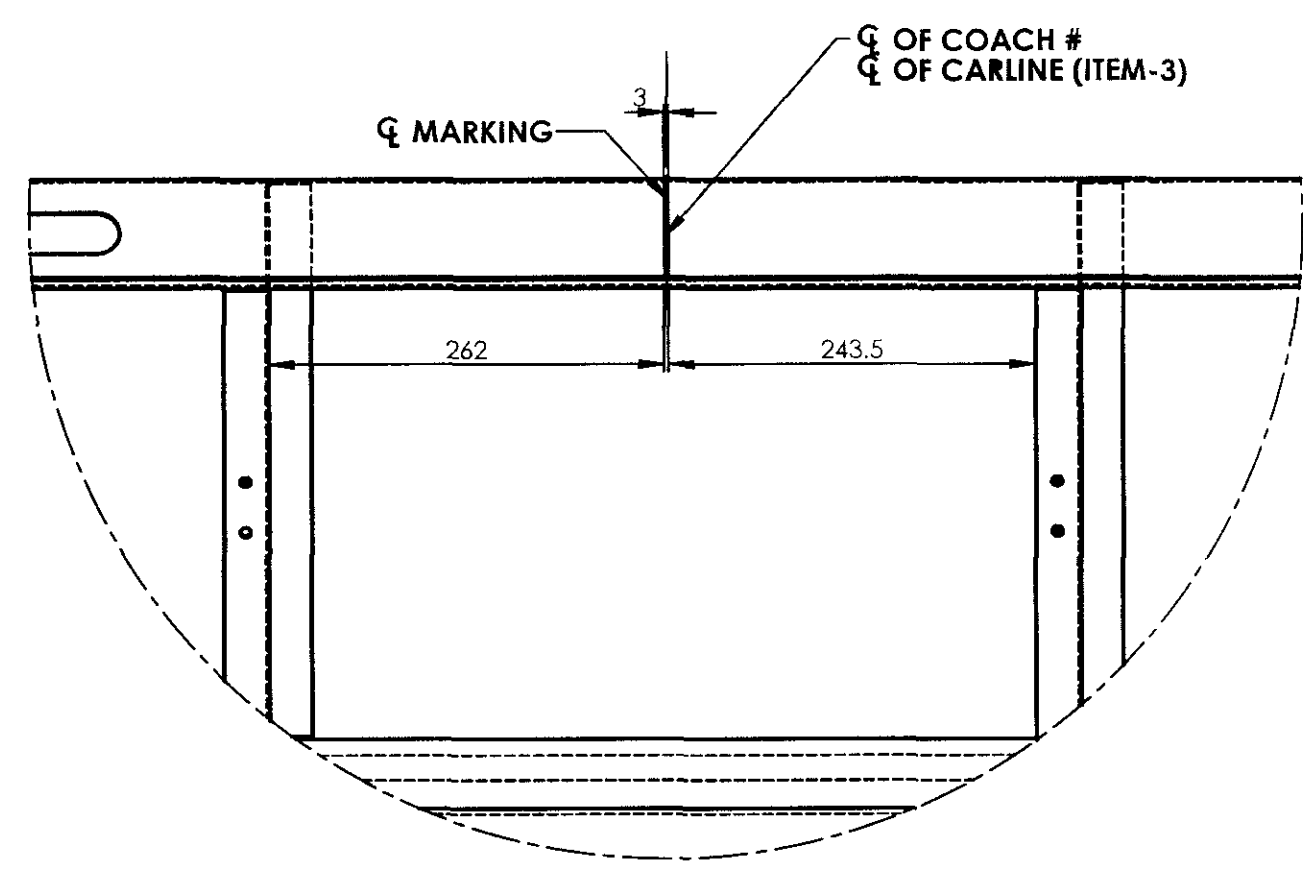


DETAIL K  
SCALE 1 : 5



DETAIL L  
SCALE 1 : 5

# CENTERLINE MARKING NOTE:

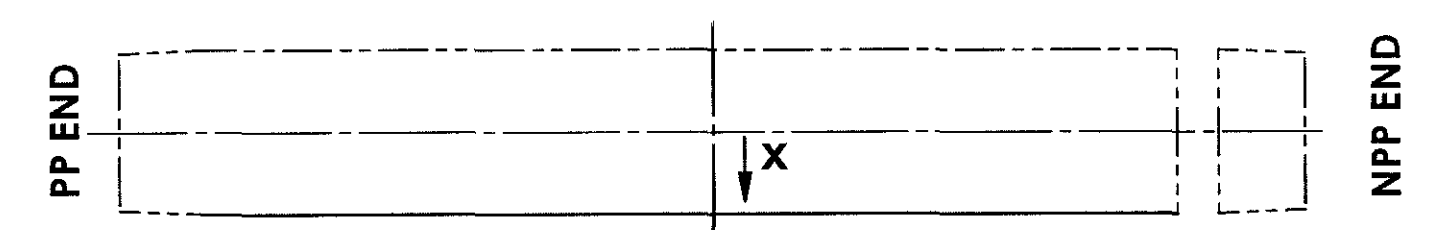
CENTER LINE OF COACH TO BE MARKED ON BOTH SIDES OF SIDEWALL

LENGTH OF MARKING - 80 mm  
COLOUR OF MARKING-RED  
WIDTH OF MARKING -2 TO 3 mm

CENTERLINE TO BE MARKED AFTER WELDING THE RESPECTIVE WELD PARTS.

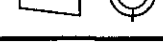
NOTE:

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.
10. ITEMS MARKED THUS ⊕ TO BE SUPPLIED LOOSE AND WELDED AT BODY SHELL STAGE.
11. SCHEDULE OF REQUIREMENTS FOR MANUFACTURE OF SIDEWALL ASSEMBLY SHALL COMPLY TO ICF/MD/SPEC-200 LATEST REVISION.
12. ITEM-4 (NAME PLATE) SHALL BE WELDED OR RIVETTED AT SUITABLE LOCATION AS SHOWN IN THE DRAWING IF PROCURED FROM TRADE.



REF. DIAGRAM

1	LOCATION OF BACKPIECES ON SIDEWALL (CORRIDOR SIDE)		6	83014005		2.82	
1	NAME PLATE FOR SUPPLIER IDENTIFICATION		5	AAA51072		0.043	
1	DOOR CUT OUT ASSEMBLY		4	SSA14028		59.287	
1	CARLINE COMPLETE RIGHT		3	83014013		209.456	
1	SIDEWALL SHEET COMPLETE RIGHT		2	83014009		493.74	
1	SIDEWALL FRAME WORK RIGHT COMPLETE		1	83014011		456.436	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS

GROUP: 1-4 Body Side Walls		SURFACE AREA IN Sq.m.: 138.84		WT/ASSY IN Kgs:		
SIDEWALL RIGHT COMPLETE				SCALE 1:30	SSE'D <i>R. Santhosh</i>	
					CHD	
				ALT.	ALTD	
				ERN	R. SANTHOSH KUMAR	
INDIAN RAILWAY STANDARDS					LWCBAC/PP2	
INTEGRAL COACH FACTORY, CHENNAI - 600038						
SHEET 2 OF 2				83014003		A1

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.

83014004

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

(1) ROUGH CLEANED  
(11) BURRS REMOVED  
(18) CHAMFERED

VIEW FROM X

DETAIL A  
SCALE 1 : 10

DETAIL C  
SCALE 1 : 10

SECTION B-B  
SCALE 1 : 5

SECTION D-D  
SCALE 1 : 5

SECTION E-E  
SCALE 1 : 5

SECTION AD-AD  
SCALE 1 : 5

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 IS 13:1986. WEIGHT GIVEN IN DRAWINGS IS FOR INDICATIVE PURPOSE ONLY.

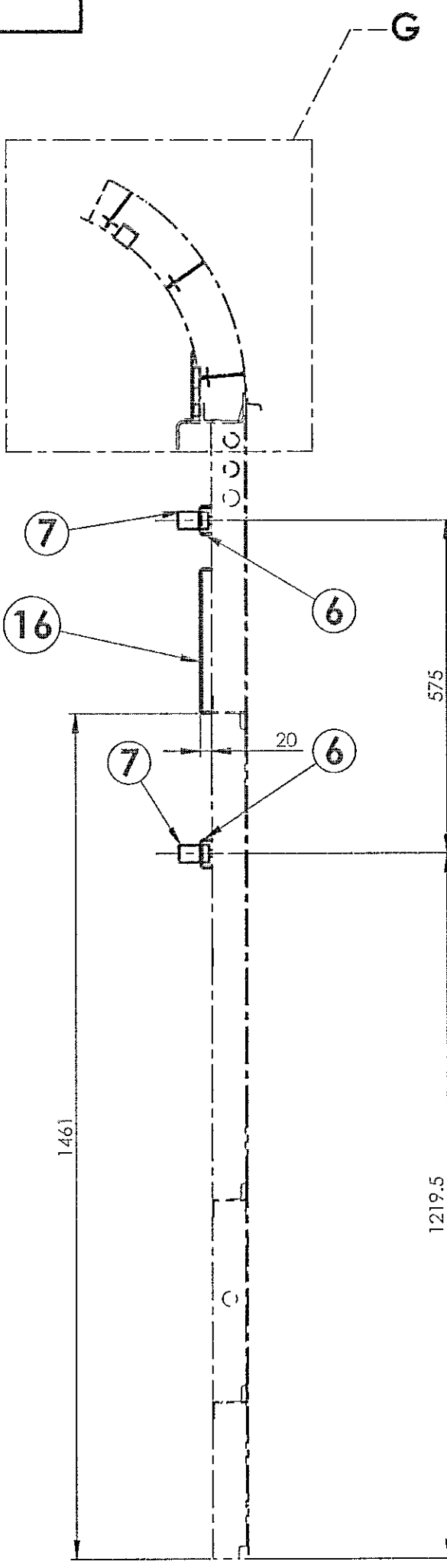
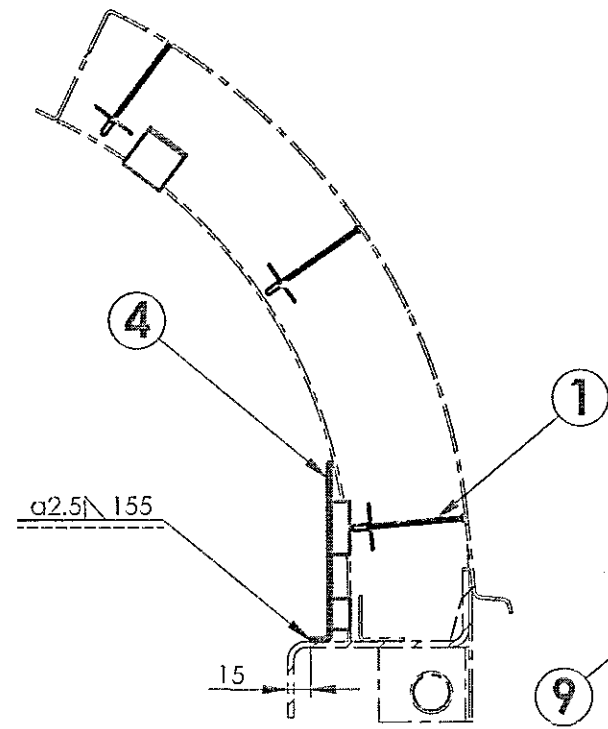
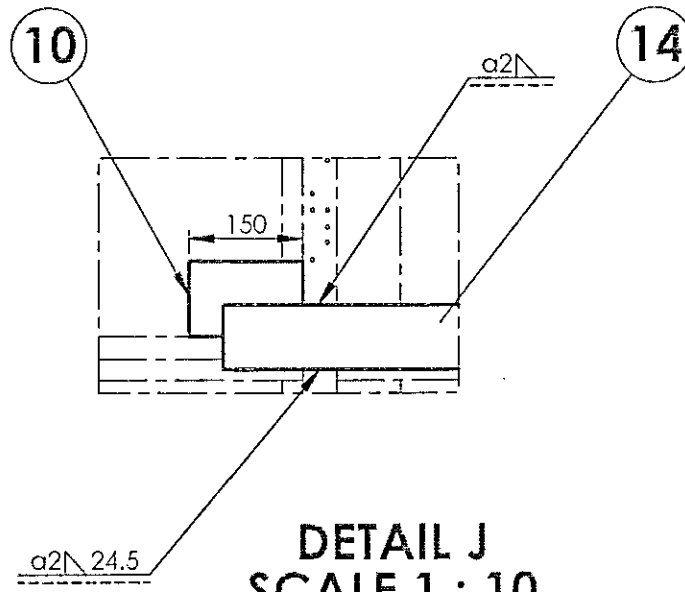
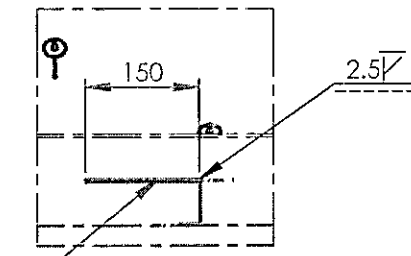
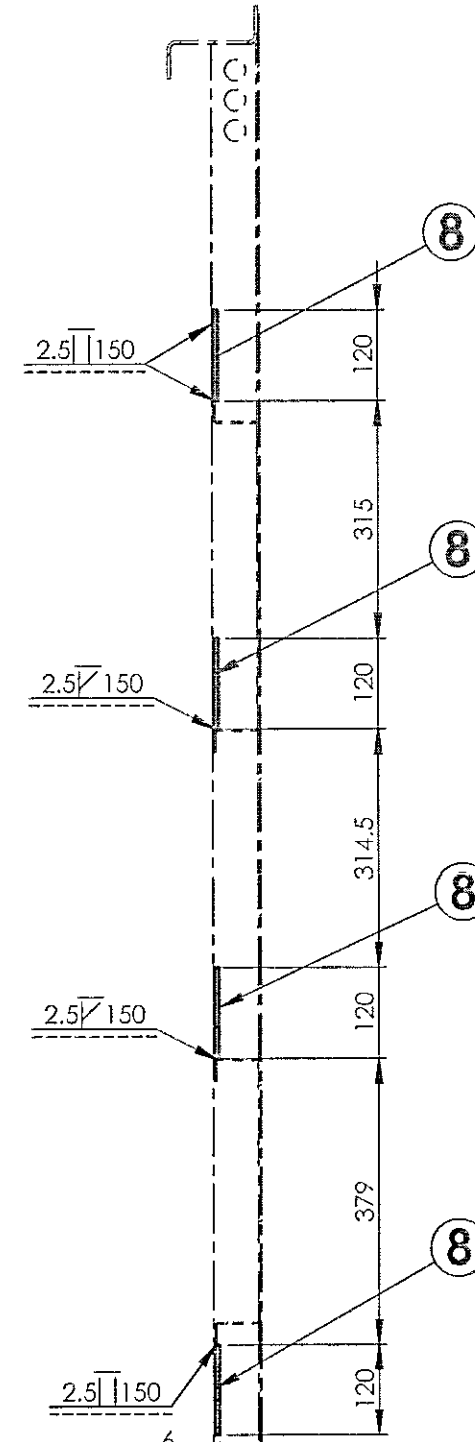
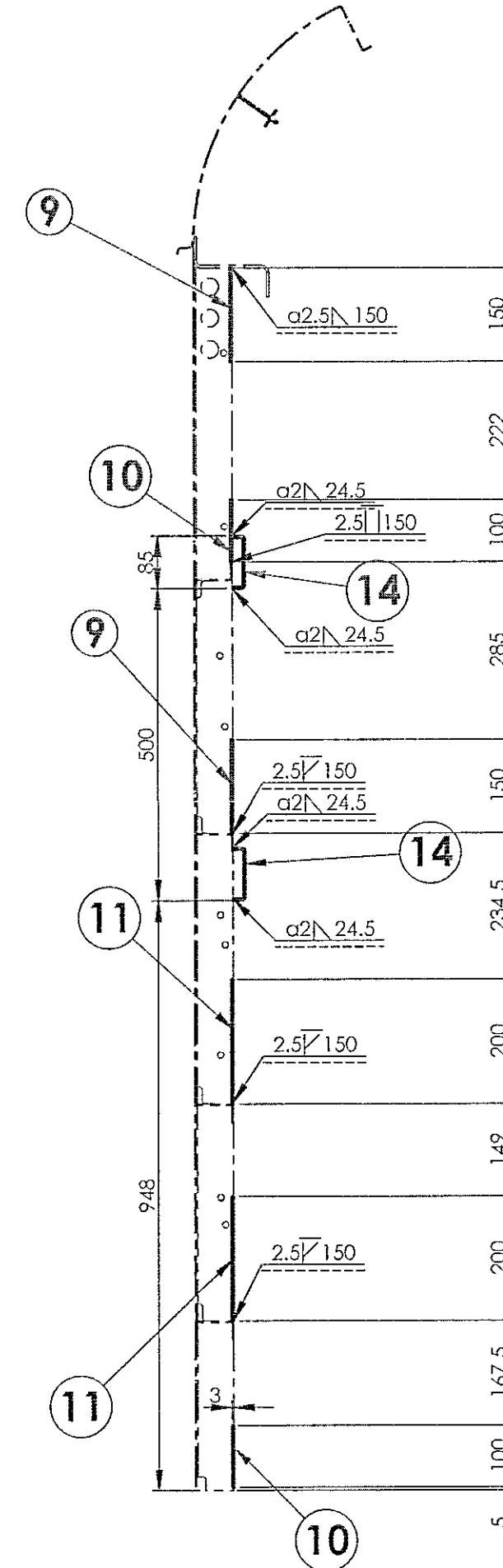
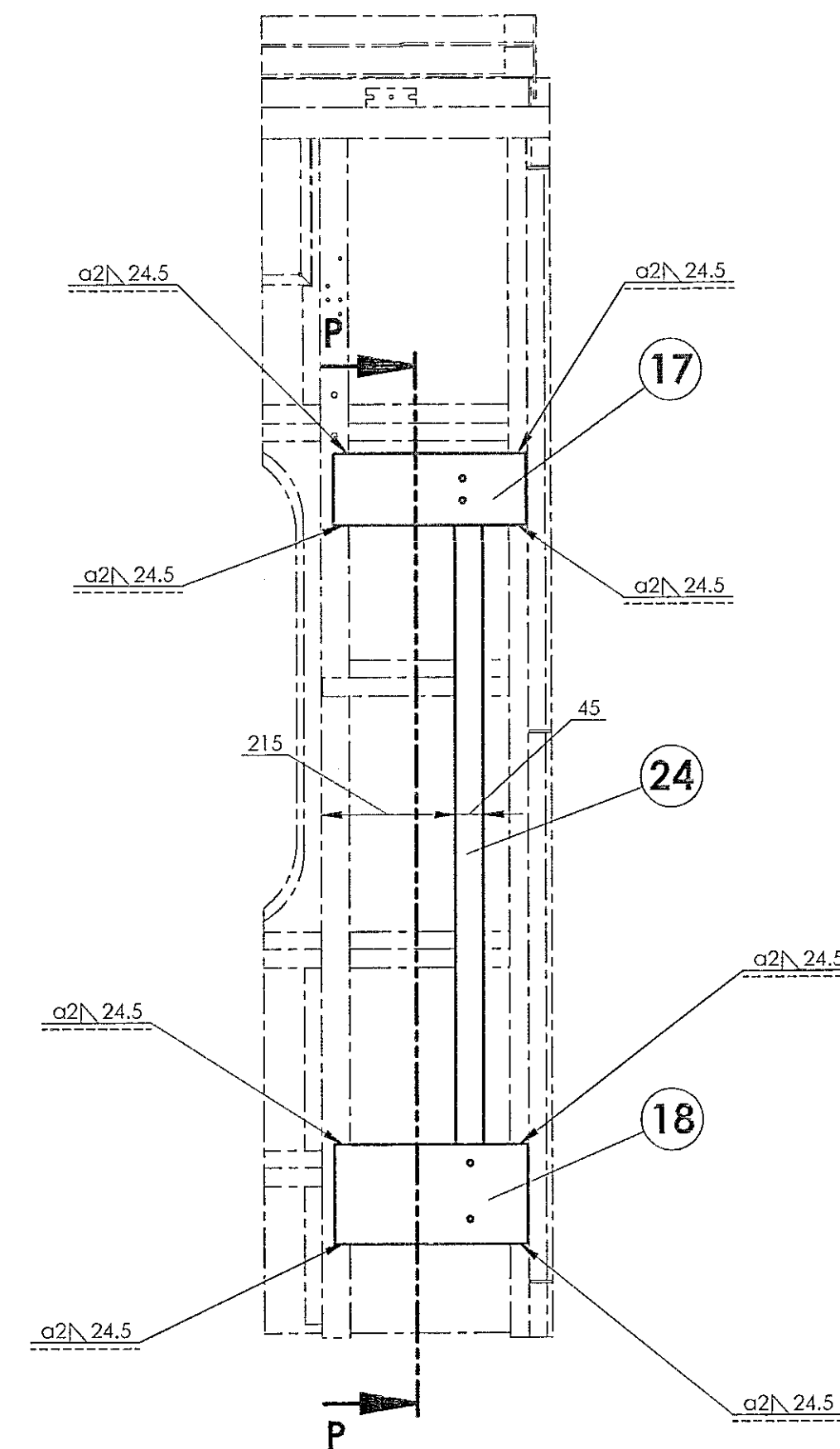
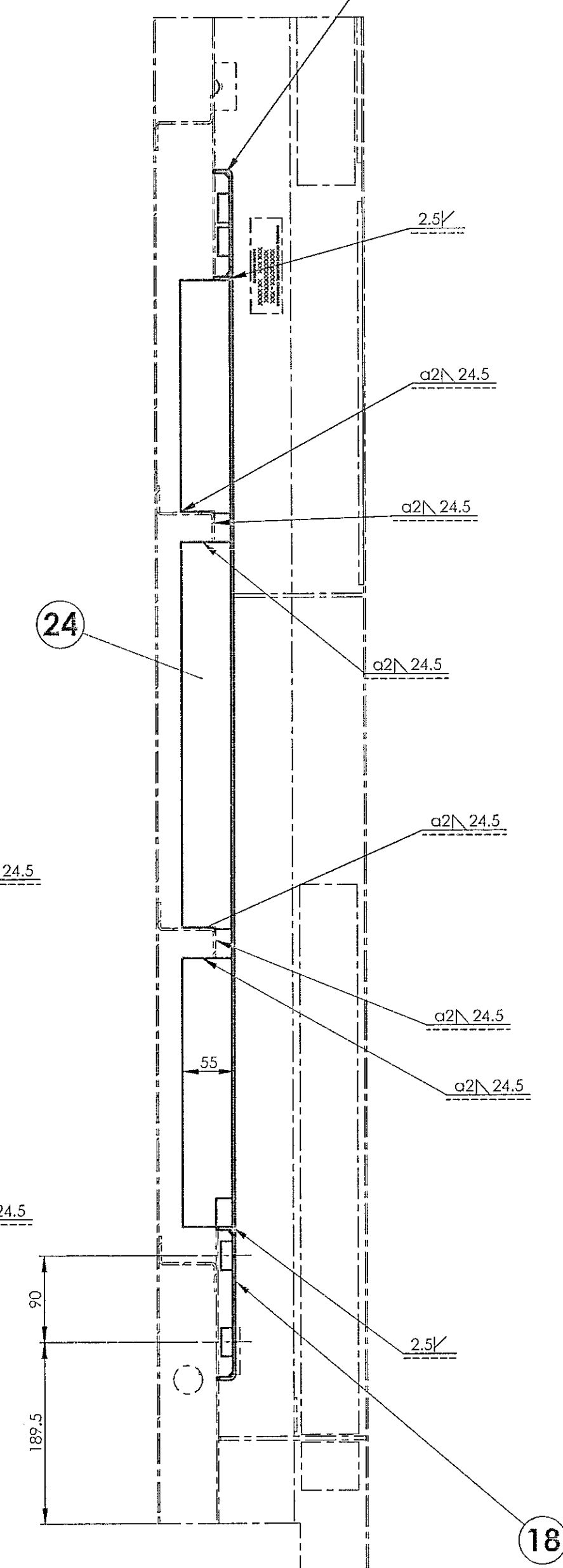
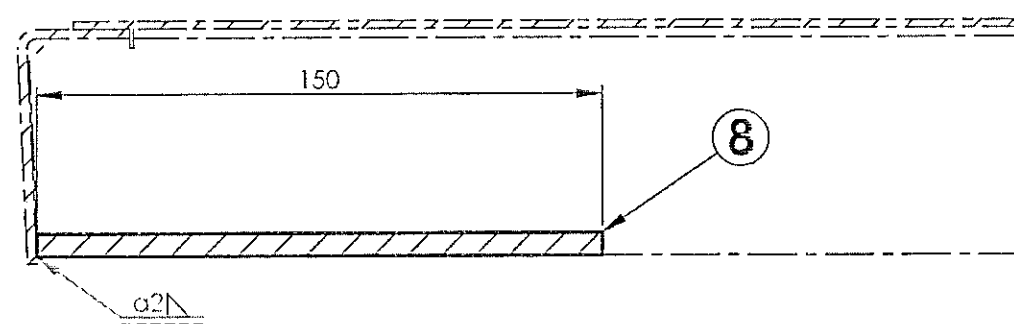
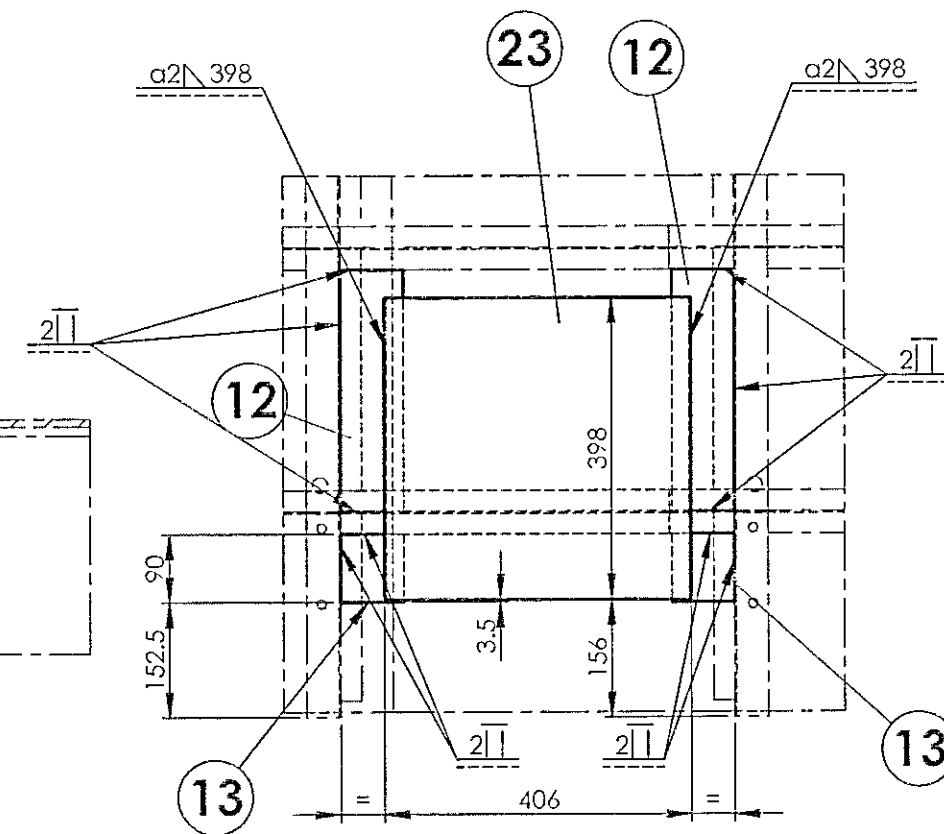
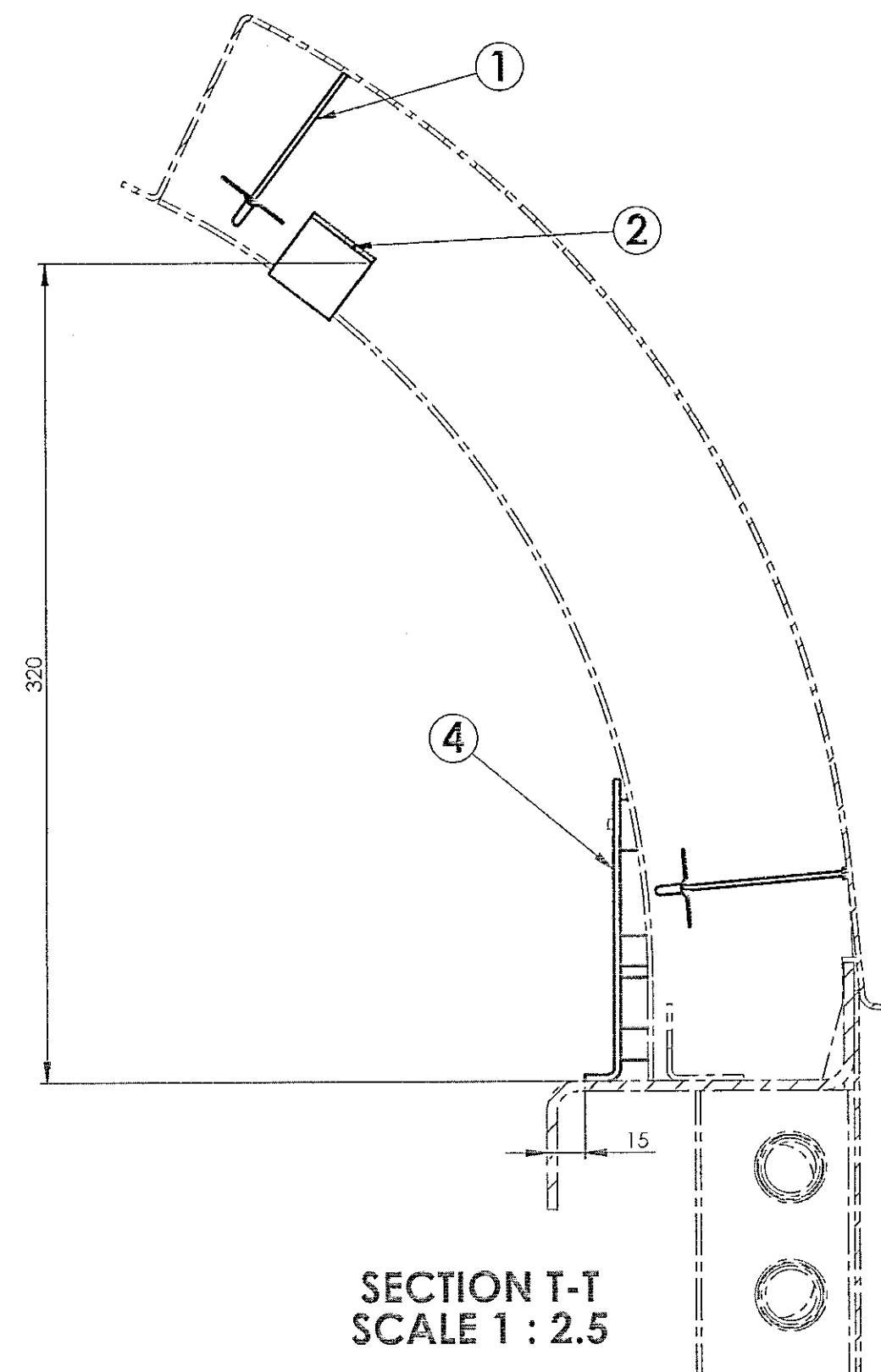
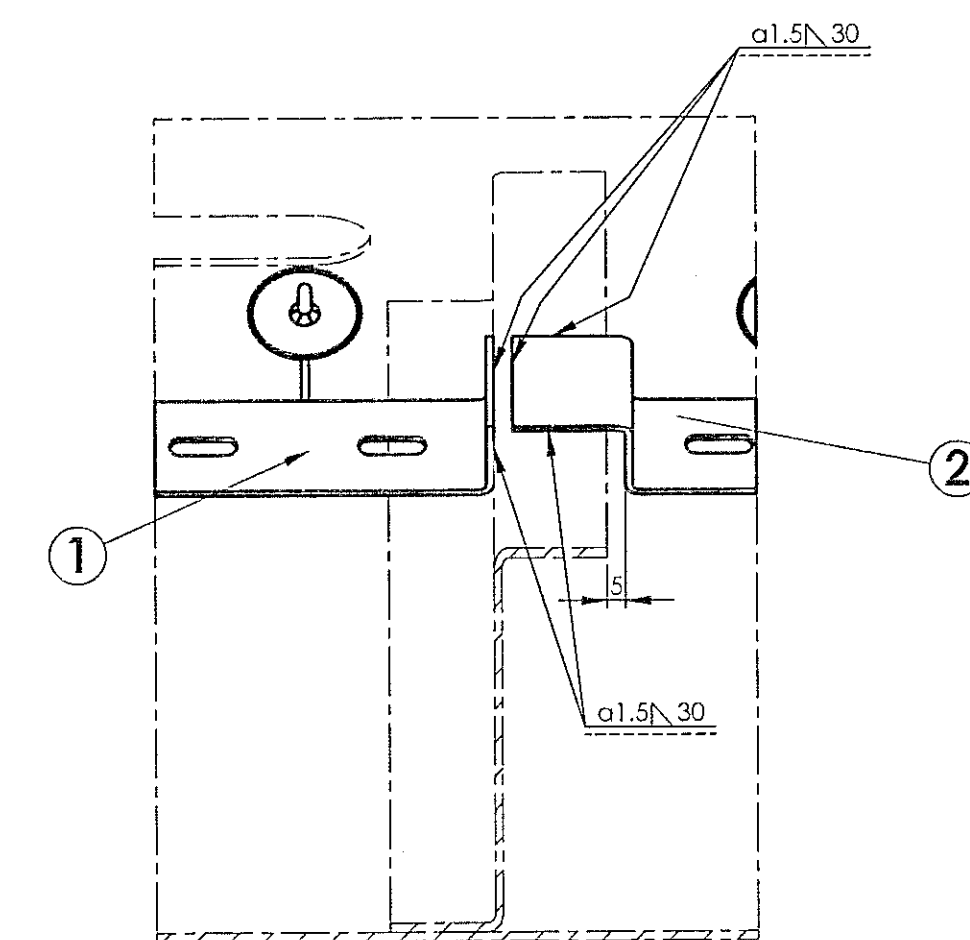
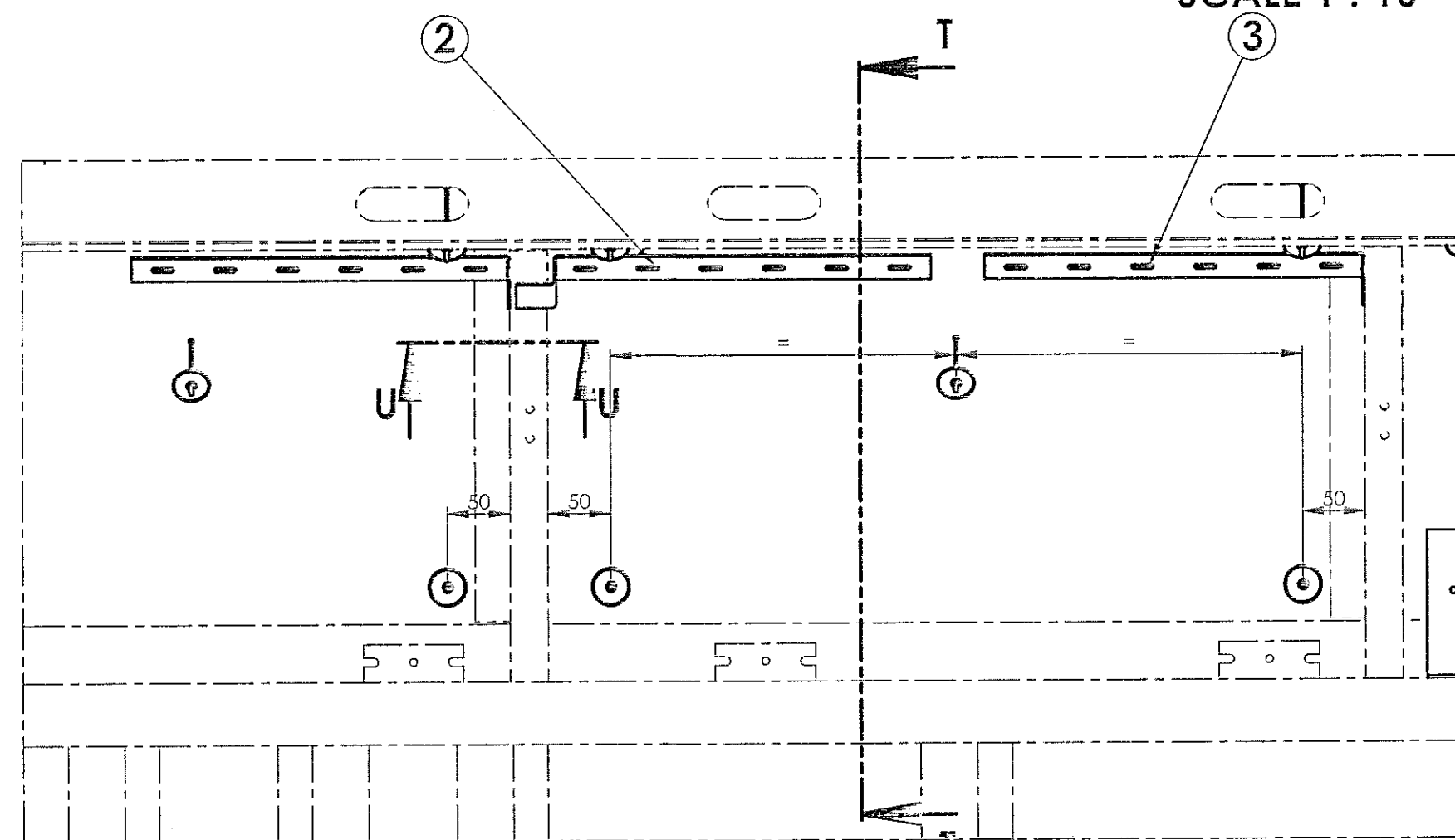
REF.DRG.NO.LH14340a/-

5-11-2025 16-07-2025  
DATE OF LATEST ALT. DATE OF FIRST ISSUE  
AME/SME

GROUP: 1-4 Body Side Walls		SURFACE AREA IN Sq.m.: 157.86		WT/ASSY IN Kgs:	
LOCATION OF BACKPIECES ON SIDEWALL (PANTRY SIDE)		SCALE 1:25	SSE/D	R. SANTHOSH KUMAR	
		CHD	ALT	R. SANTHOSH KUMAR	
		DRN	DRN	R. SANTHOSH KUMAR	
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038		SHEET 1 OF 3		LWCBAC/PP2	
		83014004		A1	

83014004

▽ ROUGH MACHINED	(01) ROUGH CLEANED
▽▽ FINISH MACHINED	(02) BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	(03) CHAMFERED

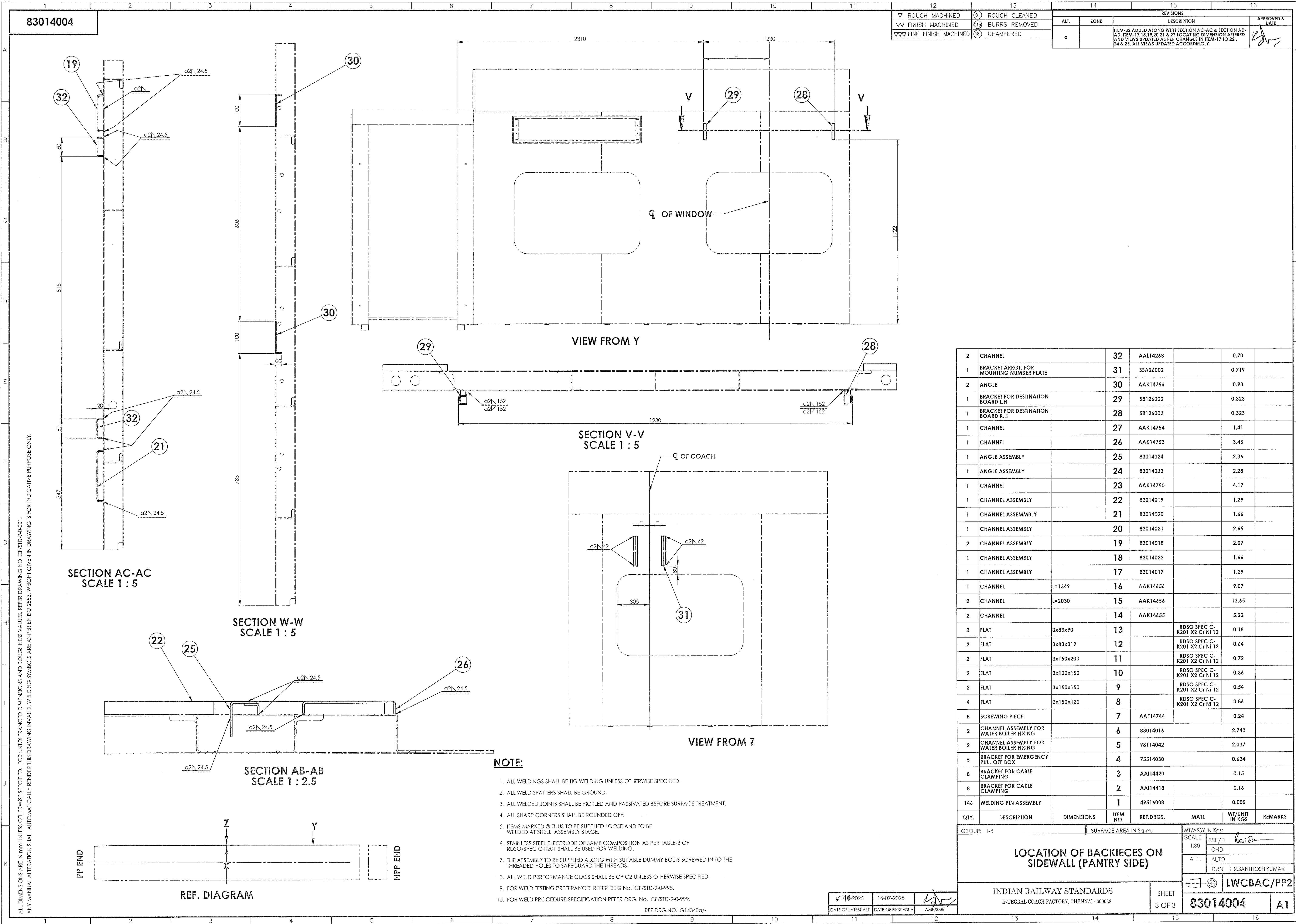
SECTION F-F  
SCALE 1 : 10DETAIL G  
SCALE 1 : 5DETAIL J  
SCALE 1 : 10DETAIL K  
SCALE 1 : 10SECTION L-L  
SCALE 1 : 10SECTION M-M  
SCALE 1 : 10DETAIL N  
SCALE 1 : 10SECTION P-P  
SCALE 1 : 5SECTION Q-Q  
SCALE 1 : 2DETAIL R  
SCALE 1 : 10SECTION T-T  
SCALE 1 : 2.5SECTION U-U  
SCALE 1 : 2DETAIL S  
SCALE 1 : 5

REF.DRG.NO.LH14340a/-

5-11-2025	16-07-2025	AME/SME
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	

GROUP: 1-4 Body Side Walls		SURFACE AREA IN Sq.m.: 157.86		WT/ASSY IN Kgs:	
SCALE 1:30		SSE/D		CHD	
ALT. a		ALTD		R. SANTHOSH KUMAR	
		DRN		R. SANTHOSH KUMAR	
INDIAN RAILWAY STANDARDS		SHEET 2 OF 3		LWCBAC/PP2	
INTEGRAL COACH FACTORY, CHENNAI - 600038		83014004		A1	





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

01	ROUGH CLEANED
010	BURRS REMOVED
010	CHAMFERED

REVISIONS		APPROVED & DATE
ALT.	ZONE	
a		

ITEM-32 ADDED ALONG WITH SECTION AC-AC & SECTION AD-AD. ITEM-17,18,19,20,21 & 22 LOCATING DIMENSION ALTERED AND VIEWS UPDATED AS PER CHANGES IN ITEM-17 TO 22, 24 & 25. ALL VIEWS UPDATED ACCORDINGLY.

2	CHANNEL		32	AAI14268		0.70	
1	BRACKET ARRGT. FOR MOUNTING NUMBER PLATE		31	SSA26002		0.719	
2	ANGLE		30	AAK14756		0.93	
1	BRACKET FOR DESTINATION BOARD L.H		29	58126003		0.323	
1	BRACKET FOR DESTINATION BOARD R.H		28	58126002		0.323	
1	CHANNEL		27	AAK14754		1.41	
1	CHANNEL		26	AAK14753		3.45	
1	ANGLE ASSEMBLY		25	83014024		2.36	
1	ANGLE ASSEMBLY		24	83014023		2.28	
1	CHANNEL		23	AAK14750		4.17	
1	CHANNEL ASSEMBLY		22	83014019		1.29	
1	CHANNEL ASSEMBLY		21	83014020		1.66	
1	CHANNEL ASSEMBLY		20	83014021		2.65	
2	CHANNEL ASSEMBLY		19	83014018		2.07	
1	CHANNEL ASSEMBLY		18	83014022		1.66	
1	CHANNEL ASSEMBLY		17	83014017		1.29	
1	CHANNEL	L=1349	16	AAK14656		9.07	
2	CHANNEL	L=2030	15	AAK14656		13.65	
2	CHANNEL		14	AAK14655		5.22	
2	FLAT	3x83x90	13		RDSO SPEC C-K201 X2 Cr Ni 12	0.18	
2	FLAT	3x83x319	12		RDSO SPEC C-K201 X2 Cr Ni 12	0.64	
2	FLAT	3x150x200	11		RDSO SPEC C-K201 X2 Cr Ni 12	0.72	
2	FLAT	3x100x150	10		RDSO SPEC C-K201 X2 Cr Ni 12	0.36	
2	FLAT	3x150x150	9		RDSO SPEC C-K201 X2 Cr Ni 12	0.54	
4	FLAT	3x150x120	8		RDSO SPEC C-K201 X2 Cr Ni 12	0.86	
8	SCREWING PIECE		7	AAF14744		0.24	
2	CHANNEL ASSEMBLY FOR WATER BOILER FIXING		6	83014016		2.740	
2	CHANNEL ASSEMBLY FOR WATER BOILER FIXING		5	98114042		2.037	
5	BRACKET FOR EMERGENCY PULL OFF BOX		4	75514030		0.634	
8	BRACKET FOR CABLE CLAMPING		3	AAI14420		0.15	
8	BRACKET FOR CABLE CLAMPING		2	AAI14418		0.16	
146	WELDING PIN ASSEMBLY		1	49516008		0.005	

QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS
GROUP: 1-4				SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:	
				SCALE 1:30		SSE/D CHD	
						ALT. ALTD	
						DRN R.SANTHOSH KUMAR	
						LWCBAC/PP2	
						83014004	
						A1	

- NOTE:**
- ALL WELDINGS SHALL BE TIG WELDING UNLESS OTHERWISE SPECIFIED.
  - ALL WELD SPATTERS SHALL BE GROUND.
  - ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
  - ALL SHARP CORNERS SHALL BE ROUNDED OFF.
  - ITEMS MARKED @ THUS TO BE SUPPLIED LOOSE AND TO BE WELDED AT SHELL ASSEMBLY STAGE.
  - STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC C-K201 SHALL BE USED FOR WELDING.
  - THE ASSEMBLY TO BE SUPPLIED ALONG WITH SUITABLE DUMMY BOLTS SCREWED IN TO THE THREADED HOLES TO SAFEGUARD THE THREADS.
  - ALL WELD PERFORMANCE CLASS SHALL BE CP C2 UNLESS OTHERWISE SPECIFIED.
  - FOR WELD TESTING PREFERENCES REFER DRG.No. ICF/STD-9-0-998.
  - FOR WELD PROCEDURE SPECIFICATION REFER DRG. No. ICF/STD-9-0-999.

REF.DRG.NO.LG14340a/-

14-07-2025	14-07-2025	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

INDIAN RAILWAY STANDARDS  
INTEGRAL COACH FACTORY, CHENNAI - 600038

SHEET  
3 OF 3

▽ ROUGH MACHINED	⑨⑩ ROUGH CLEANED	REVISIONS			
▽▽ FINISH MACHINED	⑩⑪ BURRS REMOVED	ALT.	ZONE	DESCRIPTION	APPROVED & DATE
▽▽▽ FINE FINISH MACHINED	⑪⑫ CHAMFERED				

**VIEW FROM - Y**

SECTION B-B  
SCALE 1 : 5

SECTION D-D  
SCALE 1 : 5

Technical drawing of a rectangular room layout. The drawing shows a central rectangular area with dimensions indicated by double lines and arrows. The width is marked as 50 on both the left and right sides. The length is marked with two segments, each labeled with a double line and an arrow. There are four circular elements, each with a dot in the center, located at the corners of the central rectangle. A callout line points from a circle labeled '3' to one of these corner elements. Another callout line points from a circle labeled '5' to a detail of a door or window frame on the right side of the drawing. The drawing is enclosed in a dashed rectangular border.


REF. DIAGRAM

The diagram shows a horizontal beam element. The left end is labeled "PP END" and the right end is labeled "NPP END". A vertical line passes through the center of the beam, with a downward arrow labeled "x" and an upward arrow labeled "y".

**NOTE:**


1. ALL WELDINGS SHALL BE TIG WELDING UNLESS OTHERWISE SPECIFIED.
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. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RSO/SPEC-C-K201 SHALL BE USED FOR WELDING.
6. THE ASSEMBLY TO BE SUPPLIED ALONG WITH SUITABLE DUMMY BOLTS SCREWED IN TO THE THREADED HOLES TO SAFEGUARD THE THREADS.
7. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
8. FOR WELD TESTING PREFERENCES REFER DRG. No. ICF/STD-9-0-998.
9. FOR WELD PROCEDURE SPECIFICATION REFER DRG. No. ICF/STD-9-0-999.

1	BRACKET ARRGT. FOR MOUNTING NUMBER PLATE		6	SSA24002		0.719	
9	BRACKET FOR CABLE CLAMPING		5	AAI14420		0.15	
1	BRACKET FOR CABLE CLAMPING		4	AAI14418		0.14	
145	WELDING PIN ASSEMBLY		3	49514008		0.005	
1	BRACKET FOR DESTINATION BOARD L.H		2	58124003		0.323	
1	BRACKET FOR DESTINATION BOARD R.H		1	58124002		0.323	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT./UNIT IN KGS	REMARKS

GROUP: 1-4 Body Side Walls		SURFACE AREA IN Sq.m:		WT/ASSY IN Kgs:	
<b>WELDING PARTS ON SIDEWALL RIGHT</b>		SCALE 1:30		SSE/D <i>R. SANTOSH</i>	
		CHD		CHD	
		ALT		ALTD	
		DIRN		R. SANTOSH KUMAR	
<b>INDIAN RAILWAY STANDARDS</b> INTEGRAL COACH FACTORY, CHENNAI - 600038		SHEET		 <b>LWCBAC/PP2</b>	
		1 OF 1		<b>83014005</b>	
				<b>A1</b>	

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO. ICF/STD-9-0001. 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.

REF.DRG.NO.LH14341

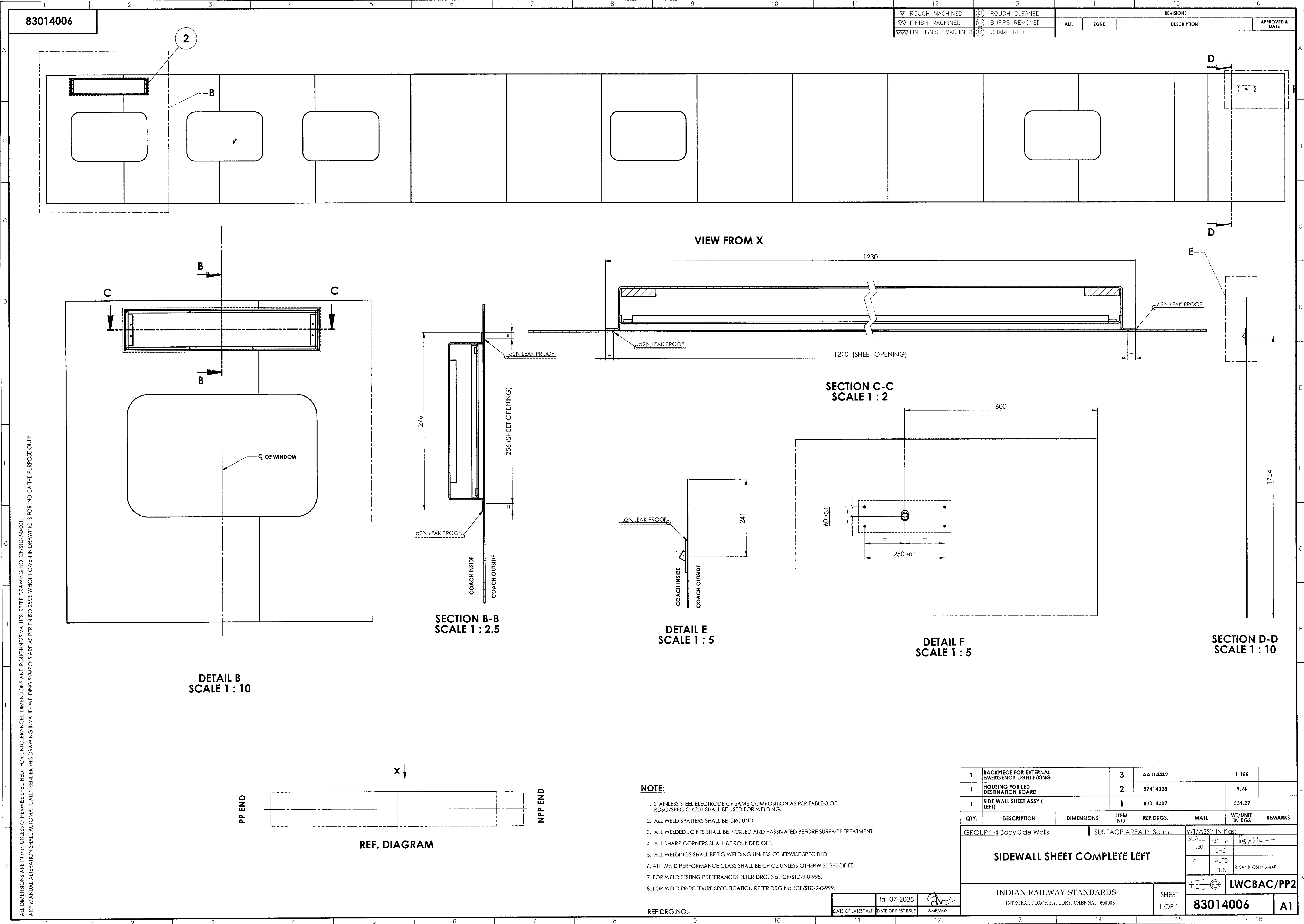
-	16-07-2025	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

INDIAN RAILWAY STANDARDS  
INTEGRAL COACH FACTORY, CHENNAI - 600038

SHEET  
1 OF 1

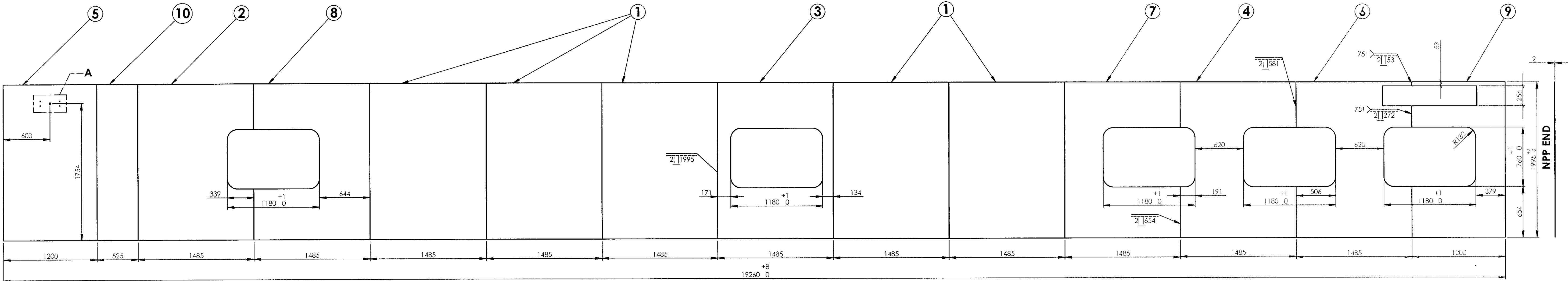
83014005

A1

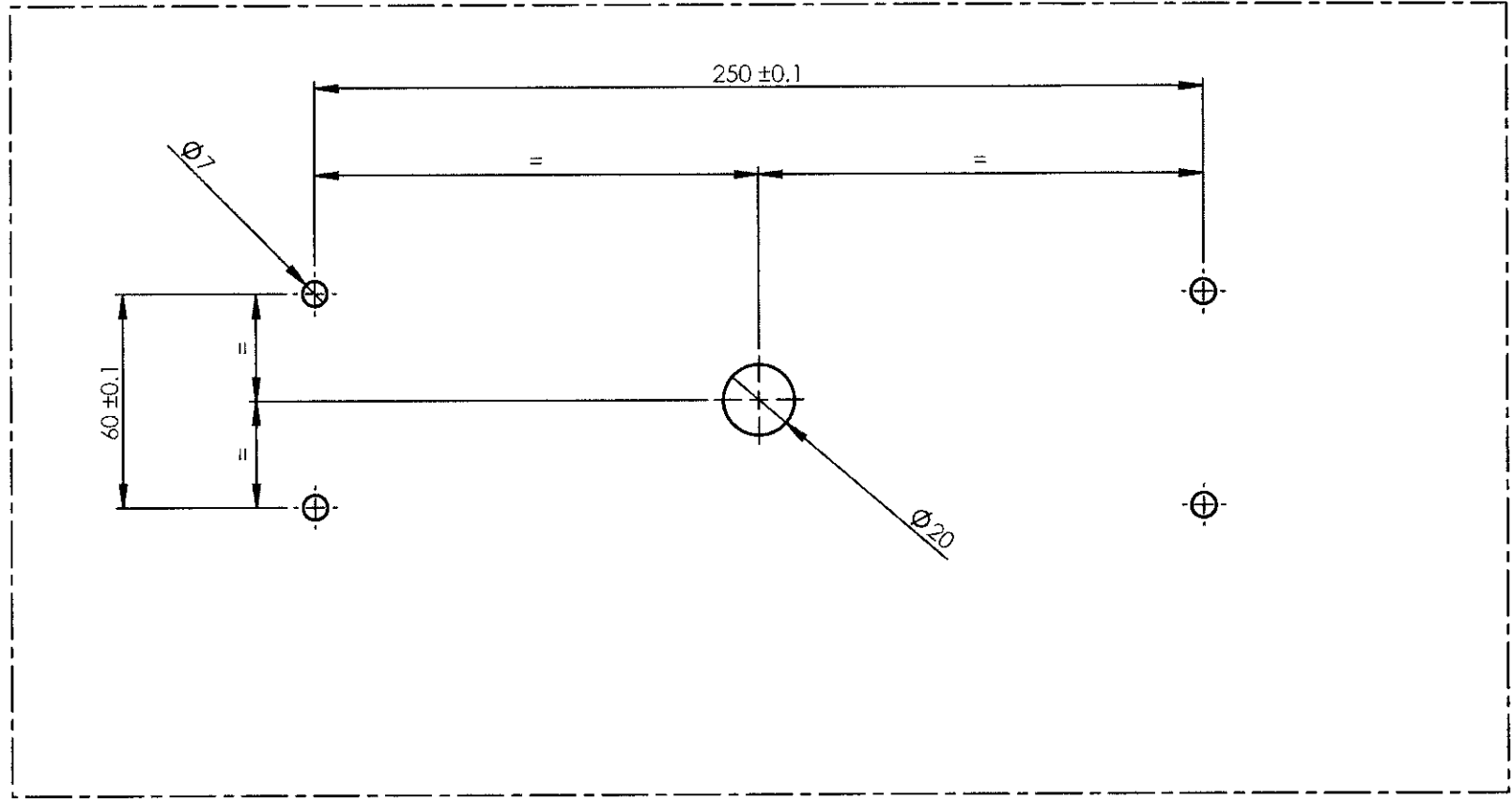


83014007

▽ ROUGH MACHINED	① ROUGH CLEANED	REVISIONS			
▽▽ FINISH MACHINED	② BURRS REMOVED	ALT.	ZONE	DESCRIPTION	APPROVED & DATE
▽▽▽ FINE FINISH MACHINED	③ CHAMFERED				



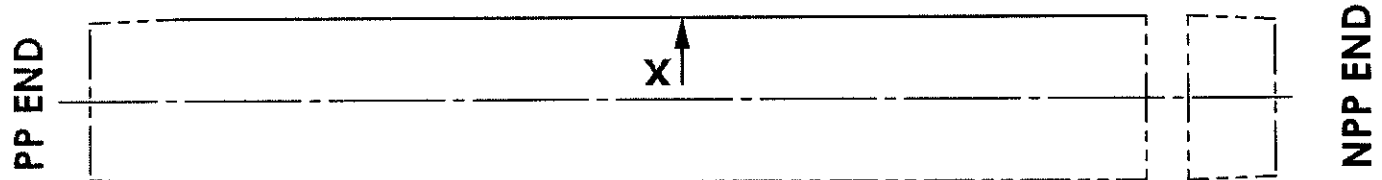
VIEW FROM X



DETAIL A  
SCALE 1 : 2

NOTE:

- ALL WELDINGS SHALL BE LASER WELDING UNLESS OTHERWISE SPECIFIED.
- THERE SHALL NOT BE ANY EXCESS WELD METAL ON COACH OUTSIDE.
- ALL WELD SPATTERS SHALL BE BUFFED.
- 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 PREFERENCES REFER DRG. No. ICF/STD-9-0-998.
- FOR WELD PROCEDURE SPECIFICATION REFER DRG. No. ICF/STD-9-0-999.
- SIDE WALL SHEET JOINT WITH 1230mm SIZE (USING 1250mm WIDTH RM SHEET) SHALL ALSO BE PERMITTED AND JOINT SHALL BE AWAY FROM WINDOW RADIUS.



REF. DIAGRAM

1	SHEET	2x225x1995	10		RDSO/SPEC C-1201 X2CrNi12	10.70	
1	SHEET	2x1200x1995	9		RDSO/SPEC C-K201 X2CrNi12	25.02	
1	SHEET	2x1485x1995	8		RDSO/SPEC C-K201 X2CrNi12	37.29	
1	SHEET	2x1485x1995	7		RDSO/SPEC C-K201 X2CrNi12	35.49	
1	SHEET	2x1485x1995	6		RDSO/SPEC C-K201 X2CrNi12	35.59	
1	SHEET	2x1200x1995	5		RDSO/SPEC C-K201 X2CrNi12	38.30	
1	SHEET	2x1485x1995	4		RDSO/SPEC C-K201 X2CrNi12	37.12	
1	SHEET	2x1485x1995	3		RDSO/SPEC C-K201 X2CrNi12	35.29	
1	SHEET	2x1485x1995	2		RDSO/SPEC C-K201 X2CrNi12	43.40	
5	SHEET	2x1485x1995	1		RDSO/SPEC C-K201 X2CrNi12	47.40	
QTY.	DESCRIPTION	DIMENSION	ITEM NO.	REF. DRGS	MATL. SPEC.	WT/UNIT IN KGS	REMARKS

GROUP: 1-4 Body Side Walls		SURFACE AREA IN Sq.m:		WT/ASSY IN Kgs:	
SIDE WALL SHEET ASSY ( LEFT )		SCALE 1:26	DATE	DATE	DATE
		CHD	CHD	CHD	CHD
		ALT.	ALT.	ALT.	ALT.
		GRN	GRN	GRN	GRN
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038		SHEET 1 OF 1		LWCBAC/PP2	
		83014007		A1	

-	16-07-2025	AME/SME
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME



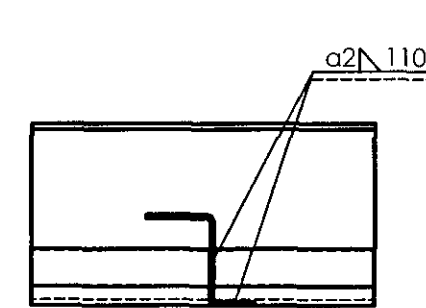


Technical drawing of a vertical assembly. The drawing shows a side view of a structure with several horizontal sections. Key dimensions and callouts are as follows:

- Top Section:** A horizontal dimension of 47 is shown. A callout 39 points to a top flange, and callout 53 points to a vertical component.
- Upper Section:** A vertical dimension of 1963.6 is shown on the left. Callout 53 points to a series of circular features. A horizontal dimension of 784.5 is shown for a section below the top flange.
- Middle Section:** A vertical dimension of 842 is shown on the right. Callout 13 points to a horizontal flange. Below this, callout 12 points to a vertical component.
- Lower Section:** A vertical dimension of 349 is shown on the right. Callout 14 points to a horizontal flange. A vertical dimension of 272.5 is shown at the bottom right.
- Bottom Section:** A vertical dimension of 649 is shown on the left.

Technical drawing of Detail B, Scale 1:5, showing a cross-section of a structural joint. The drawing includes a vertical member (1) and a horizontal member (6). A horizontal member (24) is shown at the top, with a vertical member (25) passing through it. A horizontal member (26) is shown below the vertical member (25). The drawing includes various dimensions and labels: 'G' for vertical loads, 'H' for horizontal loads, 'J' for horizontal dimensions, 'D' for vertical dimensions, and 'E' for horizontal dimensions. The drawing is labeled 'DETAIL B' and 'SCALE 1:5'.

**DETAIL B**  
**SCALE 1 : 5**



Technical drawing of a rectangular frame with dimensions and tolerances:

- Top horizontal edge:  $2\sqrt{27.5}$
- Left vertical edge:  $2\sqrt{75}$
- Right vertical edge:  $2.5\sqrt{27.5}$

Technical drawing of a stepped profile. The profile consists of a vertical section on the left and a horizontal section on the right. The vertical section has a total height of 27.5, with a top segment of 2.5 and a bottom segment of 25. The horizontal section has a total width of 27.5, with a left segment of 2.5 and a right segment of 25. The profile is drawn with solid lines for the top and bottom surfaces and dashed lines for the internal vertical and horizontal boundaries. Arrows point from the dimension labels to the corresponding parts of the profile.


Technical drawing of a stepped profile. The drawing shows a cross-section of a part with three distinct steps. The dimensions are as follows:

- The top horizontal surface has a width of  $2\sqrt{27.5}$ .
- The second step from the top has a width of  $2.5\sqrt{27.5}$ .
- The bottom horizontal surface has a width of  $2\sqrt{75}$ .

Technical drawing of a square frame. Callout 40 points to the top-left corner. Callout 2.5 points to the top edge. Callout 38 points to the right edge. Callout 30 points to the bottom edge. The drawing includes dashed lines indicating internal structure or hidden edges.

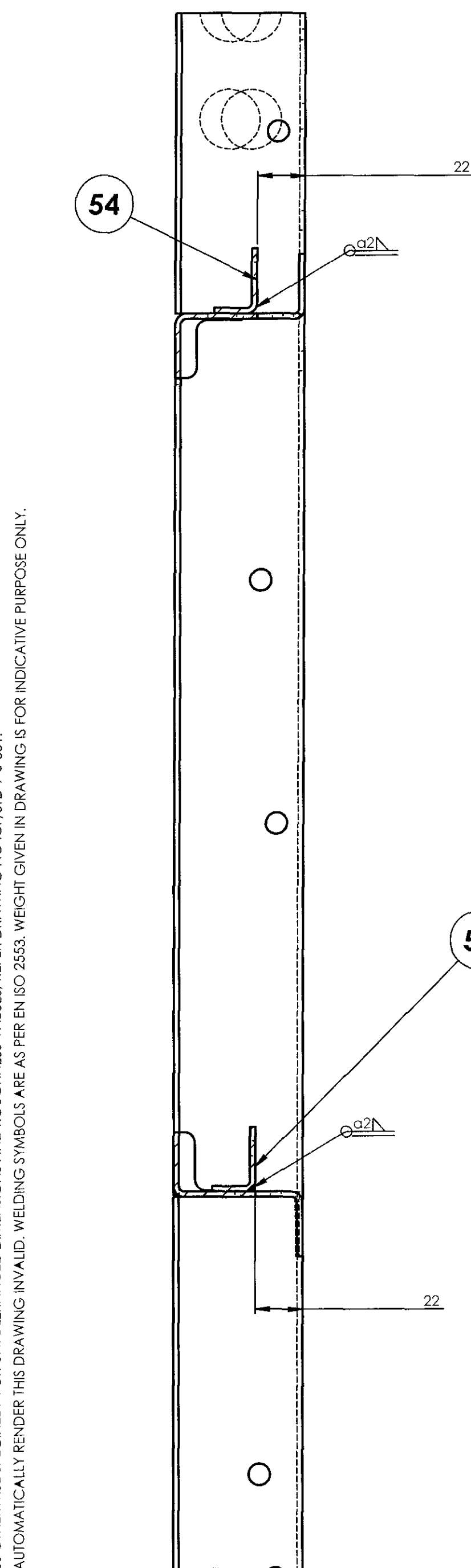
DETAIL L  
SCALE 1 : 2.5

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO. IC/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.

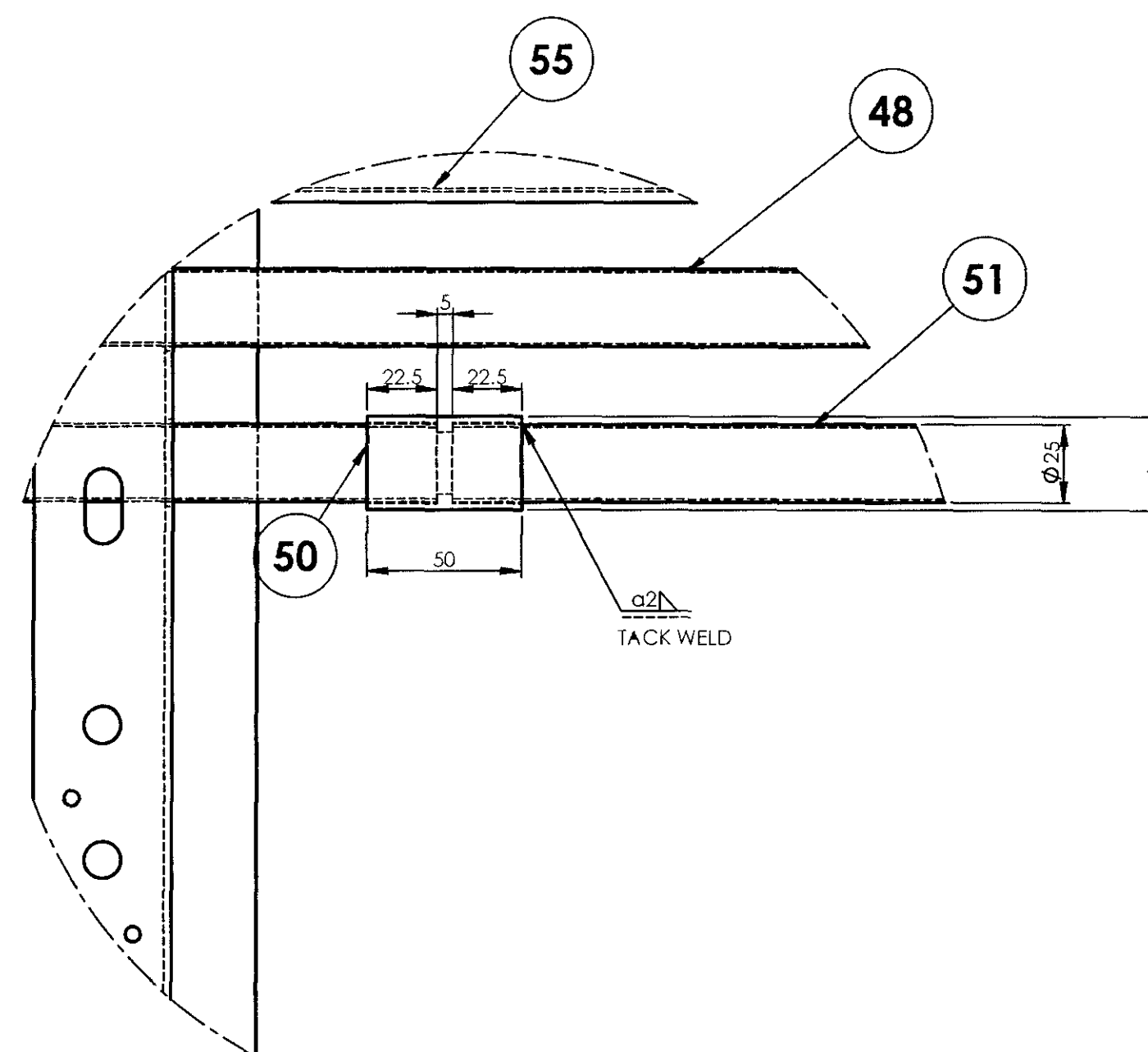
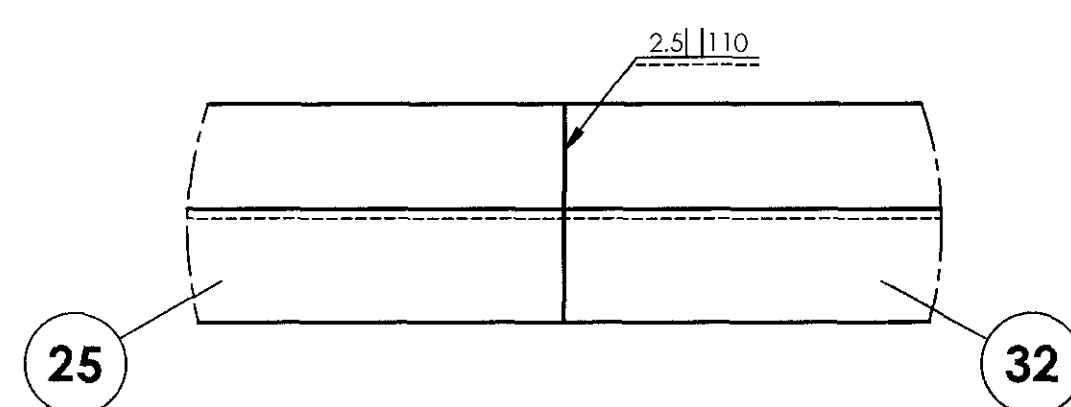
-	16-07-2025	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

GROUP: 1-4 Body Side Walls		SURFACE AREA IN Sq.m.: 48.464		WT/ASSY IN Kgs:	
<b>SIDEWALL FRAME WORK LEFT COMPLETE</b>				SCALE	30E/D
				1:20	CHD
				ALT.	ALTD
				-	DIRN
				3D P. SANTHOSH KUMAR 230 KLARE, THAKUR	
INDIAN RAILWAY STANDARDS		SHEET		LWCBAC/PP2	
INTEGRAL COACH FACTORY, CHENNAI - 600038		1 OF 2		83014008	
				A1	



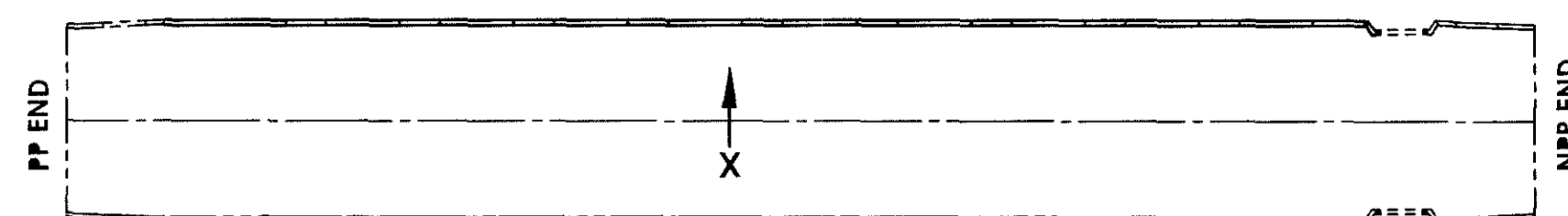


**DETAIL P**  
**SCALE 1 : 2**



**DETAIL Q**  
**SCALE 1 : 2**


1. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF K201/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.

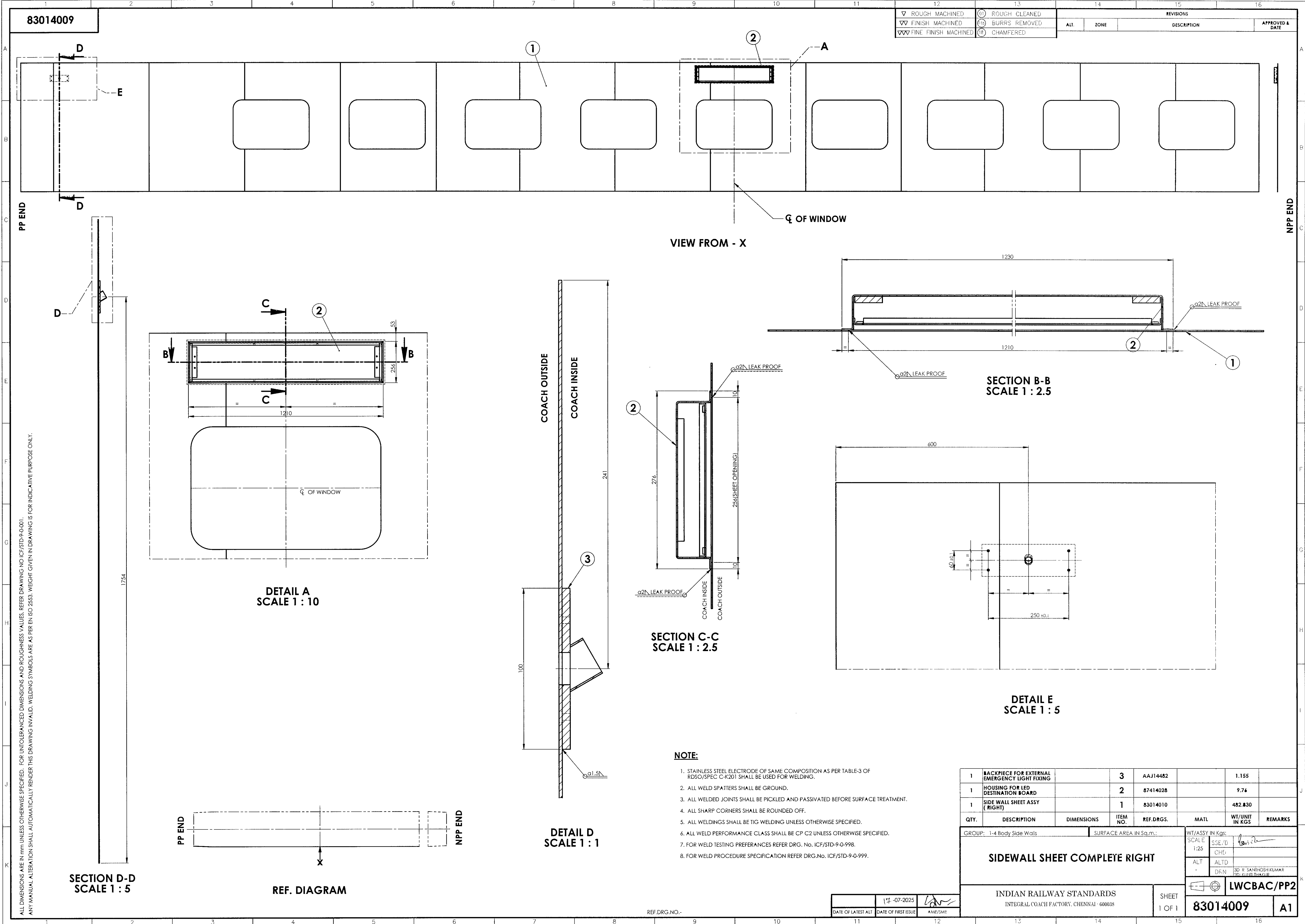


REF. DIAGRAM

1	CONDUIT	OD 25 x 11 x2700	56		SS-304	1.61	
1	CONDUIT	OD 25 x 11 x3000	55		SS-304	1.79	
4	ANGLE		54	AAD14428		0.05	
3	CONDUIT	OD 25 x 11 x2200	53		SS-304	0.89	
1	CONDUIT	OD 25 x 11 x2000	52		SS-304	1.19	
4	CONDUIT	OD 25 x 11 x 1000	51		SS-304	0.60	
4	COUPLER FOR CONDUITS		50	AAC14320		0.08	
3	CONDUIT	OD 25 x 11 x800	49		SS-304	0.48	
2	CONDUIT	OD 25 x 11 x2500	48		SS-304	1.49	
3	CONDUIT	OD 25 x 11 x1700	47		SS-304	1.01	
1	CONDUIT	OD 25 x 11 x1400	46		SS-304	0.95	
1	CONDUIT	OD 25 x 11 x3500	45		SS-304	2.08	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARK

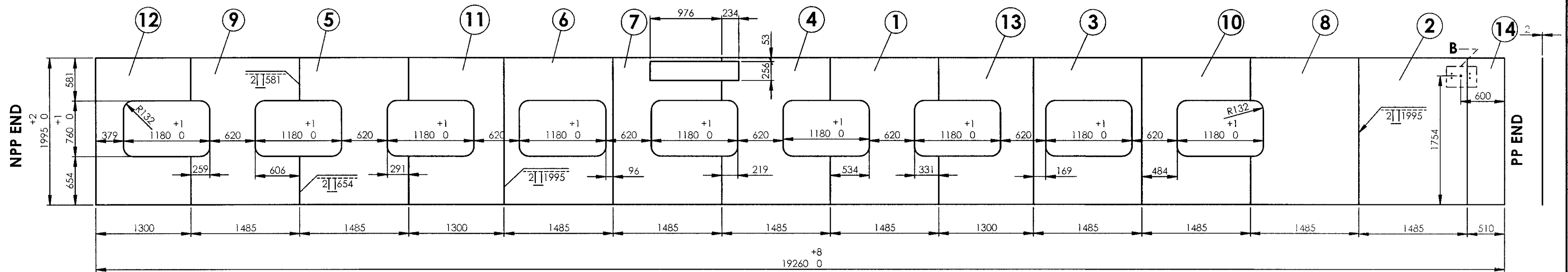
1	PILLAR LEFT		44	AAK14407		4.87	
1	PILLAR RIGHT		43	AAK14404		4.872	
4	PART PILLAR TOP LEFT		42	AAK14419		1.21	
4	PART PILLAR TOP RIGHT		41	AAK14418		1.215	
1	ANGLE-LH		40	AAJ14241		3.387	
1	ROOF FLANGE ASSEMBLY LEFT		39	83014014		125.15	
3	HORIZONTAL MEMBER		38	AAF14503		4.52	
1	HORIZONTAL MEMBER		37	AAF14502		4.516	
1	HORIZONTAL MEMBER		36	AAF14501		2.93	
1	HORIZONTAL MEMBER		35	AAF14500		2.94	
1	HORIZONTAL MEMBER		34	AAF14499		1.58	
1	HORIZONTAL MEMBER		33	AAK14513		2.922	
4	HORIZONTAL MEMBER		32	AAF14497		3.92	
2	HORIZONTAL MEMBER		31	AAK14449		3.895	
1	HORIZONTAL MEMBER		30	AAF14495		2.28	
1	HORIZONTAL MEMBER		29	AAF14494		2.29	
1	HORIZONTAL MEMBER		28	AAF14493		0.93	
1	HORIZONTAL MEMBER		27	AAF14492		2.288	
2	HORIZONTAL MEMBER		26	AAF14491		3.89	
2	HORIZONTAL MEMBER		25	AAF14490		3.90	
2	HORIZONTAL MEMBER		24	AAK14450		2.53	
2	HORIZONTAL MEMBER		23	AAK14514		3.869	
3	HORIZONTAL MEMBER		22	AAF14487		2.57	
1	HORIZONTAL MEMBER		21	AAF14486		2.571	
1	HORIZONTAL MEMBER		20	AAF14485		3.86	
1	HORIZONTAL MEMBER		19	AAF14484		3.86	
1	HORIZONTAL MEMBER		18	AAF14483		2.51	
1	HORIZONTAL MEMBER		17	AAF14482		3.864	
1	PART PILLAR TOP (L.H.)		16	AAK14402		0.77	
11	PILLAR( L.H.)		15	AAK14404		4.8	
2	HORIZONTAL MEMBER		14	AAF14478		3.86	
2	HORIZONTAL MEMBER		13	AAK14944		3.815	
2	HORIZONTAL MEMBER		12	AAK14945		3.82	
1	HORIZONTAL MEMBER		11	AAK14942		2.05	
1	HORIZONTAL MEMBER		10	AAK14943		2.05	
1	HORIZONTAL MEMBER		9	AAF14474		2.07	
2	HORIZONTAL MEMBER		8	AAK14947		1.11	
1	HORIZONTAL MEMBER		7	AAK14946		0.69	
4	PILLAR RIGHT		6	AAK14416		4.957	
4	PILLAR LEFT		5	AAK14417		4.96	
12	PILLAR( R.H.)		4	AAK14403		4.804	
1	PART PILLAR TOP (R.H.)		3	AAK14401		0.770	
5	PART PILLAR		2	AAA14390		1.515	
5	PART PILLAR		1	AAA14389		1.515	
QTY.	DESCRIPTION	DIMENSIONS	ITEM	REF.DRGS.	MATL	WT/UNIT	REMARKS

GROUP: 1-4 Body Side Walls		SURFACE AREA IN Sq.m: 48.464		WT/ASSY IN Kgs:	
<b>SIDEWALL FRAME WORK LEFT COMPLETE</b>		SCALE		SCALE 1:25 <i>Person File</i>	
		SCE/D		CHD	
		ALT.		ALTD -	
		DRN		DO P SANTHOSH KUMAR 20 KUNDI THAKKIL	
<b>INDIAN RAILWAY STANDARDS</b> INTEGRAL COACH FACTORY, CHENNAI - 600038		SHEET		 <b>LWCBAC/PP2</b>	
		2 OF 2			
		<b>83014008</b>		<b>A1</b>	

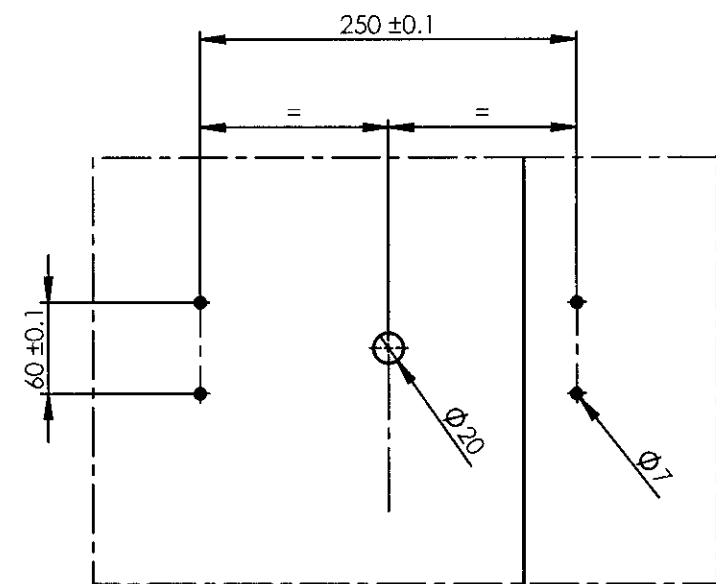


▽ ROUGH MACHINED	① ROUGH CLEANED
▽▽ FINISH MACHINED	② BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	③ CHAMFERED

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



### VIEW FROM X



**DETAIL B**  
**SCALE 1 : 5**

**NOTE:**

1. ALL WELDINGS SHALL BE LASER WELDING UNLESS OTHERWISE SPECIFIED.
2. THERE SHALL NOT BE ANY EXCESS WELD METAL ON COACH OUTSIDE.
3. ALL WELD SPATTERS SHALL BE BUFFED.
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.
9. SIDE WALL SHEET JOINT WITH 1230mm SIZE (USING 1250mm WIDTH RM SHEET) SHALL ALSO BE PERMITTED AND JOINT SHALL BE AWAY FROM WINDOW RADIUS.

1	SHEET	2x510x1995	14		RDSO/SPEC C-K201 X2CrNi12		
1	SHEET	2x1300x1995	13		RDSO/SPEC C-K201 X2CrNi12		
1	SHEET	2x1300x1995	12		RDSO/SPEC C-K201 X2CrNi12		
1	SHEET	2x1300x1995	11		RDSO/SPEC C-K201 X2CrNi12		
1	SHEET	2x1485x1995	10		RDSO/SPEC C-K201 X2CrNi12		
1	SHEET	2x1485x1995	9		RDSO/SPEC C-K201 X2CrNi12		
1	SHEET	2x1485x1995	8		RDSO/SPEC C-K201 X2CrNi12		
1	SHEET	2x1485x1995	7		RDSO/SPEC C-K201 X2CrNi12		
1	SHEET	2x1485x1995	6		RDSO/SPEC C-K201 X2CrNi12		
1	SHEET	2x1485x1995	5		RDSO/SPEC C-K201 X2CrNi12		
1	SHEET	2x1485x1995	4		RDSO/SPEC C-K201 X2CrNi12		
1	SHEET	2x1485x1995	3		RDSO/SPEC C-K201 X2CrNi12		
1	SHEET	2x1485x1995	2		RDSO/SPEC C-K201 X2CrNi12		
1	SHEET	2x1485x1995	1		RDSO/SPEC C-K201 X2CrNi12		
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATERIAL	WT/UNIT IN KGS	REMARKS

GROUP: 1-4 Body Side Walls	SURFACE AREA IN Sq.m.:	WT/ASSY IN Kgs:
----------------------------	------------------------	-----------------


## SIDE WALL SHEET (RIGHT) COMPLETE

INDIAN RAILWAY STANDARDS  
INTEGRAL COACH FACTORY, CHENNAI - 600038

SHEET  
1 OF 1

**83014010**

A2

SCALE 1:40	SSE/D	
	CHD	
ALT	ALTD	
	DRN	3D R. SANTHOSH KUMAR 2D: KUNTI THAKUR



**LWCBAC/PP2**

83014010	A2
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▽	ROUGH MACHINED
▽▽	FINISH MACHINED
▽▽▽	FINE FINISH MACHINE

①	ROUGH CLEANED
②	BURRS REMOVED
③	CHAMFERED

## REVISIONS

**ALT.**

ZONE

DESCRIPTION

APPROVE  
DATE



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

1	ARCH		7	AAA14859		1.783	
1	STIFFENING ANGLE - RH		6	AAK14941		2.372	
1	STIFFENING ANGLE - LH		5	AAK14940		2.350	
1	BRACKET COMPLETE		4	59314012		0.404	
1	ARCH		3	AAA14840		1.783	
30	ARCH		2	AAA14858		0.940	
1	CARLINE LEFT (CRF)		1	AAK14452		172.995	
QTY.	DESCRIPTION	DIMENSIONS	ITEM	REF.DRGS.	MATL	WT/UNIT	REMARK

GROUP: 1-4


SURFACE AREA IN Sq.m.:

WT/ASSY IN Kqs:

**CARLINE COMPLETE LEFT**

INDIAN RAILWAY STANDARDS  
INTEGRAL COACH FACTORY, CHENNAI - 600038

SHEET  
1 OF 1

	LWC BAC/PP2
83014012	A1

REF.DRG.NO.

	DATE OF LATEST A

16-07-2025
DATE OF FIRST ISSUE

	
E	AME/SMF

83014013

▽ ROUGH MACHINED  
▽ FINISH MACHINED  
▽ FIN. 100% MACHINED

① ROUGH CLEANED  
② BURRS REMOVED  
③ CHAMFERED

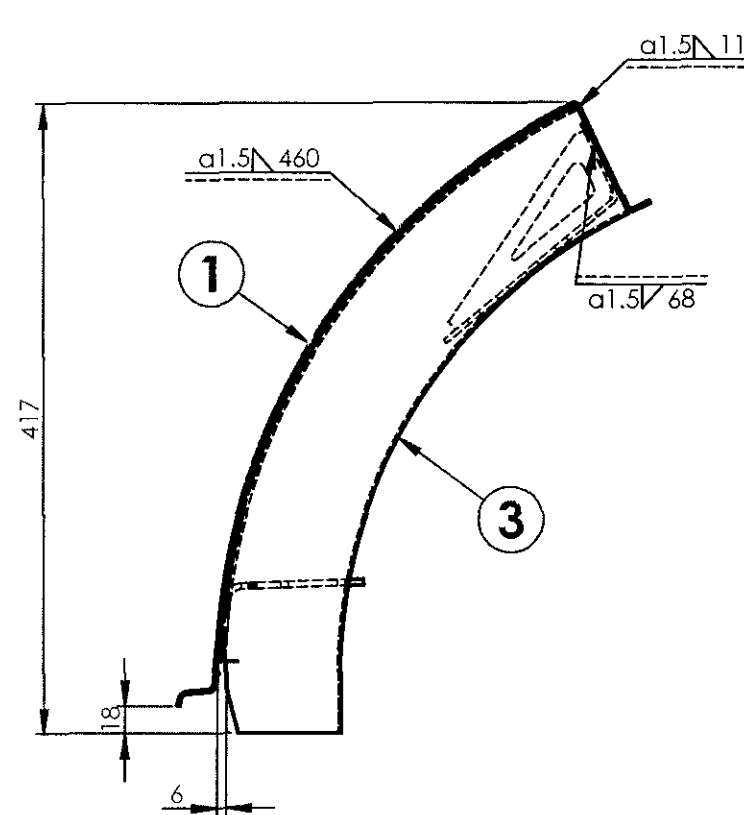
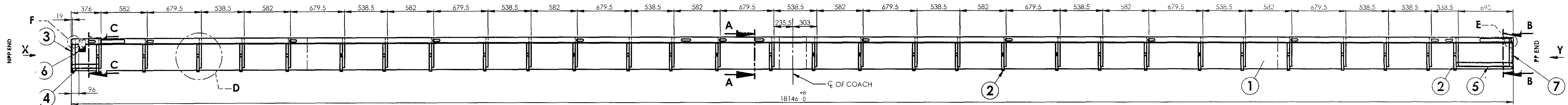
REVISIONS

ALT.

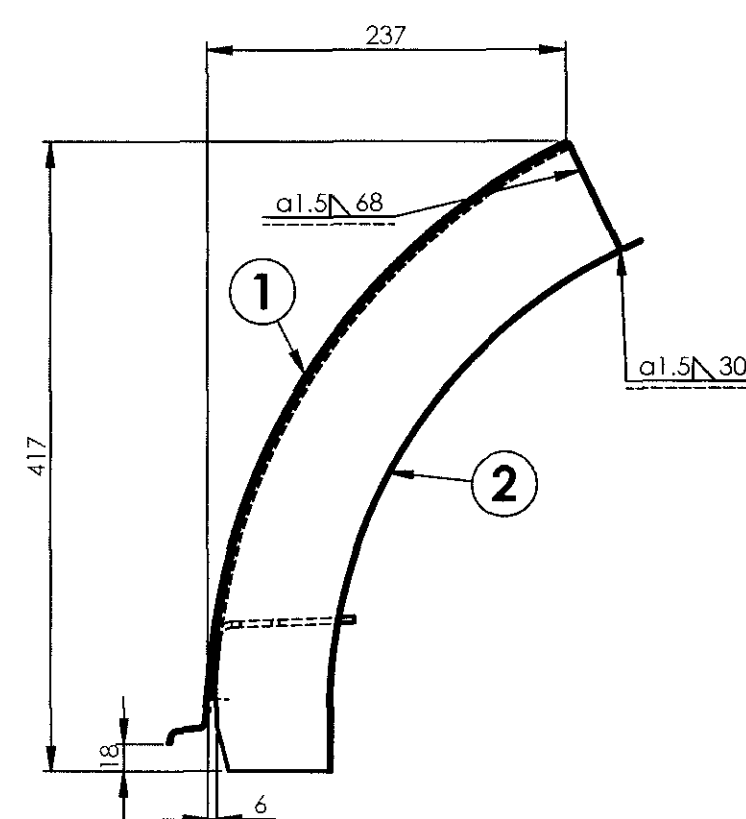
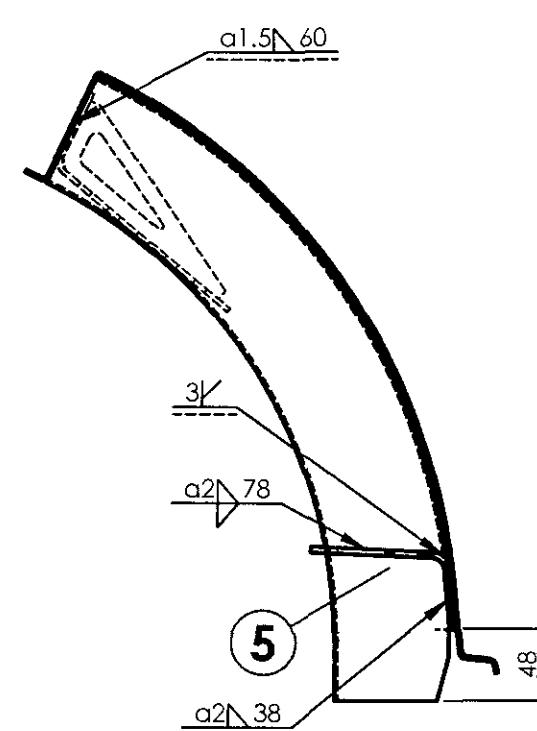
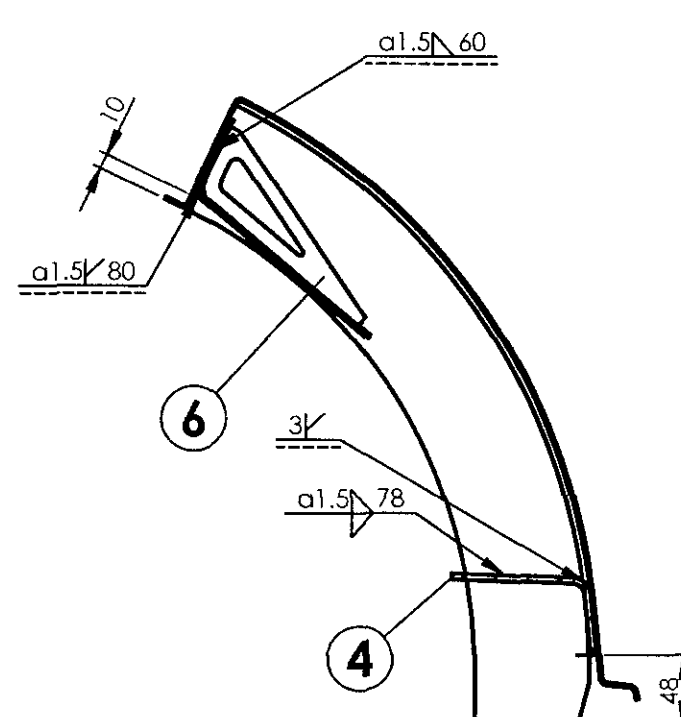
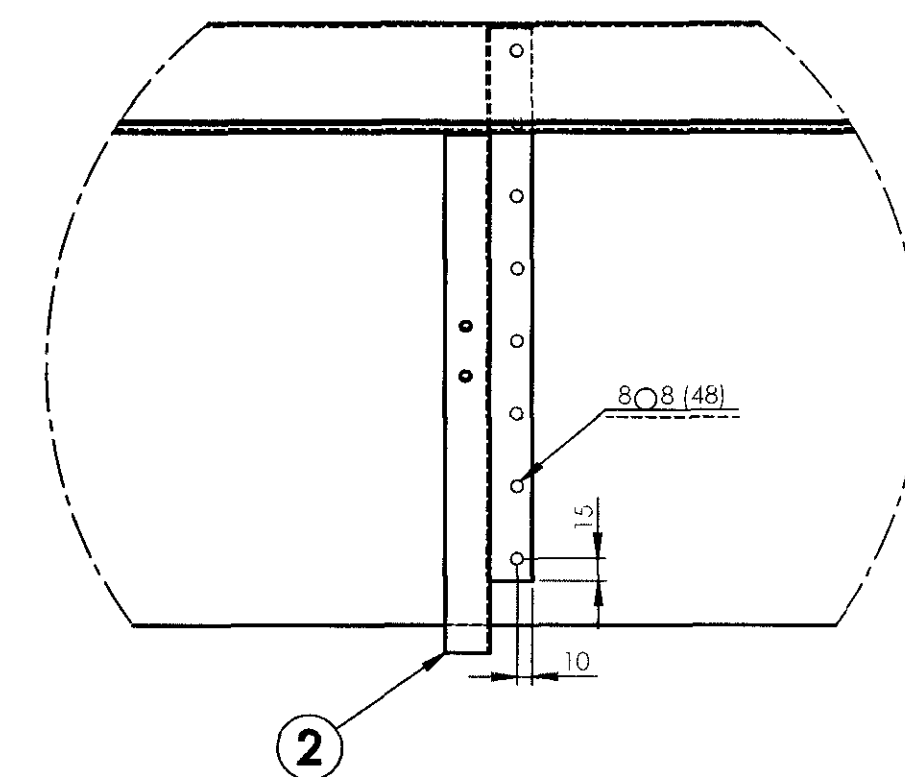
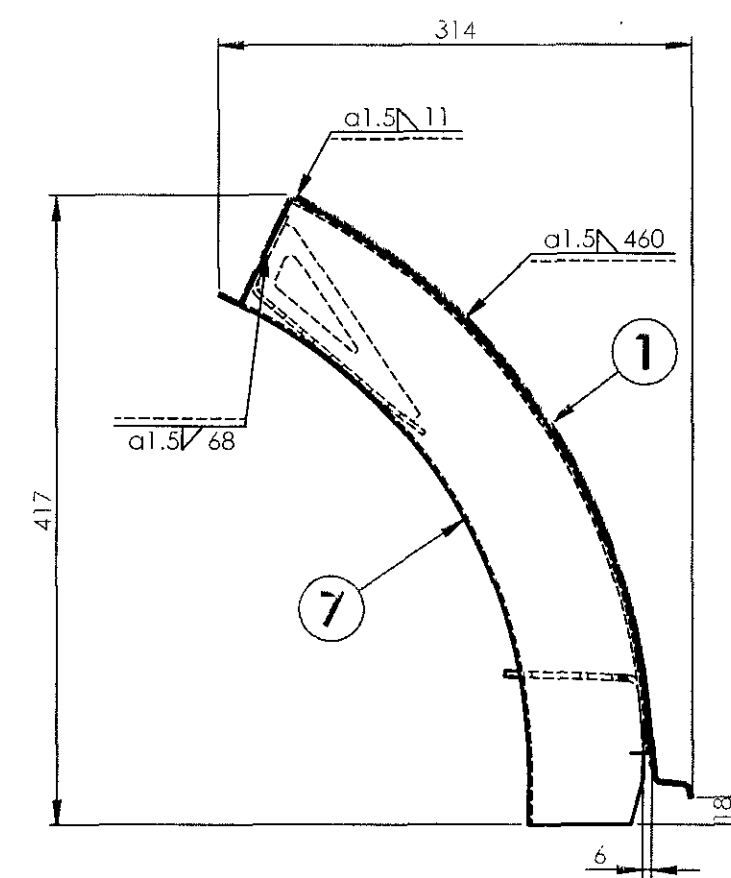
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DESCRIPTION

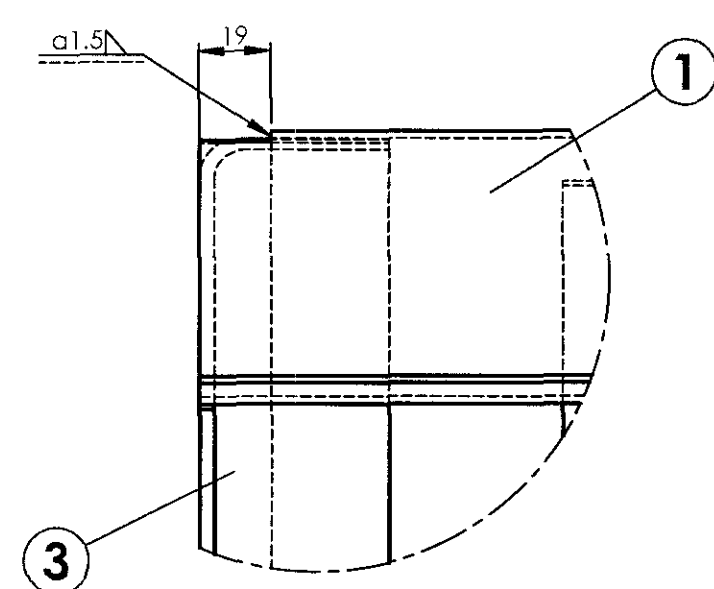
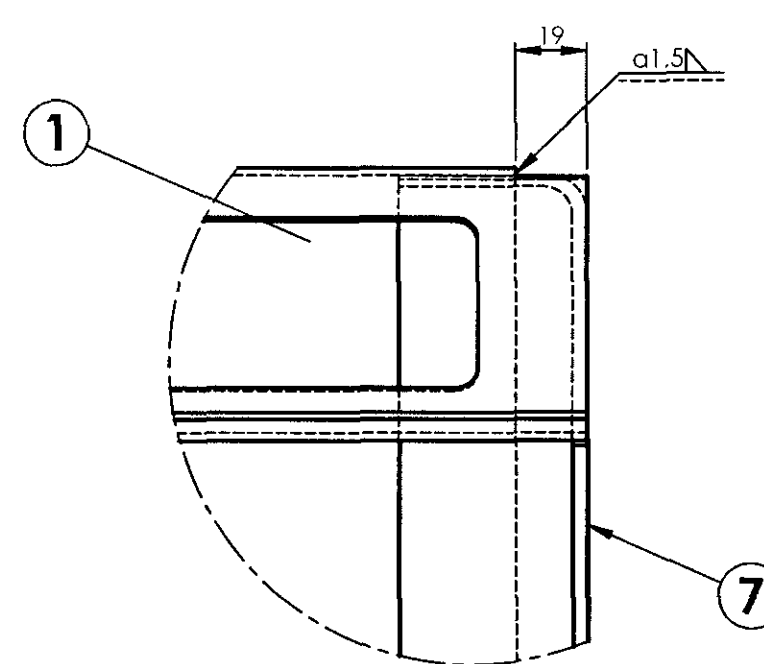
APPROVED &amp; DATE



VIEW X

SECTION A-A  
SCALE 1 : 5SECTION B-B  
SCALE 1 : 5SECTION C-C  
SCALE 1 : 5DETAIL D  
SCALE 1 : 5

VIEW Y

DETAIL F  
SCALE 1 : 2DETAIL E  
SCALE 1 : 2

## 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.

1	ARCH		7	AAA14860		1.783	
1	BRACKET COMPLETE		6	59314012		0.406	
1	STIFFENING ANGLE - RH		5	AAK14948		2.350	
1	STIFFENING ANGLE - LH		4	AAF14522		1.354	
1	ARCH		3	AAA14859		1.783	
30	ARCH		2	AAA14857		0.940	
1	CARLINE LEFT (CRF)		1	AAK14451		173.172	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS

GROUP: 1-4 Body Side Walls		SURFACE AREA IN Sq.m.: 25.922		WT/ASSY IN Kgs:	
SCALE 1:25		CHD		LWCAC/PP2	
ALT		ALTD		83014013	
DRN		DRN		A1	
INDIAN RAILWAY STANDARDS		SHEET 1 OF 1		83014013	
INTEGRAL COACH FACTORY, CHENNAI - 600038					

REF.DRG.NO.

DATE OF LATEST ALT. 16-07-2025  
DATE OF FIRST ISSUE  
NAME/SME

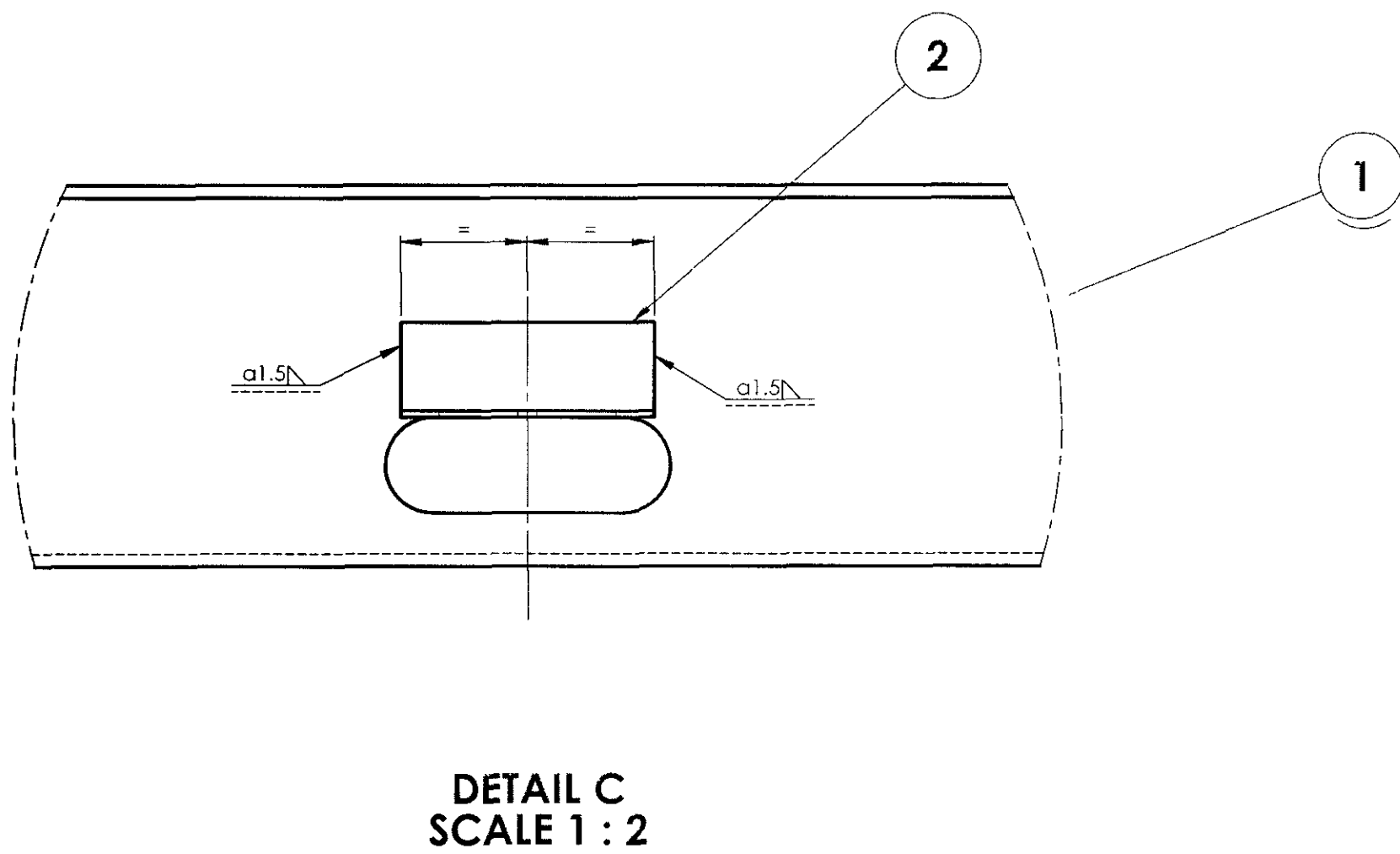
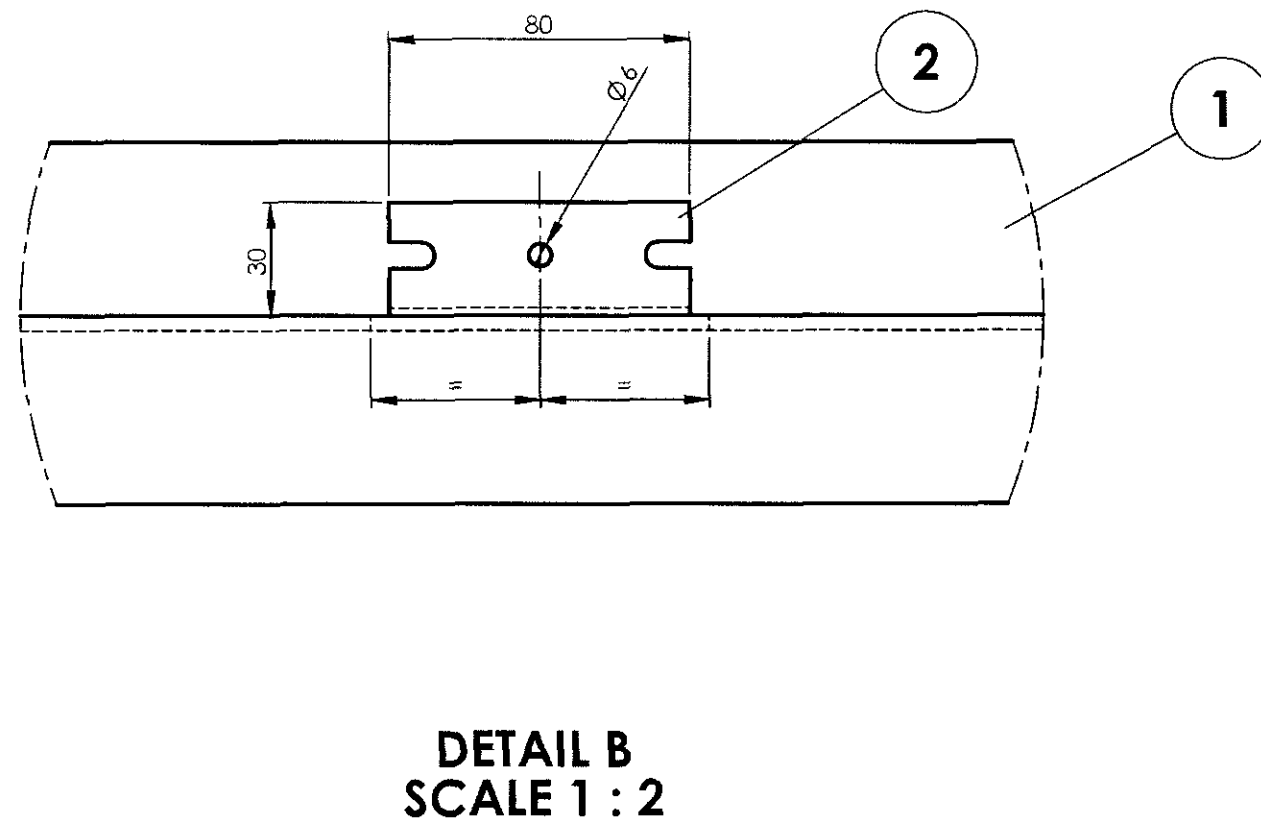
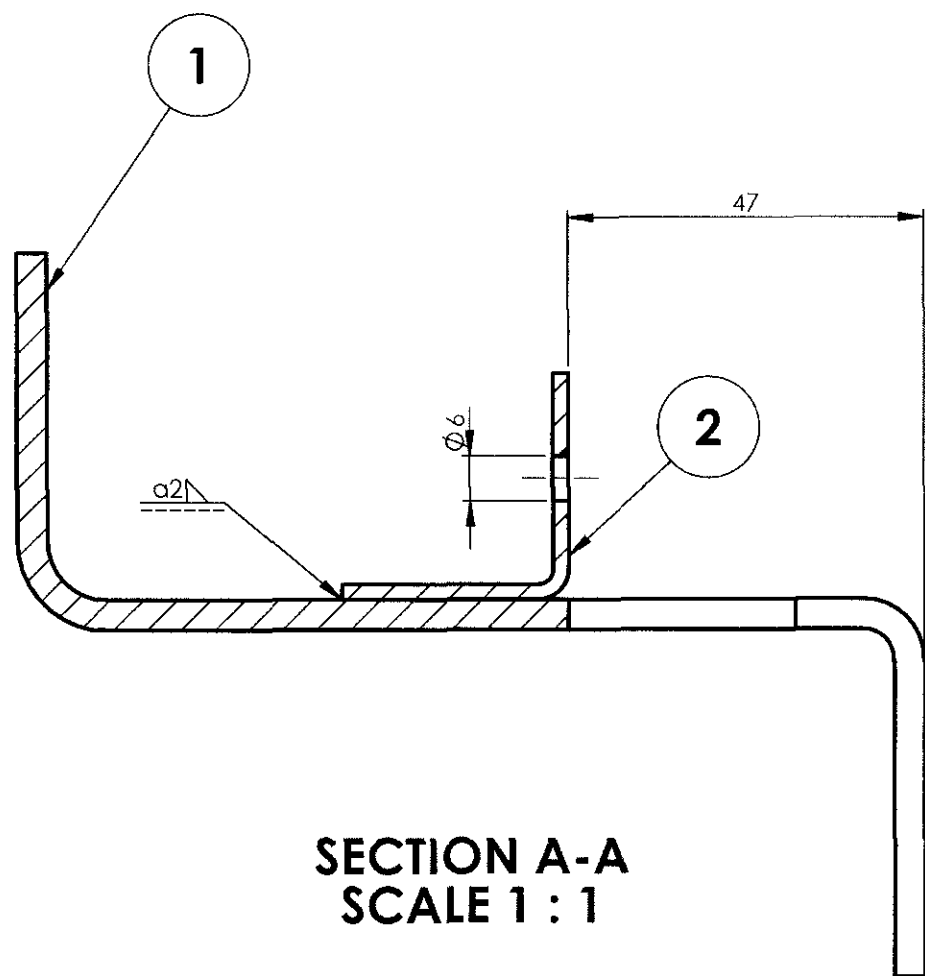
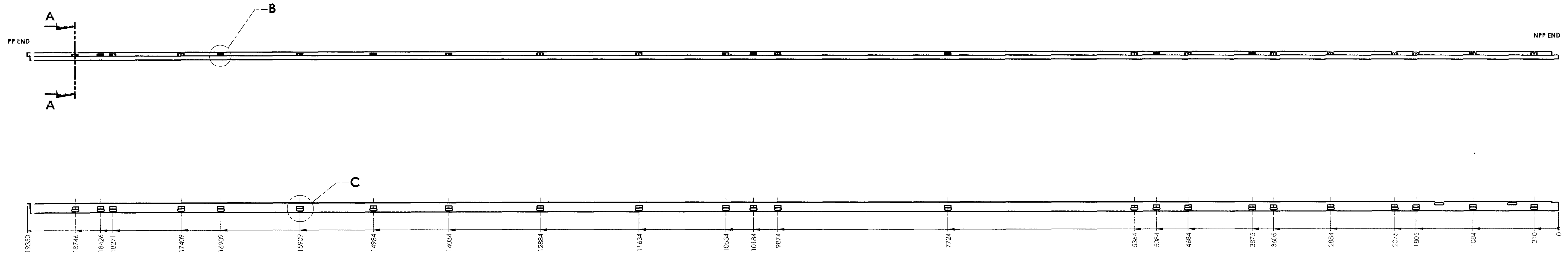
83014014

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

⑪ ROUGH CLEANED  
⑫ BURRS REMOVED  
⑬ CHAMFERED

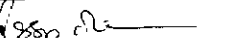
REVISIONS

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 PREFERENCES REFER DRG. No. ICF/STD-9-0-998.
8. FOR WELD PROCEDURE SPECIFICATION REFER DRG. No. ICF/STD-9-0-999.

24	CABLE CLAMP		2	AAC14244		0.07	
1	ROOF FLANGE(CRF)		1	AAK14507		124.54	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS
GROUP: 1-4 Body Side Walls			SURFACE AREA IN Sq.m: 8.19			WT/ASSY IN Kgs:	
ROOF FLANGE ASSEMBLY LEFT					SCALE	SSE/D	
					1:25	CHD	
					ALT	ALTD	
					-	DRN	
INDIAN RAILWAY STANDARDS					SHEET 1 OF 1	LWCBAC/PP2	
INTEGRAL COACH FACTORY, CHENNAI - 600038						83014014	
							A1

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.63014007

DATE OF LATEST ALT. 16-07-2025  
DATE OF FIRST ISSUE  
A/E/SME

83014015

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

① ROUGH CLEANED  
② BURRS REMOVED  
③ CHAMFERED

REVISIONS

ALT.

ZONE

DESCRIPTION

APPROVED &  
DATE

NPP END

PP END

SECTION A-A  
SCALE 1 : 1

DETAIL B  
SCALE 1 : 2

DETAIL C  
SCALE 1 : 2

ISOMETRIC VIEW

NOTE:

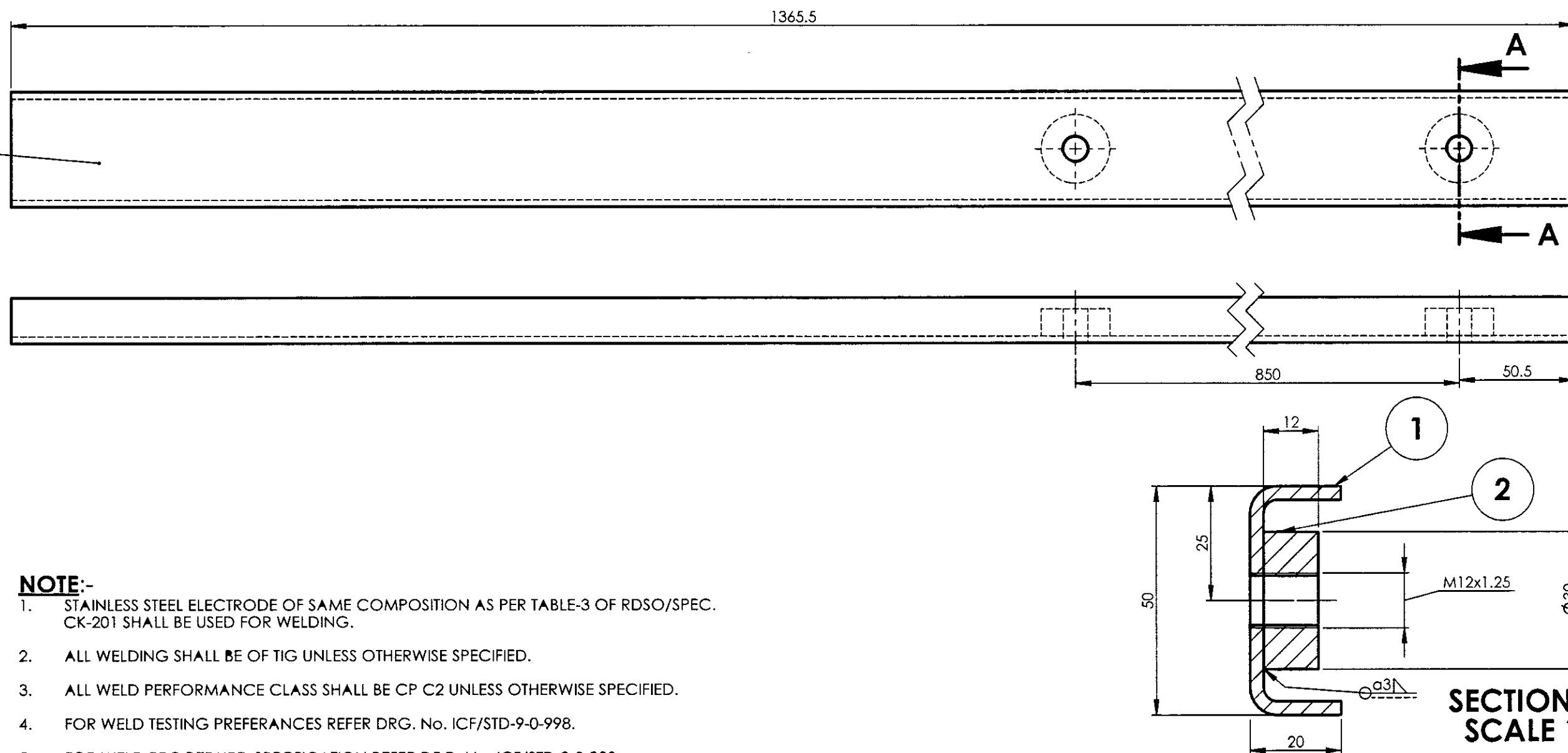
1. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE 3 OF RDSO/SPEC C-K201 SHALL BE USED FOR WELDING.
2. ALL WELDINGS SHALL BE TIG WELDING UNLESS OTHERWISE SPECIFIED.
3. ALL WELD SPATTERS SHALL BE GROUND.
4. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
5. ALL SHARP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

15	CABLE CLAMP		2	AAC14244		0.07	
1	ROOF FLANGE RIGHT (CRF)		1	AAK14510		124.210	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS.	REMARKS
GROUP: 1-4 Body Side Walls		SURFACE AREA IN Sq.m.: 8.08		WT/ASSY IN Kgs:			
ROOF FLANGE ASSEMBLY RIGHT		SCALE: 1:20		CSE/D			
				CHD			
				ALT.			
				DRN: R. SANTHOSH KUMAR			
INDIAN RAILWAY STANDARDS		SHEET		LWCBAC/PP2			
INTEGRAL COACH FACTORY, CHENNAI - 600038		1 OF 1		83014015			
				A1			



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

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



**NOTE:**

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

2	SCREWING PIECE		2	AAA14807		0.068	
1	CHANNEL		1	AAK14654		2.626	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS

GROUP: 1-4

SURFACE AREA IN Sq.m.:0.233

WT/ASSY IN Kgs:

## CHANNEL ASSEMBLY FOR WATER BOILER FIXING

SCALE  
1:2

SSE/D
CHD

ALT.  
.

ALTD
DRN

R. SANTHOSH KUMAR

**LWCBAC/PP2**

# INDIAN RAILWAY STANDARDS

INTEGRAL COACH FACTORY, CHENNAI - 600038

SHEET  
1 OF 1

**83014016**

A3


REF.DRG.NO.-

-	16-07-2025	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	A.M.E./S.M.E

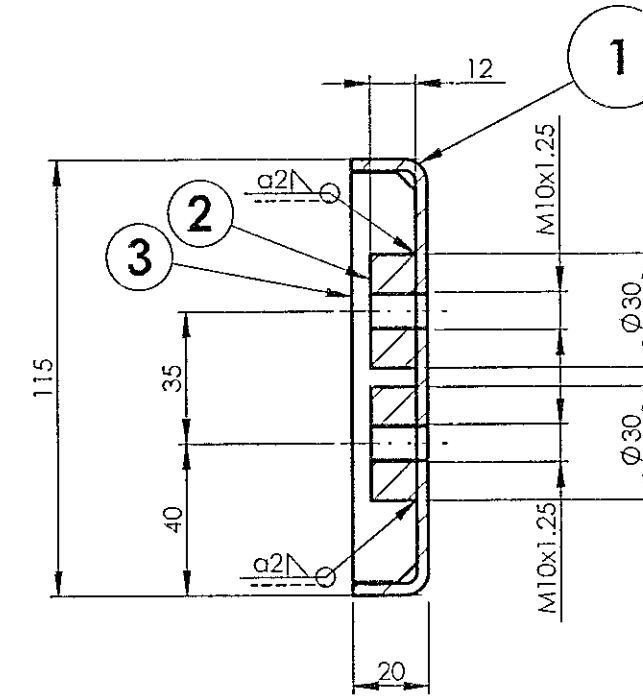
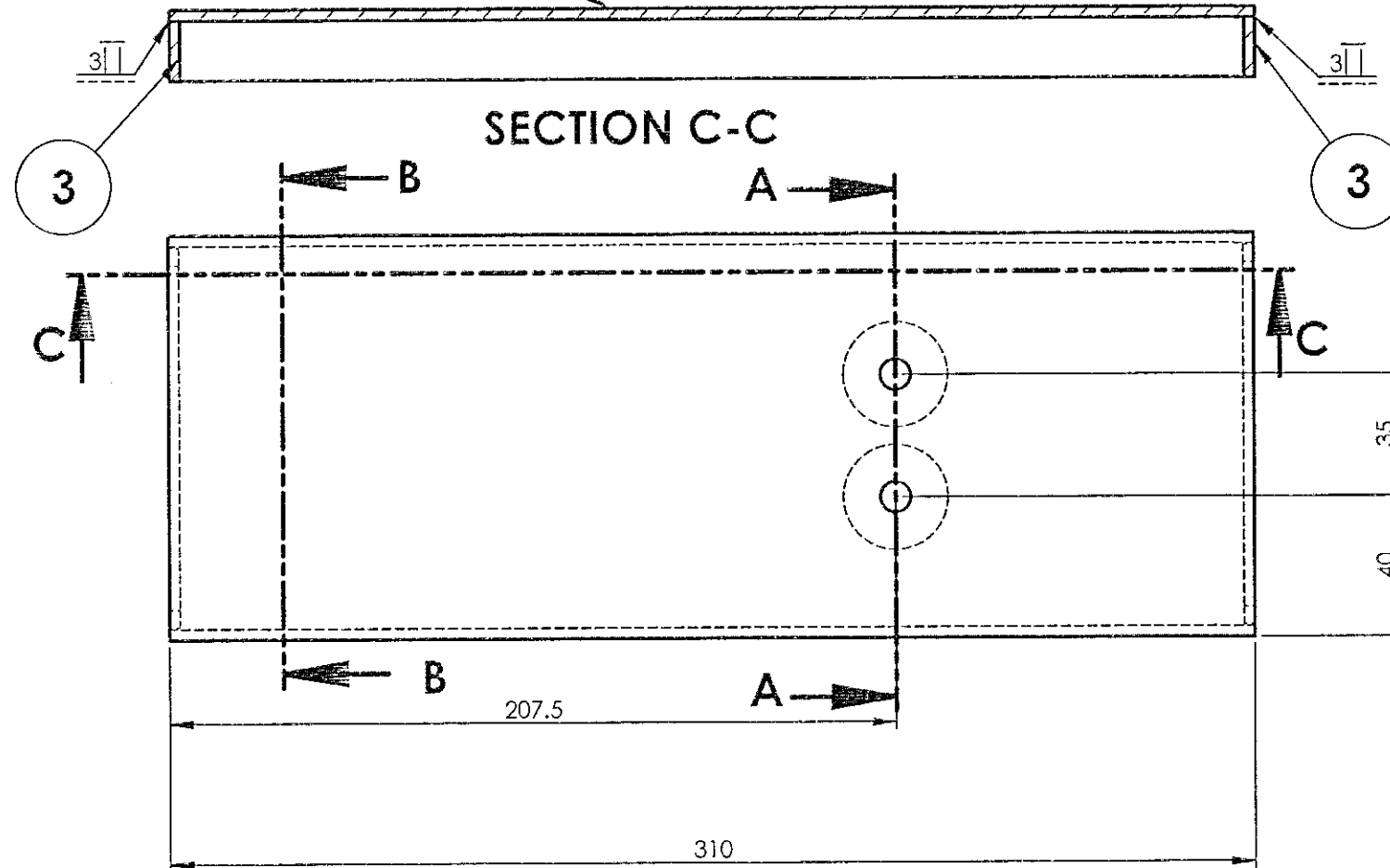
83014017

1

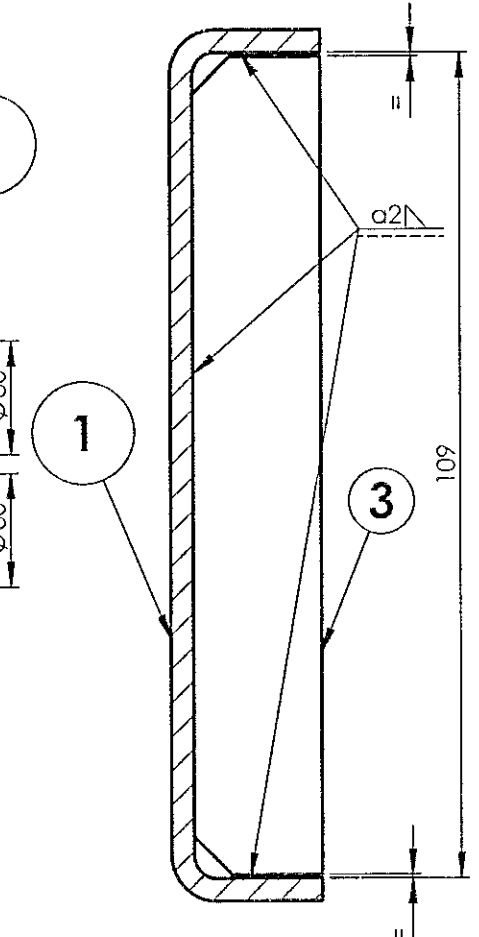
▽ ROUGH MACHINED	①1 ROUGH CLEANED
▽▽ FINISH MACHINED	①1b BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	①18 CHAMFERED

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE
a		ITEM-3 ADDED ALONG WITH SECTION B-B & SECTION C-C.	

## SECTION C-C



## SECTION A-A

SECTION B-B  
SCALE 1 : 1

## NOTE:-

1. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC. CK-201 SHALL BE USED FOR WELDING.
2. ALL WELDING SHALL BE OF TIG UNLESS OTHERWISE SPECIFIED.
3. ALL WELD PERFORMANCE CLASS SHALL BE CP C2 UNLESS OTHERWISE SPECIFIED.
4. FOR WELD TESTING PREFERANCES REFER DRG. No. ICF/STD-9-0-998.
5. FOR WELD PROCEDURE SPECIFICATION REFER DRG. No. ICF/STD-9-0-999.
6. ALL WELDED JOINTS SPATTERS SHALL BE GROUND.
7. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
8. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
9. STANDARDISATION OF GS SEAT FOR ICF AND LHB TYPES VIDE CDE/MECH APPROVAL NOTE NO:MD/Fur/LBS/104.Dt.25.07.2016.
10. ALL THE THREADED HOLES SHALL BE PROVIDED WITH SUITABLE DUMMY BOLTS TO SAFEGUARD THREADS.

2	BACKPIECE	L=108	3	AAL14270		0.04	
2	SCREWING PIECE		2	AAA14807		0.068	
1	CHANNEL	L=310	1	AAK14657		1.08	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS

GROUP: 1-4 Body Side Walls

SURFACE AREA IN Sq.m.:0.11

WT/ASSY IN Kgs:

## CHANNEL ASSEMBLY

SCALE 1:2	SSE/D CHD	<i>[Signature]</i>
ALT. a	ALTD DRN	R. SANTHOSH KUMAR

LWCBAC/PP2

INDIAN RAILWAY STANDARDS

INTEGRAL COACH FACTORY, CHENNAI - 600038

SHEET  
1 OF 1

83014017

A3

05-10-2025

17-07-2025

AME/SME

REF.DRG.NO.LH14342

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

83014018

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

① ROUGH CLEANED  
①b BURRS REMOVED  
⑱ CHAMFERED

REVISIONS

ALT.

ZONE

DESCRIPTION

APPROVED &  
DATE

ITEM-3 ADDED ALONG WITH SECTION B-B &amp; SECTION C-C.

## SECTION C-C

## SECTION A-A

SECTION B-B  
SCALE 1 : 1

## NOTE:-

1. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC. CK-201 SHALL BE USED FOR WELDING.
2. ALL WELDING SHALL BE OF TIG UNLESS OTHERWISE SPECIFIED.
3. ALL WELD PERFORMANCE CLASS SHALL BE CP C2 UNLESS OTHERWISE SPECIFIED.
4. FOR WELD TESTING PREFERANCES REFER DRG. No. ICF/STD-9-0-998.
5. FOR WELD PROCEDURE SPECIFICATION REFER DRG. No. ICF/STD-9-0-999.
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7. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
8. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
9. STANDARDISATION OF GS SEAT FOR ICF AND LHB TYPES VIDE CDE/MECH APPROVEL NOTE NO:MD/Fur/LBS/104.Dt.25.07.2016.
10. ALL THE THREADED HOLES SHALL BE PROVIDED WITH SUITABLE DUMMY BOLTS TO SAFEGUARD THREADS.

REF.DRG.NO.LH14343

5-10-2025

16-07-2025

AME/SME

DATE OF LATEST ALT.

DATE OF FIRST ISSUE

AME/SME

2	BACKPIECE	L=108	3	AAL14270		0.04	
4	SCREWING PIECE		2	AAA14807		0.068	
1	CHANNEL	L=500	1	AAK14657	RDSO SPEC C- K201 X2 Cr Ni 12	1.74	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS

GROUP: 1-4 Body Side Walls

SURFACE AREA IN Sq.m.:0.17

WT/ASSY IN Kgs:

## CHANNEL ASSEMBLY

SCALE

1:2

SSE/D

CHD

ALT.

a

ALTD

DRN

R. SANTHOSH KUMAR

R. SANTHOSH KUMAR



LWCBAC/PP2

INDIAN RAILWAY STANDARDS

INTEGRAL COACH FACTORY, CHENNAI - 600038

SHEET

1 OF 1

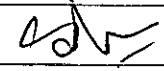
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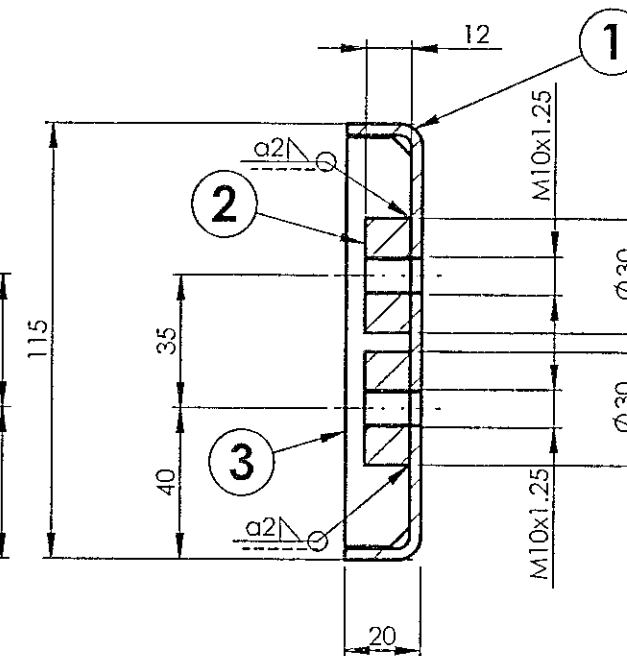
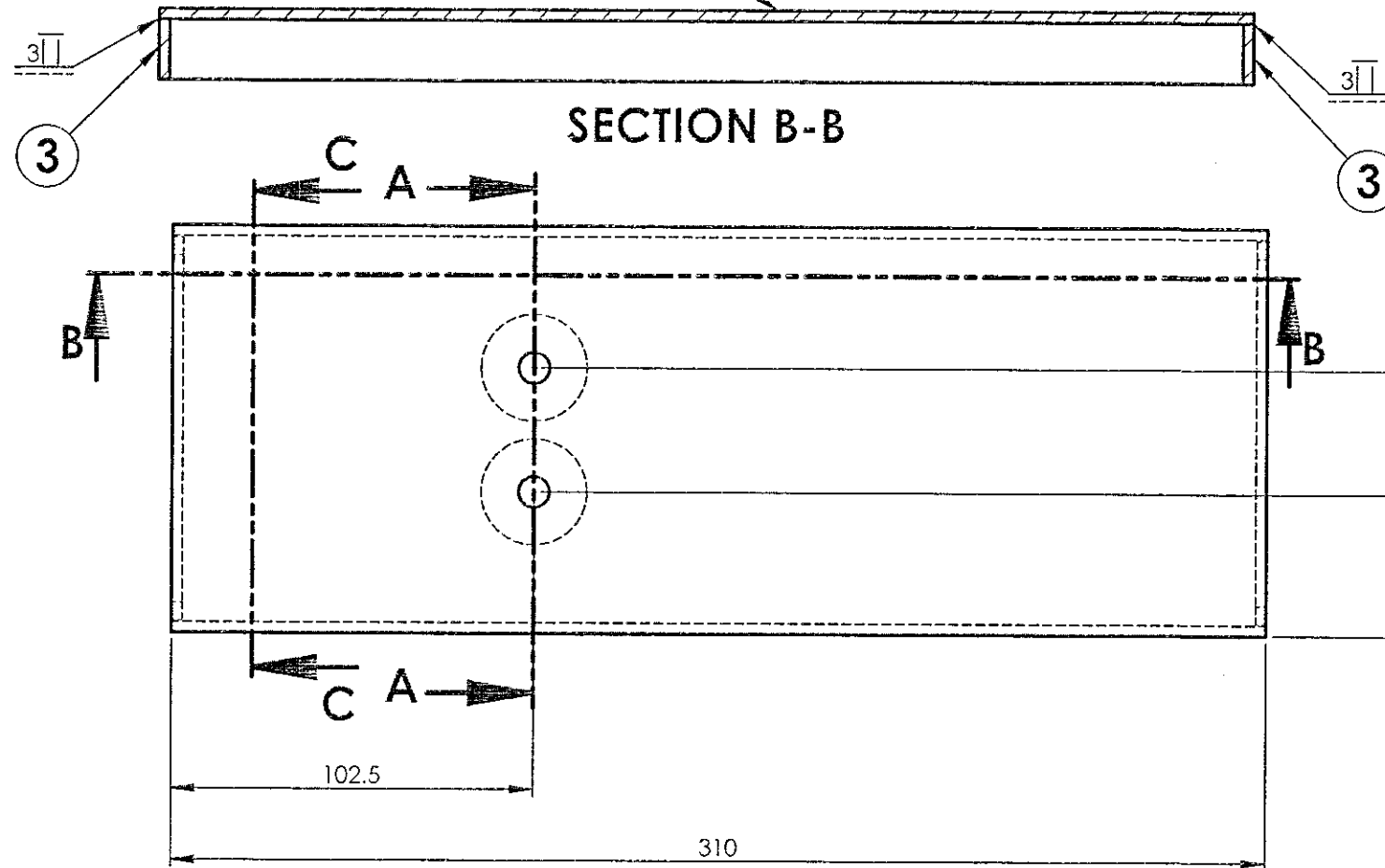
A3

83014019

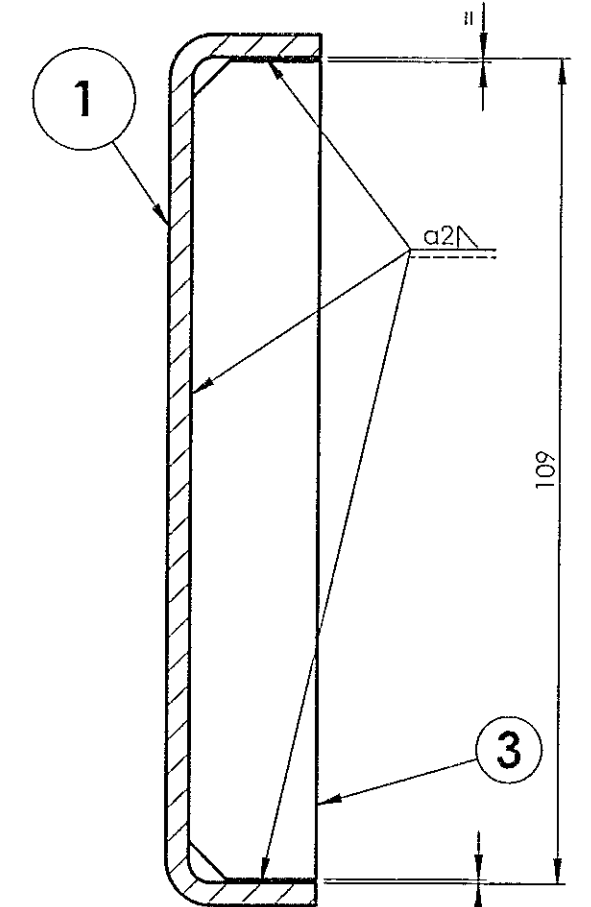
▽ ROUGH MACHINED	① ROUGH CLEANED
▽▽ FINISH MACHINED	①b BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	①8 CHAMFERED

## REVISIONS

ALT.	ZONE	DESCRIPTION	APPROVED & DATE
a		ITEM-3 ADDED ALONG WITH SECTION B-B & SECTION C-C.	



SECTION A-A

SECTION C-C  
SCALE 1 : 1

## NOTE:-

1. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC. CK-201 SHALL BE USED FOR WELDING.
2. ALL WELDING SHALL BE OF TIG UNLESS OTHERWISE SPECIFIED.
3. ALL WELD PERFORMANCE CLASS SHALL BE CP C2 UNLESS OTHERWISE SPECIFIED.
4. FOR WELD TESTING PREFERANCES REFER DRG. No. ICF/STD-9-0-998.
5. FOR WELD PROCEDURE SPECIFICATION REFER DRG. No. ICF/STD-9-0-999.
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7. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
8. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
9. STANDARDISATION OF GS SEAT FOR ICF AND LHB TYPES VIDE CDE/MECH APPROVAL NOTE NO:MD/Fur/LBS/104.D1.25.07.2016.
10. ALL THE THREADED HOLES SHALL BE PROVIDED WITH SUITABLE DUMMY BOLTS TO SAFEGUARD THREADS.

2	BACKPIECE	L=108	3	AAL14270		0.04	
2	SCREWING PIECE		2	AAA14807		0.068	
1	CHANNEL	L=310	1	AAK14657		1.08	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS

GROUP: 1-4 Body Side Walls

SURFACE AREA IN Sq.m.:0.11

WT/ASSY IN Kgs:

## CHANNEL ASSEMBLY

SCALE 1:2  
SSE/D CHDALT. a  
ALTD DRNR. SANTHOSH KUMAR  
R. SANTHOSH KUMAR

LWCBAC/PP2

INDIAN RAILWAY STANDARDS

INTEGRAL COACH FACTORY, CHENNAI - 600038

SHEET 1 OF 1

83014019

A3

5-10-2025

16-07-2025



DATE OF LATEST ALT.

DATE OF FIRST ISSUE

AME/SME

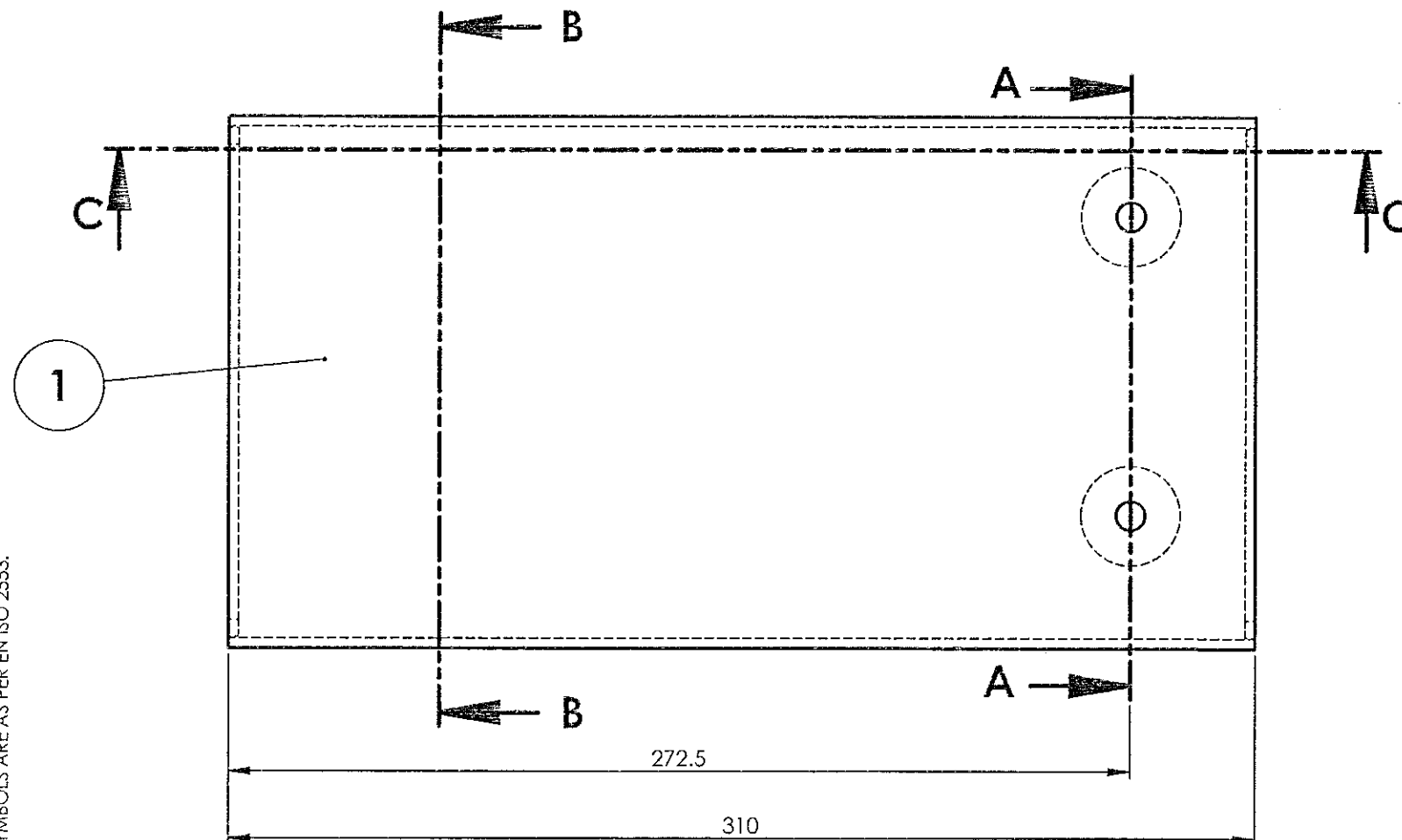
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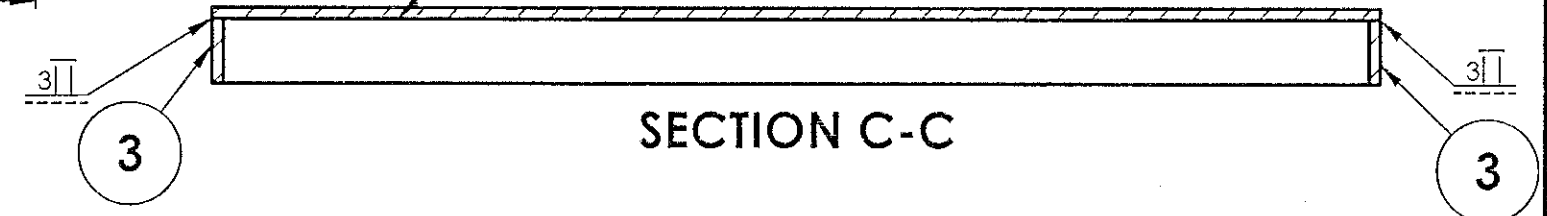
83014020

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

REVISIONS				APPROVED & DATE
ALT.	ZONE	DESCRIPTION		
a		ITEM-3 ADDED ALONG WITH SECTION B-B & SECTION C-C.		

**NOTE:-**

1. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC. CK-201 SHALL BE USED FOR WELDING.
2. ALL WELDING SHALL BE OF TIG UNLESS OTHERWISE SPECIFIED.
3. ALL WELD PERFORMANCE CLASS SHALL BE CP C2 UNLESS OTHERWISE SPECIFIED.
4. FOR WELD TESTING PREFERENCES REFER DRG. No. ICF/STD-9-0-998.
5. FOR WELD PROCEDURE SPECIFICATION REFER DRG. No. ICF/STD-9-0-999.
6. ALL WELDED JOINTS SPATTERS SHALL BE GROUND.
7. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
8. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
9. STANDARDISATION OF GS SEAT FOR ICF AND LHB TYPES VIDE CDE/MECH APPROVAL NOTE NO:MD/Fur/LBS/104.Dt.25.07.2016.
10. ALL THE THREADED HOLES SHALL BE PROVIDED WITH SUITABLE DUMMY BOLTS TO SAFEGUARD THREADS.

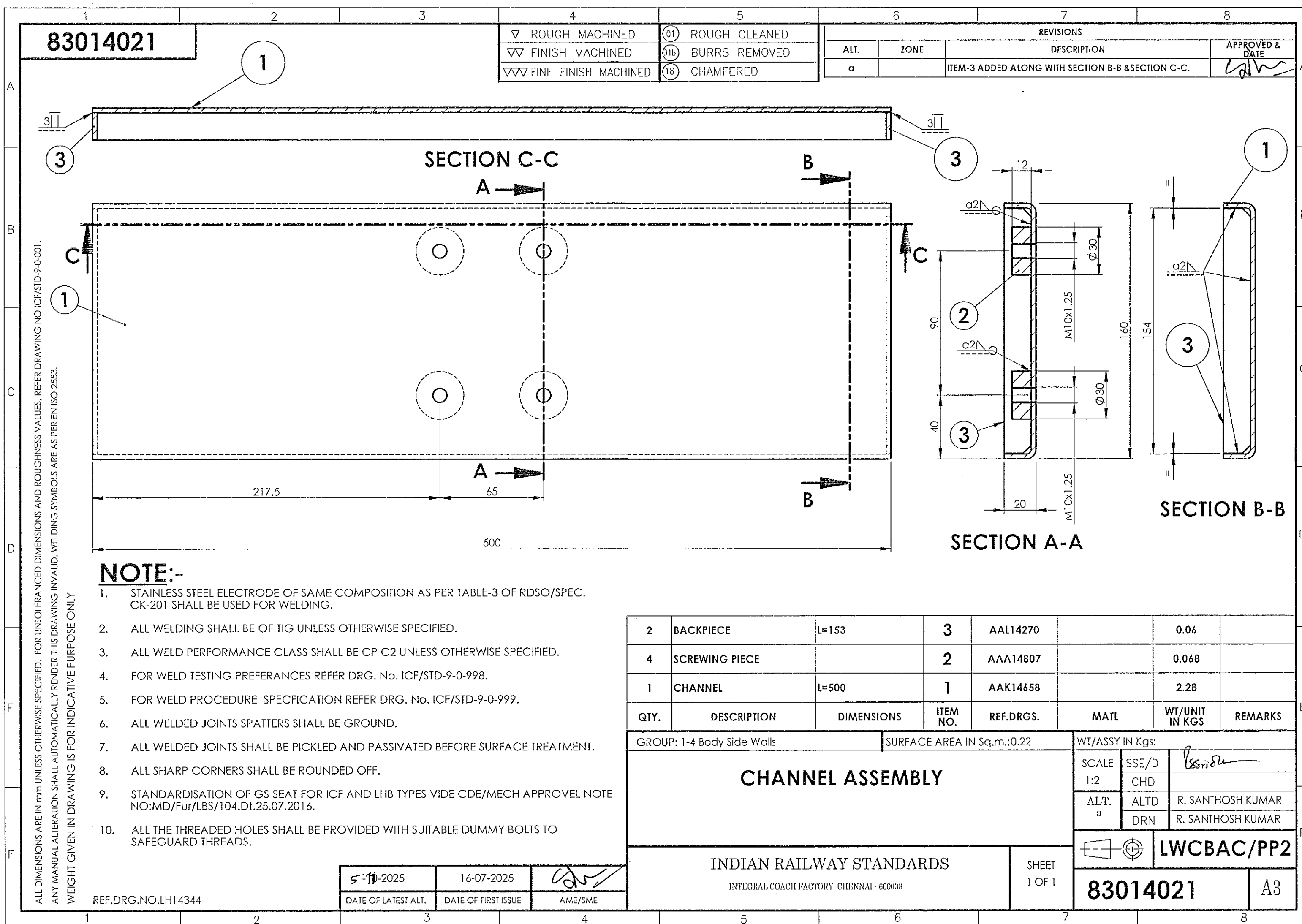



2	BACKPIECE	L=153	3	AAL14270		0.06	
2	SCREWING PIECE		2	AAA14807		0.068	
1	CHANNEL	L=310	1	AAK14658		1.41	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS
GROUP: 1-4 Body Side Walls				SURFACE AREA IN Sq.m.:0.14		WT/ASSY IN Kgs:	
<b>CHANNEL ASSEMBLY</b>					SCALE 1:2	SSE/D CHD	
					ALT. a	ALTD DRN	R. SANTHOSH KUMAR
							R. SANTHOSH KUMAR
INDIAN RAILWAY STANDARDS					SHEET 1 OF 1		
INTEGRAL COACH FACTORY, CHENNAI - 600038					LWCBAC/PP2		
					83014020		A3

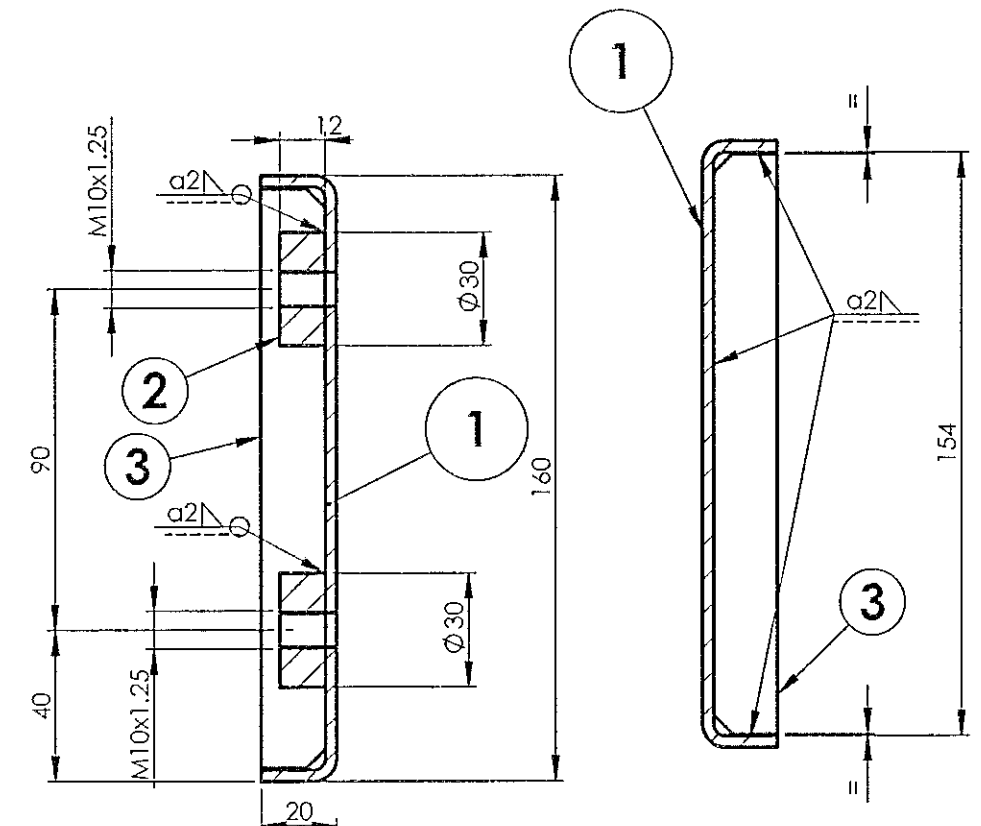
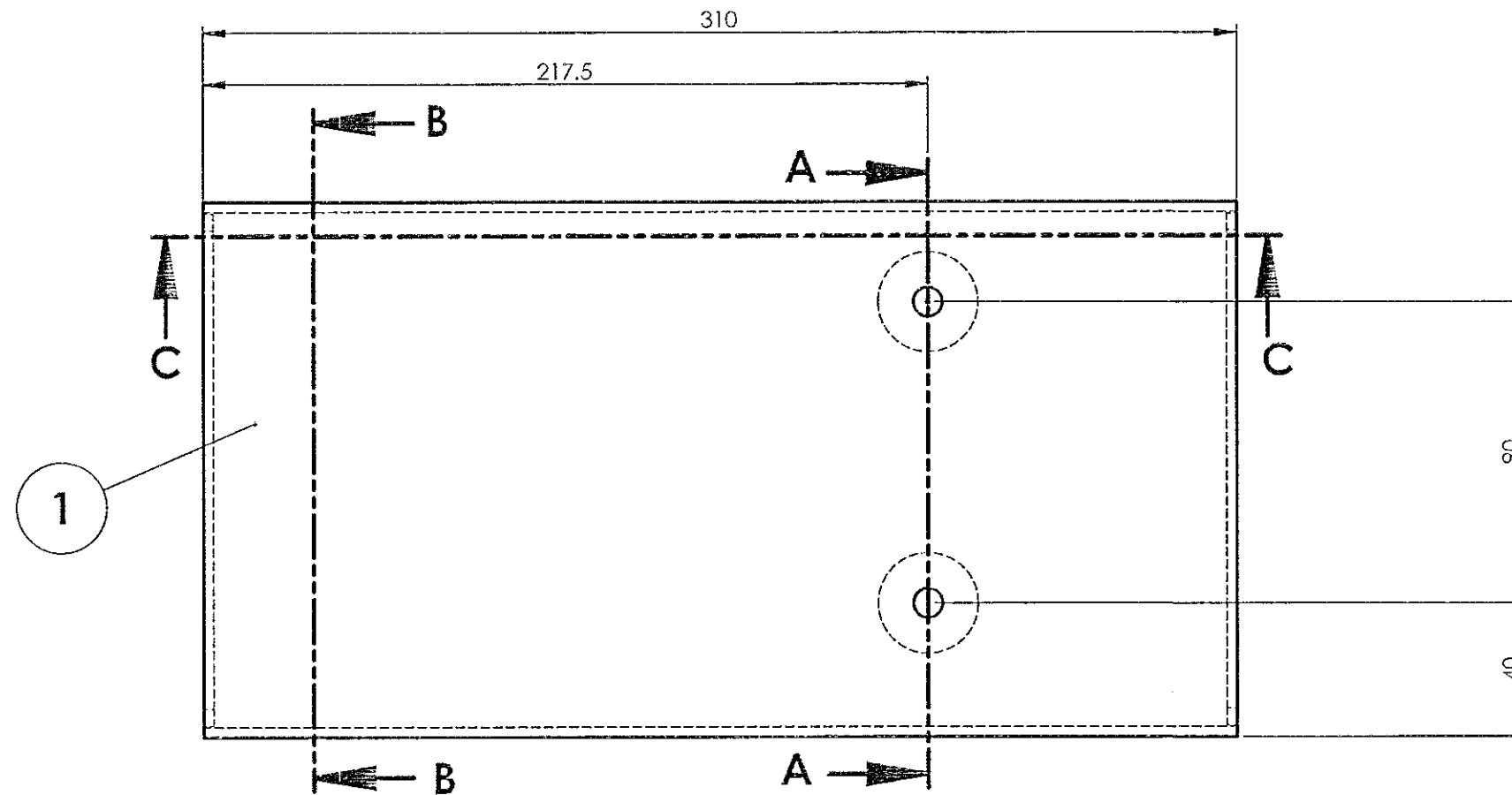
5-10-2025	16-07-2025	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

REF.DRG.NO.LH14346

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



REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE
a		LOCATING DIMENSION OF ITEM -2 ALTERED. ITEM-3 ADDED ALONG WITH SECTION B-B & SECTION C-C.	

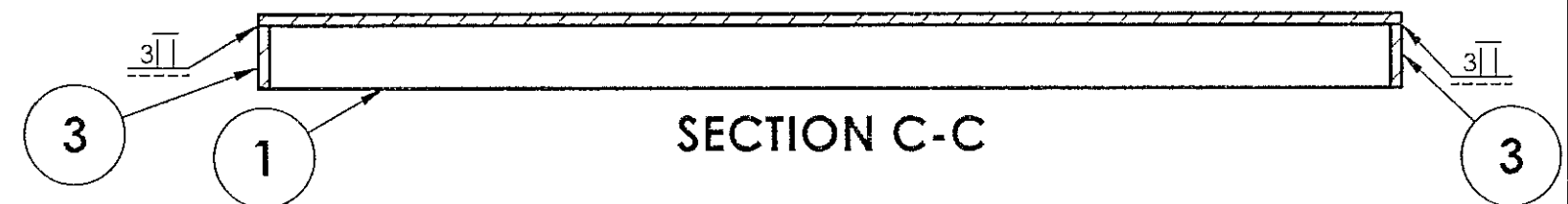


SECTION A-A

## SECTION B-B

**NOTE:-**

1. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION AS PER TABLE-3 OF RDSO/SPEC. CK-201 SHALL BE USED FOR WELDING.
2. ALL WELDING SHALL BE OF TIG UNLESS OTHERWISE SPECIFIED.
3. ALL WELD PERFORMANCE CLASS SHALL BE CP C2 UNLESS OTHERWISE SPECIFIED.
4. FOR WELD TESTING PREFERENCES REFER DRG. No. ICF/STD-9-0-998.
5. FOR WELD PROCEDURE SPECIFICATION REFER DRG. No. ICF/STD-9-0-999.
6. ALL WELDED JOINTS SPATTERS SHALL BE GROUND.
7. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
8. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
9. STANDARDISATION OF GS SEAT FOR ICF AND LHB TYPES VIDE CDE/MECH APPROVAL NOTE NO:MD/Fur/LBS/104.Dt.25.07.2016.
10. ALL THE THREADED HOLES SHALL BE PROVIDED WITH SUITABLE DUMMY BOLTS TO SAFEGUARD THREADS.



SECTION C-C

2	BACKPIECE	L=153	3	AAL14270		0.06	
2	SCREWING PIECE		2	AAA14807		0.068	
1	CHANNEL	L=310	1	AAK14658		1.41	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS

GROUP: 1-4 Body Side Walls

SURFACE AREA IN Sq.m.:0.14

WT/ASSY IN Kgs:

## CHANNEL ASSEMBLY

SCALE  
1:2

SSE/D
CHD

ALT.  
a

ALTO
DRN

	R. SANTHOSH KUMAR
	R. SANTHOSH KUMAR

LWCBAC/PP2

INDIAN RAILWAY STANDARDS

INTEGRAL COACH FACTORY, CHENNAI - 600038

SHEET  
1 OF 1

83014022

A3

5-10-2025

16-07-2025

CA

DATE OF LATEST ALT.

DATE OF FIRST ISSUE

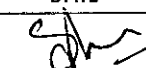
AME/SME

REF.DRG.NO.LH14351

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

83014023

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

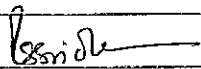
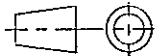
REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE
a		VIEW UPDATED AS PER CHANGE IN ITEM-1.	


2.5√30

SECTION A-A  
SCALE 1 : 2

**NOTE:-**

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

3	ANGLE PIECES	L=30	2	AAK14755		0.03		
1	ANGLE		1	AAK14751		2.20		
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS	
GROUP: 1-4 Body Side Walls		SURFACE AREA IN Sq.m.:0.2			WT/ASSY IN Kgs:			
ANGLE ASSEMBLY					SCALE	SSE/D		
					1:10	CHD		
					ALT.	ALTD	R. SANTHOSH KUMAR	
					a	DRN	R. SANTHOSH KUMAR	
INDIAN RAILWAY STANDARDS							LWCBAC/PP2	
INTEGRAL COACH FACTORY, CHENNAI - 600038					SHEET 1 OF 1		83014023	A3

5-10-2025	16-07-2025	
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



83014024

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

ALT.	ZONE	DESCRIPTION	APPROVED & DATE
a		VIEW UPDATED AS PER CHANGE IN ITEM-1.	

SECTION C-C  
SCALE 1 : 2SECTION B-B  
SCALE 1 : 2DETAIL D  
SCALE 1 : 2**NOTE:-**

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

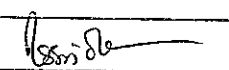
1	ANGLE PIECES	L=39	3	AAK14755		0.03	
2	ANGLE PIECES	L=30	2	AAK14755		0.03	
1	ANGLE		1	AAK14752		2.29	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS

GROUP: 1-4 Body Side Walls

SURFACE AREA IN Sq.m.:0.21

WT/ASSY IN Kgs:

**ANGLE ASSEMBLY**

SCALE 1:5	SSE/D	
	CHD	
ALT. a	ALTD	R. SANTHOSH KUMAR
	DRN	R. SANTHOSH KUMAR

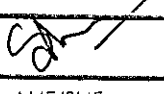
INDIAN RAILWAY STANDARDS

INTEGRAL COACH FACTORY, CHENNAI - 600038

SHEET  
1 OF 1 **LWCBAC/PP2****83014024****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

REF.DRG.NO.-

5-10-2025	16-06-2025	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

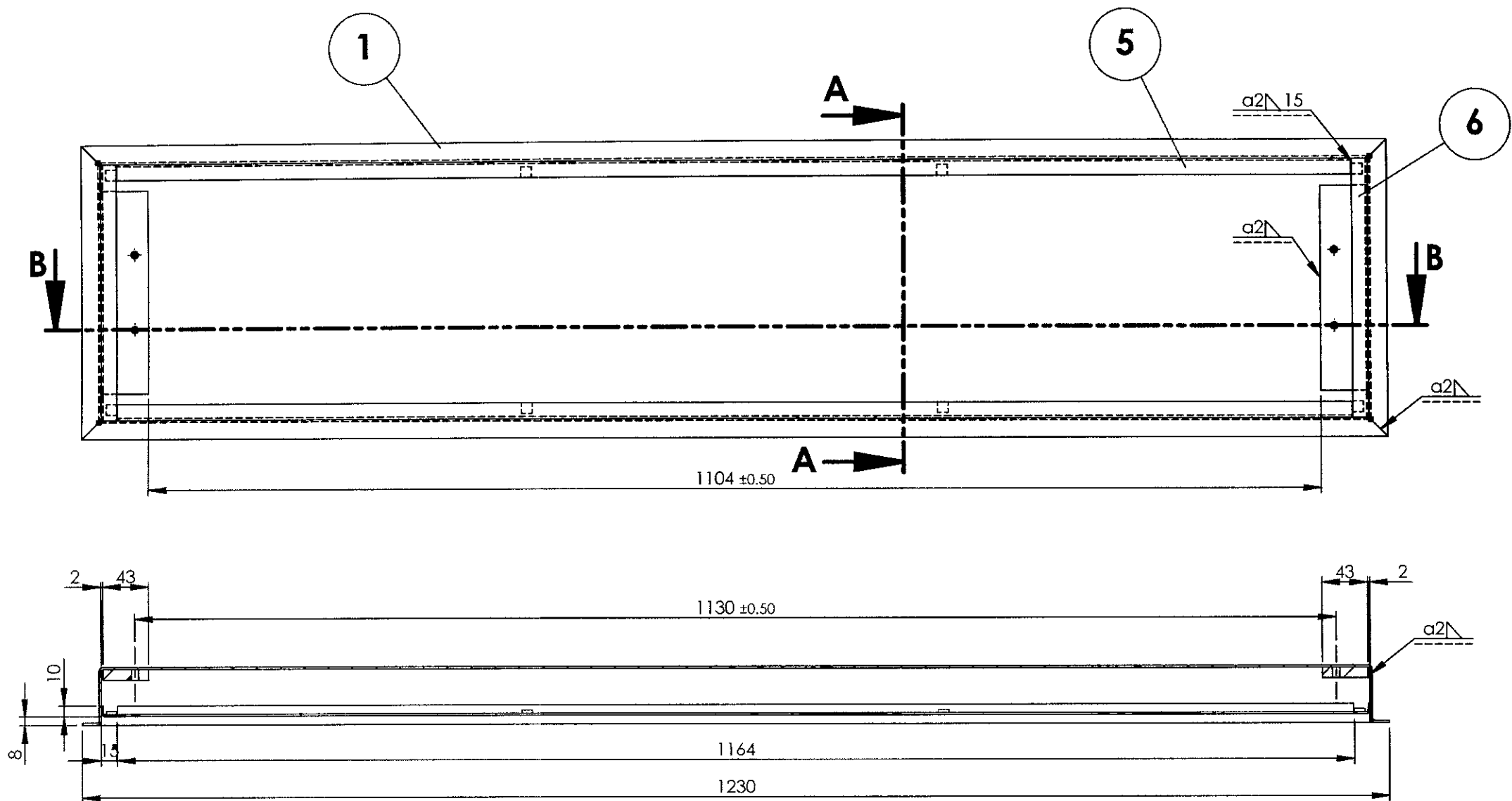
87414028

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

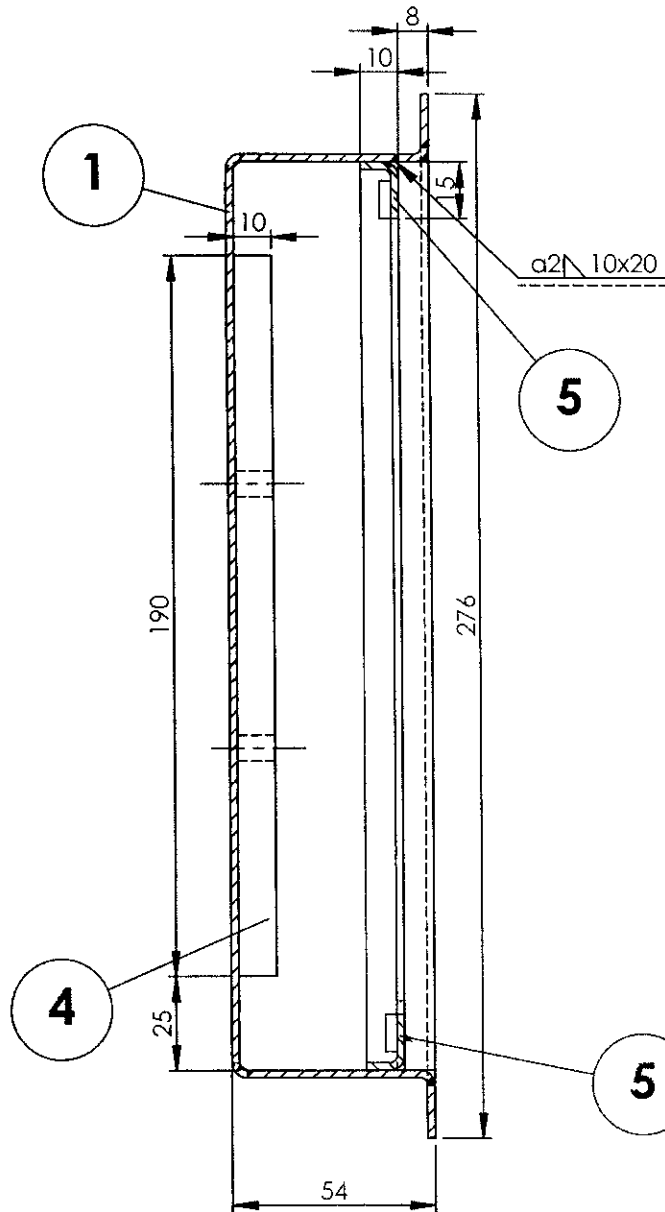
① ROUGH CLEANED  
①b BURRS REMOVED  
①s CHAMFERED

REVISIONS

ALT.	ZONE	DESCRIPTION	APPROVED & DATE
a		NOTE ADDED.	-sd-
b		ITEM-2 & 3 DELETED. ITEM-5 & 6 ADDED	<i>Autar Singh</i>



SECTION B-B

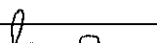
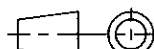


SECTION A-A  
SCALE 1 : 2

NOTE:-

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

2	ANGLE ASSEMBLY		6	87414085		0.088	
2	ANGLE ASSEMBLY		5	87414084		0.409	
2	FLAT		4	AAG14752		0.648	
2	ANGLE		3	AAG14751		0.083	
2	ANGLE		2	AAG14750		0.404	
1	HOUSING FOR LED DESTINATION BOARD		1	AAG14749		7.466	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS

GROUP: 1-4 Body Side Walls		SURFACE AREA IN Sq.m.: 1.121		WT/ASSY IN Kgs:		
HOUSING FOR LED DESTINATION BOARD				SCALE 1:5	SSE/D	
					CHD	
				ALT b	ALTD	T.UKKRAPANDIAN
					DRN	G.VIMALA
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038						LWACCN/EOG/GR
				SHEET 1 OF 1		87414028

28-05-2024	28-02-2022	<i>Autar Singh</i>
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

REF.DRG.NO.MI007347

87414084

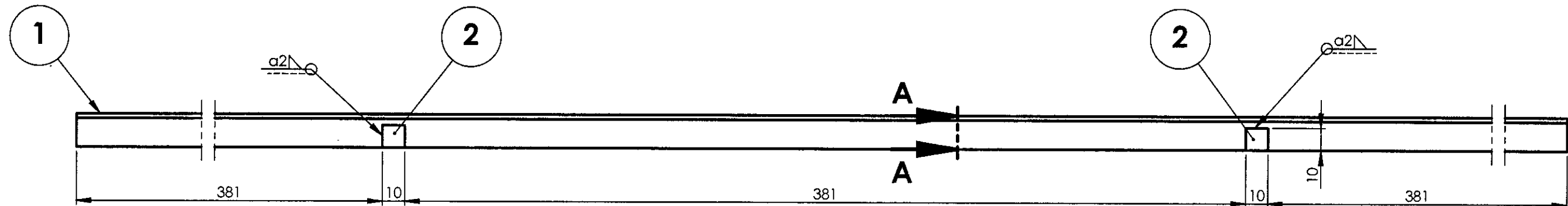
▽ ROUGH MACHINED	① ROUGH CLEANED
▽▽ FINISH MACHINED	①b BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	①c CHAMFERED

## REVISIONS

ALT.

ZONE

DESCRIPTION

APPROVED &  
DATESECTION A-A  
SCALE 1 : 1**NOTE:-**

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

2	SCRWING PIECE	3x10x10	2		RDSO SPEC C-K201 X2 Cr Ni 12	0.00	
1	ANGLE		1	AAG14750		0.40	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS
GROUP: 1-4 Body Side Walls				SURFACE AREA IN Sq.m.:0.06		WT/ASSY IN Kgs:	
ANGLE ASSEMBLY					SCALE 1:2	SSE/D	CHD
					ALT.	ALTD	
						DRN	T.Ukkirapandian
INDIAN RAILWAY STANDARDS				SHEET 1 OF 1		LWACCN/EOG/GR	
INTEGRAL COACH FACTORY, CHENNAI - 600038				87414084		A3	

REF.DRG.NO.-

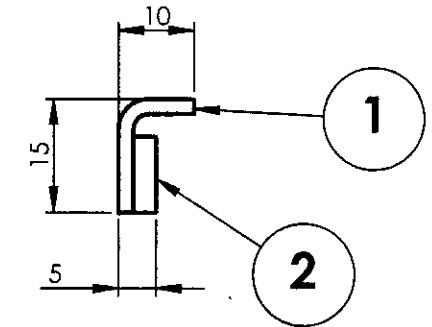
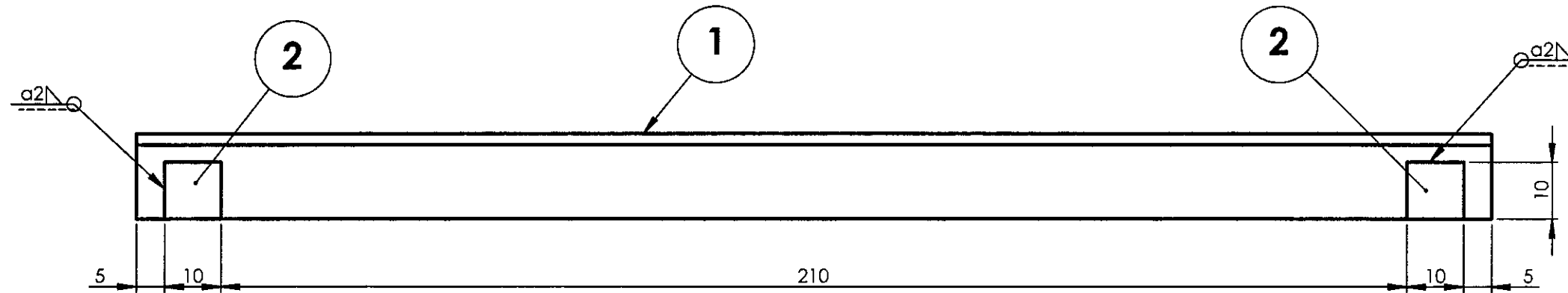
28-05-2026		
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

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

87414085

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

2	SCRWING PIECE	3x10x10	2		RDSO SPEC C-K201 X2 Cr Ni 12	0.00	
1	ANGLE		1	AAG14751		0.08	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS
GROUP: 1-4 Body Side Walls				SURFACE AREA IN Sq.m.:0.01		WT/ASSY IN Kgs:	
ANGLE ASSEMBLY					SCALE	SSE/D	
					1:1	CHD	
					ALT.	ALTD	
						DRN	T.Ukkirapandian
INDIAN RAILWAY STANDARDS				SHEET 1 OF 1		LWACCN/EOG/GR	
INTEGRAL COACH FACTORY, CHENNAI - 600038				87414085		A3	

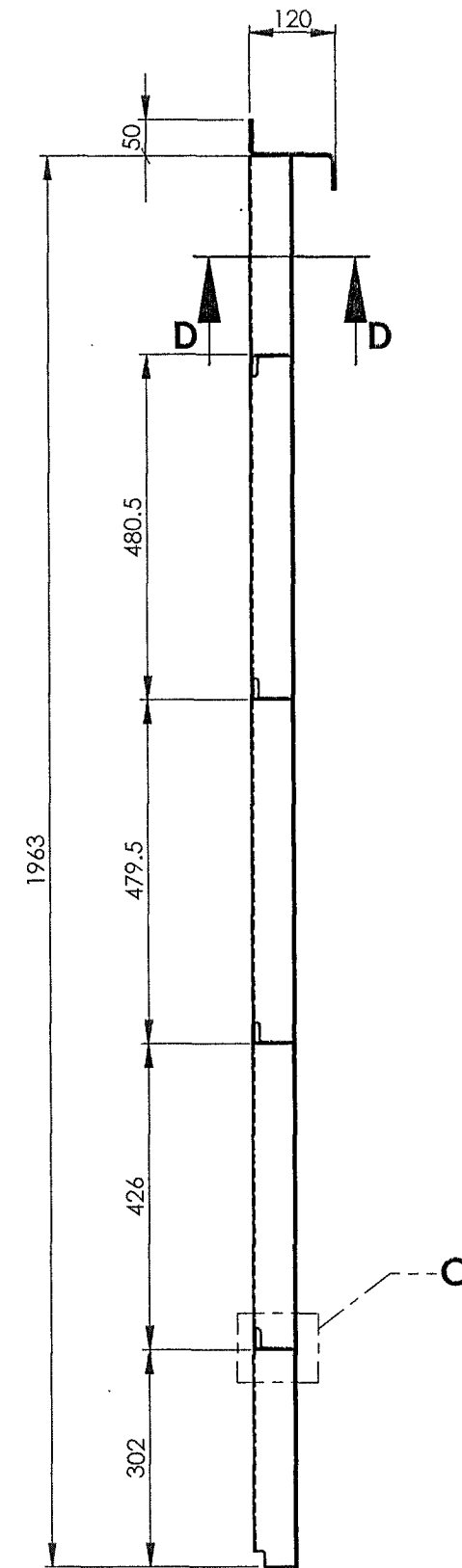
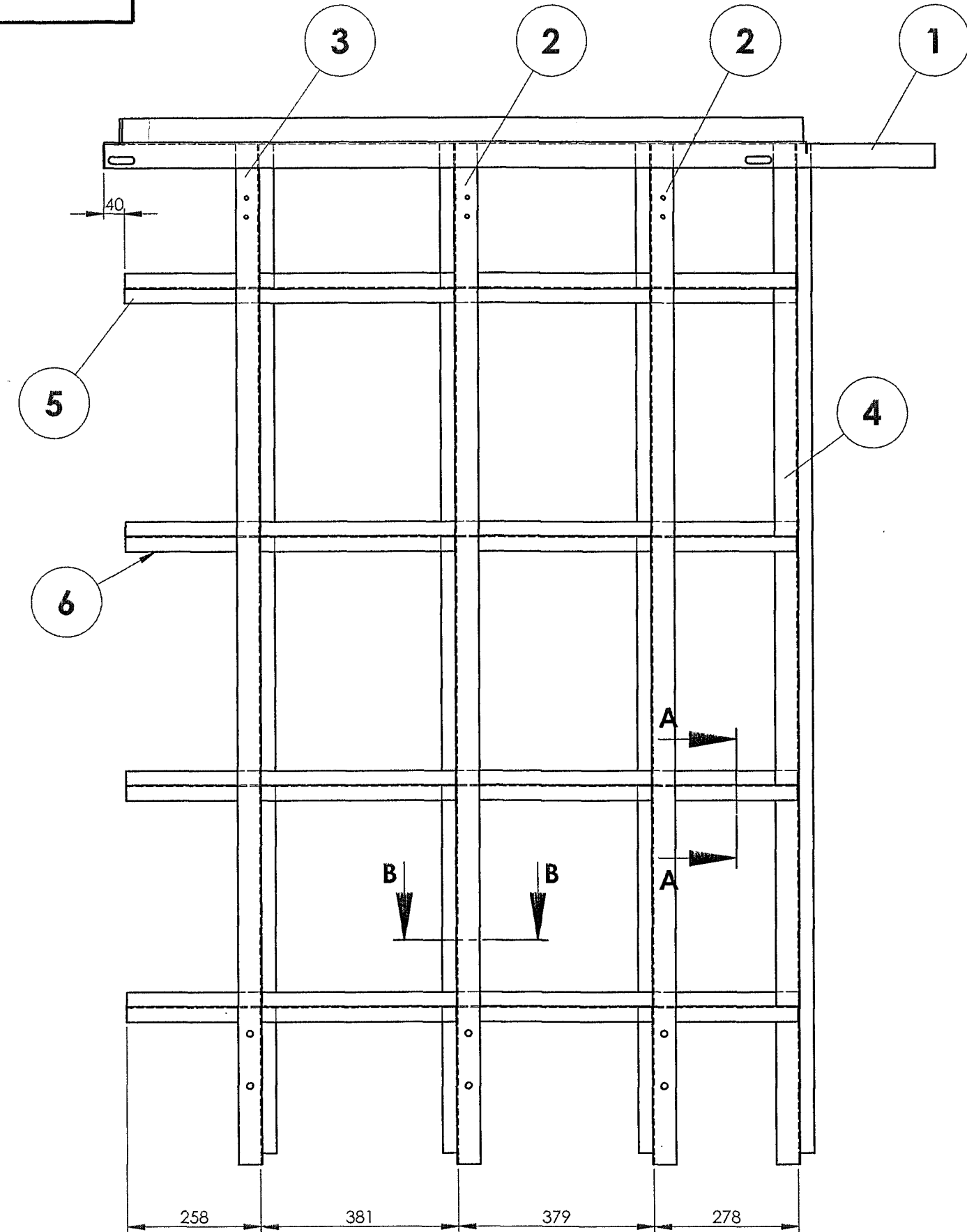
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	28-05-2024	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

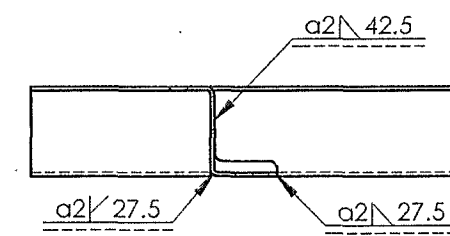
88814011

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

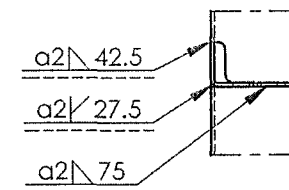
REVISIONS				APPROVED & DATE	
ALT.	ZONE	DESCRIPTION			



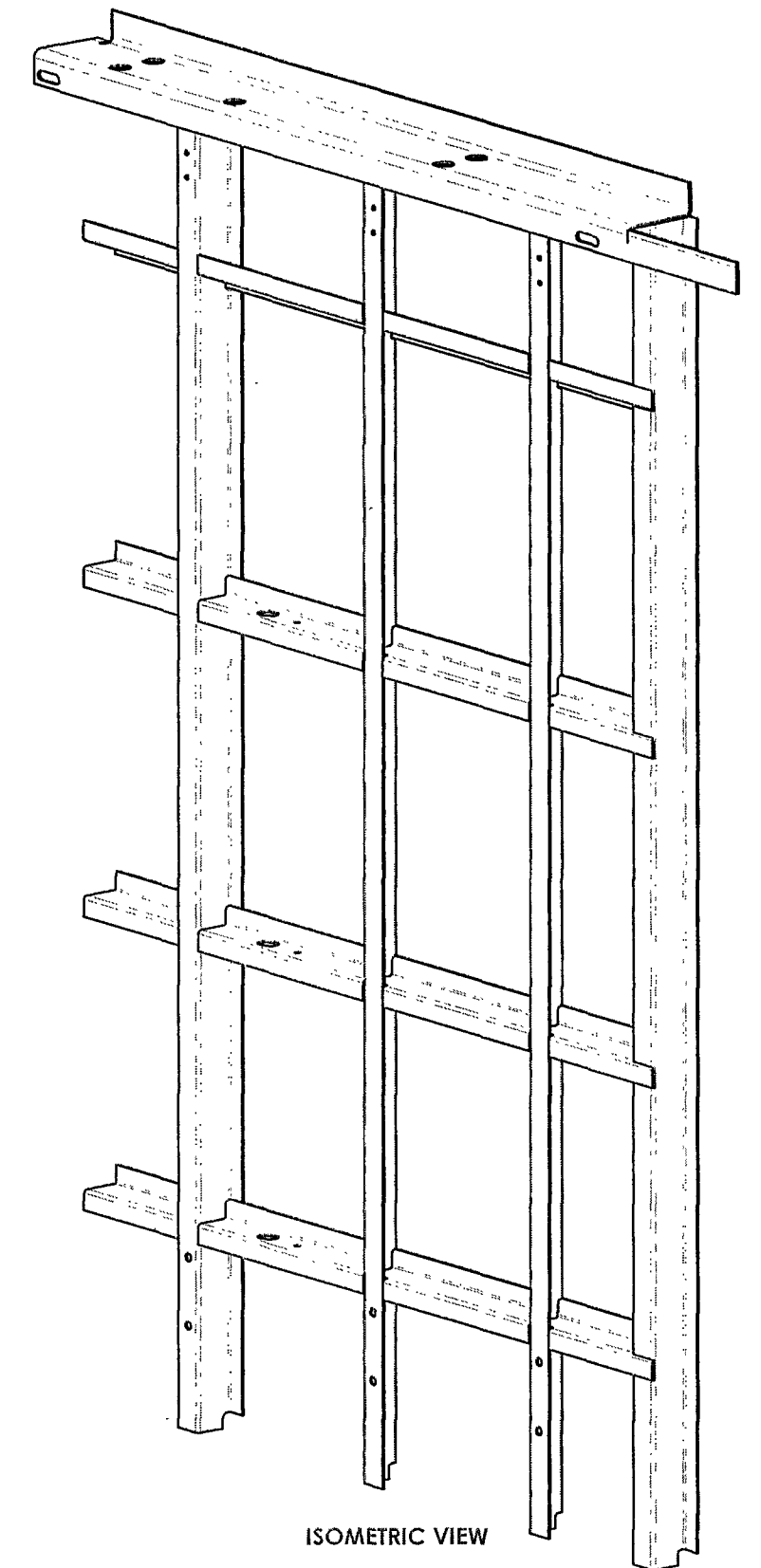
SECTION A-A  
SCALE 1 : 5



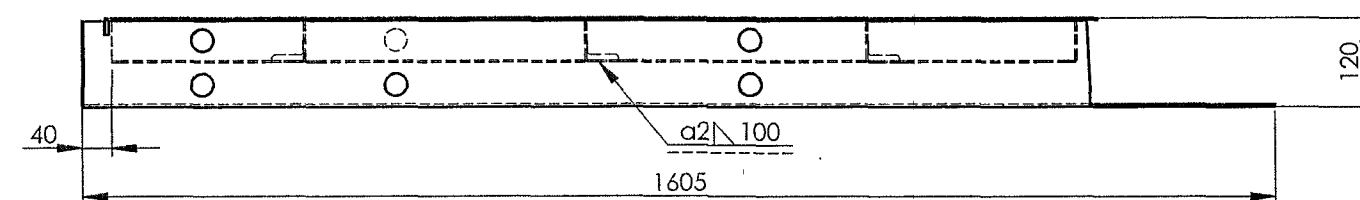
SECTION B-B  
SCALE 1 : 5



DETAIL C  
SCALE 1 : 5



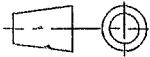
ISOMETRIC VIEW



SECTION D-D  
SCALE 1 : 5

**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.

3	HORIZONTAL MEMBER		6	AAA14953		2.781	
1	HORIZONTAL MEMBER		5	AAA14949		2.796	
1	PILLAR		4	AAA14939		4.854	
1	PILLAR		3	AAA14932		4.862	
2	PILLAR		2	AAA14931		4.862	
1	ROOF FLANGE		1	AAG14974		8.97	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS
GROUP: 1-4 Body Side Walls			SURFACE AREA IN Sq.m.:3.715		WT/ASSY IN Kgs:		
SIDEWALL FRAME WORK RIGHT COMPLETE					SCALE 1:10	SSE/D	L. Panduranga Rao
						CHD	
					ALT	ALTD	
						DRN	VIJAYAKUMAR R
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038							VP
							88814011
					SHEET 1 OF 1		

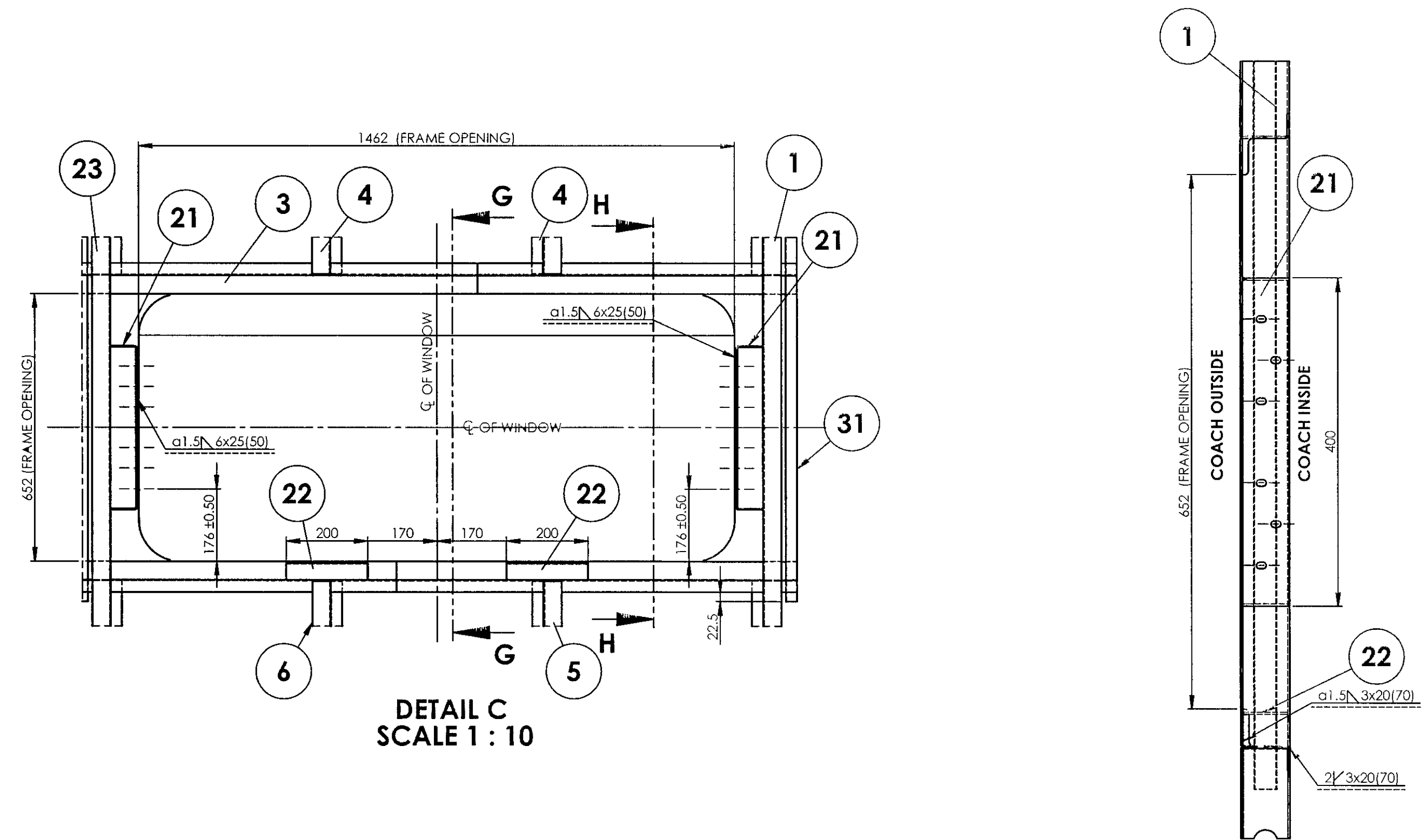
ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICF/STD-9-0001. ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER IS:813-1986. WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY.

REF.DRG.NO.

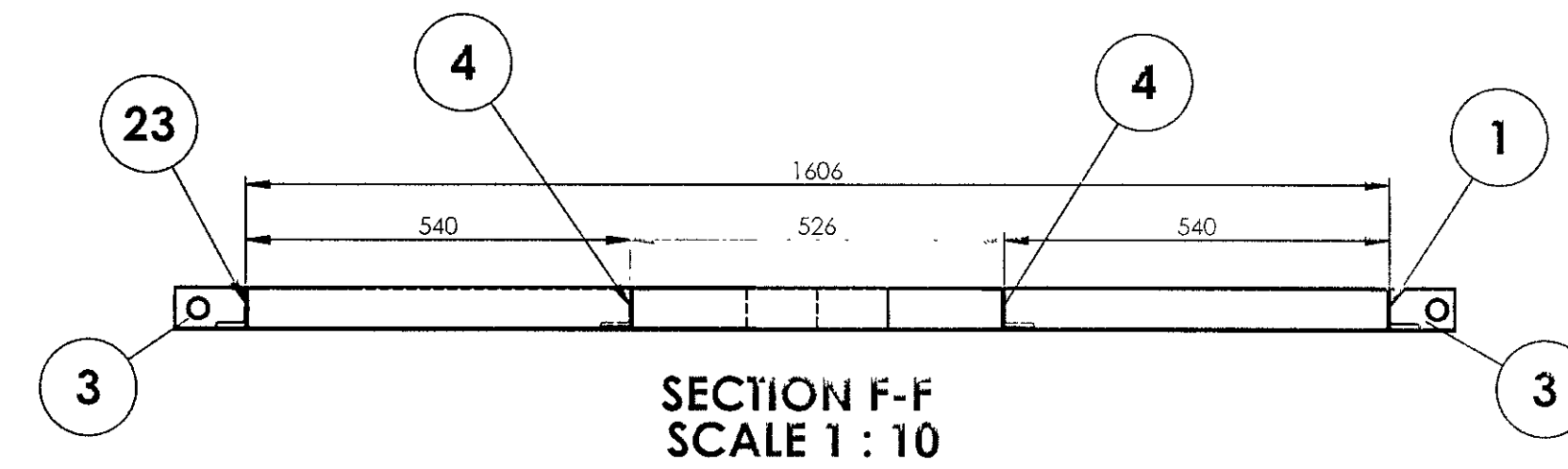
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME
	11-2021	



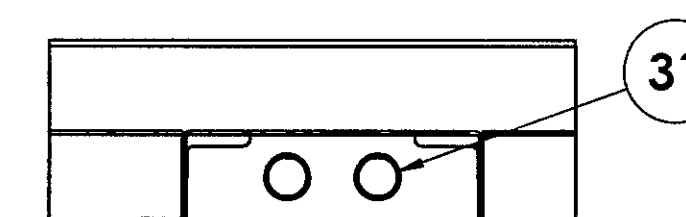
▽ ROUGH MACHINED	(01) ROUGH CLEANED
▽▽ FINISH MACHINED	(11) BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	(18) CHAMFERED



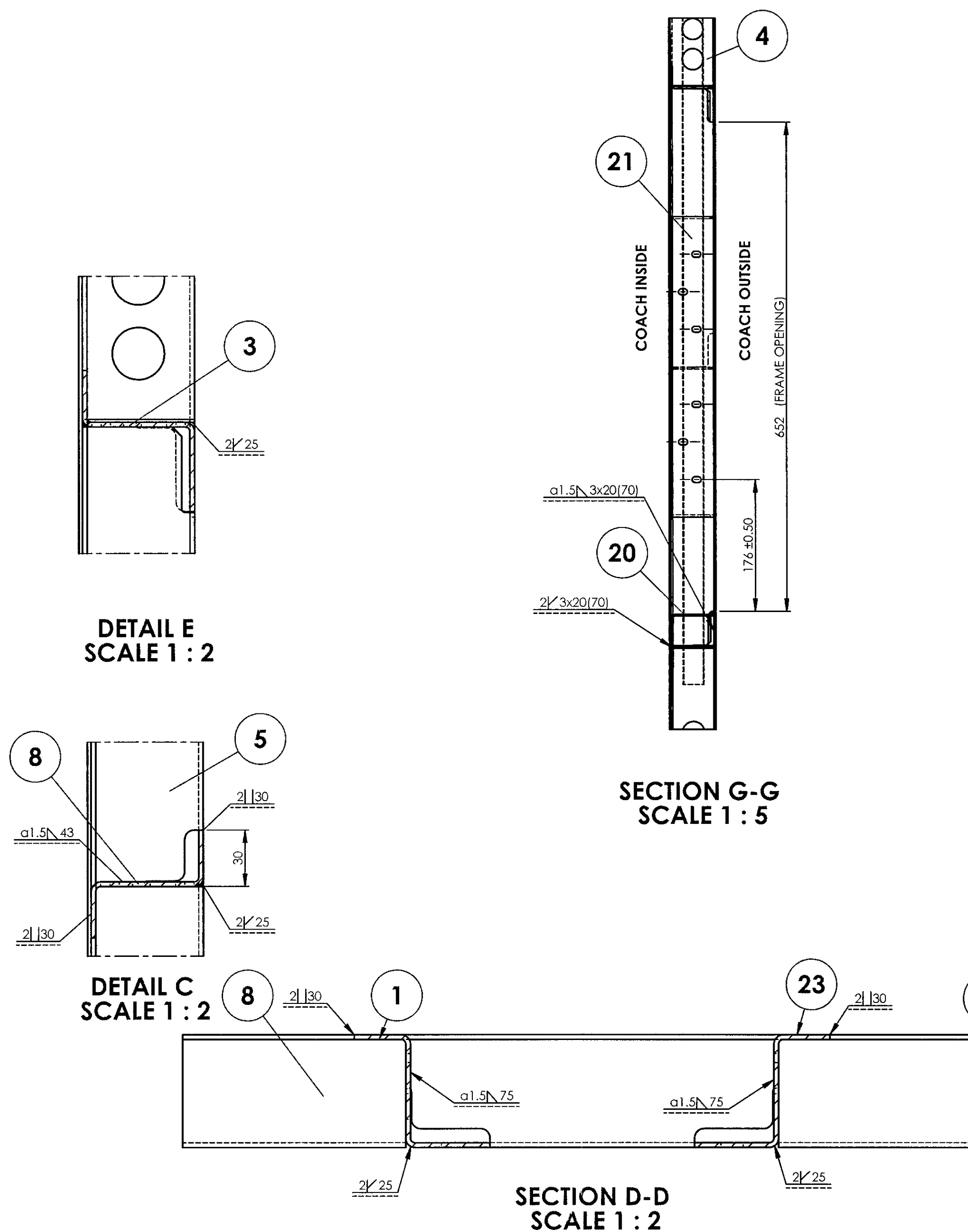
SECTION H-H  
SCALE 1 : 5



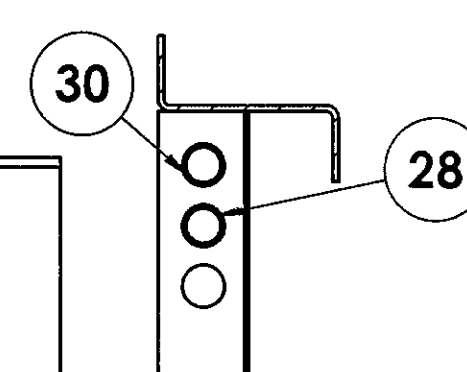
SECTION F-F  
SCALE 1 : 10



SECTION K-K  
SCALE 1 : 5




**SECTION D-D**  
**SCALE 1 : 2**



SECTION J-J  
SCALE 1 : 5

REF.DRG.NC

	30-10-2023	<i>[Signature]</i>
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	NAME/NAME

GROUP: 1-4 Body Side Walls		SURFACE AREA IN Sq.m.		WT/ASSY IN Kgs.	
FRAME WORK COMPLETE L.H.				SCALE	SSE/D
				1:25	CHD
				ALT	ALTD
				DRN	DRD: R. SANTOSH KUMAR 220: KUNITH THACUR
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038		SHEET 1 OF 2		 <b>LWCB/PP</b>	
				<b>98114012</b>	
				A1	