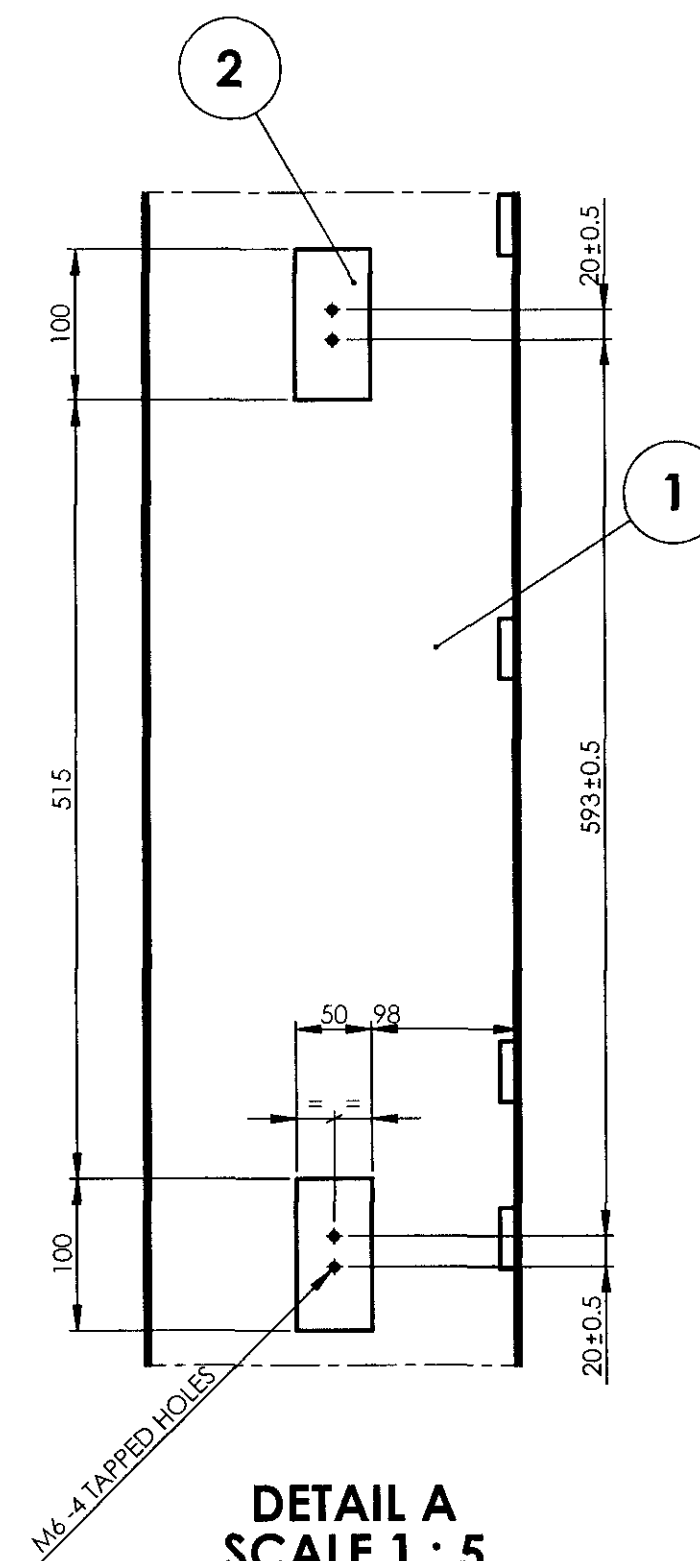
REF.DRG.NO.-

DATE OF LATEST ALT.	30-07-2025	AME/SME
DATE OF FIRST ISSUE		

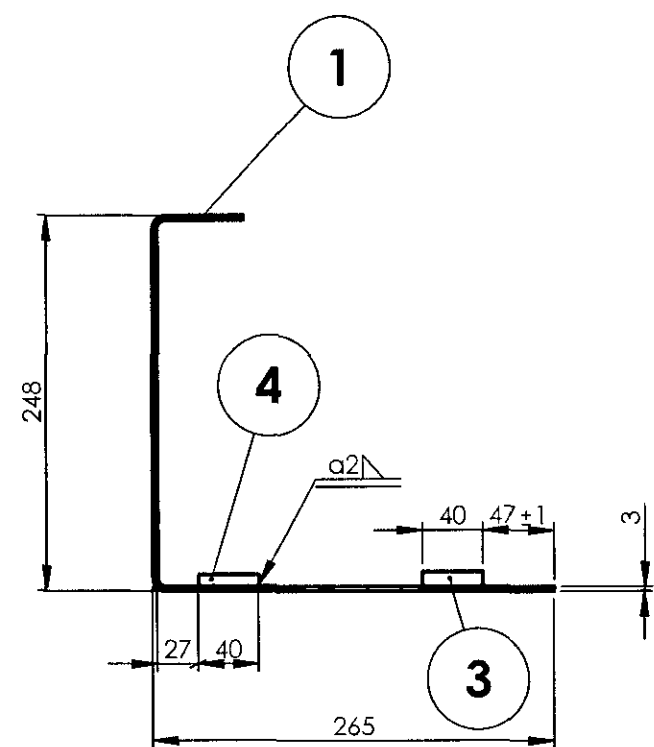
H	G	F	D	C
<p>ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO. ICF/STD-9-0-001.</p> <p>ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER EN ISO 2553. WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY</p>				

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE

1. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC C-K201 SHALL BE USED FOR WELDING.
2. ALL WELDINGS SHALL BE TIG WELDING UNLESS OTHERWISE SPECIFIED.
3. ALL WELD SPATTERS SHALL BE GROUND.
4. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
5. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
6. ALL WELD PERFORMANCE CLASS SHALL BE **CP C2** UNLESS OTHERWISE SPECIFIED.
7. FOR WELD TESTING PREFERENCES REFER DRG. No. ICF/STD-9-0-998.
8. FOR WELD PROCEDURE SPECIFICATION REFER DRG. No. ICF/STD-9-0-999.

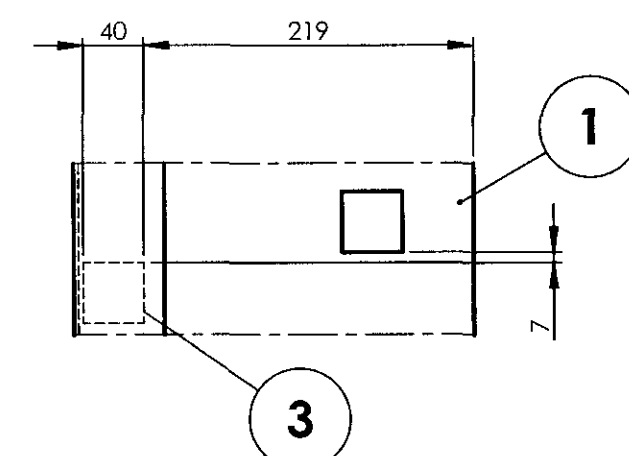


DETAIL A
SCALE 1 : 5



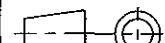
SECTION B-B
SCALE 1 : 5

SECTION C-C
SCALE 1 : 5



DETAIL D
SCALE 1 : 5

1	BACK PIECE	8x40x85	4		RDSO SPEC C- K201 X2 Cr Ni 12	0.22	
9	BACK PIECE	10x40x40	3		RDSO SPEC C- K201 X2 Cr Ni 12	0.13	
2	BACK PIECE	8 x 50 x 100	2		SS-409M	0.32	
1	PILLAR RH		1	AAE15039		24.56	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS

GROUP: 1-5 End Construction		SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:	
RAM PILLAR ASSEMBLY				SCALE 1:20	SSE/D CHD
				ALT	ALTD
				DRN	MAHESH
					
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038			SHEET 1 OF 1	LWCB/PP	
				75415025	
				A2	

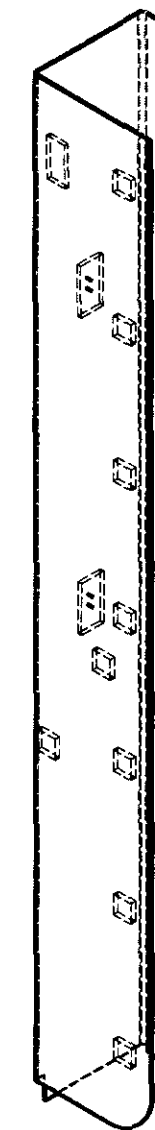
75415026

▽ ROUGH MACHINED	①1 ROUGH CLEANED
▽▽ FINISH MACHINED	①1b BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	①8 CHAMFERED

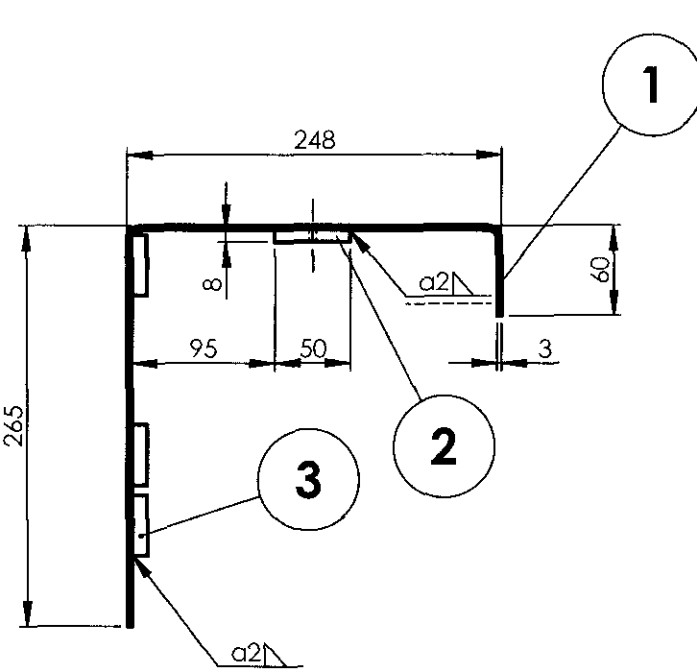
REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE

NOTE:

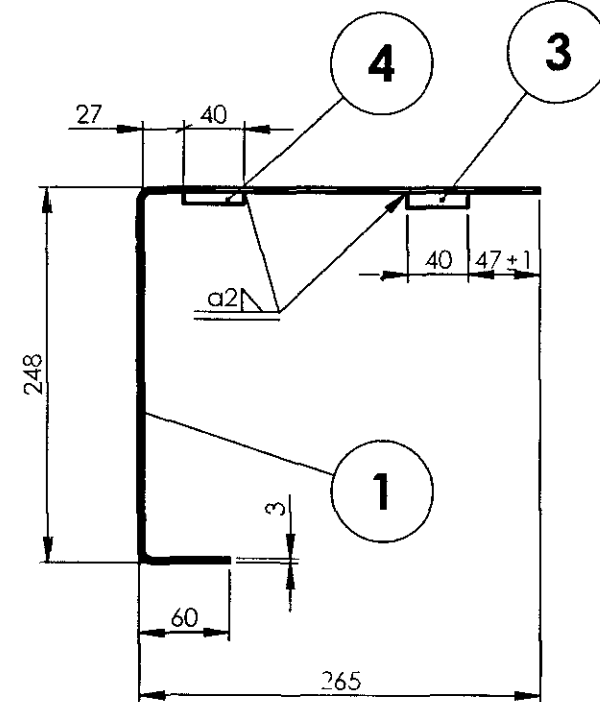
1. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC C-K201 SHALL BE USED FOR WELDING.
2. ALL WELDINGS SHALL BE TIG WELDING UNLESS OTHERWISE SPECIFIED.
3. ALL WELD SPATTERS SHALL BE GROUND.
4. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
5. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
6. ALL WELD PERFORMANCE CLASS SHALL BE **CP C2** UNLESS OTHERWISE SPECIFIED.
7. FOR WELD TESTING PREFERANCES REFER DRG. No. ICF/STD-9-0-998.
8. FOR WELD PROCEDURE SPECIFICATION REFER DRG. No. ICF/STD-9-0-999.



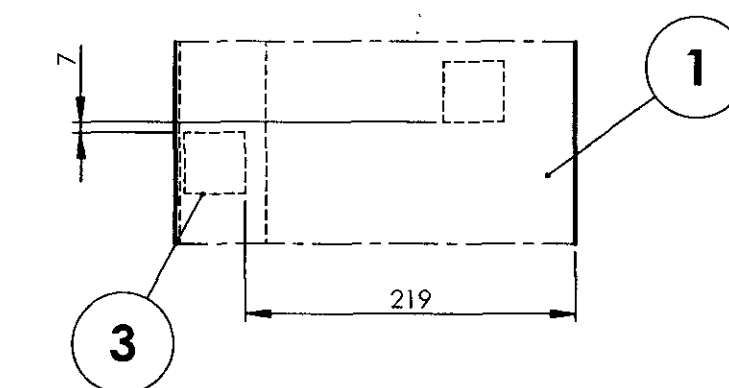
ISOMETRIC VIEW



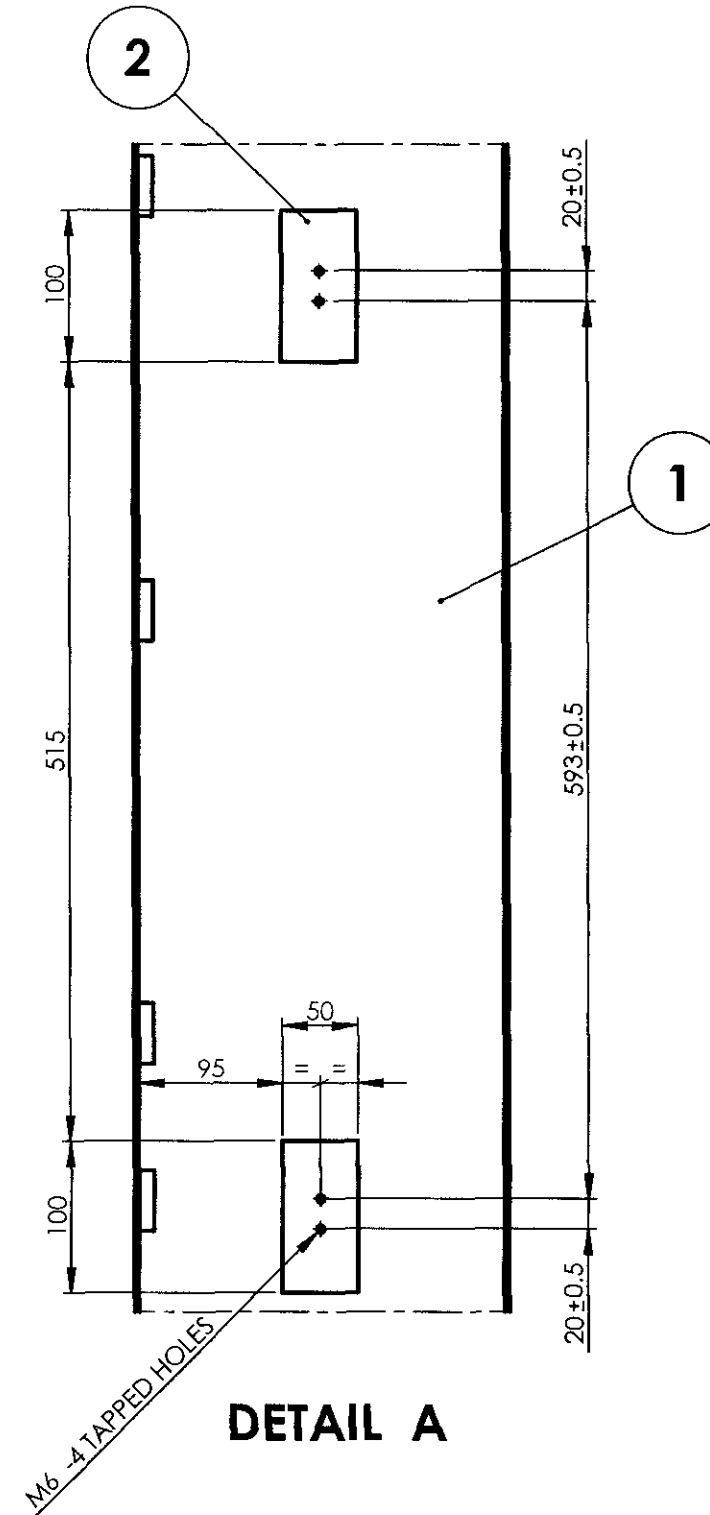
SECTION B-B
SCALE 1 : 5



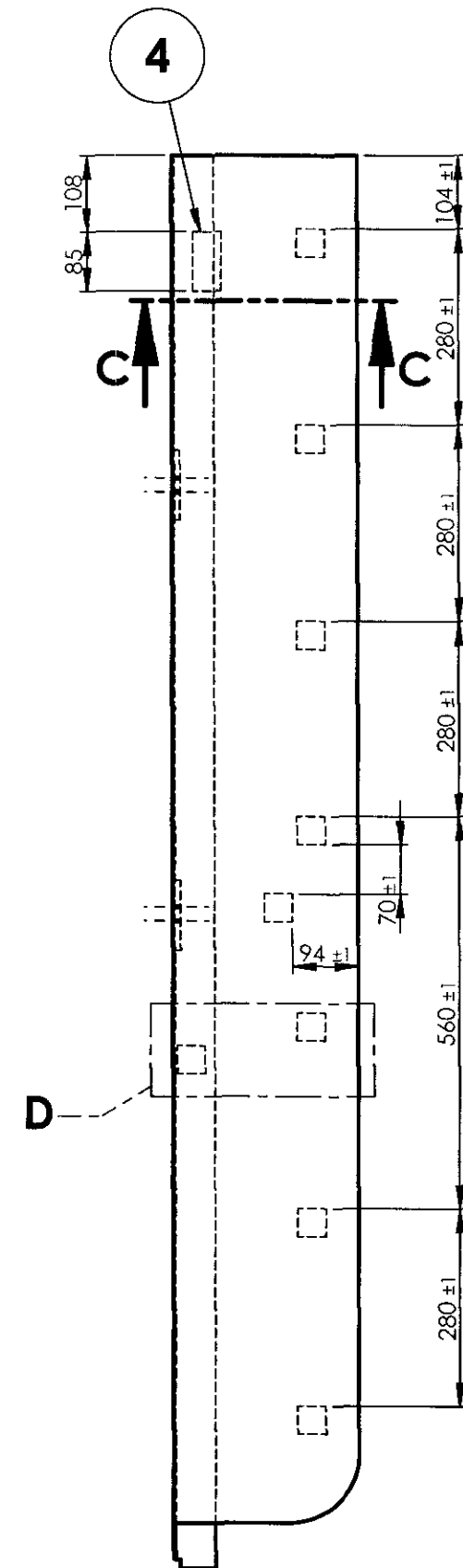
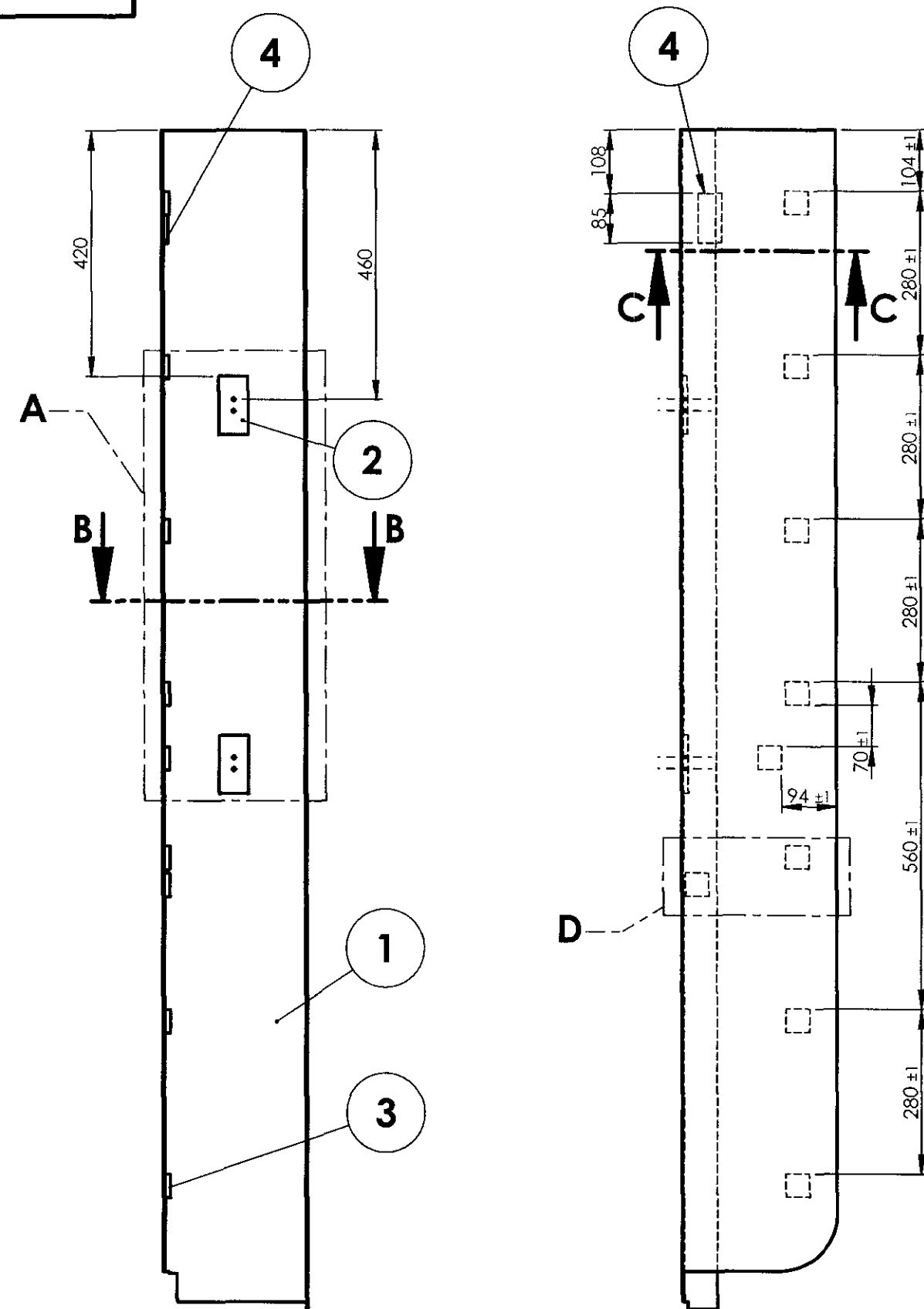
SECTION C-C
SCALE 1 : 5



DETAIL D
SCALE 1 : 5

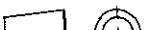


DETAIL A



ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO. ICF/STD-9-0-001.
ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER EN ISO 2553. WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY

1	BACK PIECE	8x40x85	4		RDSO SPEC C-K201 X2 Cr Ni 12	0.22	
9	BACK PIECE	10x40x40	3		RDSO SPEC C-K201 X2 Cr Ni 12	0.13	
2	BACK PIECE	8 x 50 x 100	2		SS-409M	0.32	
1	PILLAR LH		1	AAE15040		26.56	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS

GROUP: 1-5 End Construction		SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:		
RAM PILLAR ASSEMBLY				SCALE 1:20	SSE/D	B. Sankar
					CHD	
				ALT	ALTD	
				DRN	MAHESH	
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038			SHEET 1 OF 1		LWCB/PP	
					75415026	
				A2		

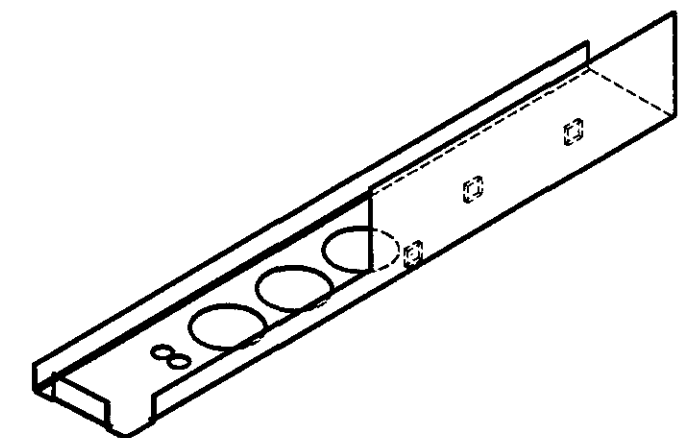
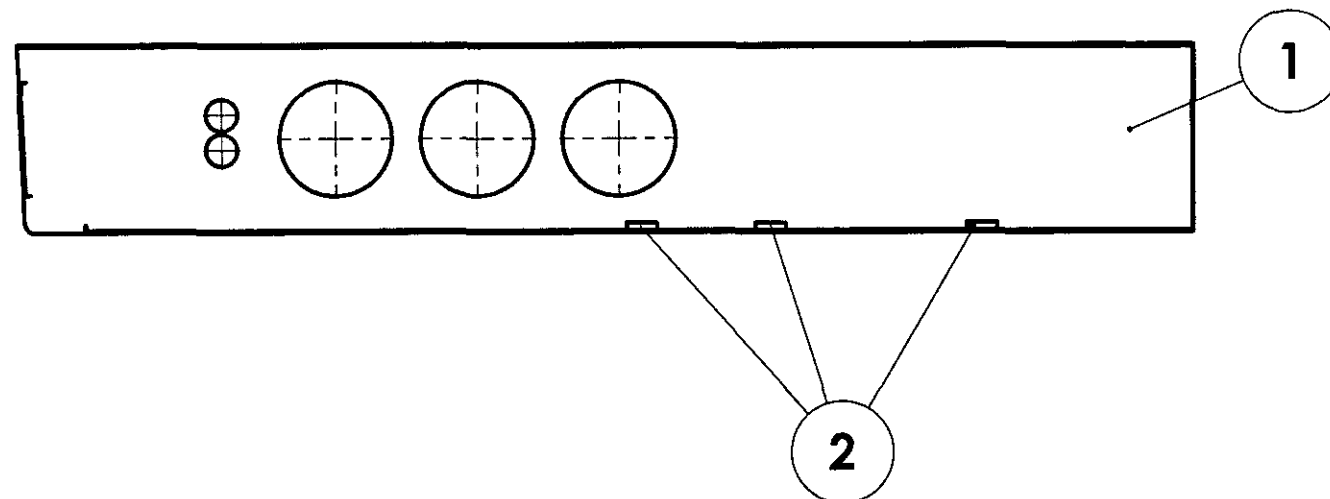
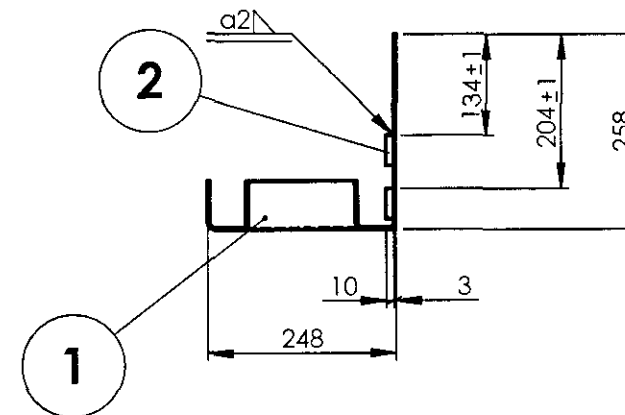
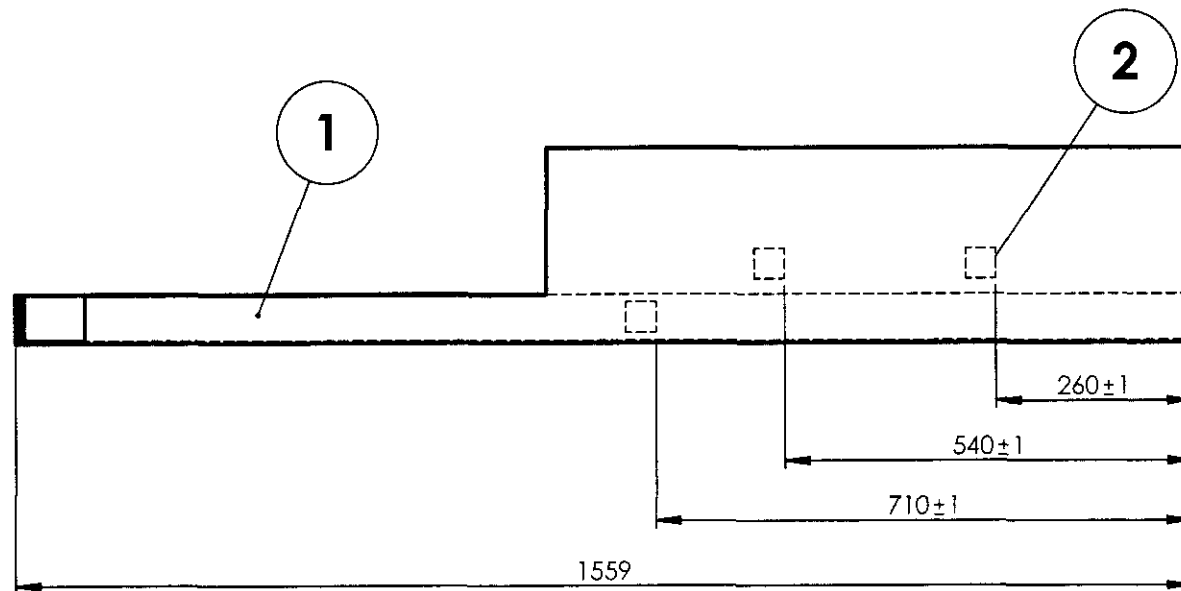
DATE OF LATEST ALT.	3007-2025	AME/SME
DATE OF FIRST ISSUE		

REF.DRG.NO.:-

75415027

▽ ROUGH MACHINED	01 ROUGH CLEANED
▽▽ FINISH MACHINED	01b BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	18 CHAMFERED

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



ISOMETRIC VIEW

NOTE:

1. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC C-K201 SHALL BE USED FOR WELDING.
2. ALL WELDINGS SHALL BE TIG WELDING UNLESS OTHERWISE SPECIFIED.
3. ALL WELD SPATTERS SHALL BE GROUND.
4. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
5. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
6. ALL WELD PERFORMANCE CLASS SHALL BE **CP C2** UNLESS OTHERWISE SPECIFIED.
7. FOR WELD TESTING PREFERENCES REFER DRG. No. ICF/STD-9-0-998.
8. FOR WELD PROCEDURE SPECIFICATION REFER DRG. No. ICF/STD-9-0-999.
9. FINISHED ASSEMBLY SHALL BE APPLIED WITH (AIRLESS SPRAY) ECO FRIENDLY WATER BASED MODIFIED EPOXY ZINC PHOSPHATE ETCH PRIMER TO ICF/MD/SPEC-231.

3	BACK PIECE	10x40x40	2		RDSO SPEC C-K201 X2 Cr Ni 12	0.13	
1	FLANGE		1	AAE15041		16.262	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS

GROUP: 1-5 End Construction

SURFACE AREA IN Sq.m.:1387769.89

WT/ASSY IN Kgs:

FLANGE

SCALE	SSE/D	
1:10	CHD	
ALT.	ALTD	
	DRN	Maresh

	LWS/PP2
--	----------------

INDIAN RAILWAY STANDARDS

INTEGRAL COACH FACTORY, CHENNAI - 600038

SHEET
1 OF 1

75415027

A3

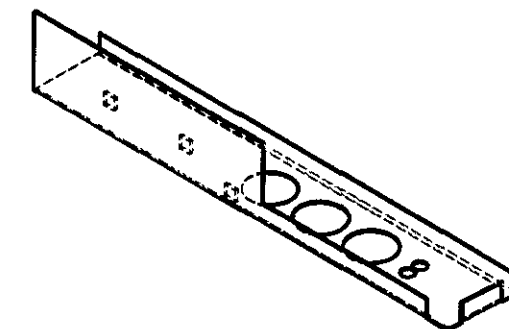
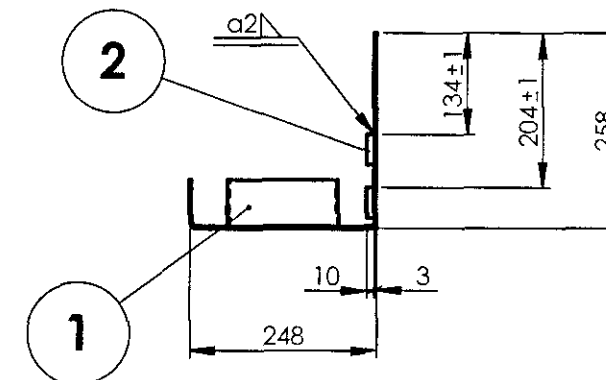
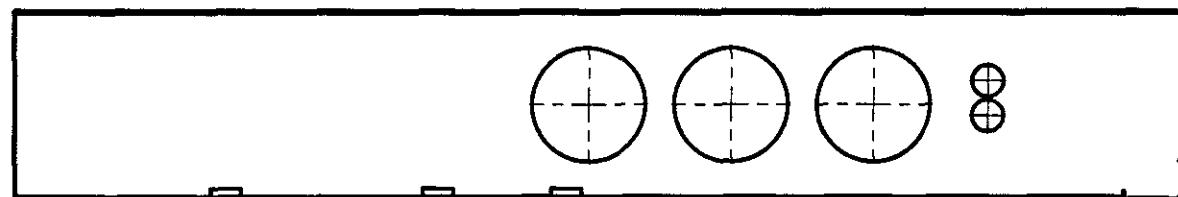
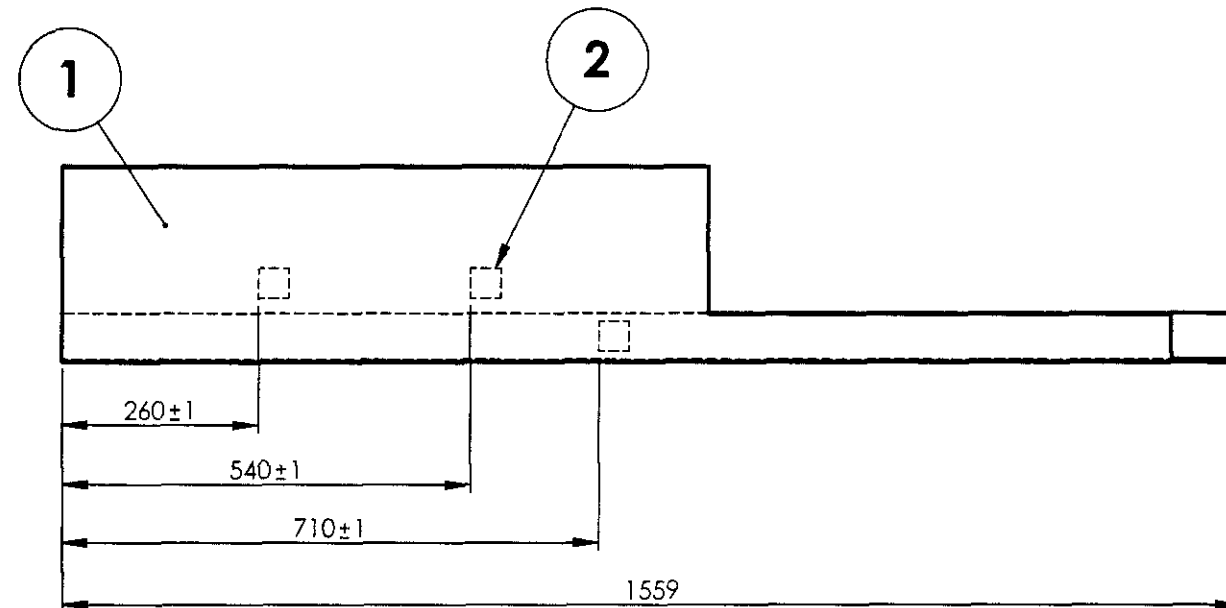
	30/07-2025	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

REF.DRG.NO.-

75415028

▽ ROUGH MACHINED	01 ROUGH CLEANED
▽▽ FINISH MACHINED	01b BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	18 CHAMFERED

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



ISOMETRIC VIEW

NOTE:

1. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC C-K201 SHALL BE USED FOR WELDING.
2. ALL WELDINGS SHALL BE TIG WELDING UNLESS OTHERWISE SPECIFIED.
3. ALL WELD SPATTERS SHALL BE GROUND.
4. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
5. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
6. ALL WELD PERFORMANCE CLASS SHALL BE **CP C2** UNLESS OTHERWISE SPECIFIED.
7. FOR WELD TESTING PREFERENCES REFER DRG. No. ICF/STD-9-0-998.
8. FOR WELD PROCEDURE SPECIFICATION REFER DRG. No. ICF/STD-9-0-999.
9. FINISHED ASSEMBLY SHALL BE APPLIED WITH (AIRLESS SPRAY) ECO FRIENDLY WATER BASED MODIFIED EPOXY ZINC PHOSPHATE ETCH PRIMER TO ICF/MD/SPEC-231.

3	BACK PIECE	10x40x40	2		RDSO SPEC C-K201 X2 Cr Ni 12	0.13	
1	FLANGE		1	AAE15042		14.262	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS
GROUP: 1-5 End Construction				SURFACE AREA IN Sq.m.: 1387767.01		WT/ASSY IN Kgs:	
FLANGE					SCALE	SSE/D	B. Smith
					1:10	CHD	
					ALT.	ALTD	
						DRN	Maresh
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038					LWS/PP2		
					75415028		A3

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICF/STD-9-0-001.
ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER EN ISO 2553.
WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY

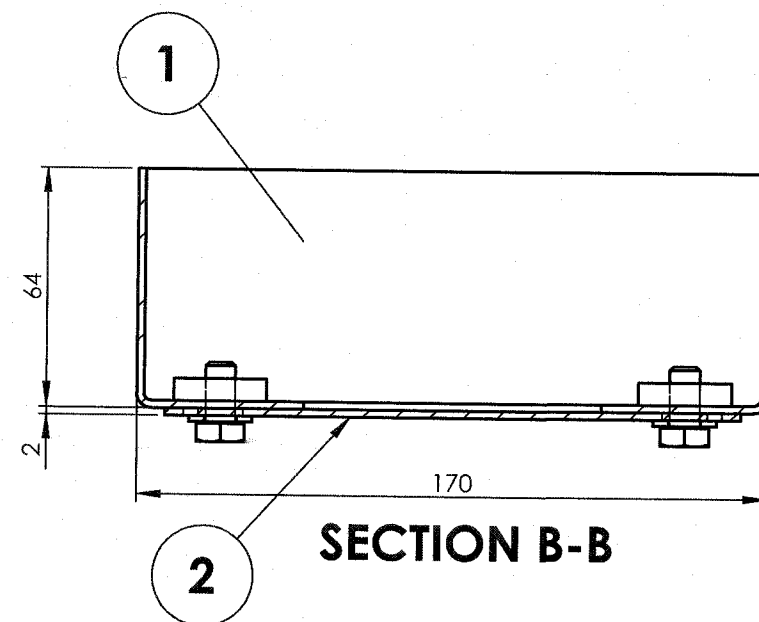
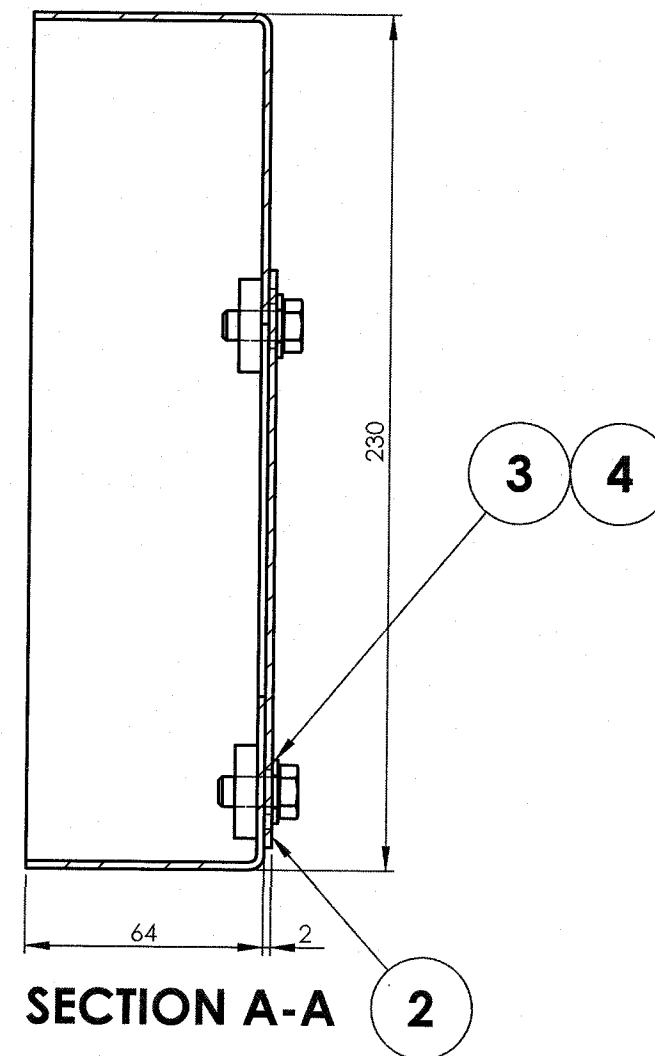
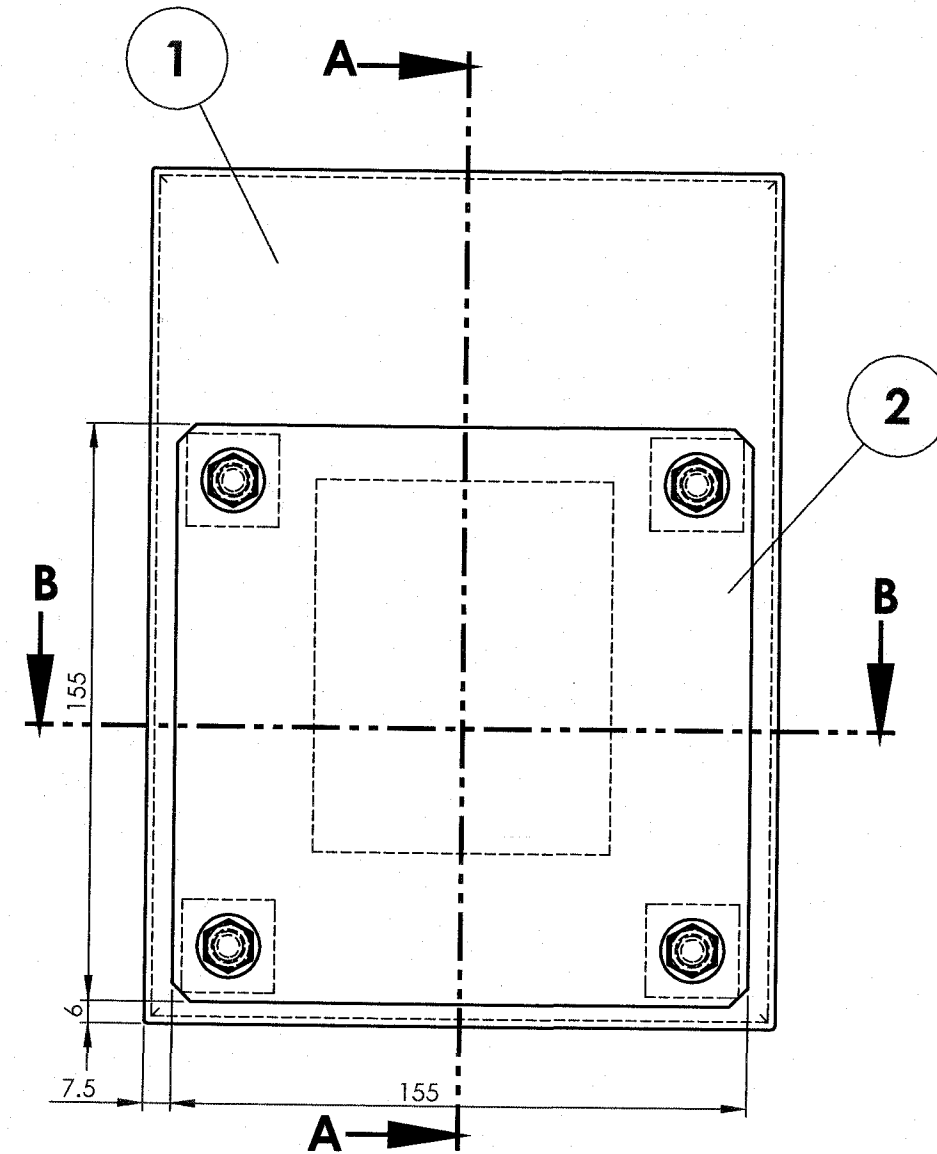
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	30-07-2025	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

79115005

▽ ROUGH MACHINED	① ROUGH CLEANED
▽▽ FINISH MACHINED	①b BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	①8 CHAMFERED

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



NOTE:

1. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC C-K201 SHALL BE USED FOR WELDING.
2. ALL WELD SPATTERS SHALL BE GROUND.
3. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
4. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
5. ALL WELDINGS SHALL BE TIG WELDING UNLESS OTHERWISE SPECIFIED.

WELD TESTING PREFERENCES AS PER EN 15085-3:2007 (E) TABLE-4

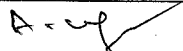
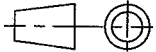
WELD PERFORMANCE CLASS	QUALITY LEVEL FOR IMPERFECTIONS EN ISO 5817 €	INSPECTION CLASS	VOLUMETRIC TEST RT or UT	SURFACE TEST MPT or DPT	VISUAL EXAMINATION VT
CP C2	B	CT2 \$	NOT REQUIRED	NOT REQUIRED	100%

THE TEST METHODS INDICATED IN THIS TABLE SHALL BE THE MINIMUM CAPABLE OF ENSURING COMPLIANCE OF THE WELDED JOINTS. ADDITIONAL TESTS DEPENDING ON THE MATERIAL, THE DESIGN OR CUSTOMER REQUIREMENTS MAY BE NECESSARY.

\$ FOR INSPECTION CLASS CT2, THE VISUAL EXAMINATION SHALL BE PERFORMED BY PERSONNEL CERTIFIED ACCORDING TO ISO-9712 AND SHALL BE DOCUMENTED.

€ ALL APPLICABLE CLAUSES FOR VISUAL INSPECTION SHALL BE CARRIED OUT.

FOR APPLICABLE WELDING PROCEDURE SPECIFICATION (WPS) REFER DRAWING NO ICF/STD-9-0-999

4	HEXAGON HEAD SCREW	IS 1364 (Part-2)/ ISO 4017 - M8 x 16-A2-70	4	IS:1364 (PART-2)	IS:1367 (P-14) A2-70			
4	PUNCHED WASHER	A9 IS:2016-SS	3	IS:2016	AISI-304			
1	CLOSING PIECE FOR GPS ANTENA ASSY		2	AAB15423		0.38		
1	BRACKET ASSY FOR GPS ANTENA		1	79115006		1.374		
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS	
GROUP: 1-5			SURFACE AREA IN Sq.m.: 0.222		WT/ASSY IN Kgs:			
BRACKET ASSY COMPLETE FOR GPS ANTENA					SCALE 1:2	SSE/D		
						CHD		
					ALT	ALTD		
						DRN		V.SURESHBA3U
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038						EMU/US/MC/AC		
						79115005		
					SHEET 1 OF 1			A2

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICF/STD-9-0-001. ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER IS:813-1986. WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY

REF.DRG.NO.-

DATE OF LATEST ALT.	11-08-2018	AME/SME
DATE OF FIRST ISSUE		

79115006

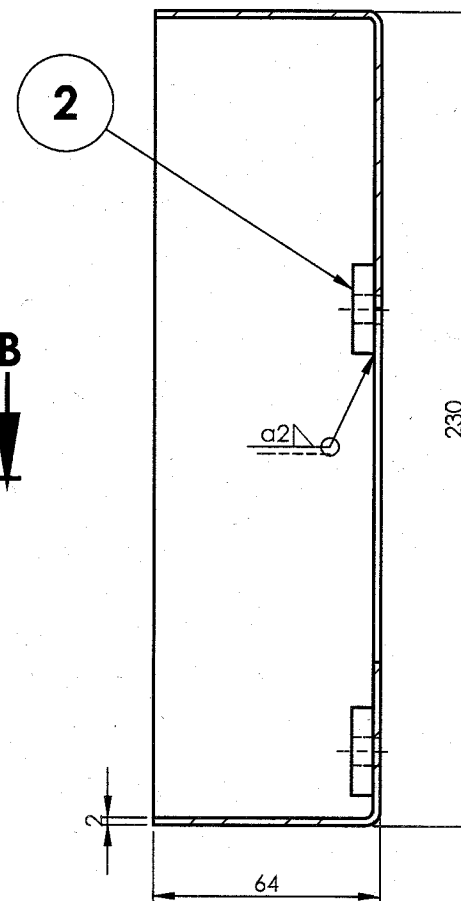
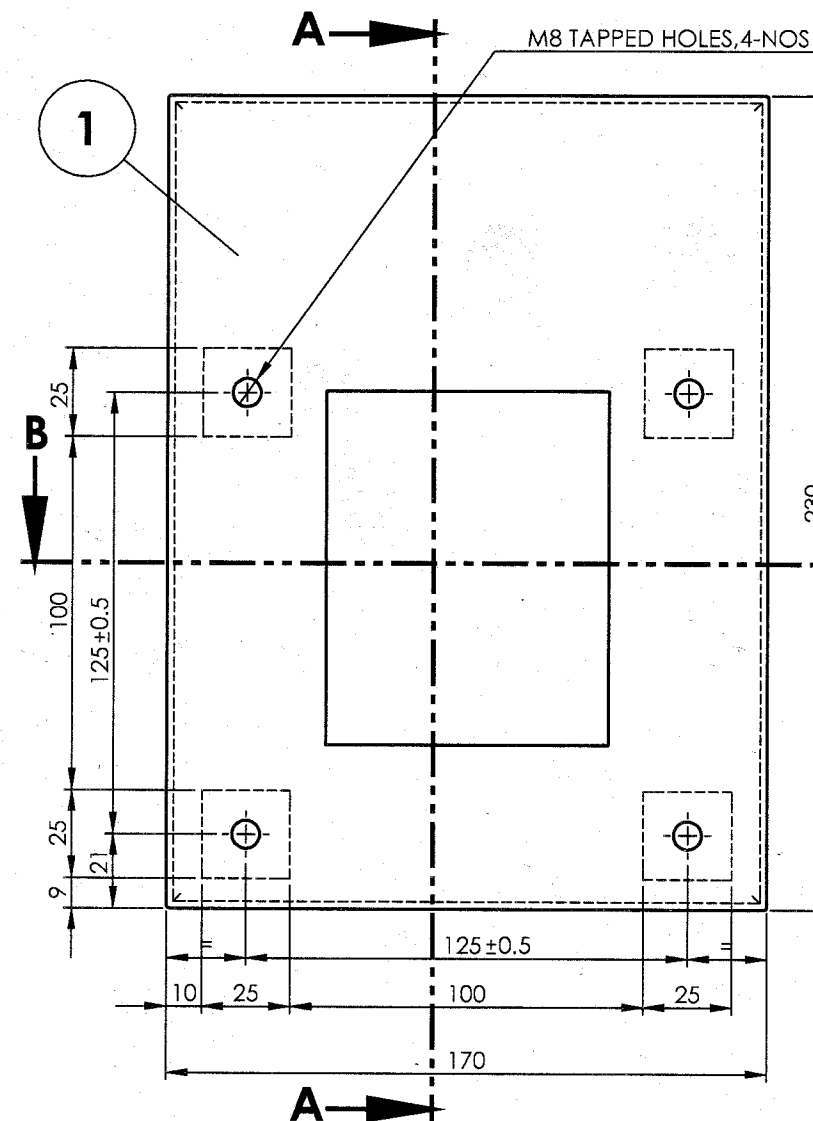
▽ ROUGH MACHINED	01 ROUGH CLEANED
▽▽ FINISH MACHINED	01b BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	018 CHAMFERED

REVISIONS

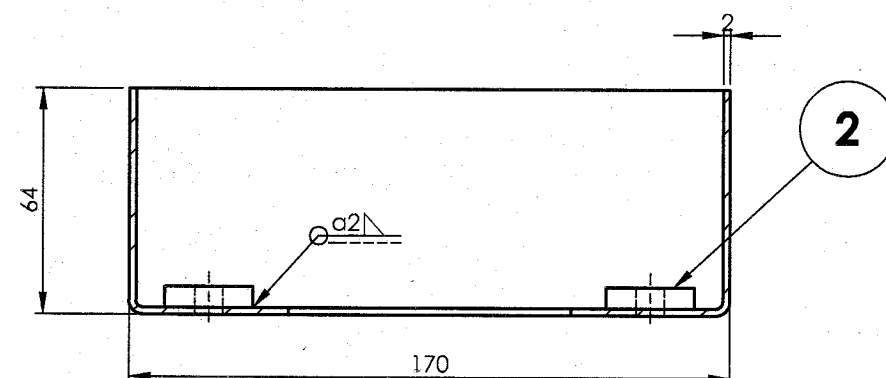
ALT.

ZONE

DESCRIPTION

APPROVED &
DATE

SECTION A-A



SECTION B-B

NOTE:

1. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC C-K201 SHALL BE USED FOR WELDING.
2. ALL WELD SPATTERS SHALL BE GROUND.
3. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
4. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
5. ALL WELDINGS SHALL BE TIG WELDING UNLESS OTHERWISE SPECIFIED.

WELD TESTING PREFERENCES AS PER EN 15085-3:2007(E) TABLE-4

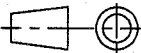
WELD PERFORMANCE CLASS	QUALITY LEVEL FOR IMPERFECTIONS EN ISO 5817 €	INSPECTION CLASS	VOLUMETRIC TEST RT or UT	SURFACE TEST MPT or DPT	VISUAL EXAMINATION VT
CP C2	B	CT2 \$	NOT REQUIRED	NOT REQUIRED	100%

THE TEST METHODS INDICATED IN THIS TABLE SHALL BE THE MINIMUM CAPABLE OF ENSURING COMPLIANCE OF THE WELDED JOINTS. ADDITIONAL TESTS DEPENDING ON THE MATERIAL, THE DESIGN OR CUSTOMER REQUIREMENTS MAY BE NECESSARY.

\$ FOR INSPECTION CLASS CT2, THE VISUAL EXAMINATION SHALL BE PERFORMED BY PERSONNEL CERTIFIED ACCORDING TO ISO-9712 AND SHALL BE DOCUMENTED.

€ ALL APPLICABLE CLAUSES FOR VISUAL INSPECTION SHALL BE CARRIED OUT.

FOR APPLICABLE WELDING PROCEDURE SPECIFICATION (WPS) REFER DRAWING NO ICF/STD-9-0-999

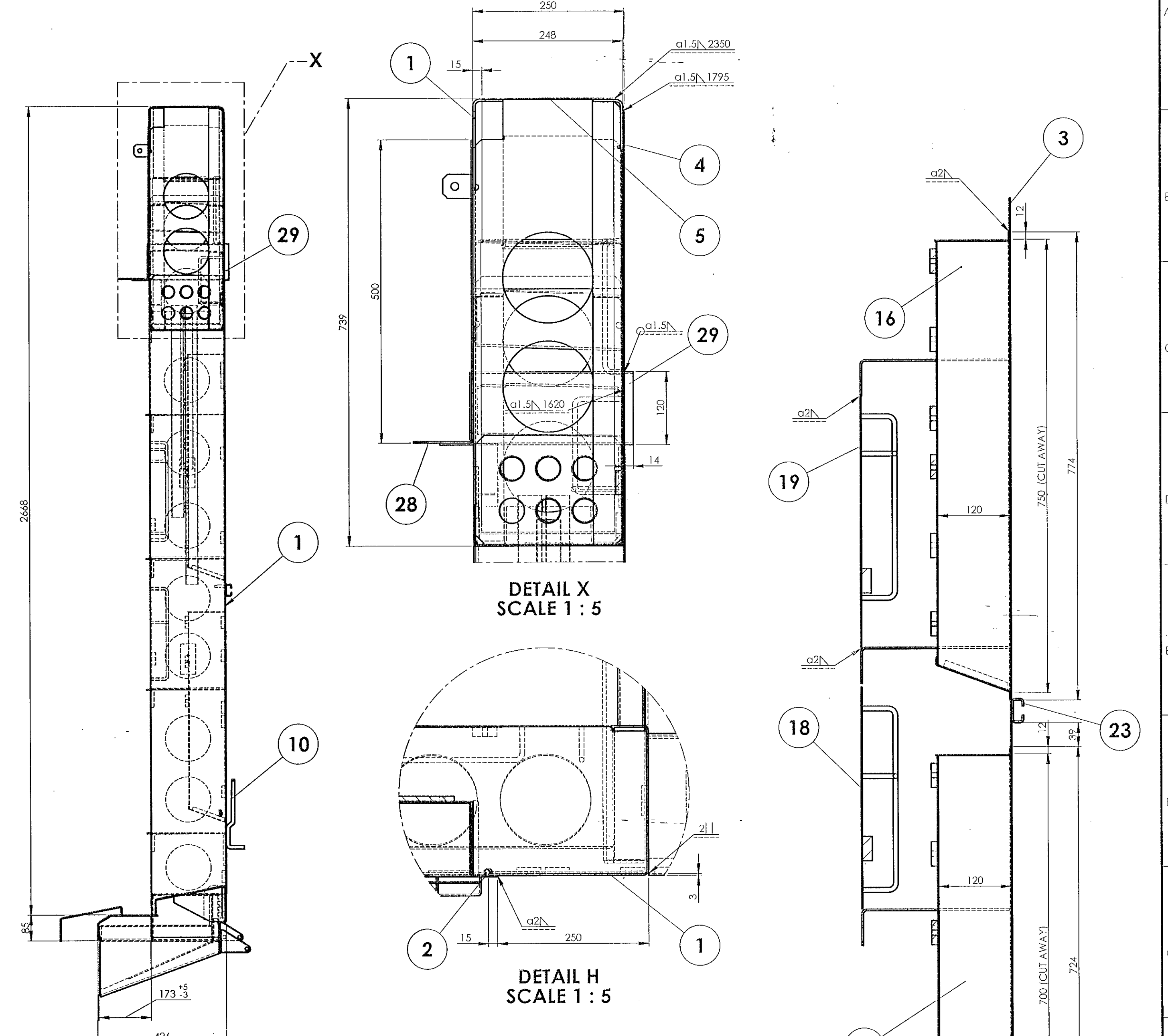
4	FLAT	6x25x25	2		SS-409M	0.03	
1	BRACKET FOR GPS ANTENA		1	AAB15410		1.27	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS
GROUP: 1-5		SURFACE AREA IN Sq.m.:0.168			WT/ASSY IN Kgs:		
BRACKET ASSY FOR GPS ANTENA					SCALE	SSE/D	A-08
					1:2	CHD	
					ALT.	ALTD	
						DRN	V.SURESHBABU
INDIAN RAILWAY STANDARDS						EMU/US/MC/AC	
INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1		79115006	
						A3	

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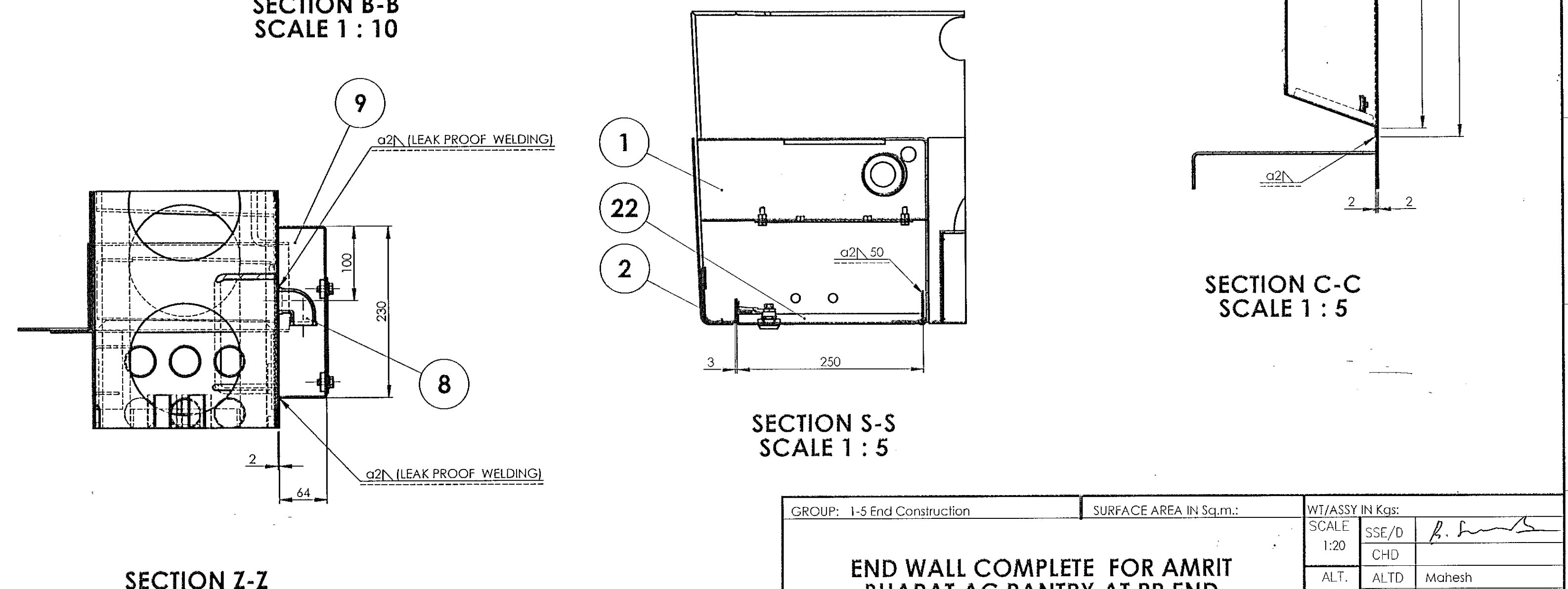
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11-08-2018	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE
	AME/SME

12	13	14		15	16
▽ ROUGH MACHINED	⑪ ROUGH CLEANED	REVISONS			
▽▽ FINISH MACHINED	⑫ BURRS REMOVED	ALT.	ZONE	DESCRIPTION	APPROVED & DATE
▽▽▽ FINE FINISH MACHINED	⑬ CHAMFERED				






SECTION B-B
SCALE 1 : 10



SECTION Z-Z
SCALE 1 : 5

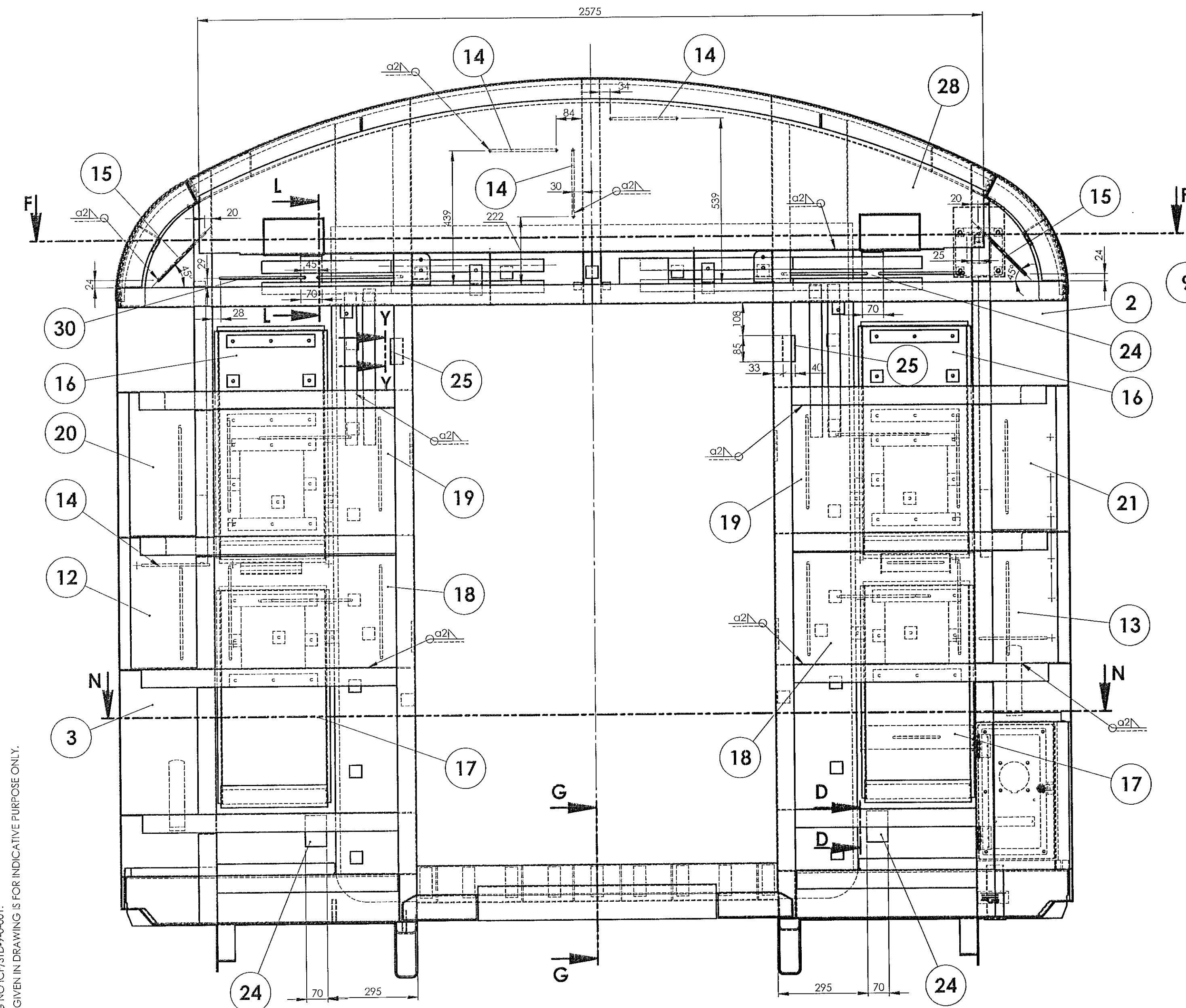


SECTION C-C
SCALE 1 : 5

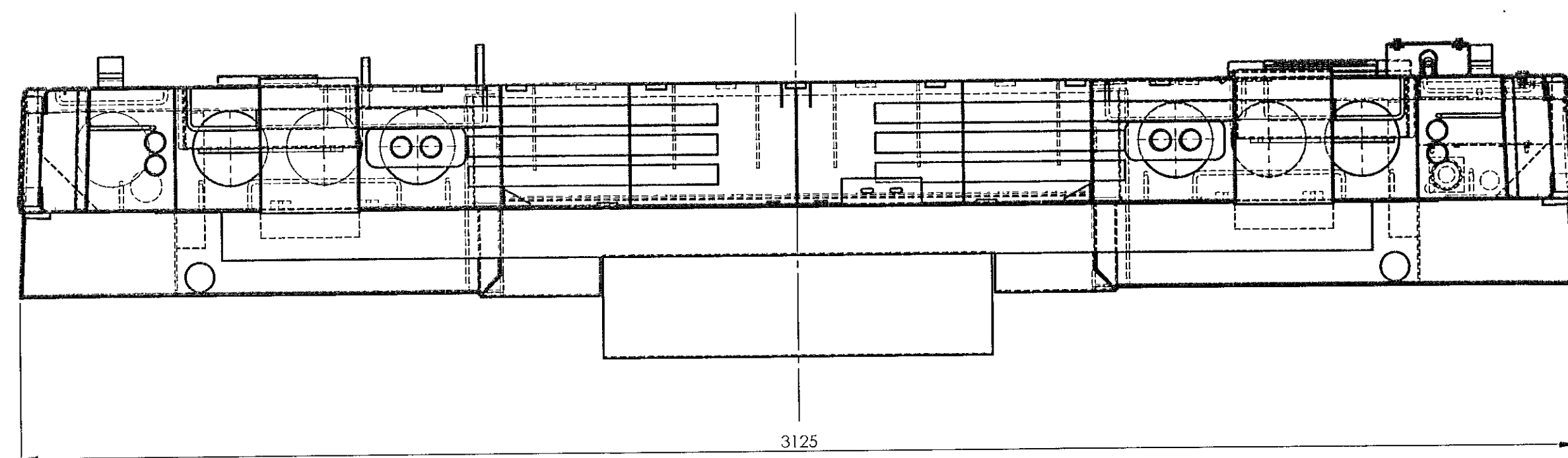
GROUP: 1-5 End Construction		SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:	
<h2 style="text-align: center;">END WALL COMPLETE FOR AMRIT BHARAT AC PANTRY AT PP END</h2>				SCALE 1:20	SSE/D 
				CHD	
				ALT. a	ALTD DRN
				Mahesh B.Suresh	
				 LWCBC/PP2	
<h3 style="text-align: center;">INDIAN RAILWAY STANDARDS</h3> <p style="text-align: center;">INTEGRAL COACH FACTORY, CHENNAI - 600038</p>				SHEET 1 OF 3	83015001
14-01-2026	01-08-2025				A1
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME			

83015001

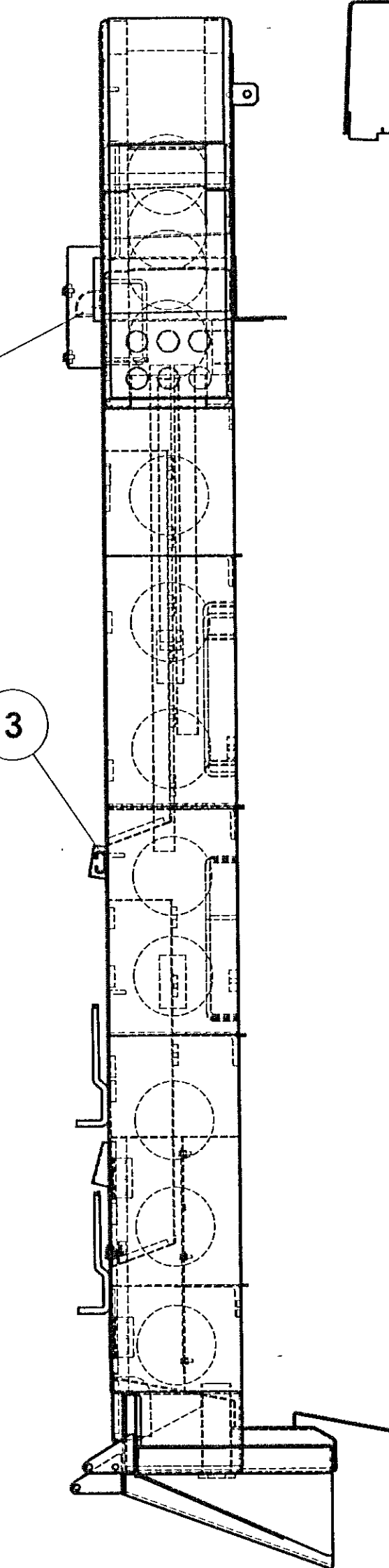
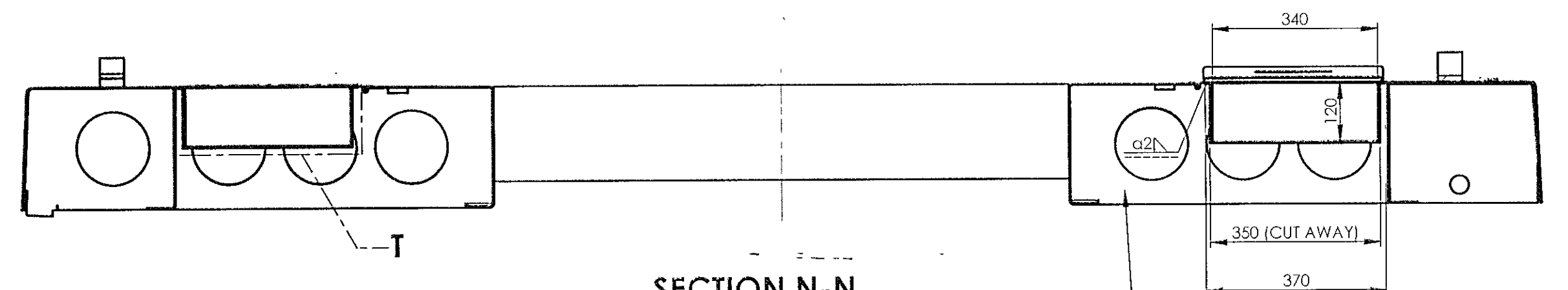
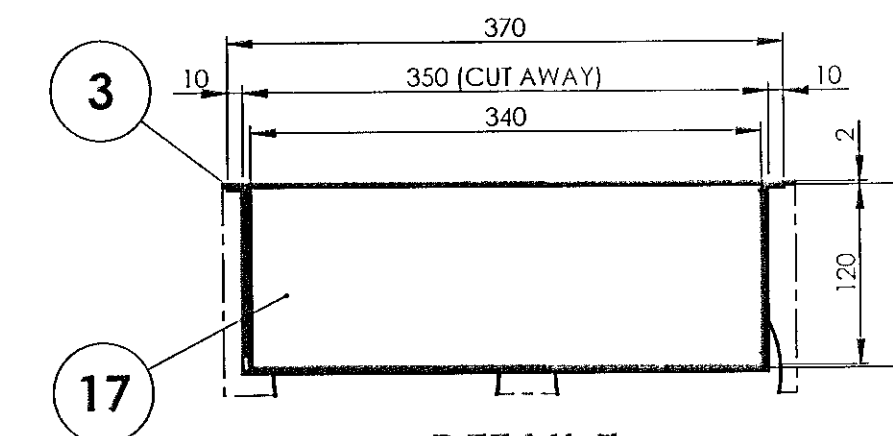
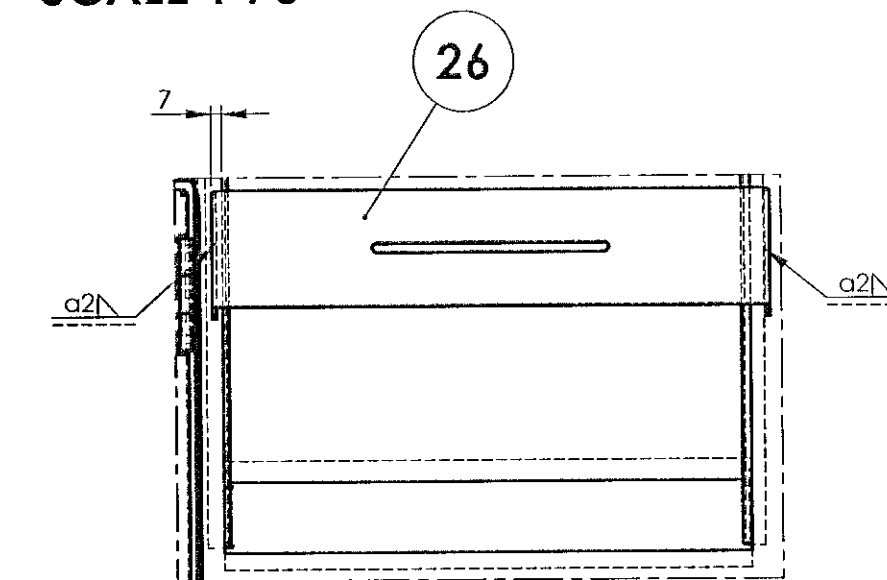
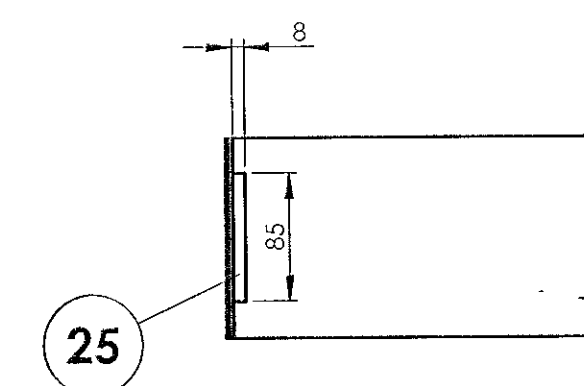
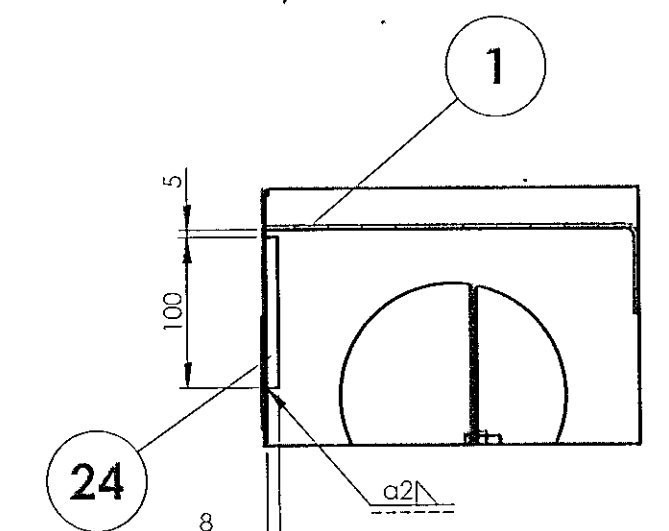
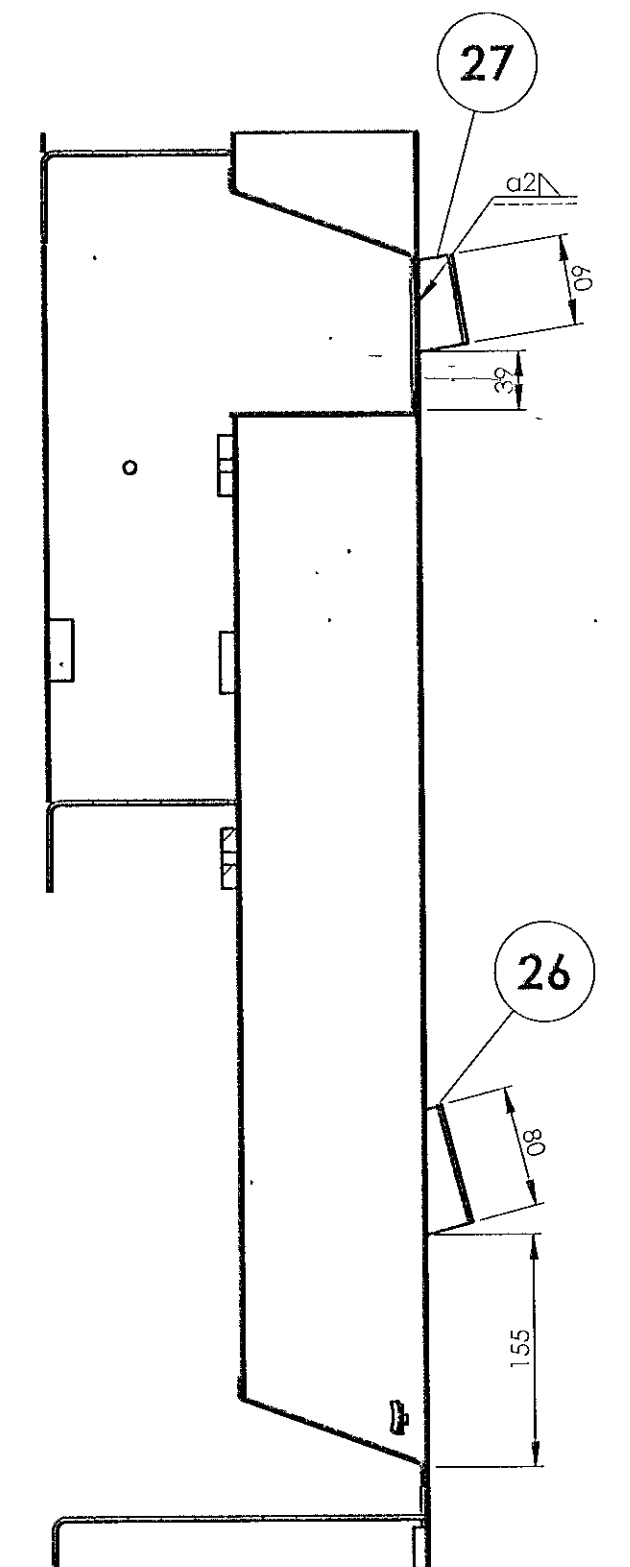
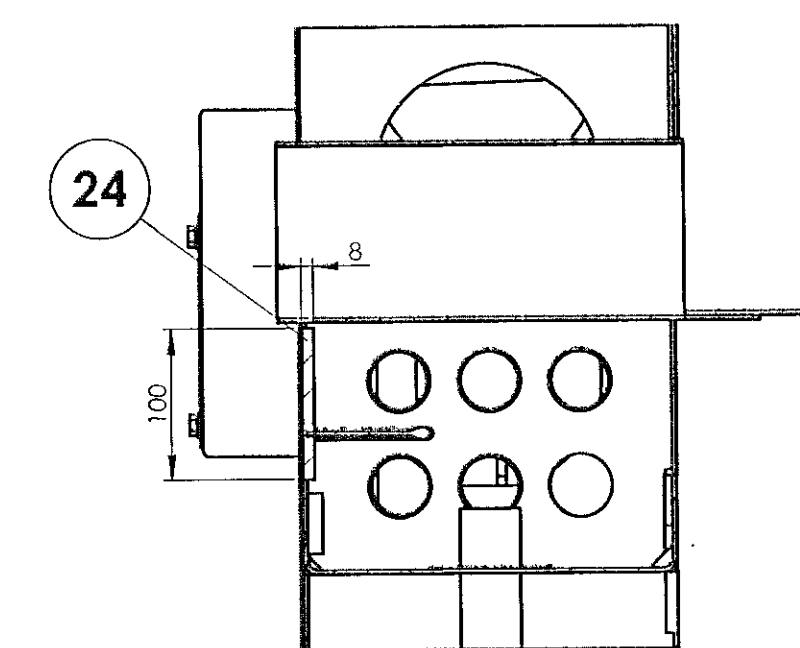
▽ ROUGH MACHINED	① ROUGH CLEANED
▽▽ FINISH MACHINED	② BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	③ CHAMFERED



VIEW FROM COACH INSIDE

SECTION F-F
SCALE 1 : 10

REF.DRG.NO.

SECTION G-G
SCALE 1 : 5SECTION N-N
SCALE 1 : 10DETAIL T
SCALE 1 : 5DETAIL F
SCALE 1 : 5SECTION Y-Y
SCALE 1 : 5SECTION D-D
SCALE 1 : 5SECTION M-M
SCALE 1 : 5SECTION L-L
SCALE 1 : 5

ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO. IC/STD-90-001.
ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER EN ISO 2553. WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY.

GROUP: 1-5 End Construction		SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:	
SCALE	1:20	SSE/D	CHD	ALT	ALTO
		DRN	DRN		
END WALL COMPLETE FOR AMRIT BHARAT AC PANTRY AT PP END				LWCBAC/PP2	
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038				83015001	
SHEET 2 OF 3				A1	

14-01-2026	01-08-2025	AME/SME
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	

83015001

REVISIONS		APPROVED & DATE	
ALT.	ZONE	DESCRIPTION	
a		ITEM-1 DESIGN REVISED & VIEWS UPDATED ACCORDINGLY.	

NOTE:

1. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 QF RDSO/SPEC C-K201 SHALL BE USED FOR WELDING.
2. ALL WELD SPATTERS SHALL BE GROUND.
3. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
4. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
5. ALL WELDINGS SHALL BE TIG WELDING UNLESS OTHERWISE SPECIFIED.
6. FINISHED ASSEMBLY SHALL BE APPLIED WITH (AIRLESS SPRAY) ECO FRIENDLY WATER BASED MODIFIED EPOXY ZINC PHOSPHATE ETCH PRIMER TO ICF/MD/SPEC-231.
7. ITEM-11 (NAME PLATE) SHALL BE WELDED OR RIVETTED AT SUITABLE LOCATION AS SHOWN IN THE DRAWING IF PROCURED FROM TRADE.
8. ALL TAPPED HOLES TO BE CLOSED USING SUITABLE PVC PLUGS BEFORE PAINTING.
9. BEFORE APPLYING PRIMER THE FACES OF THE ANGLE MARKED @ THUS TO BE MASKED ALONG WITH THE SHELL JOINING AREAS OF ENDWALL.
10. ALL WELD PERFORMANCE CLASS SHALL BE CP C2 UNLESS OTHERWISE SPECIFIED.
11. FOR WELD TESTING PREFERENCES REFER DRG.NO.ICF/STD-9-0-998.
12. FOR WELD PROCEDURE SPECIFICATION REFER DRG.NO.ICF/STD-9-0-999

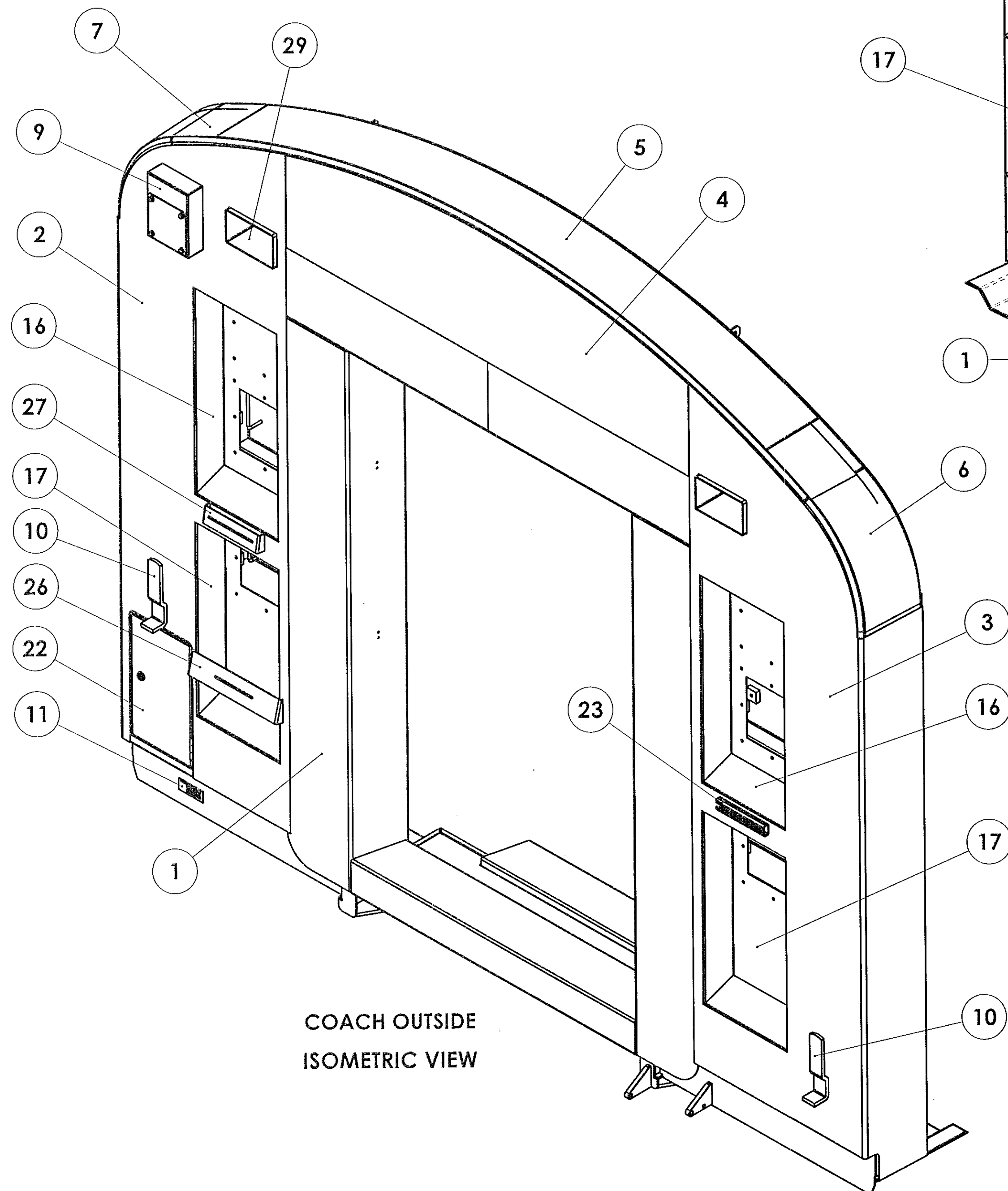
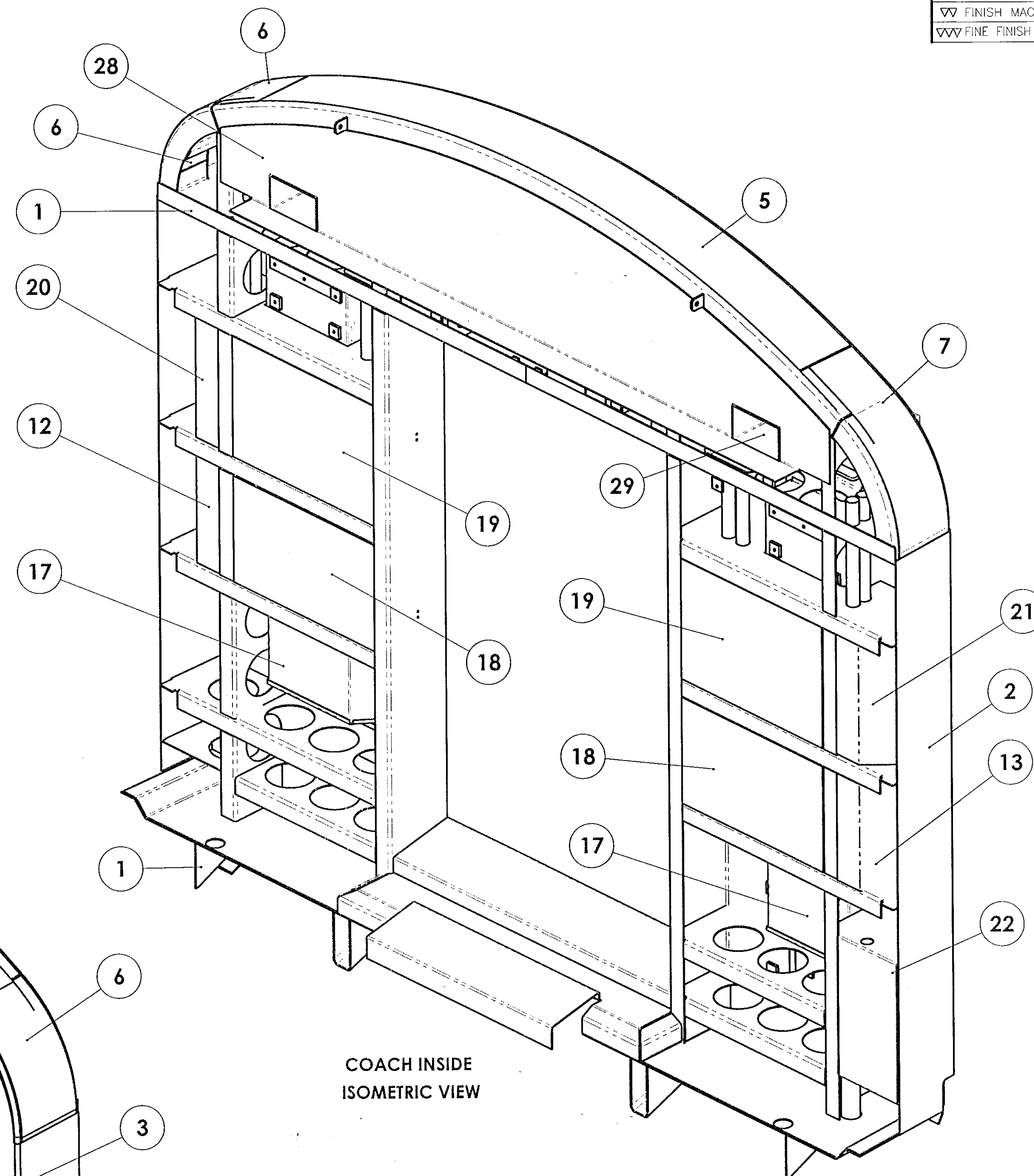
4	CABLE SUPPORTING ROD		30	AAE15021		0.17	
2	RECTANGULAR TUBE		29	AAE15016		4.22	
1	FLANGE		28	AAE15007		28.814	
1	SUPPORTING BRACKET		27	AAD15985		0.37	
1	SUPPORTING BRACKET		26	AAD15978		0.75	
2	BACK PIECE	8x40x85	25		RDSO SPEC C-K201 X2 Cr Ni 12	0.22	
4	BACK PIECE	8x70x100	24		RDSO SPEC C-K201 X2 Cr Ni 12	0.45	
1	MOUNTING RAIL	L=200	23	AAE11737		0.41	
1	SHUTTER ASSEMBLY FOR EFT SOCKET		22	58115015		1.990	
1	ELEC COUPLER COVER COMPLETE		21	75415014		2.99	
1	ELEC COUPLER COVER COMPLETE		20	75415013		3.01	
2	ELEC COUPLER CLOSING PLATE		19	75415011		4.85	
2	ELEC COUPLER CLOSING PLATE		18	75415010		4.37	
2	BRACKET ASSEMBLY FOR EFT AND PARKING		17	75415007		9.50	
2	BRACKET ASSEMBLY FOR EFT AND PARKING		16	75415006		12.06	
2	CABLE SUPPORTING ROD		15	AAE15022		0.15	
5	CABLE TIE ROD		14	AAE15116		0.11	
1	ELEC COUPLER COVER COMPLETE		13	97115005		2.73	
1	ELEC COUPLER COVER COMPLETE		12	97115004		2.75	
1	NAME PLATE FOR SUPPLIER IDENTIFICATION		11	AAA51072		0.063	
2	BRACKET		10	AAA26077		1.286	
1	BRACKET ASSY COMPLETE FOR GPS ANTENNA		9	79115005		1.806	
1	ELBOW	1/2" A1	8	IS:1879-2010 TAB-4	AISI-304	0.156	
1	COVERING SHEET		7	AAA15259		2.389	
1	COVERING SHEET		6	AAA15219		2.389	
1	COVERING SHEET		5	AAA15180		8.203	
1	END WALL TOP SHEET		4	AAE15067		11.206	
1	ENDWALL SHEET		3	AAD15989		25.134	
1	ENDWALL SHEET		2	AAD15988		23.088	
1	FRAME WORK		1	83015002		310.356	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS

GROUP: 1-5 End Construction		SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:	
SCALE	1:20	SSE/D	CHD	ALT	CHD
ALT	a	ALTD	DRN	ALT	DRN
INDIAN RAILWAY STANDARDS		SHEET		LWCBAC/PP2	
INTEGRAL COACH FACTORY, CHENNAI - 600038		3 OF 3		83015001	
				A1	

14-01-2026	01-08-2025	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

REF.DRG.NO.

ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICF/STD-9-0-001. ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER EN ISO 2553. WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY.

COACH OUTSIDE
ISOMETRIC VIEWCOACH INSIDE
ISOMETRIC VIEW

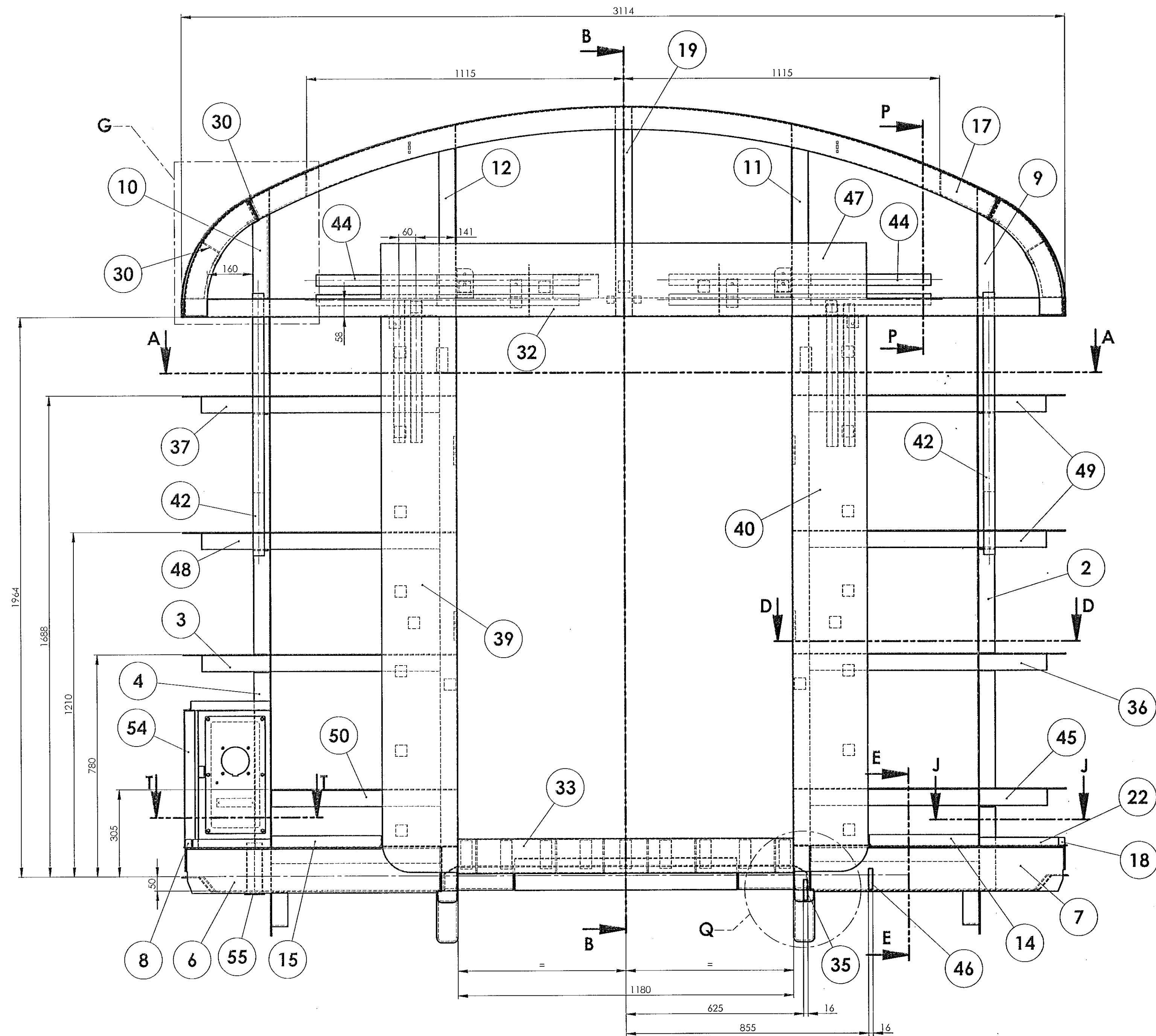
83015002

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

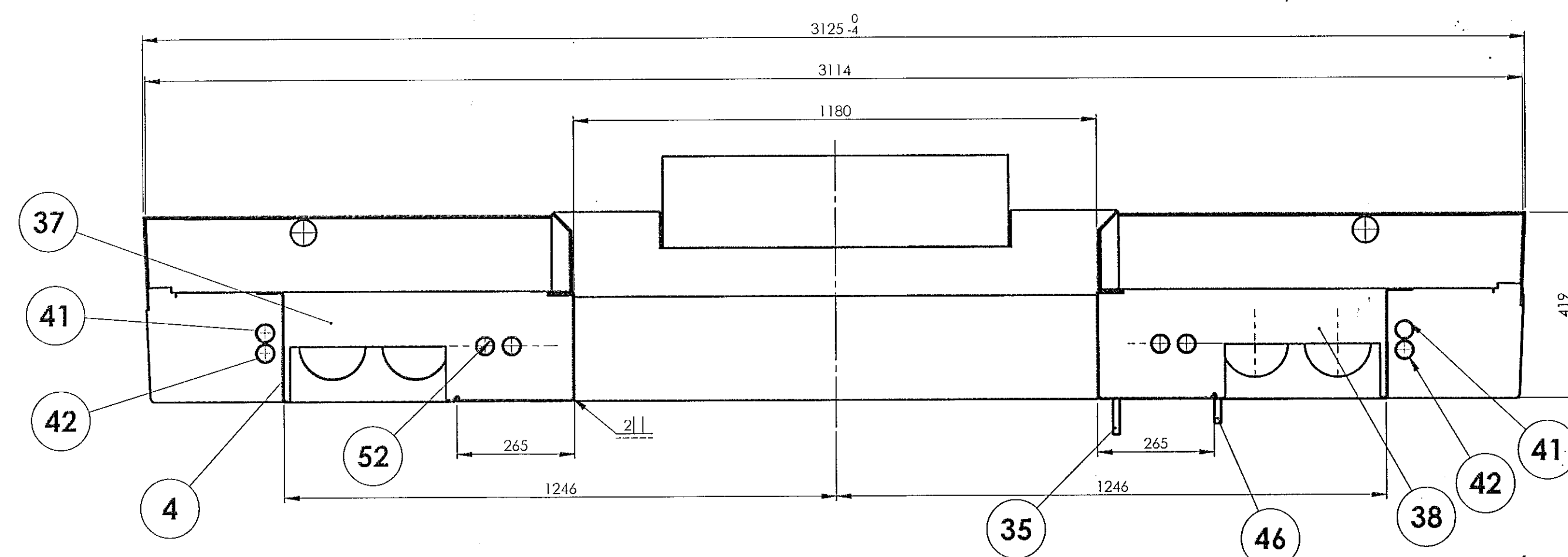
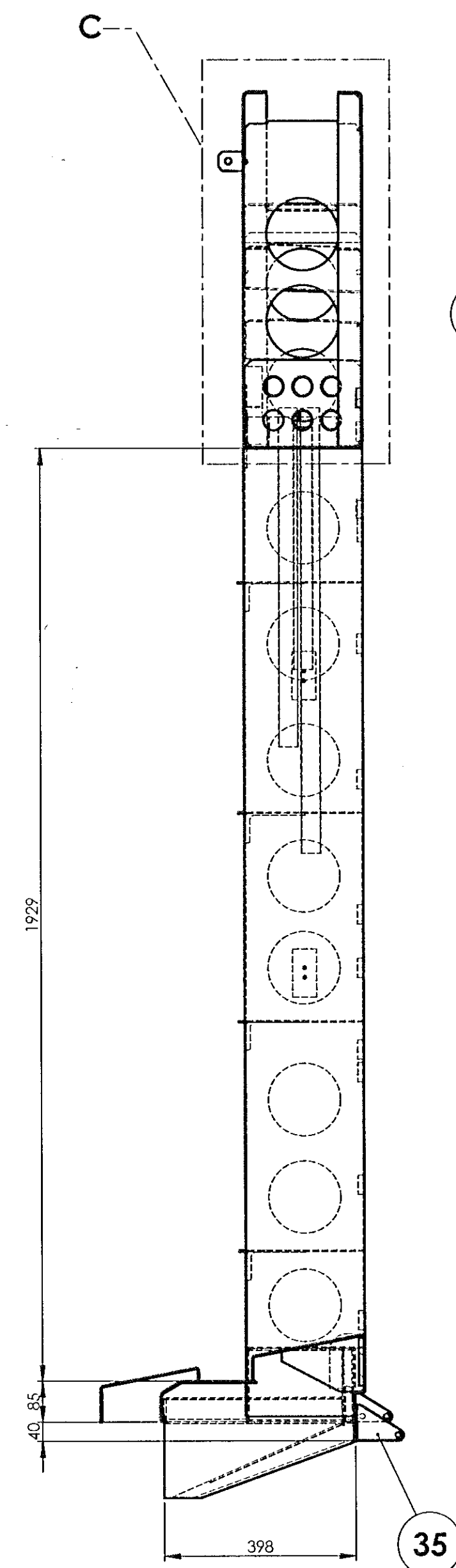
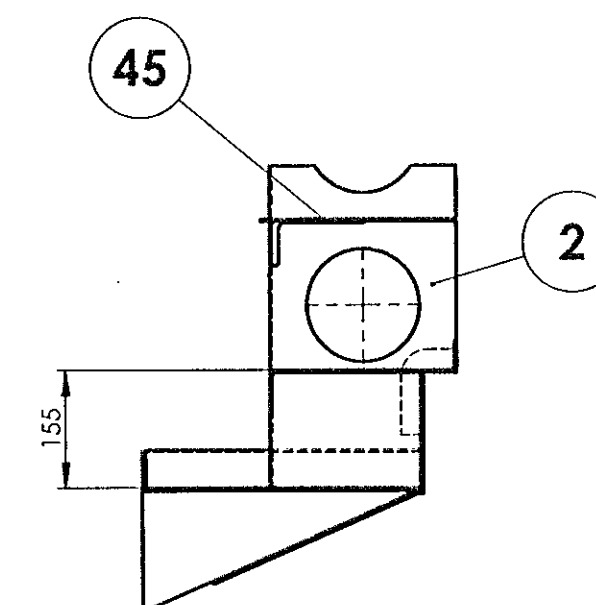
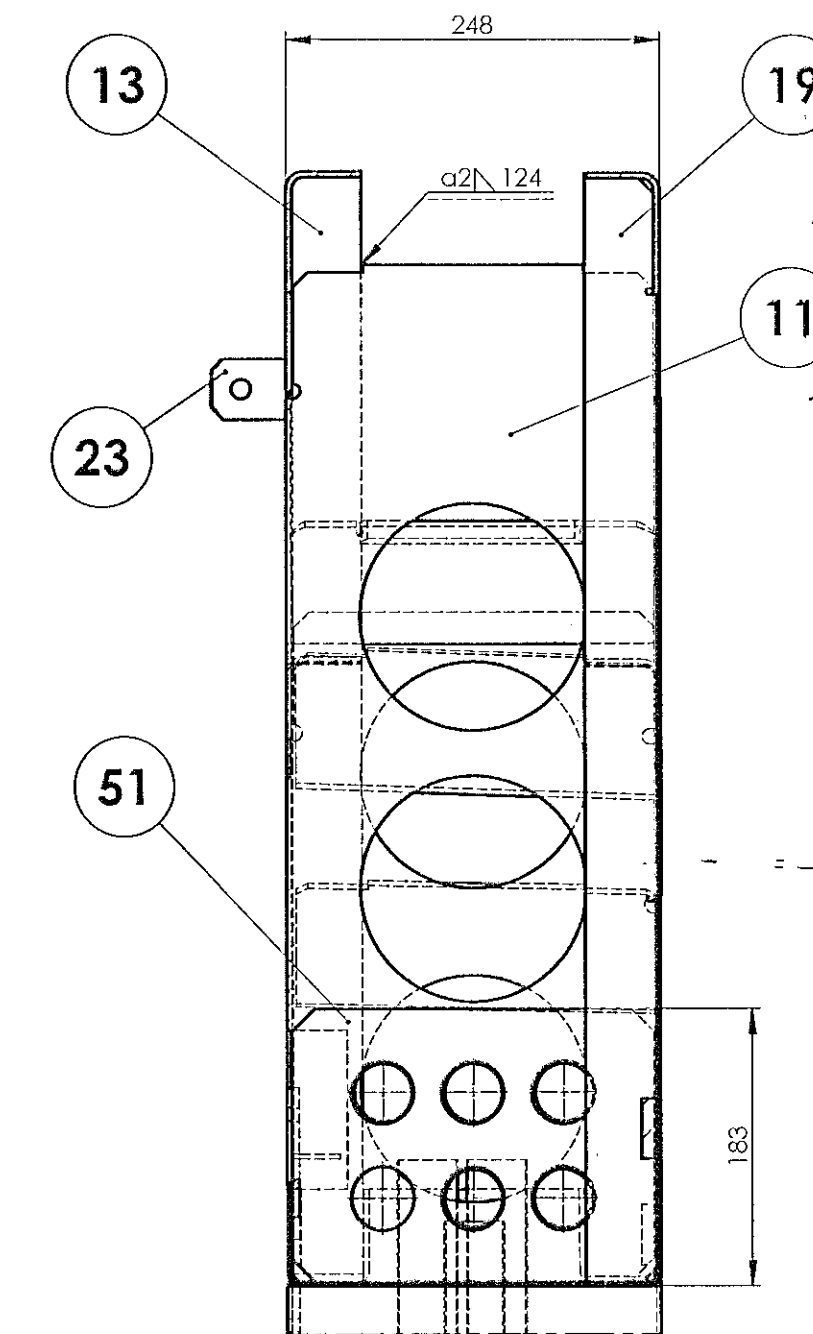
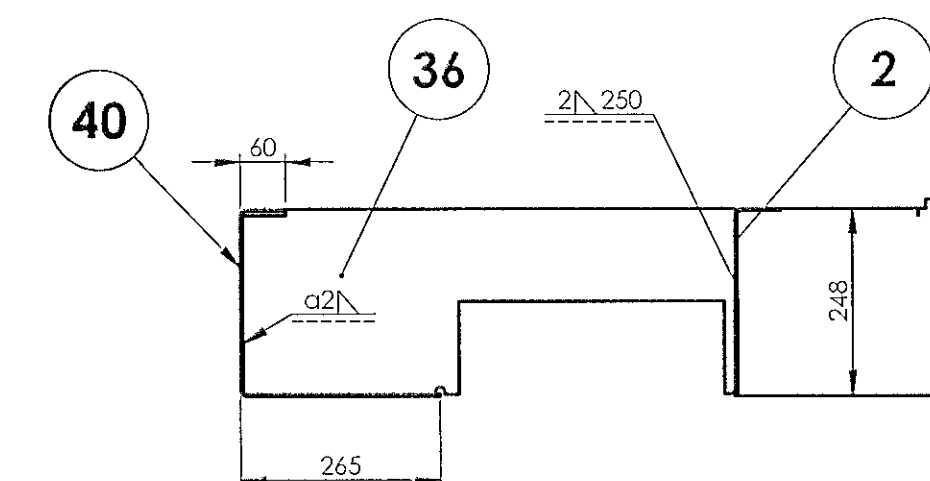
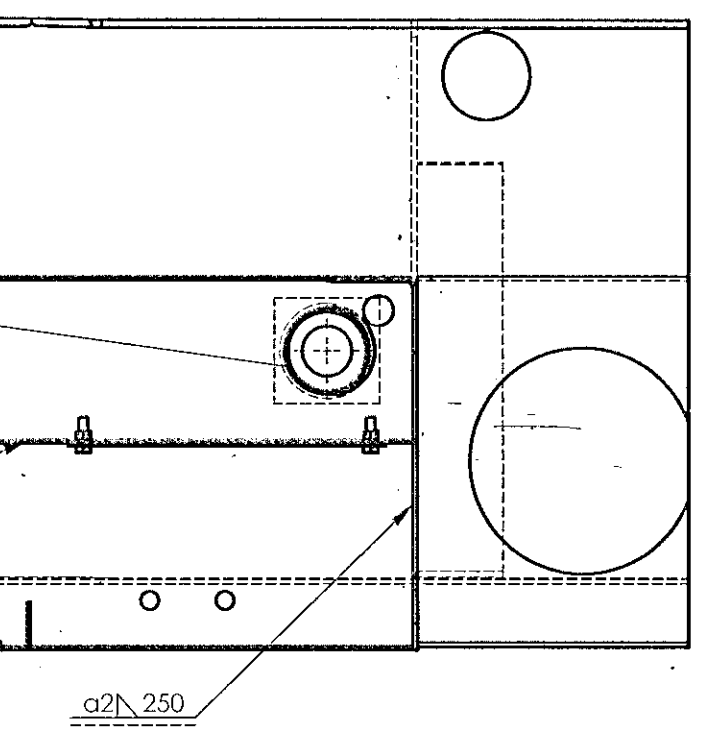
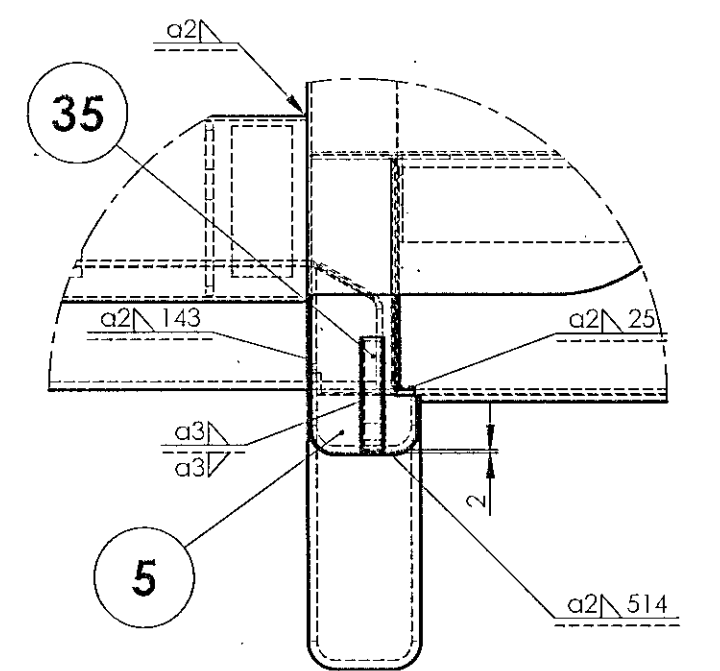
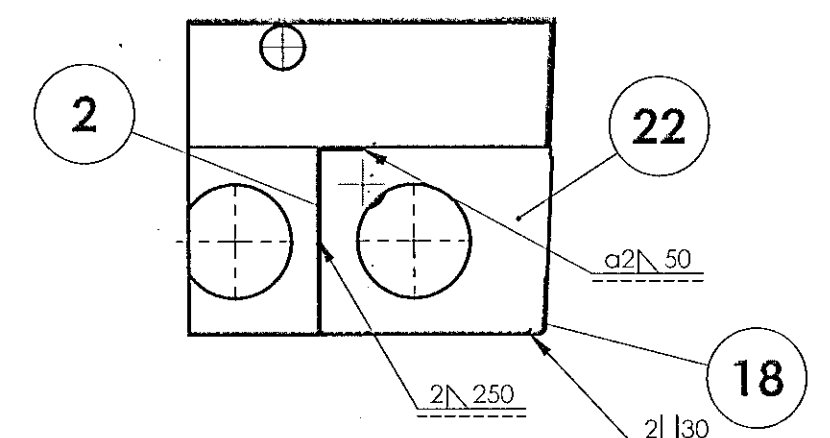
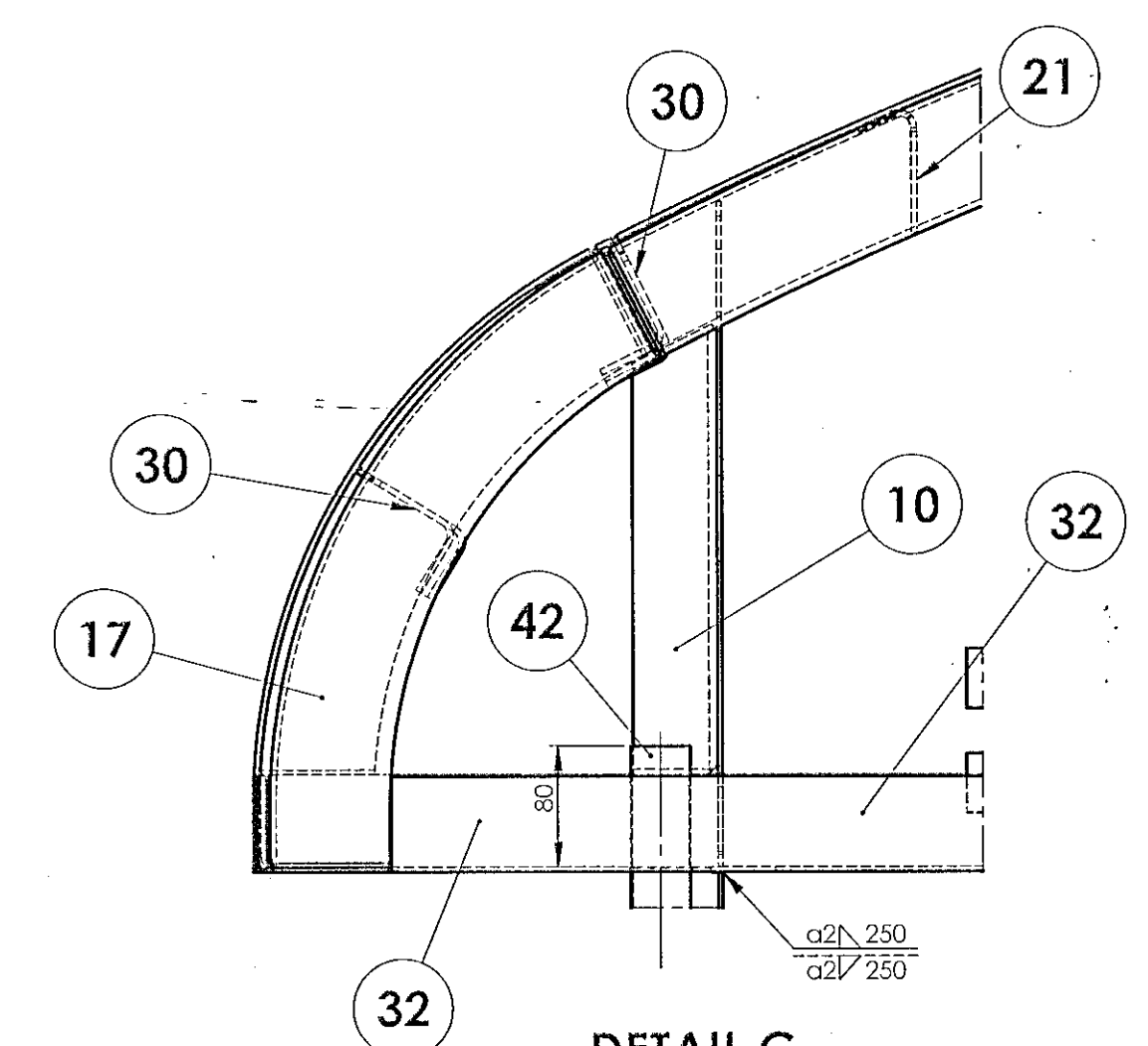
(01) ROUGH CLEANED
(010) BURRS REMOVED
(05) CHAMFERED

REVISIONS

ALT.	ZONE	DESCRIPTION	APPROVED & DATE



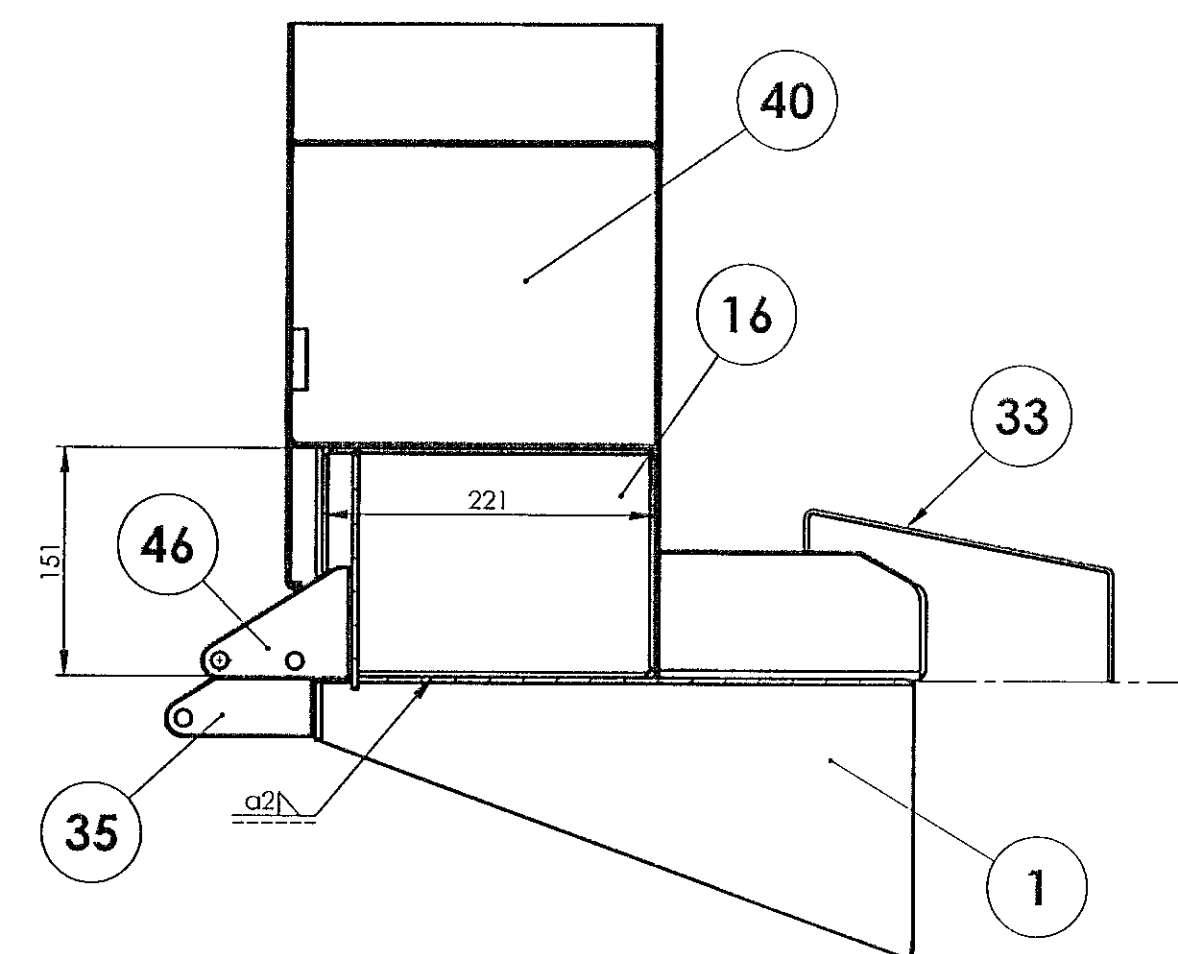
VIEW FROM COACH OUTSIDE

SECTION A-A
SCALE 1 : 10SECTION B-B
SCALE 1 : 10SECTION E-E
SCALE 1 : 10DETAIL C
SCALE 1 : 5SECTION D-D
SCALE 1 : 10SECTION T-T
SCALE 1 : 5DETAIL Q
SCALE 1 : 5SECTION J-J
SCALE 1 : 10DETAIL G
SCALE 1 : 5

GROUP: 1-5 End Construction		SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:	
SCALE 1:20		SSE/D		CHD	
ALT.		ALTD		Maresh	
a		DRN		B.Suresh	
INDIAN RAILWAY STANDARDS		SHEET 1 OF 3		LWCBAC/PP2	
INTEGRAL COACH FACTORY, CHENNAI - 600038		83015002		A1	


REF.DRG.NO.

▽ ROUGH MACHINED	(01) ROUGH CLEANED
▽▽ FINISH MACHINED	(01b) BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	(18) CHAMFERED



Technical drawing of a rectangular component. The overall width is 84 and the overall height is 40. The central square opening has a side length of 40. The drawing includes callouts for dimensions and features: $\alpha/2$ for the top edge of the central opening, 53 for the top edge of the central opening, and 32 for the right edge of the central opening. The drawing is a top-down view with dashed lines indicating hidden edges.

[illegible]

GROUP: 1-5 End Construction		SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:	
<div style="text-align: center;"> <h1>FRAME WORK</h1> </div>		SCALE 1:20		SSE/D	<i>B. Suresh</i>
				CHD	
		ALT. α	ALTD	Mahesh	
		DRN	S.Suresh		
<div style="text-align: center;"> <h2>INDIAN RAILWAY STANDARDS</h2> <p>INTEGRAL COACH FACTORY, CHENNAI - 600038</p> </div>		SHEET 2 OF 3		 LWCBAC/PP2	
				<div style="display: flex; justify-content: space-between;"> <div style="font-size: 2em; font-weight: bold;">83015002</div> <div style="border: 1px solid black; padding: 5px; font-size: 1.5em; font-weight: bold;">A1</div> </div>	

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REF DRG NC

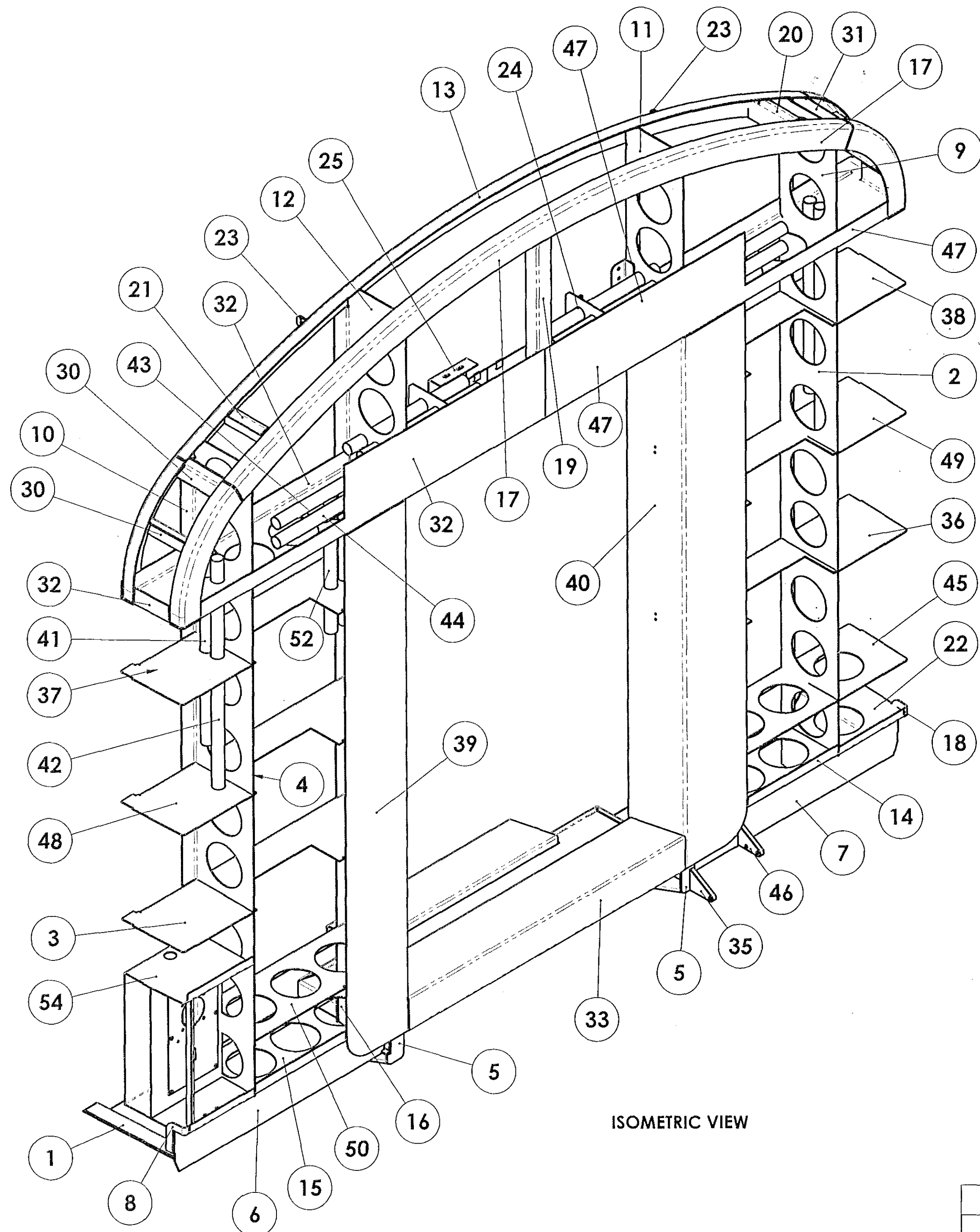
83015002

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

① ROUGH CLEANED
② BURRS REMOVED
③ CHAMFERED

REVISIONS

ALT.	ZONE	DESCRIPTION	APPROVED & DATE
a		ITEM-34 DELETED & VIEWS UPDATED ACCORDINGLY.	



ISOMETRIC VIEW

NOTE:

1. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC C-K201 SHALL BE USED FOR WELDING.
2. ALL WELD SPATTERS SHALL BE GROUND.
3. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
4. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
5. ALL WELDINGS SHALL BE TIG WELDING UNLESS OTHERWISE SPECIFIED.
6. ALL WELD PERFORMANCE CLASS SHALL BE CP C2 UNLESS OTHERWISE SPECIFIED.
7. FOR WELD TESTING PREFERENCES REFER DRG. No. ICF/STD-9-0-998.
8. FOR WELD PROCEDURE SPECIFICATION REFER DRG. No. ICF/STD-9-0-999.
9. ALL TAPPED HOLES FOR FIXING VESTIBULE SHALL BE DONE BY THE FIRM TO SUIT AT SITE.

1	PIPE COMPLETE		55	49515018		0.859	
1	BRACKET COMPLETE		54	58115004		9.128	
1	BACK PIECE	10x40x40	53		RDSO SPEC C-K201 X2 Cr Ni 12	0.13	
10	CONDUIT	1mm THK x Ø40 x 500	52		IS:17876 X04Cr19Ni9	0.49	
2	SUPPORT FOR CONDUITS		51	AAE15019		0.55	
1	FLANGE		50	AAE15079		3.355	
1	FLANGE		49	AAE15066		5.681	
1	FLANGE		48	AAE15065		5.686	
1	FLANGE		47	75415028		16.65	
1	BRACKET		46	AAD15960		0.60	
1	FLANGE		45	AAE15049		5.064	
4	CONDUIT	1mm THK x Ø40 x 925	44		IS:17876 X04Cr19Ni9	0.90	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS

2	SUPPORT FOR CONDUIT		43	AAD15711		0.21	
2	CONDUIT		42	AAD15858		0.89	
2	CONDUIT		41	AAD15859		0.68	
1	RAM PILLAR ASSEMBLY		40	75415026		28.57	
1	RAM PILLAR ASSEMBLY		39	75415025		28.57	
1	FLANGE		38	AAE15047		5.581	
1	FLANGE		37	AAE15043		5.586	
1	FLANGE		36	AAE15048		5.702	
1	BRACKET		35	AAB15007		0.61	
2	SUPPORT FOR VESTIBULE SLIDING DOOR BOTTOM RAIL		34	74115007		2.26	
1	RAMP ARRANGEMENT		33	75415022		23.787	
1	FLANGE		32	75415027		16.65	
2	REINFORCEMENT		31	AAA15474		0.911	
2	REINFORCEMENT		30	AAA15473		0.911	
2	FLAT		29	AAA10971		0.025	
2	BACK PIECE		28	AAA10969		0.102	
1	BRACKET COMPLETE		27	SSA10020		0.257	
1	BRACKET COMPLETE		26	SSA10019		0.257	
1	BRACKET		25	AAA10966		0.497	
2	BRACKET		24	AAA10961		0.222	
2	GROUNDING FLAP		23	AAA15465		0.087	
1	FLANGE		22	AAA15414		1.294	
1	REINFORCEMENT		21	AAA15205		0.761	
1	REINFORCEMENT		20	AAA15206		0.780	
1	REINFORCEMENT		19	AAA15210		1.458	
1	REINFORCEMENT		18	AAA15232		0.088	
1	ARCH COMPLETE		17	59315003		14.208	
2	WEB		16	AAA15208		0.782	
1	FLANGE LH		15	AAE15046		3.64	
1	FLANGE RH		14	AAE15050		3.65	
1	ARCH COMPLETE		13	59315004		13.994	
1	PILLAR		12	AAE15018		3.565	
1	PILLAR		11	AAE15017		3.565	
1	PILLAR		10	AAA15237		2.101	
1	PILLAR		9	AAA15238		2.101	
1	REINFORCEMENT		8	AAA15252		0.089	
1	FRAMEWORK PART		7	AAA15253		4.519	
1	FRAMEWORK PART		6	AAA15254		4.520	
2	REINFORCEMENT		5	AAA15257		0.362	
1	RAM PILLAR		4	AAD15904		10.688	
1	FLANGE		3	AAE15044		5.719	
1	RAM PILLAR		2	AAB15431		10.583	
1	SILL ARRANGEMENT		1	49515003		39.942	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS

GROUP: 1-5 End Construction

SURFACE AREA IN Sq.m.:

WT/ASSY IN Kgs:

FRAME WORK

INDIAN RAILWAY STANDARDS
INTEGRAL COACH FACTORY, CHENNAI - 600038

SHEET
3 OF 3

LWCBAC/PP2
83015002
A1

REF.DRG.NO.

14-01-2026
DATE OF LATEST ALT.

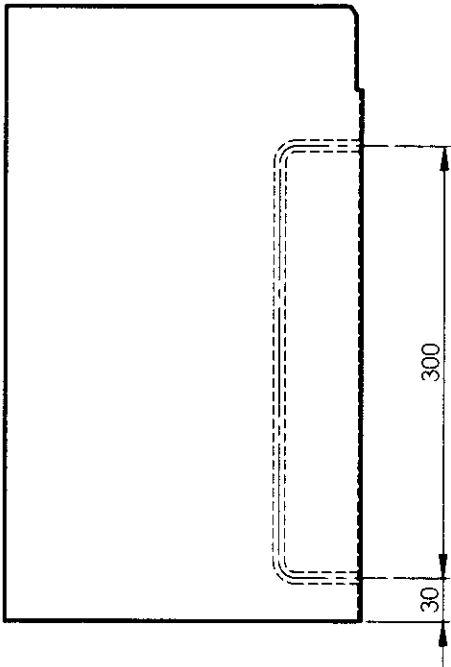
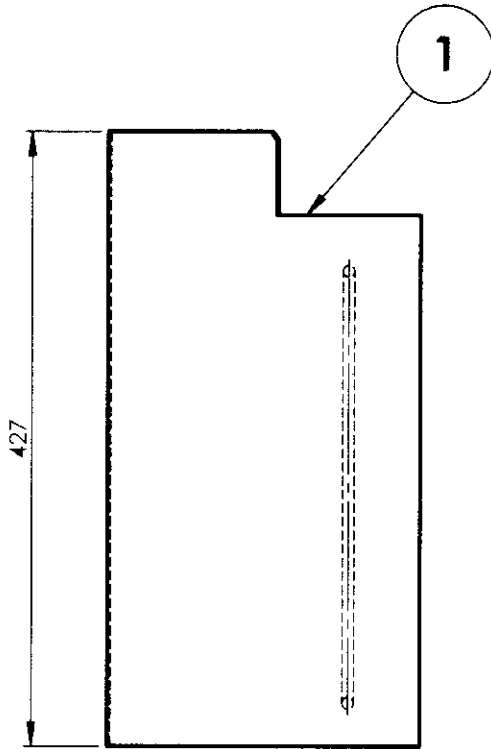
01-08-2025
DATE OF FIRST ISSUE

AME/SME

97115004

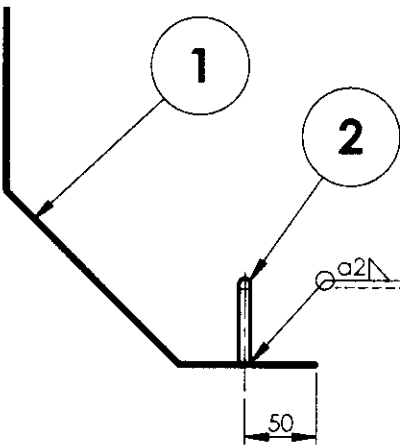
▽ ROUGH MACHINED	⊙ ROUGH CLEANED
▽▽ FINISH MACHINED	⊙ BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	⊙ CHAMFERED

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



NOTE:-

1. ALL WELDING SHALL BE OF TIG UNLESS OTHERWISE SPECIFIED.
2. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC. CK-201 SHALL BE USED FOR WELDING.
3. ALL WELDED JOINTS SPATTERS SHALL BE GROUND.
4. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
5. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
6. FOR WELD TESTING PREFERANCES REFER DRG No ICF/STD-9-0-998.
7. FOR WELD PROCEDURE SPECIFICATION REFER DRG. No ICF/STD-9-0-999.



1	ELEC CABLE TIE ROD		2	AAB15177		0.16	
1	ELEC COUPLER COVER		1	AAD15725		2.59	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS
GROUP: 1-5 End Construction				SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:	
ELEC COUPLER COVER COMPLETE					SCALE	CHD	
					1:5	CHD	
					ALT	ALT	
					DRN	DRN	SURESH B
INDIAN RAILWAY STANDARDS				SHEET 1 OF 1		LWS/VA	
INTEGRAL COACH FACTORY CHENNAI 600038				97115004		A3	

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REF.DRG.NO.

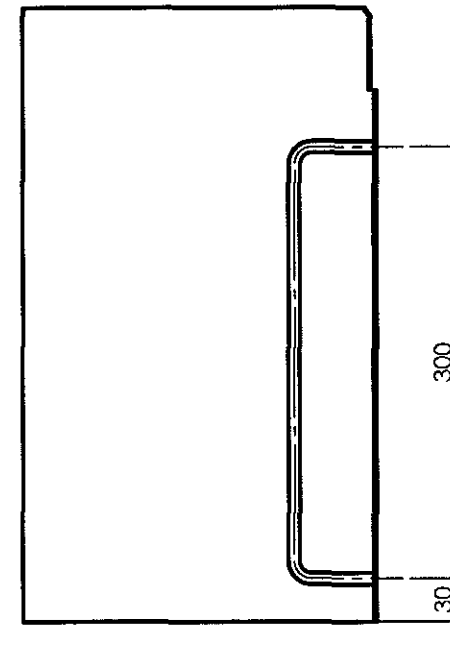
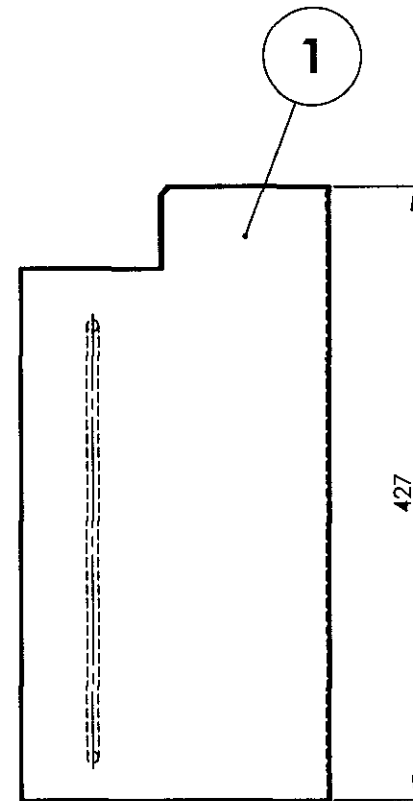
	05-09-2023	
DATE OF LATEST ALT	DATE OF FIRST ISSUE	AME/SME

97115005

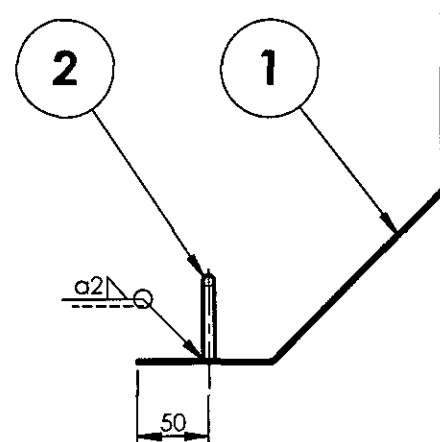
▽ ROUGH MACHINED	① ROUGH CLEANED
▽▽ FINISH MACHINED	①b BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	①c CHAMFERED

REVISIONS

ALT.	ZONE	DESCRIPTION	APPROVED & DATE
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**NOTE:-**

1. ALL WELDING SHALL BE OF TIG UNLESS OTHERWISE SPECIFIED.
2. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC. CK-201 SHALL BE USED FOR WELDING.
3. ALL WELDED JOINTS SPATTERS SHALL BE GROUND.
4. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
5. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
6. FOR WELD TESTING PREFERENCES REFER DRG. No. ICF/STD-9-0-998.
7. FOR WELD PROCEDURE SPECIFICATION REFER DRG. No. ICF/STD-9-0-999.



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WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY

REF.DRG.NO.

	05-09-2023	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

1	ELEC CABLE TIE ROD		2	AAB15177		0.16	
1	ELEC COUPLER COVER		1	AAD15726		2.57	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS

GROUP: 1-5 End Construction

SURFACE AREA IN Sq.m.:

WT/ASSY IN Kgs:

ELEC COUPLER COVER COMPLETE

SCALE	SSE/D	
1:5	CHD	
ALT.	ALTD	
	DRN	MURUGAN P

INDIAN RAILWAY STANDARDS

INTEGRAL COACH FACTORY, CHENNAI - 600038

SHEET
1 OF 1

LWS/VA

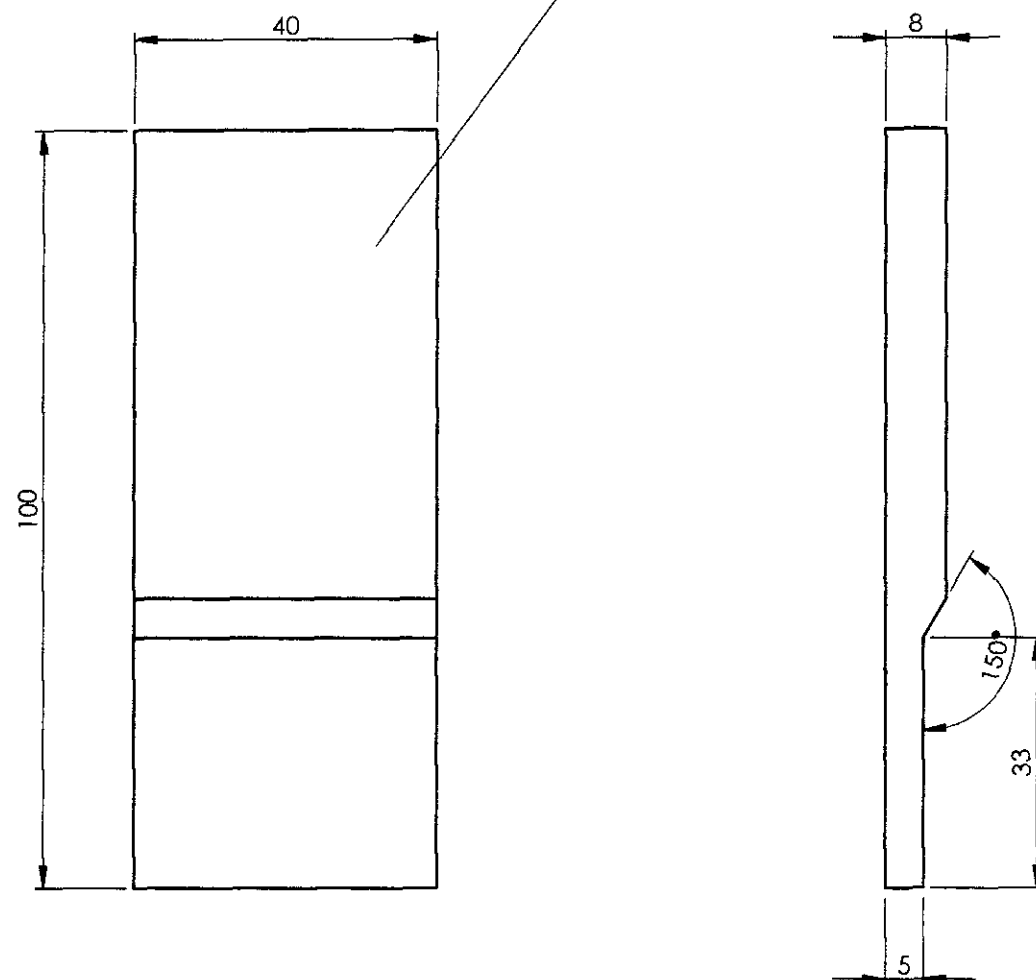
97115005

A3

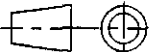
AAA10961

▽ ROUGH MACHINED	① ROUGH CLEANED
▽▽ FINISH MACHINED	①b BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	⑱ CHAMFERED

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE
a		NOTE 1 ADDED	<i>[Signature]</i>

**NOTE:**

1. ALTERNATIVELY IS 6911 X04Cr19Ni9 (OR) ASTM A240 S30400 MAY BE USED IN LIEU OF RDSO/SPEC C-K201 X5 Cr Ni 18 10 FOR ITEM 1.

1	BRACKET	8x40x100	1		RDSO/SPEC C- K201 X5 Cr Ni 18 10	0.222	
Default	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-0		SURFACE AREA IN Sq.m.:0.010			WT/ASSY IN Kgs:0.222		
BRACKET					SCALE	SSE/D	<i>L Panduranga Rao</i>
					1:1	CHD	
					ALT.	ALTD	MAHESHBABU
					a	DRN	L.PANDURANGA RAO
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1			
					AAA10961		A3

REF.DRG.NO.3 10113.0.20.095.124

AAA10966

▽ ROUGH MACHINED	⊙ ROUGH CLEANED
▽▽ FINISH MACHINED	⊙ BURRS REMOVED
▽▽▽ FINISH VACUUM	⊙ CHAMFERED

REVISIONS

ALT.

ZONE

DESCRIPTION

APPROVED &
DATE

1

160

53

R6

85

3

25

9

43.5

15

43

15

1	BRACKET	3x132x160	1		RDSO/SPEC C- K201 X2CrNi12	0.497	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-0				SURFACE AREA IN Sq.m.:0.043		WT/ASSY IN Kgs:0.497	
BRACKET					SCALE 1:1	SSE/D CHD	L.PANDURANGA RAO
					ALT.	ALTD	
						DRN	L.PANDURANGA RAO
INDIAN RAILWAY STANDARDS					SHEET 1 OF 1		
INTEGRAL COACH FACTORY, CHENNAI - 600038					AAA10966		
					A3		

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICF/SID 9 0 001.
ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER IS: 813:1986.

REF.DRG.NO.3 10113.0.20.095.159

DATE OF LATEST ALT.

10-04-2013

DATE OF FIRST ISSUE

AME/SME

10/4/13

1		2		3		4		5		6		7		8																																																																																
AAA10969				▽ ROUGH MACHINED		⊖ ROUGH CLEANED		REVISIONS																																																																																						
				▽▽ FINISH MACHINED		⊖⊖ BURRS REMOVED		ALT.		ZONE		DESCRIPTION			APPROVED & DATE																																																																															
				▽▽▽ FINE FINISH MACHINED		⊖⊖⊖ CHAMFERED																																																																																								
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<table><tr><td>1</td><td>BACK PIECE</td><td>8x40x40</td><td>1</td><td></td><td>RDSO/SPEC C-K201 X2CrNi12</td><td>0.102</td><td></td></tr><tr><td>QTY.</td><td>DESCRIPTION</td><td>DIMENSIONS</td><td>ITEM NO.</td><td>REF. DRGS</td><td>MATL.SPEC.</td><td>WT/UNIT IN KGS</td><td>REMARKS</td></tr><tr><td colspan="2">GROUP: 1-0</td><td colspan="3">SURFACE AREA IN Sq.m.:0.004</td><td colspan="3">WT/ASSY IN Kgs:0.102</td></tr><tr><td colspan="5" rowspan="4">FLAT</td><td>SCALE</td><td>SSE/D</td><td rowspan="2">L. Panduranga Rao</td></tr><tr><td>2:1</td><td>CHD</td></tr><tr><td>ALT.</td><td>ALTD</td><td rowspan="2">L.PANDURANGA RAO</td></tr><tr><td></td><td>DRN</td></tr><tr><td colspan="4">INDIAN RAILWAY STANDARDS</td><td colspan="2">SHEET 1 OF 1</td><td colspan="2">AAA10969</td><td colspan="2">A3</td></tr><tr><td colspan="4">INTEGRAL COACH FACTORY, CHENNAI - 600038</td><td colspan="2"></td><td colspan="2"></td><td colspan="2"></td></tr><tr><td colspan="2">REF.DRG.NO.LW10204; ITEM-17</td><td>10-04-2013</td><td>10/4/13</td><td colspan="2"></td><td colspan="2"></td><td colspan="2"></td></tr><tr><td colspan="2">DATE OF LATEST ALT.</td><td>DATE OF FIRST ISSUE</td><td>AME/SME</td><td colspan="2"></td><td colspan="2"></td><td colspan="2"></td></tr></table>																1	BACK PIECE	8x40x40	1		RDSO/SPEC C-K201 X2CrNi12	0.102		QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS	GROUP: 1-0		SURFACE AREA IN Sq.m.:0.004			WT/ASSY IN Kgs:0.102			FLAT					SCALE	SSE/D	L. Panduranga Rao	2:1	CHD	ALT.	ALTD	L.PANDURANGA RAO		DRN	INDIAN RAILWAY STANDARDS				SHEET 1 OF 1		AAA10969		A3		INTEGRAL COACH FACTORY, CHENNAI - 600038										REF.DRG.NO.LW10204; ITEM-17		10-04-2013	10/4/13							DATE OF LATEST ALT.		DATE OF FIRST ISSUE	AME/SME						
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