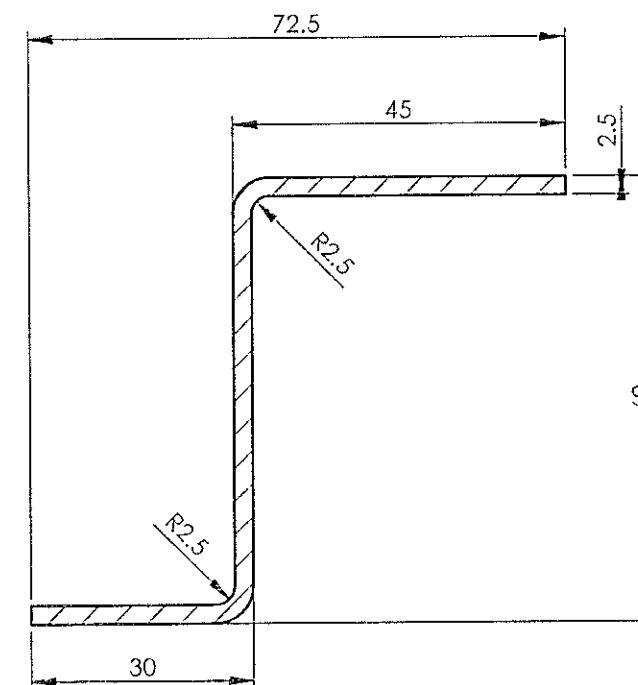
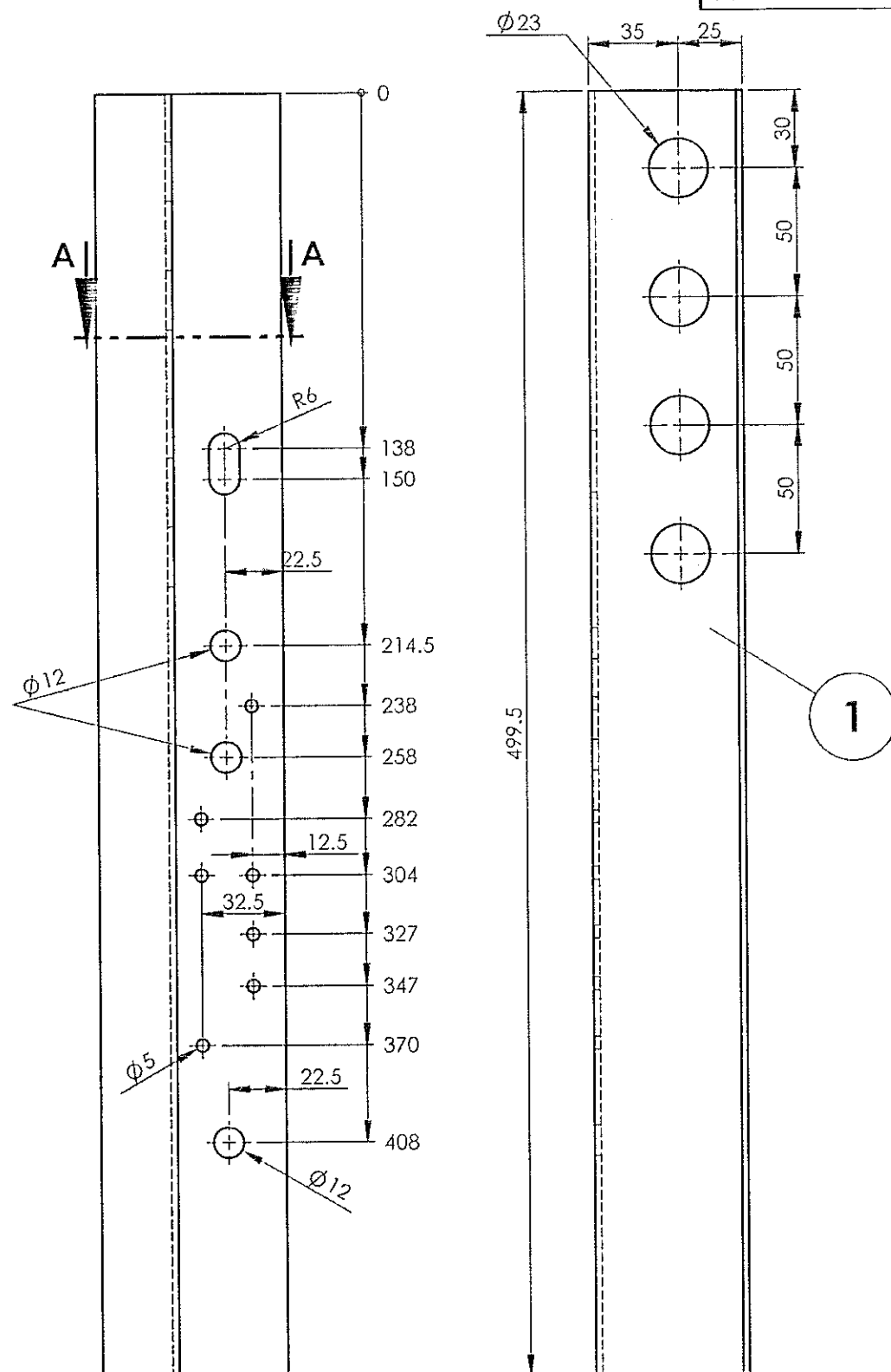


AAH14548

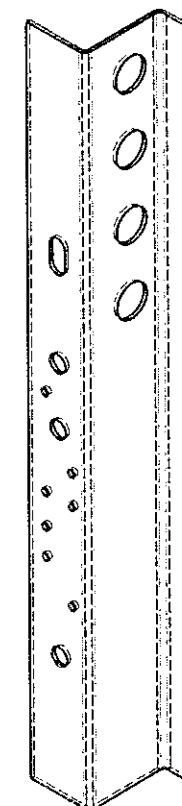
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▽▽ FINISH MACHINED	(01b) BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	(18) CHAMFERED

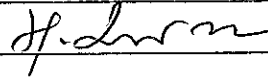
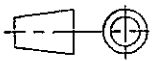
REVISIONS

ALT.	ZONE	DESCRIPTION	APPROVED & DATE
a		ø28 HOLES ALTERED TO ø23 AND LOCATING DIMENSIONS ARE ALTERED.	
b		ø23 HOLE ADDED	11/11/19



ISOMETRIC VIEW



1	PART PILLAR TOP	2.5x126x499.5	1		RDSO/SPEC C-K201 X2CrNi12	1.22	
QTY	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-4		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
PART PILLAR TOP					SCALE	SSE/D	
					1:2.5	CHD	
					ALT. b	ALTD	A Muthukumar
						DRN	E.VEDA VARSHINI
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1			
					AAH14548		A3

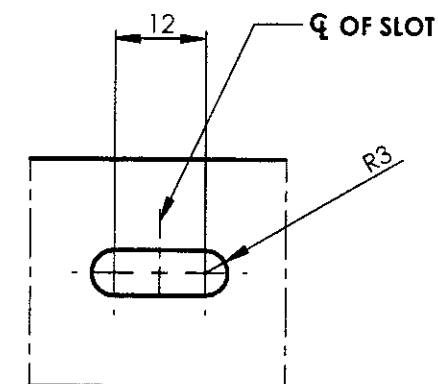
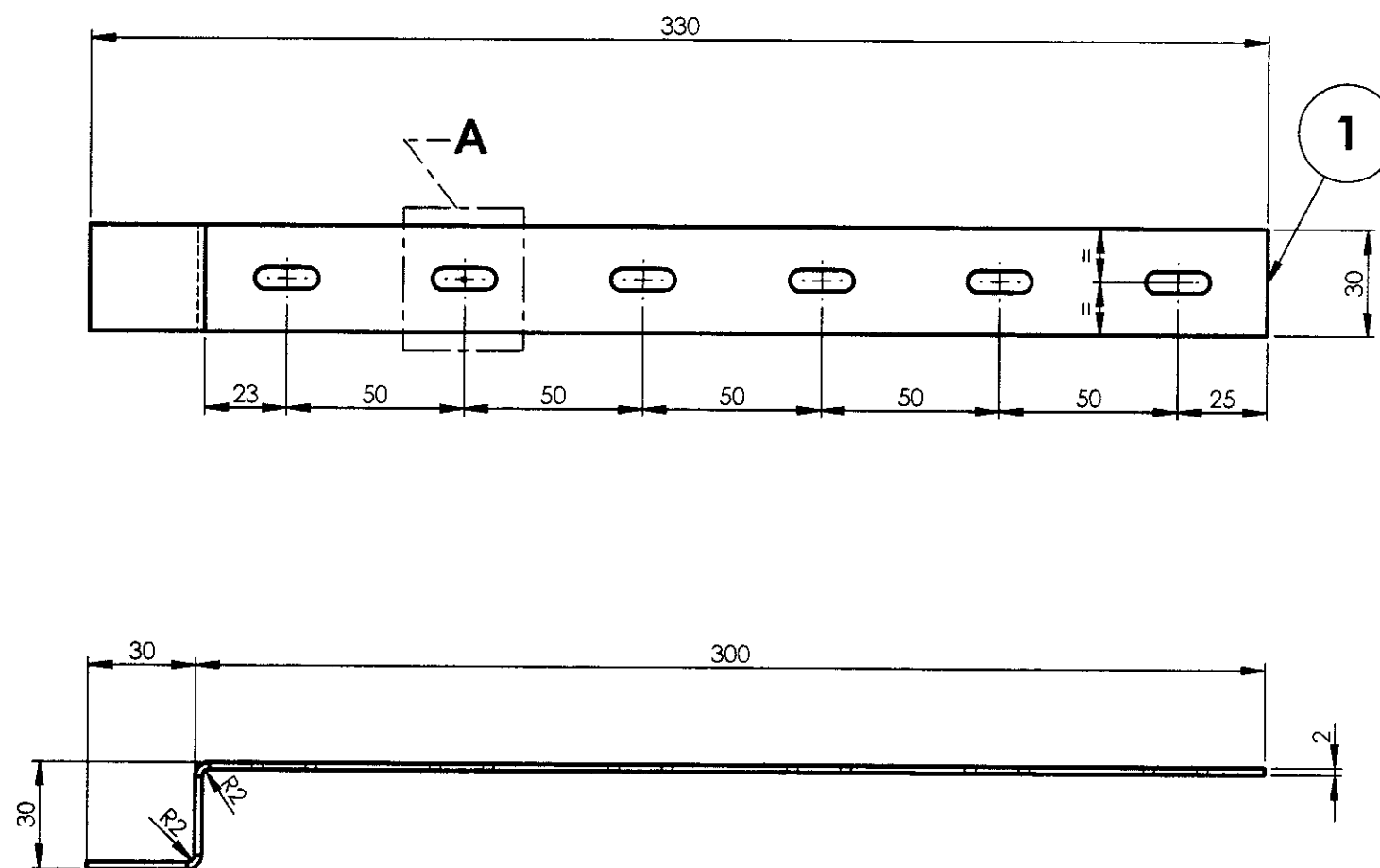
ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICF/STD-9-0-001.
ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER IS: 813-1986.
WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY

REF.DRG.NO.LW14114 Alt c/- LA14326 Alt. a/-

AAI14418

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

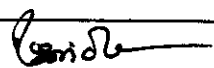
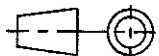
REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE

DETAIL A
SCALE 1 : 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 EN ISO 2553.
WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY

REF.DRG.NO.-

-	9-05-2023	AME/SME
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	

1	BRACKET FOR CABLE CLAMPING	2x30x354	1		RDSO SPEC C-K201 X2 Cr Ni 12	0.14	
QTY	DESCRIPTION	DIMENSIONS	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:		
BRACKET FOR CABLE CLAMPING					SCALE	SSE/D	
					1:2	CHD	
					ALT.	ALTD	
						DRN	R.Santhosh kumar
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY CHENNAI - 600038				SHEET 1 OF 1			
					AAI14418		A3

AAI14420

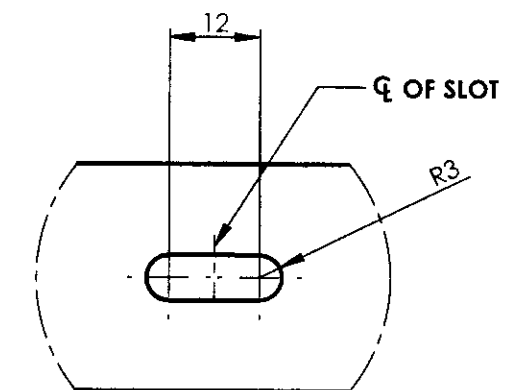
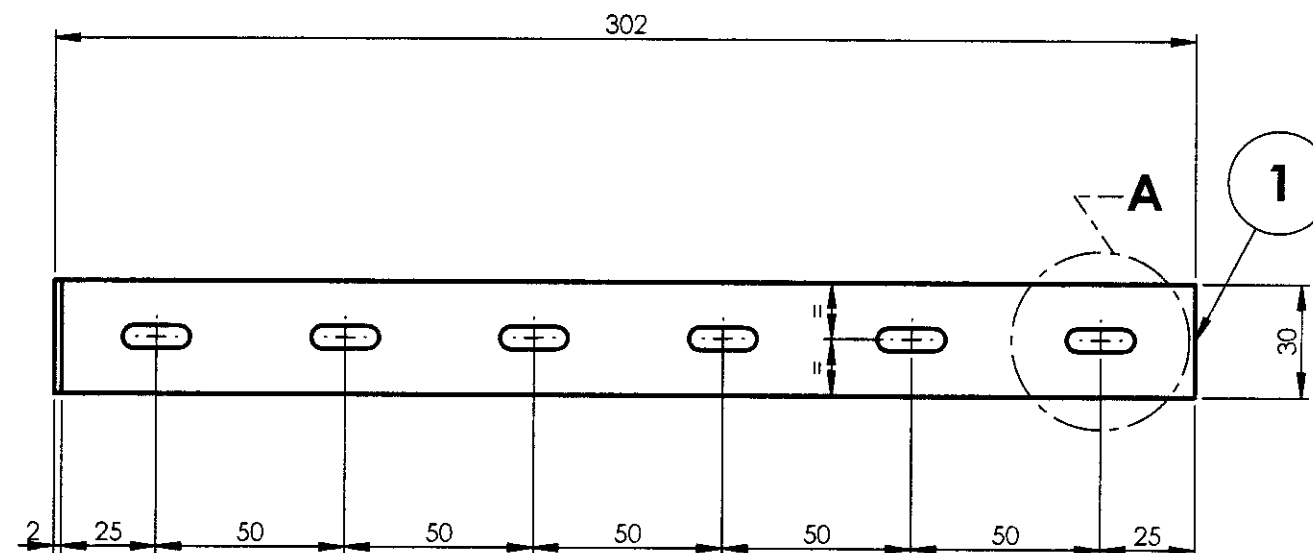
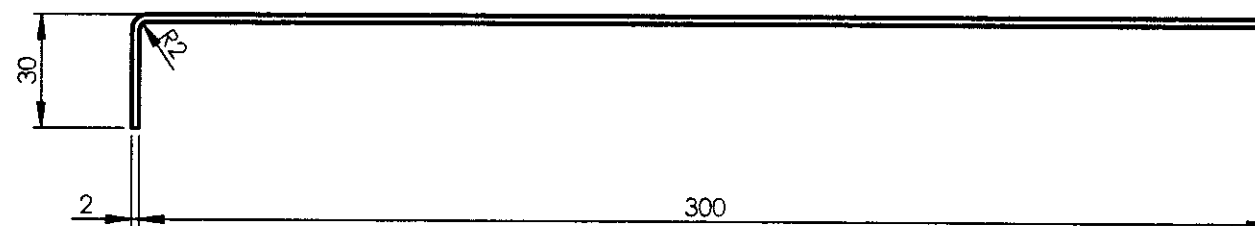
▽ ROUGH MACHINED	① ROUGH CLEANED
▽▽ FINISH MACHINED	①b BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	①8 CHAMFERED

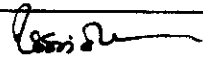
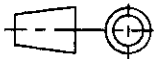
REVISIONS

ALT.

ZONE

DESCRIPTION

APPROVED &
DATEDETAIL A
SCALE 1 : 1

1	BRACKET FOR CABLE CLAMPING	2x30x328	1		RDSO SPEC C-K201 X2 Cr Ni 12	0.15	
QTY	DESCRIPTION	DIMENSIONS	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:		
BRACKET FOR CABLE CLAMPING					SCALE	SSE/D	
					1:2	CHD	
					ALT.	ALTD	
						DRN	R.Santhosh kumar
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY CHENNAI - 600038				SHEET 1 OF 1			
					AAI14420		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

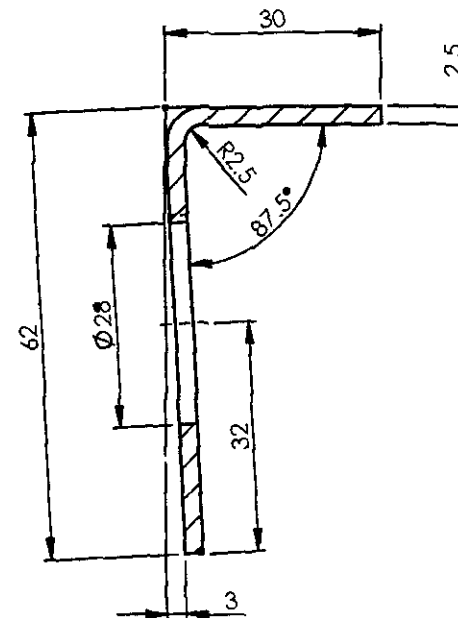
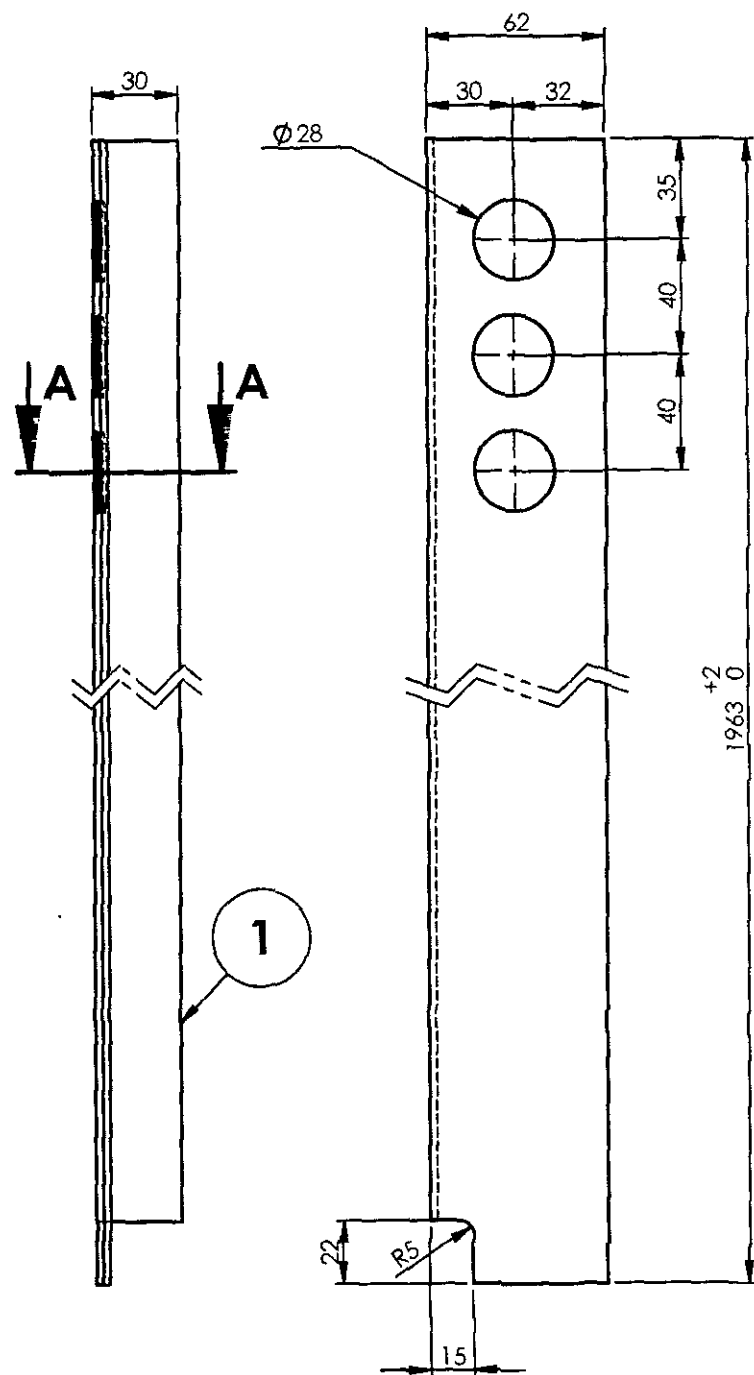
REF.DRG.NO.-

-	9 -05-2023	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

AAJ14241

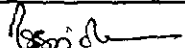
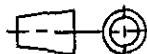
▽ ROUGH MACHINED	① ROUGH CLEANED
▽▽ FINISH MACHINED	①b BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	①c CHAMFERED

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE

SECTION A-A
SCALE 1 : 1

ISOMETRIC VIEW



1	ANGLE-LH	2.5x88x1963	1		RDSO/SPEC C- K201 X2CrNi12	3.387	
QTY	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-4 Body Side Walls		SURFACE AREA IN Sq.m.:0.350			WT/ASSY IN Kgs:		
ANGLE-LH					SCALE	SSE/D	
					1:2.5	CHD	
					ALT.	ALTD	-
						DRN	3D: R.SANTHOSH KUMAR 2D: KUNTI THAKUR
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1			
					AAJ14241		
							A3

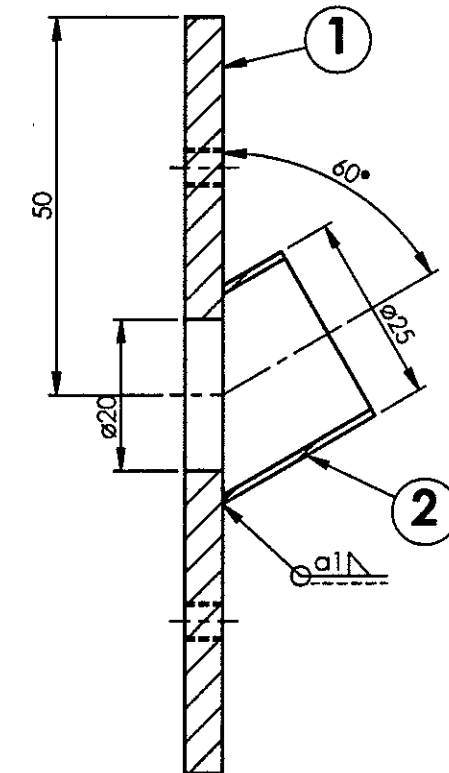
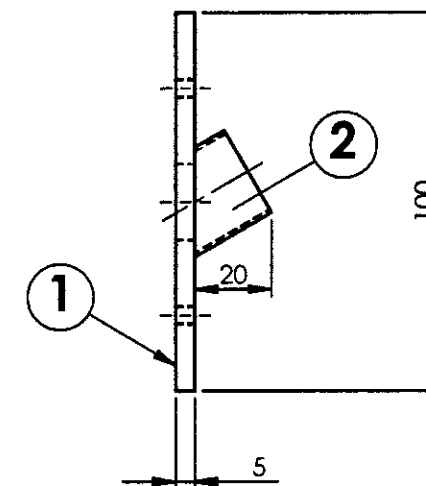
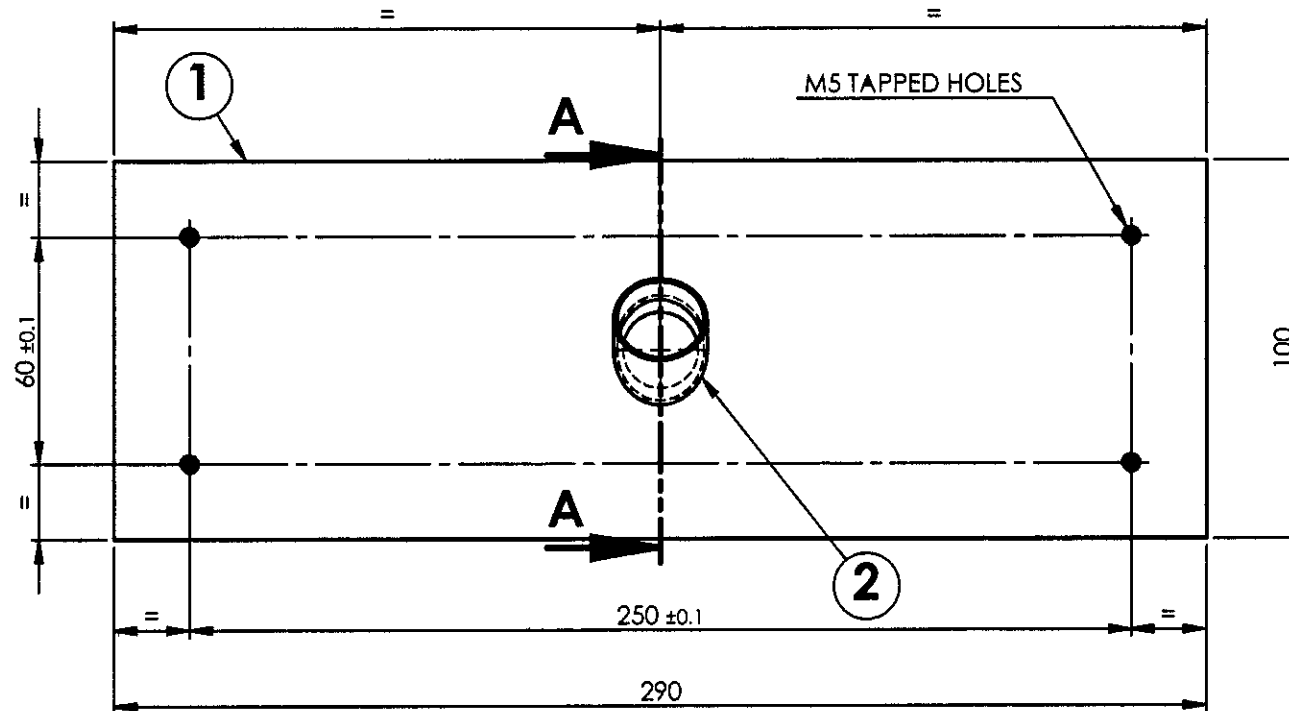
ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLEERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICF/STD-9-0-001.
ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER IS: 813-1986.

REF.DRG.NO.

AAJ14482

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

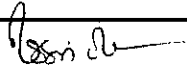
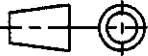
REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



SECTION A-A

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 THE THREADED HOLES SHALL BE PROVIDED WITH SUITABLE DUMMY BOLTS TO SAFEGUARD THREADS

1	PIPE	1xOD25x23	2		AISI-304	0.010		
1	BACKPIECE	5x100x290	1		RDSO/SPEC C-K 201 X2CrNi12	1.065		
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.:0.064			WT/ASSY IN Kgs:		
BACKPIECE FOR EXTERNAL EMERGENCY LIGHT FIXING						SCALE	SSE/D	
						1:1	CHD	
						ALT.	ALTD	-
						-	DRN	T.Ukkirapandian
INDIAN RAILWAY STANDARDS				SHEET 1 OF 1				
INTEGRAL COACH FACTORY, CHENNAI - 600038					AAJ14482		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.

-	26-07-2026	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

1

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3

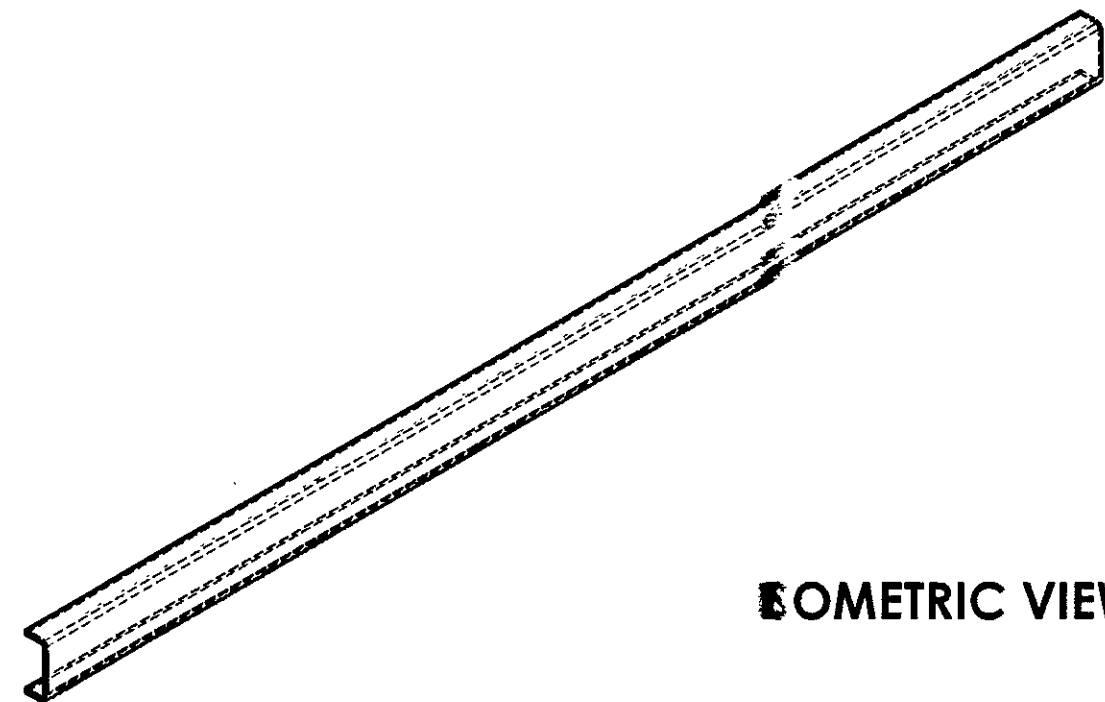
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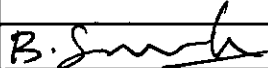
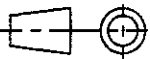
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1

01	ROUGH CLEANED
01b	BURRS REMOVED
18	CHAMFERED

APPROVED &
DATE



1	CHANNEL	3x78x1000	1		RDSO/SPEC CK-201 X2 Cr Ni 12	1.923	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REL. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-4 Body Side Walls		SURFACE AREA IN Sq. m.: 0.167			WT/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:5	CHD	
					ALT.	ALTD	
						DRN	R. SANTHOSH KUMAR
INDIAN RAILWAY STANDARDS				SHEET 1 OF 1			
INTEGRAL COACH FACTORY, CHENNAI - 600038					AAK14100		A3

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REF.DRG.NO.-

DATE LATEST ALT.

DATE OF FIRST ISSUE

AME/SME

INDIAN RAILWAY STANDARDS
INTEGRAL COACH FACTORY, CHENNAI - 600038

SHEET
1 OF 1

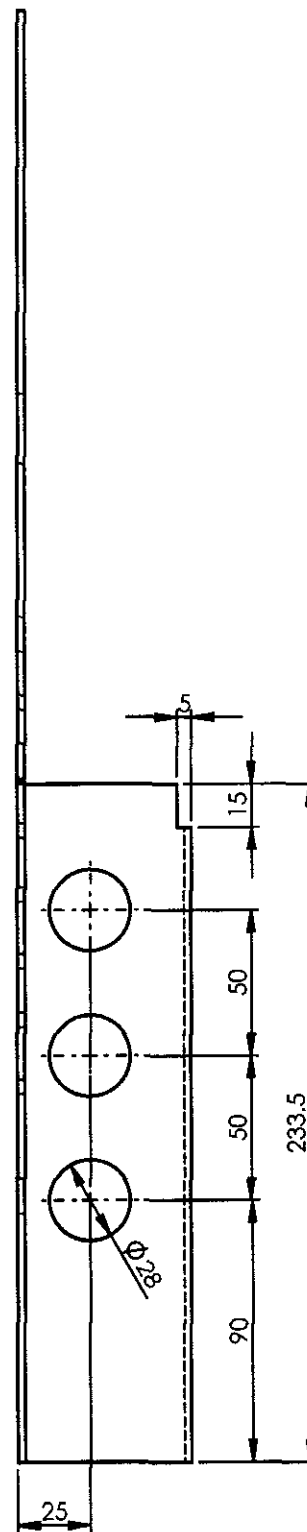
AAK14100


A3

1		2		3		4		5		6		7		8		
AAK14209				▽ ROUGH MACHINED		① ROUGH CLEANED		REVISIONS								
				▽▽ FINISH MACHINED		①b BURRS REMOVED		ALT.		ZONE		DESCRIPTION			APPROVED & DATE	
				▽▽▽ FINE FINISH MACHINED		①c CHAMFERED										
<div><div>1</div><div><div><div></div><div></div><div></div></div><div>1340</div></div><div><div><div></div><div></div><div></div></div><div>55</div></div></div>																
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<div><div>INDIAN RAILWAY STANDARDS</div><div>INTEGRAL COACH FACTORY, CHENNAI - 600038</div></div>																
<div><div>12-02-2025</div><div>DATE OF LATEST ALT.</div><div>DATE OF FIRST ISSUE</div><div>AME/SME</div></div>																
<div><div>1</div><div>CHANNEL</div><div>3X153X1340</div><div>1</div><div>ITEM NO.</div><div>REF. DRGS</div><div>RDSO/SPEC C-K201 X2CrNi12</div><div>4.934</div><div>WT/UNIT IN KGS</div><div>REMARKS</div></div>																
<div><div>GROUP: 1-4 Body Side Walls</div><div>SURFACE AREA IN Sq.m.:0.420</div><div>WT/ASSY IN Kgs:4.934</div></div>																
<div><div>CHANNEL</div><div>SCALE 1:2.5</div><div>SSE/D</div><div>CHD</div><div>ALT.</div><div>ALTD</div><div>DRN</div><div>R. SANTHOSH KUMAR</div></div>																
<div><div>INDIAN RAILWAY STANDARDS</div><div>INTEGRAL COACH FACTORY, CHENNAI - 600038</div><div>SHEET 1 OF 1</div><div>AAK14209</div><div>A3</div></div>																
1		2		3		4		5		6		7		8		

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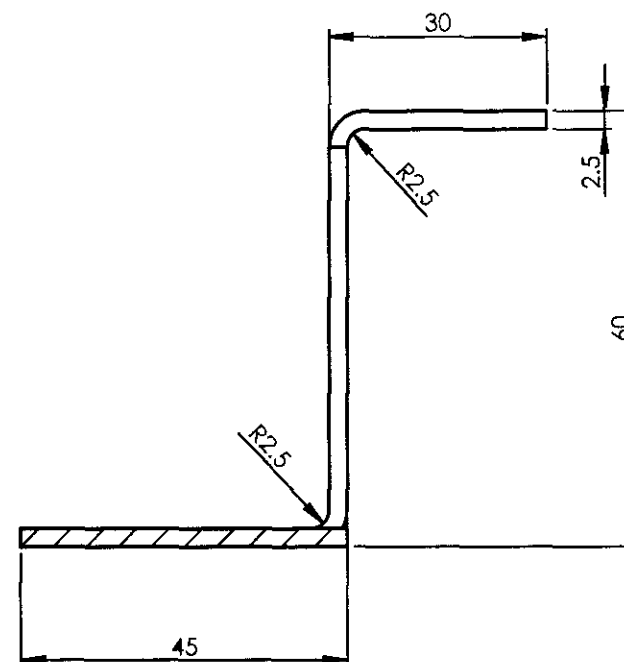
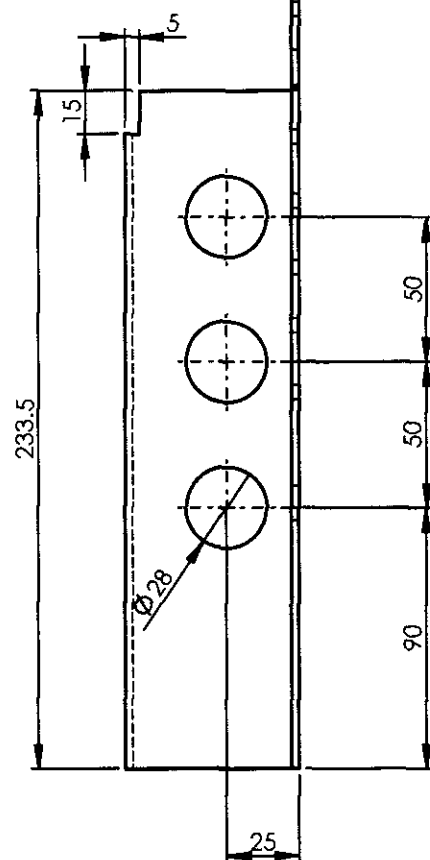
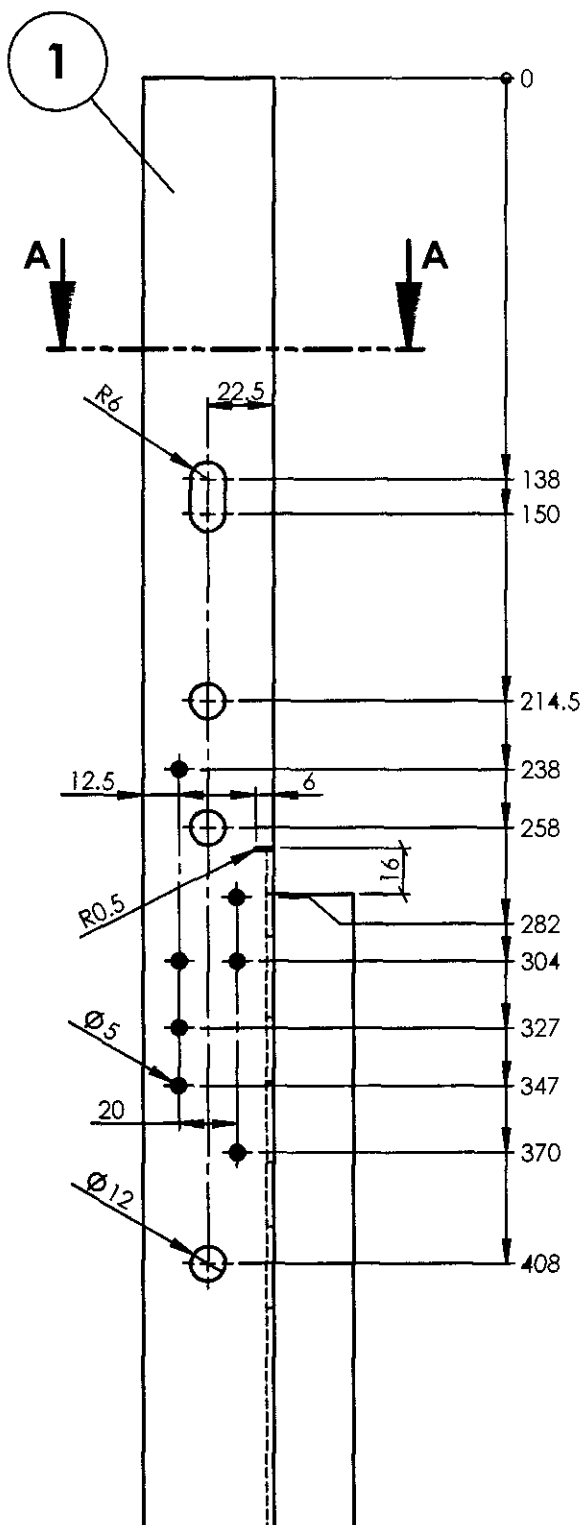
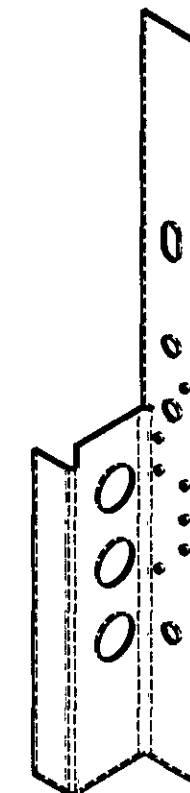
-	16-07-2025	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	A.M.E./S.M.E.

AAK14402

▽ 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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SECTION A-A
SCALE 1 : 1







ISOMETRIC VIEW

1	PART PILLAR TOP (L.H.)	2.5x125x499.5	1		RDSO/SPEC C-K201 X2CrNi12	0.77	
QTY	DESCRIPTION	DIMENSIONS	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:	
PART PILLAR TOP					SCALE	SSE/D	3D: R. SANTHOSH KUMAR 2D: KUNTI THAKUR
					1:2.5	CHD	
					ALT.	ALTD	
						DRN	
INDIAN RAILWAY STANDARDS					SHEET 1 OF 1		
INTEGRAL COACH FACTORY CHENNAI - 600038					AAK14402		
					A3		

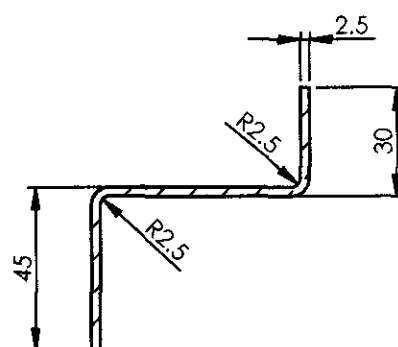
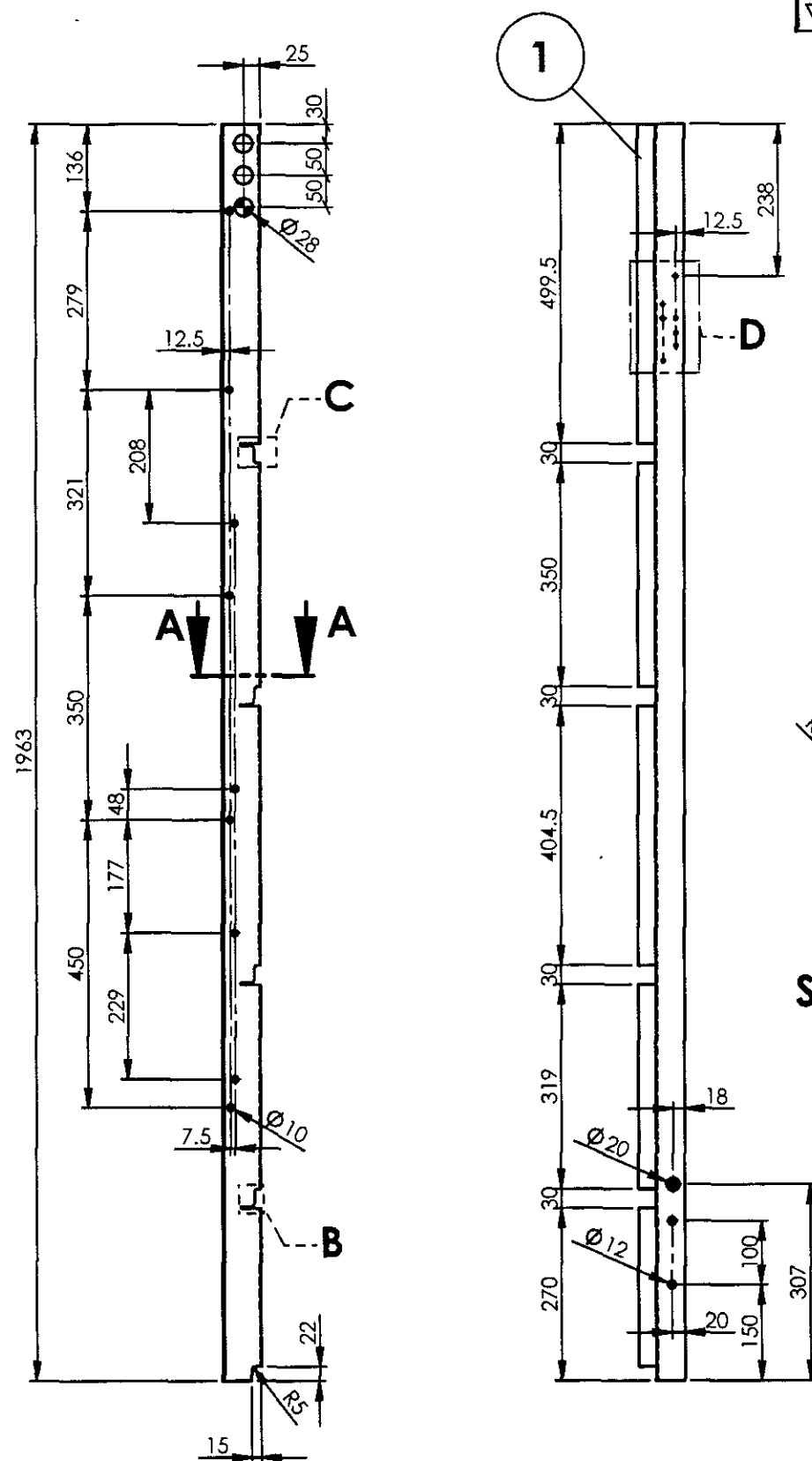
ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICF/STD-9-0-001.
ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER IS: 813-1986.
WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY

REF.DRG.NO.

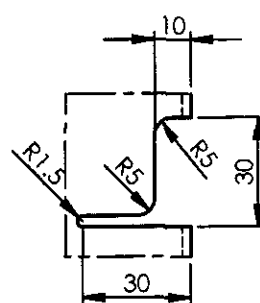
	16-07-2025	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

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

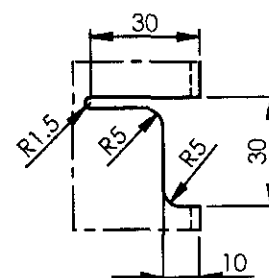
REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



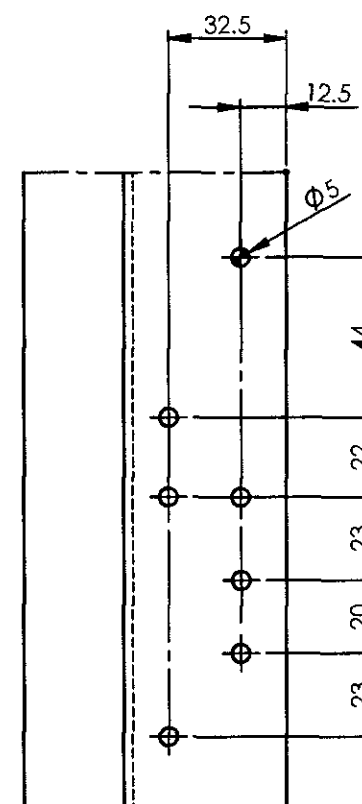
SECTION A-A
SCALE 1 : 2



DETAIL B
SCALE 1 : 2



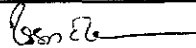
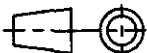
DETAIL C
SCALE 1 : 2



DETAIL D
SCALE 1 : 2

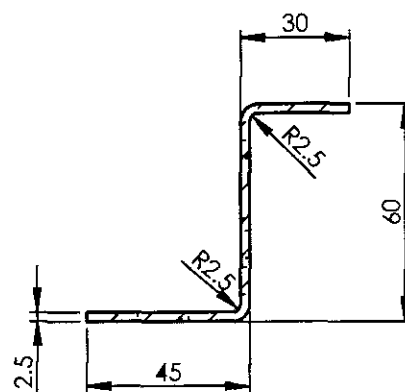


ISOMETRIC VIEW

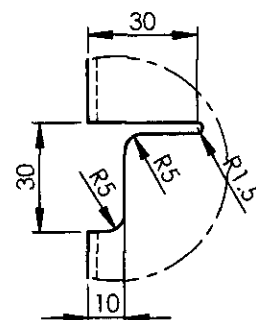
1	PILLAR(R.H)	2.5x125x1963	1		RDSO/SPEC C-K201 X2CrNi12	4.804	
QTY	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-4 Body Side Walls		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
PILLAR(R.H)					SCALE	SSE/D	
					1:10	CHD	
					ALT.	ALTD	-
					DRN	3D: R. SANTHOSH KUMAR 2D: KUNTI THAKUR	
INDIAN RAILWAY STANDARDS				SHEET 1 OF 1			
INTEGRAL COACH FACTORY, CHENNAI - 600034					AAK14403		A3

ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER IS: 813-1986.
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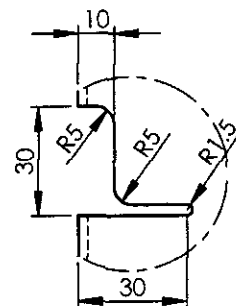
REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



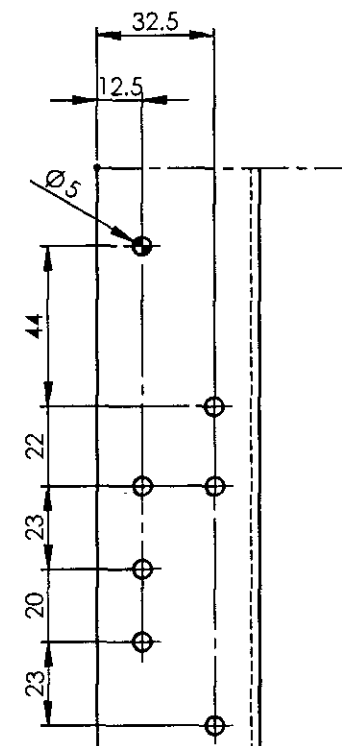
SECTION A-A
SCALE 1 : 2



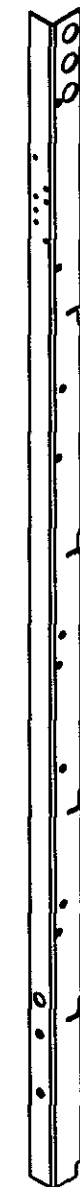
DETAIL B
SCALE 1 : 2




DETAIL C
SCALE 1 : 2



DETAIL D
SCALE 1 : 2



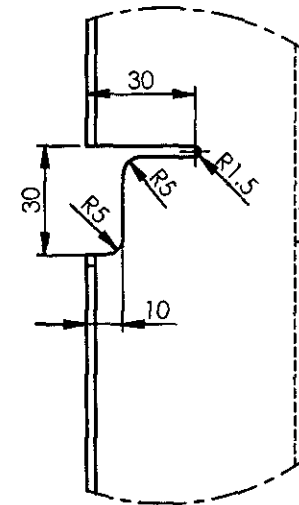
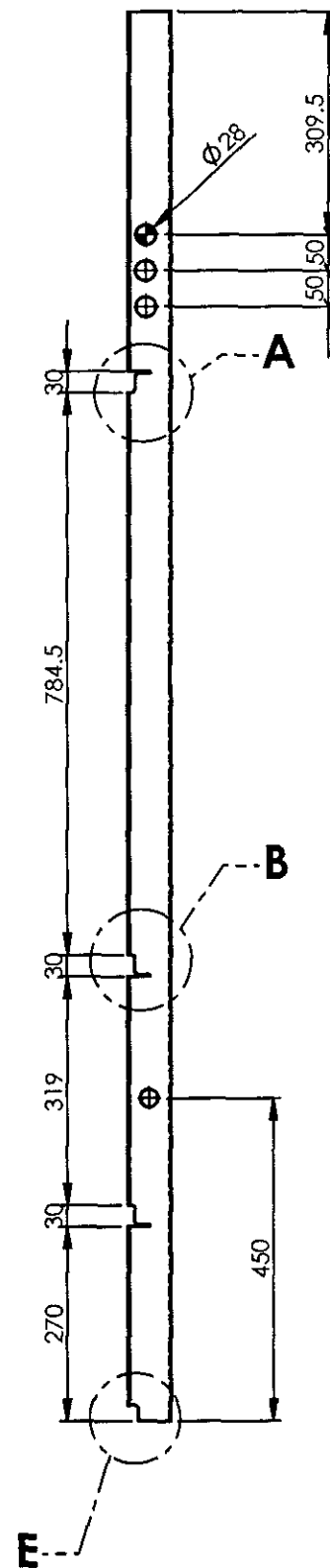
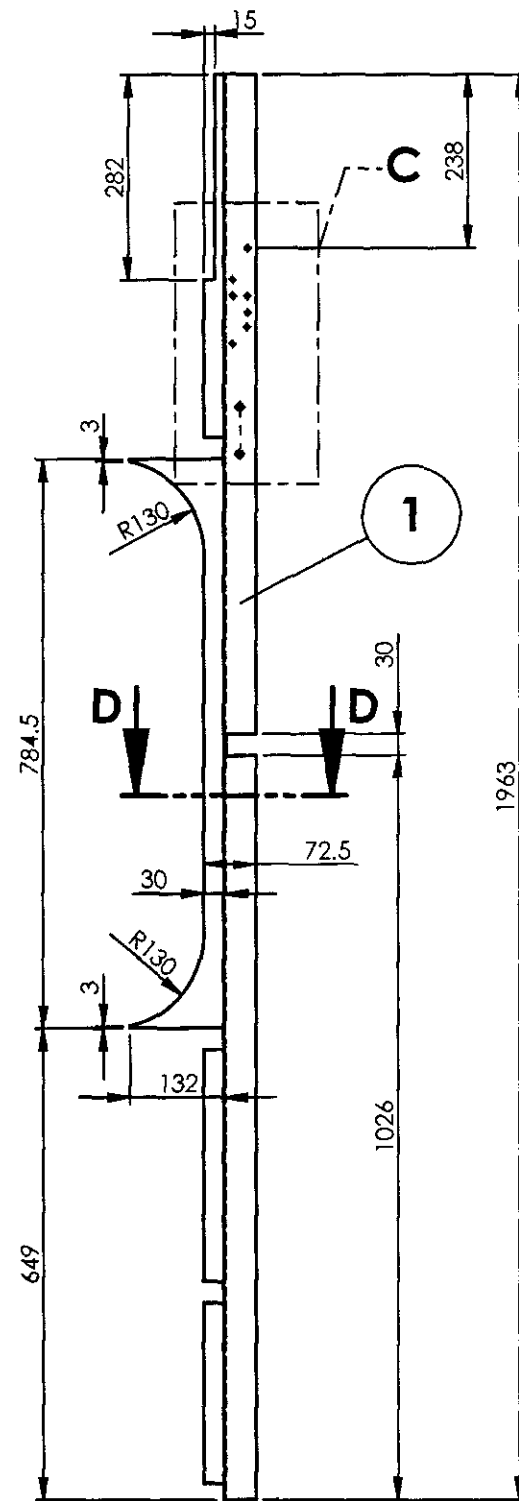
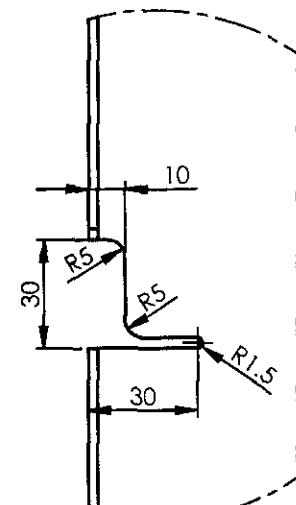
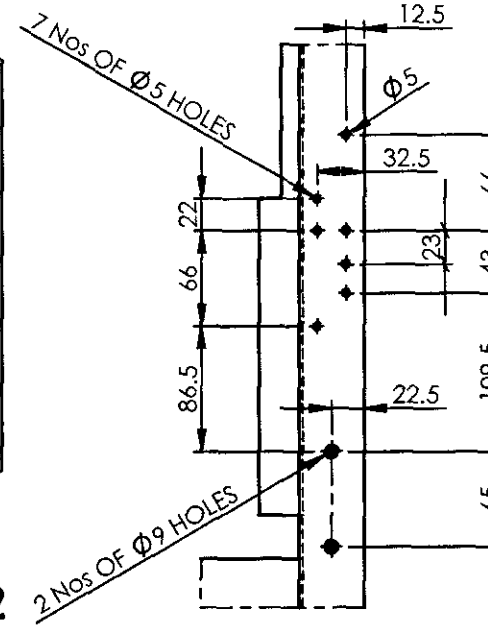
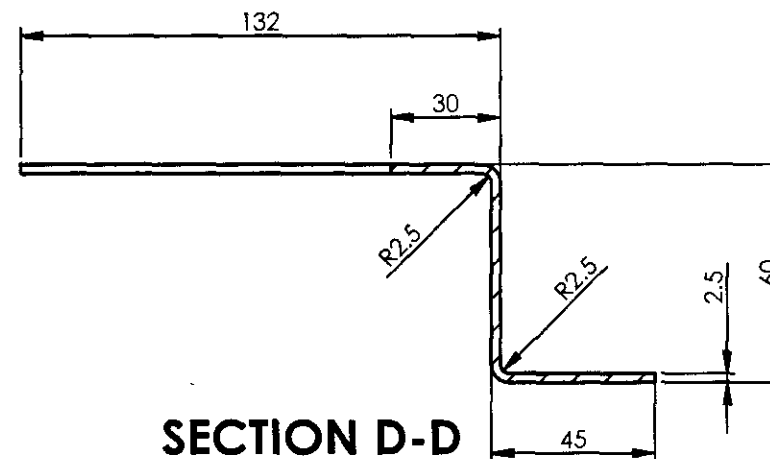
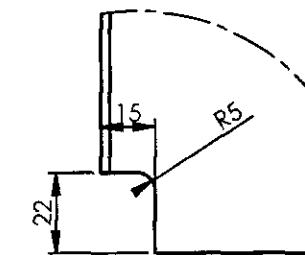
ISOMETRIC VIEW

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

AAK14406

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

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE







DETAIL A
SCALE 1 : 2DETAIL B
SCALE 1 : 2DETAIL C
SCALE 1 : 5SECTION D-D
SCALE 1 : 2DETAIL E
SCALE 1 : 2

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

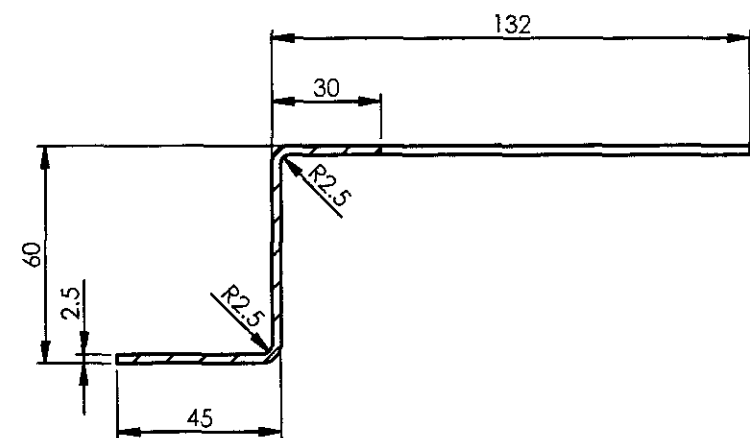
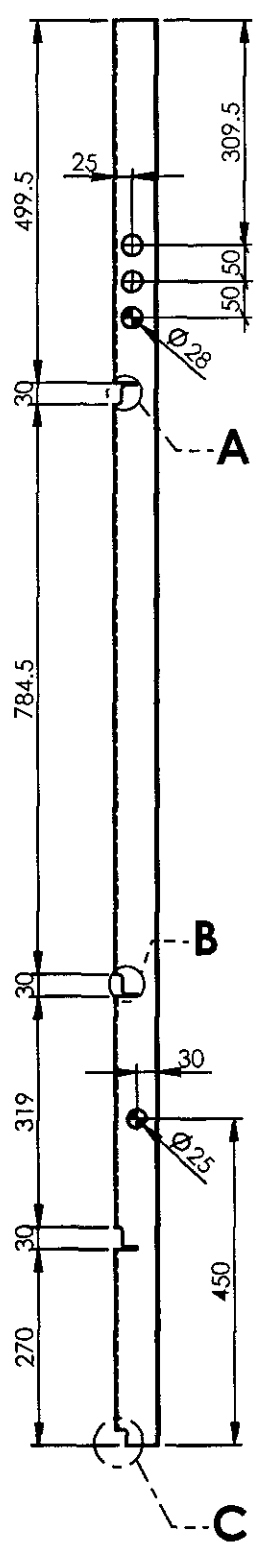
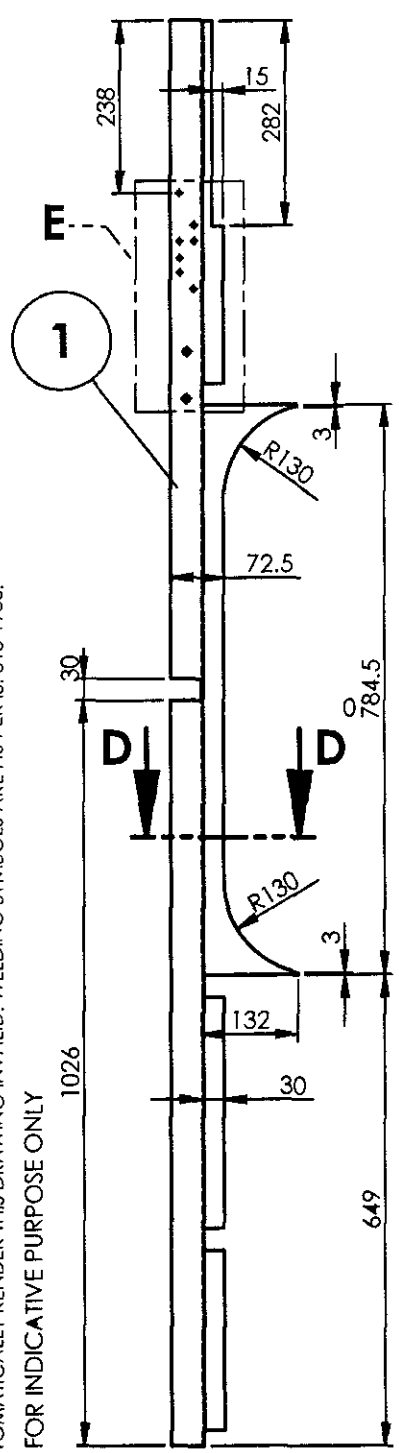
REF.DRG.NO.

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

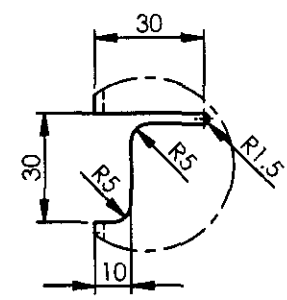
1	PILLAR RIGHT	2.5x227.5x1963	1		RDSO SPEC C-K201 X2 Cr Ni 12	4.872	
QTY	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-4 Body Side Walls				SURFACE AREA IN Sq.m.:0.501		WT/ASSY IN Kgs:	
PILLAR RIGHT					SCALE	SSE/D	
					1:20	CHD	
					ALT.	ALTD	
INDIAN RAILWAY STANDARDS					DRN	R. SANTHOSH KUMAR	
					SHEET 1 OF 1		
INTEGRAL COACH FACTORY, CHENNAI - 600038					AAK14406		
					A3		

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

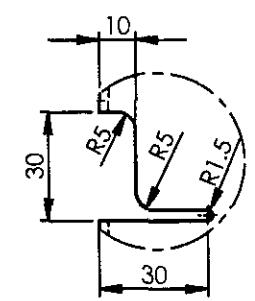
REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



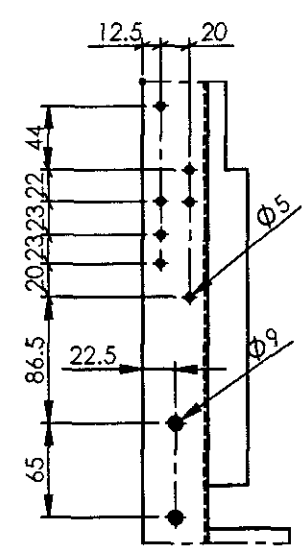
SECTION D-D
SCALE 1 : 2



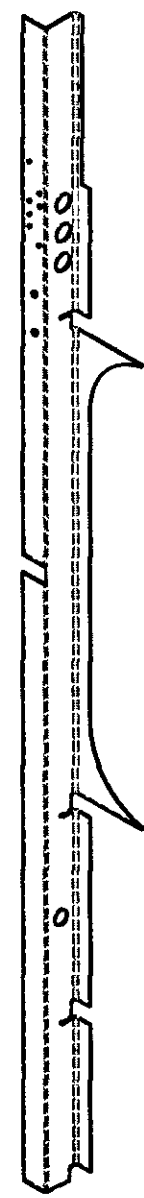
DETAIL A
SCALE 1 : 2




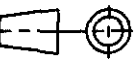
DETAIL B
SCALE 1 : 2



DETAIL E
SCALE 1 : 5



ISOMETRIC VIEW

1	PILLAR LEFT	2.5x227.5x1963	1		RDSO/SPEC C-K201 X2CrNi12	5.014	
QTY	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-4 Body Side Walls		SURFACE AREA IN Sq.m.:500741.19			WT/ASSY IN Kgs:		
PILLAR LEFT					SCALE	SSE/D	
					1:10	CHD	
					ALT.	ALTD	-
						DRN	R. SANTHOSH KUMAR
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600035				SHEET 1 OF 1			
					AAK14407		A3

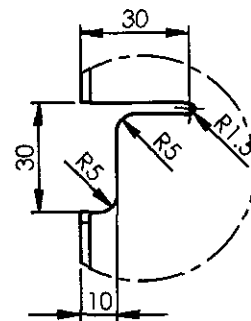
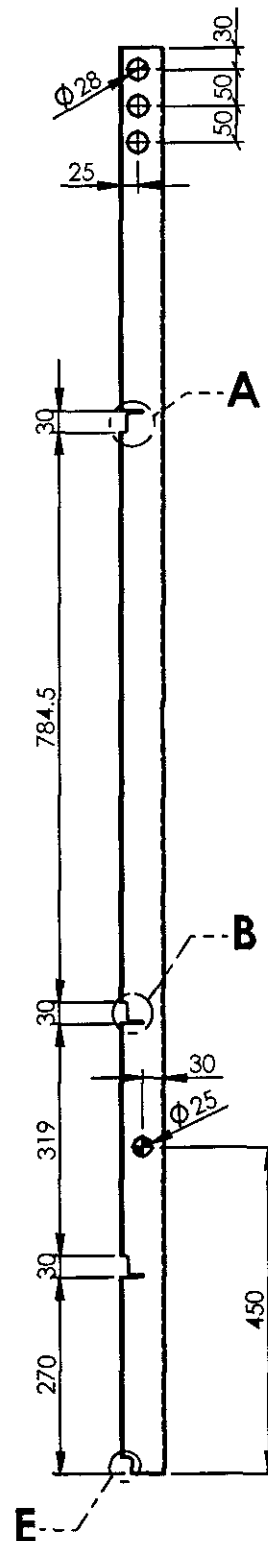
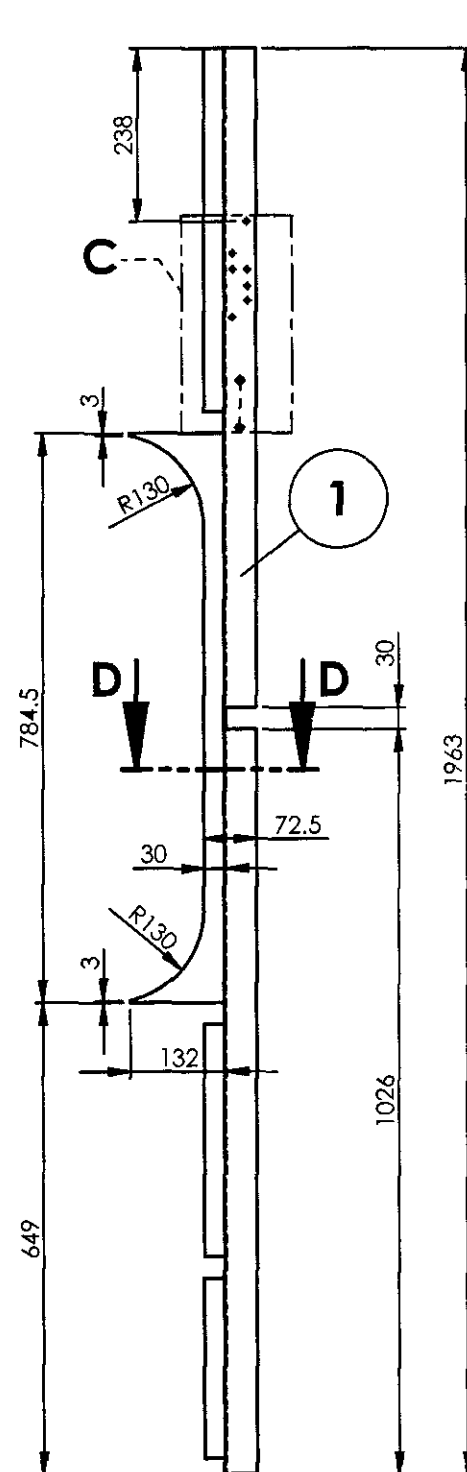
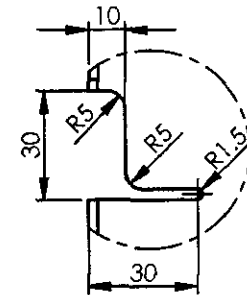
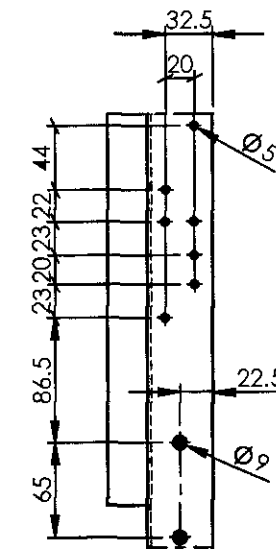
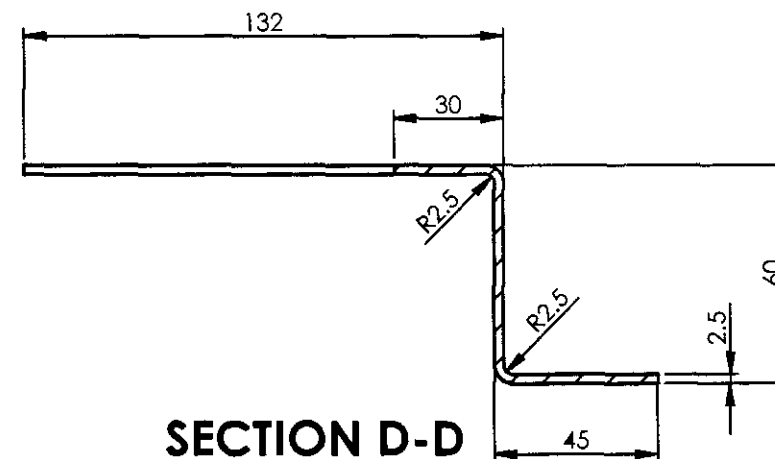
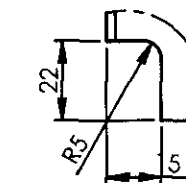
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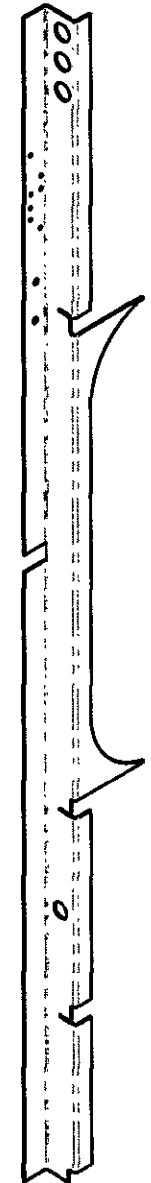
AAK14416

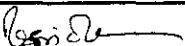
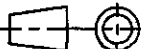
▽ ROUGH MACHINED	① ROUGH CLEANED
▽▽ FINISH MACHINED	② BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	③ CHAMFERED

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE

DETAIL A
SCALE 1 : 2DETAIL B
SCALE 1 : 2DETAIL C
SCALE 1 : 5SECTION D-D
SCALE 1 : 2DETAIL E
SCALE 1 : 2

ISOMETRIC VIEW









1	PILLAR RIGHT	2.5x227.5x1963	1		RDSO SPEC C-K201 X2 Cr Ni 12	4.957	
QTY	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-4 Body Side Walls		SURFACE AREA IN Sq.m.:0.509			WT/ASSY IN Kgs:		
PILLAR RIGHT					SCALE	SSE/D	
					1:10	CHD	
					ALT.	ALTD	-
						DRN	3D: R. SANTHOSH KUMAR 2D: KUNTI THAKUR
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1			
					AAK14416		A3

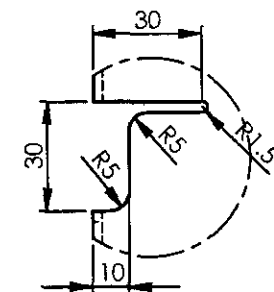
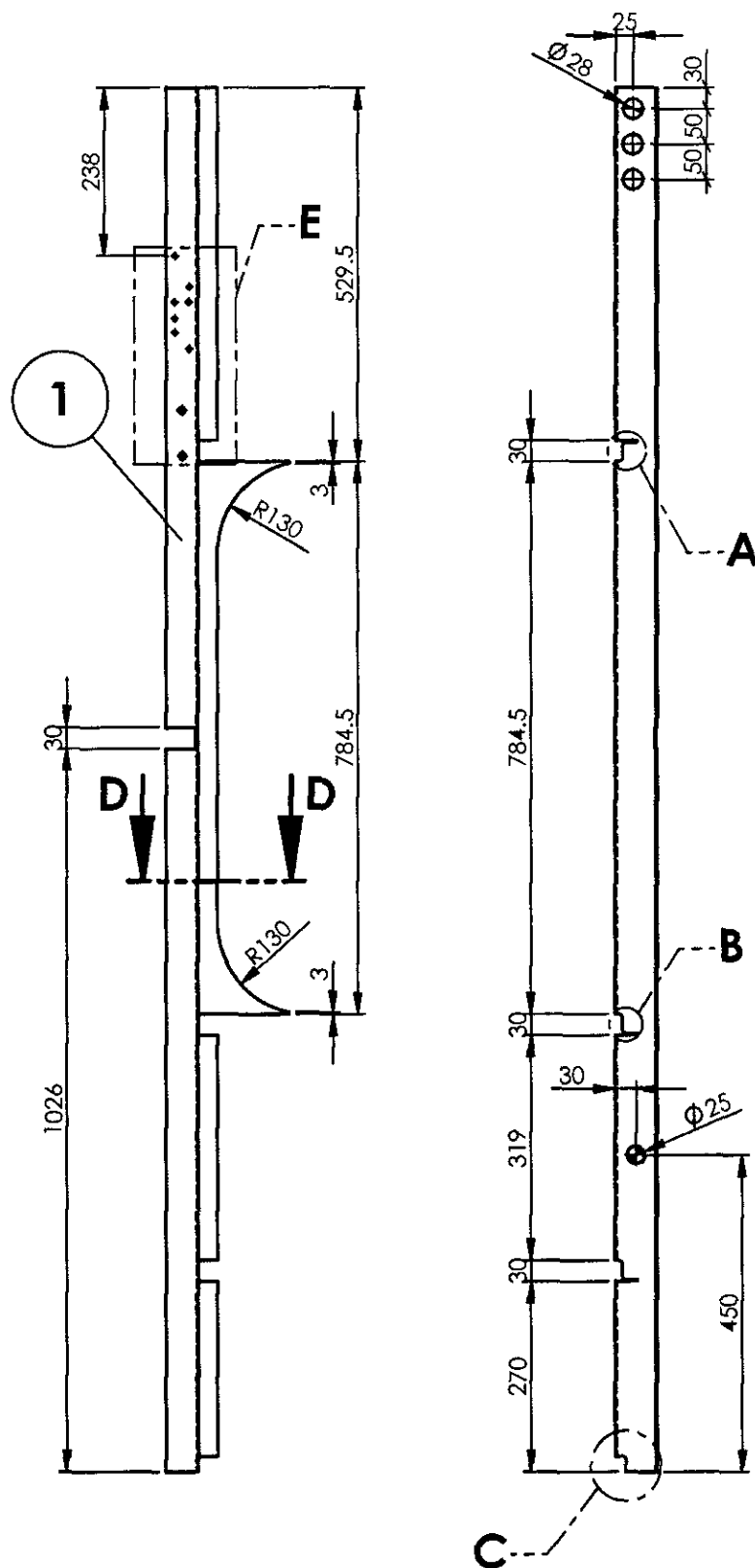
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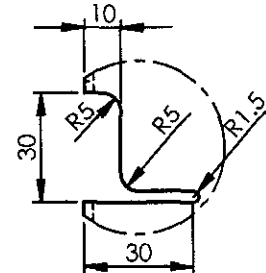
-	16-07-2025	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

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

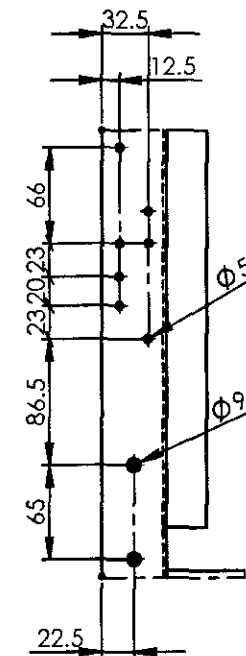
REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



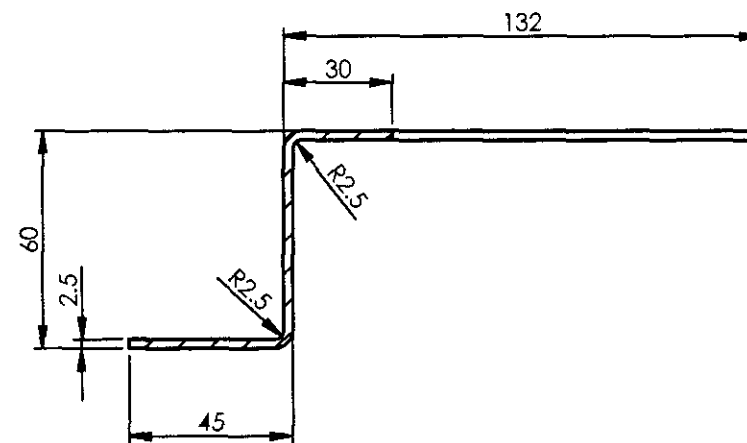
DETAIL A
SCALE 1 : 2



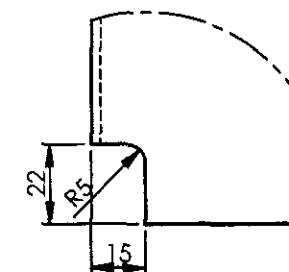
DETAIL B
SCALE 1 : 2



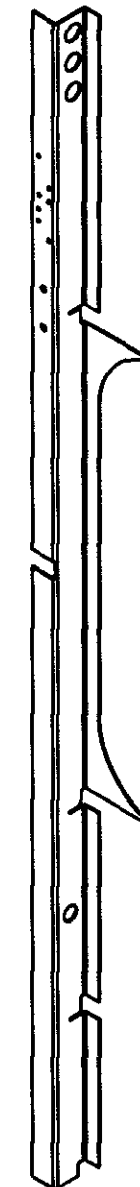
DETAIL E
SCALE 1 : 5



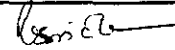

SECTION D-D
SCALE 1 : 2



DETAIL C
SCALE 1 : 2



ISOMETRIC VIEW

1	PILLAR LEFT	2.5x227.5x1963	1		RDSO SPEC C-K201 X2 Cr Ni 12	4.96	
QTY	DESCRIPTION	DIMENSIONS	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:		
PILLAR LEFT					SCALE	SSE/D	
					1:10	CHD	
					ALT.	ALTD	-
						DRN	3D: R. SANTHOSH KUMAR 2D: KUNTI THAKUR
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1			
					AAK14417		A3

AAK14418

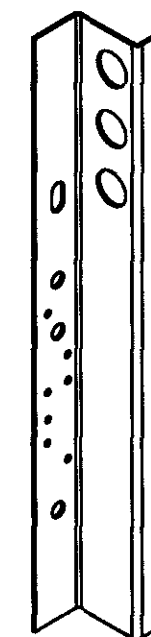
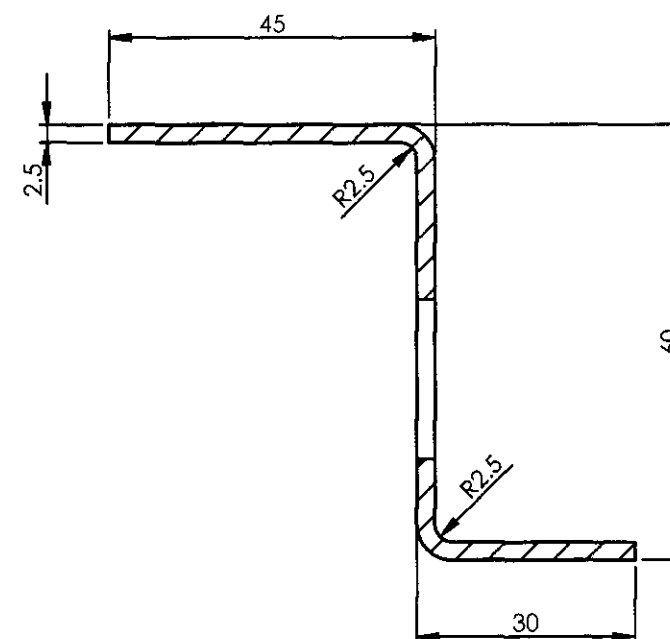
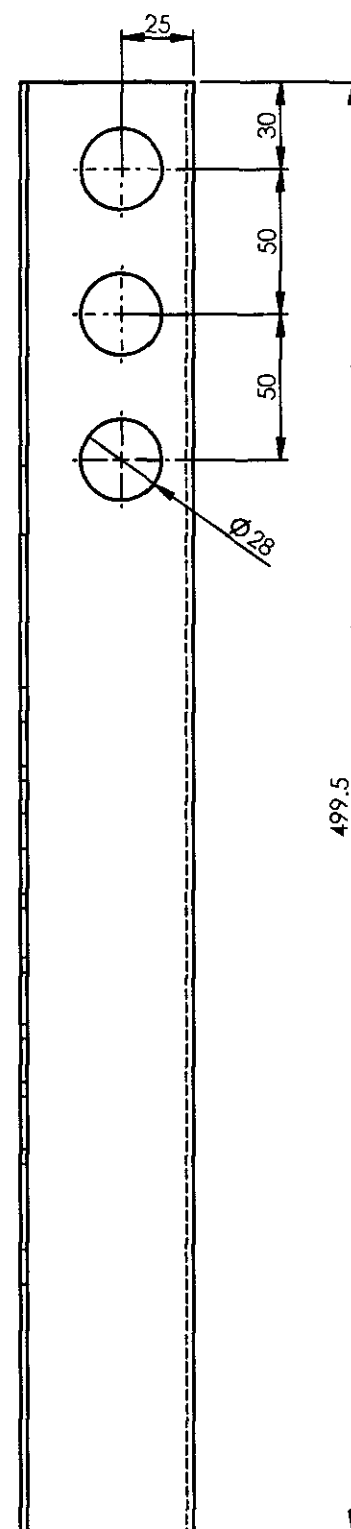
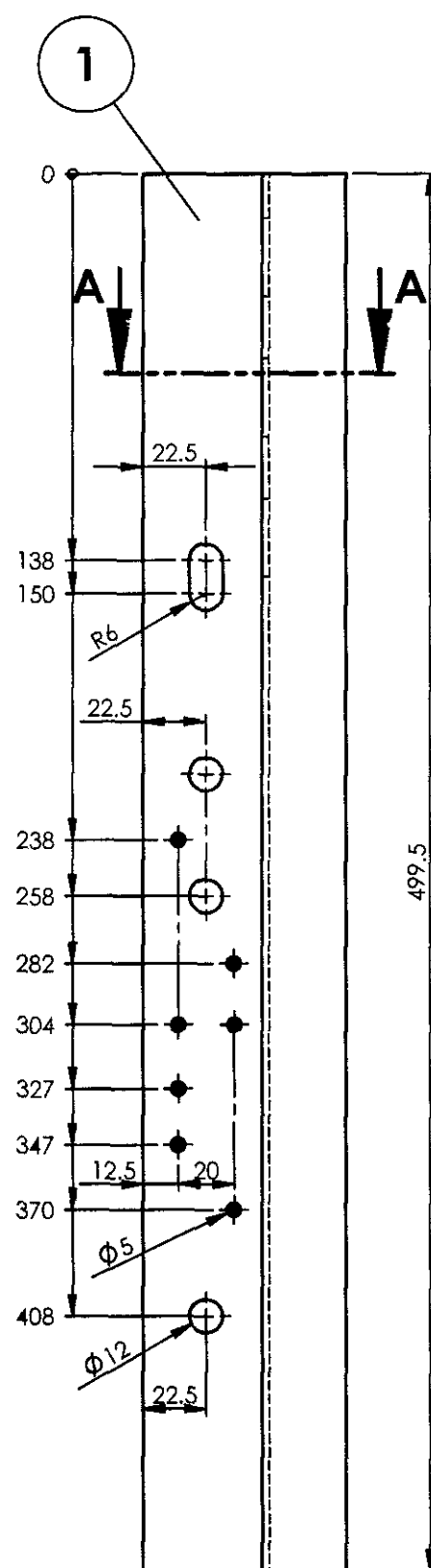
▽ ROUGH MACHINED	① ROUGH CLEANED
▽▽ FINISH MACHINED	①b BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	①c CHAMFERED

REVISIONS

ALT.

ZONE

DESCRIPTION

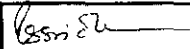
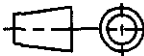
APPROVED &
DATE

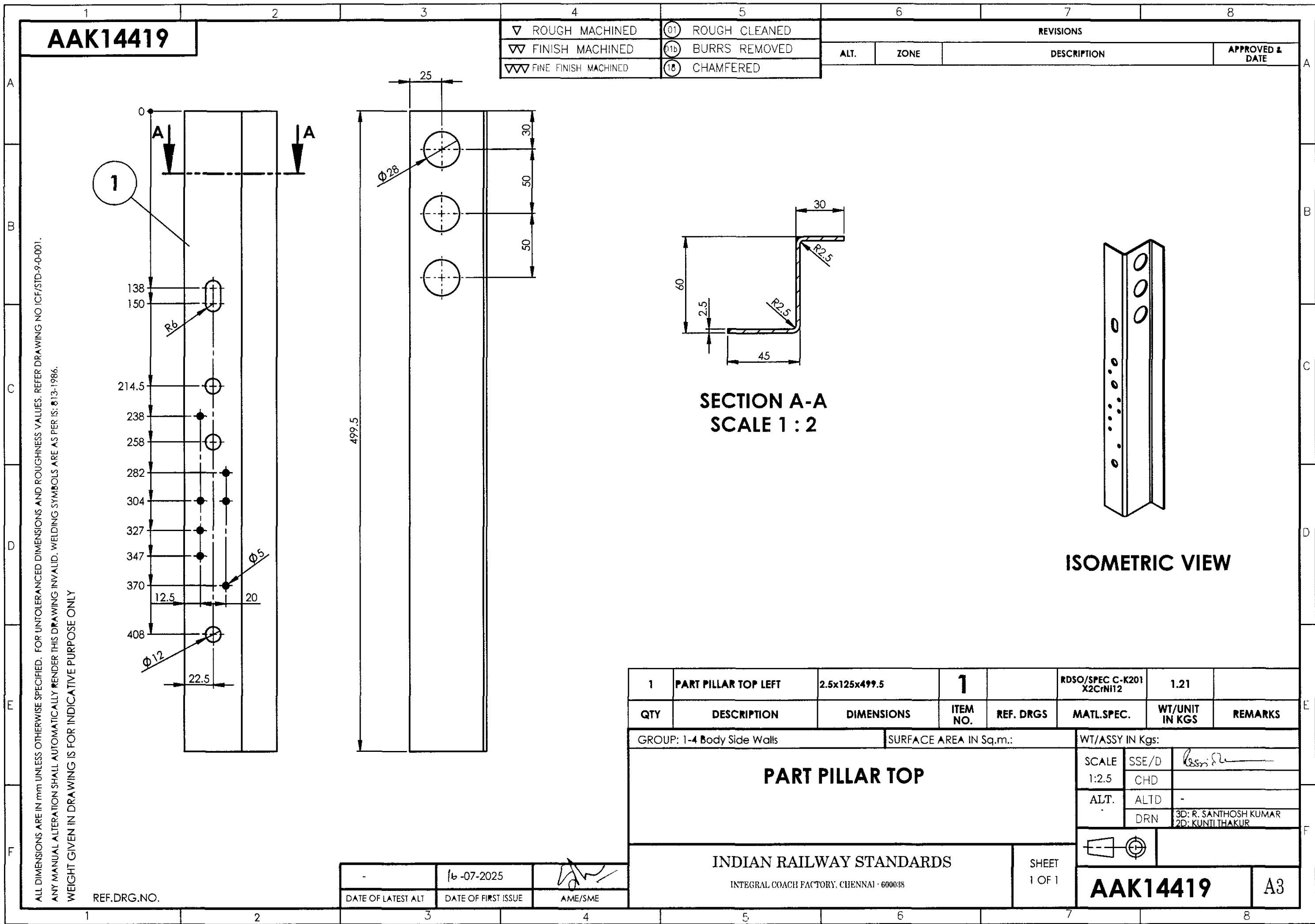
ISOMETRIC VIEW

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REF.DRG.NO.

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

1	PART PILLAR TOP RIGHT	2.5x125x499.5	1		RDSO/SPEC C- K201 X2CrNi12	1.215	
QTY	DESCRIPTION	DIMENSIONS	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:		
PART PILLAR TOP					SCALE	SSE/D	
					1:2.5	CHD	
					ALT.	ALTD	-
					DRN	3D: R. SANTHOSH KUMAR 2D: KUNTI THAKUR	
							
INDIAN RAILWAY STANDARDS				SHEET 1 OF 1			
INTEGRAL COACH FACTORY, CHENNAI - 600038							
					AAK14418		A3

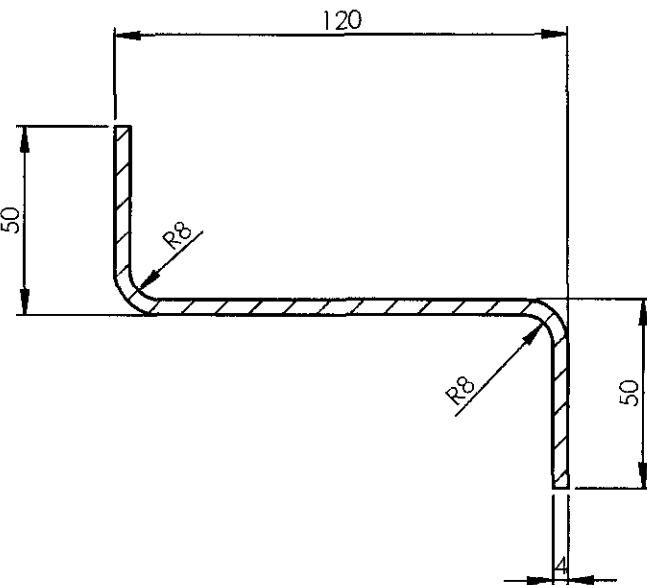
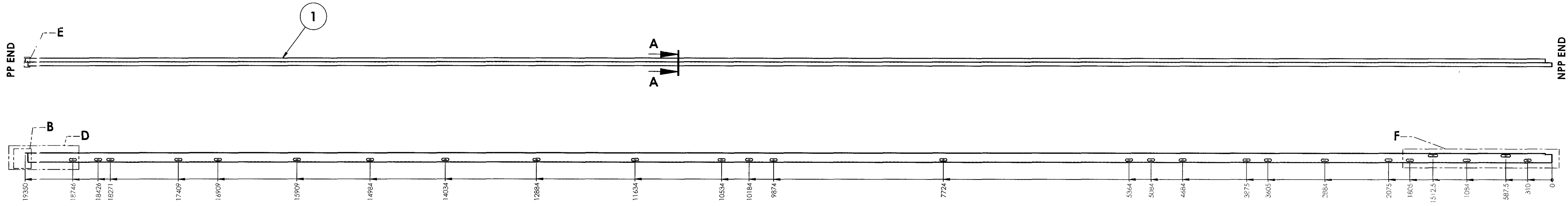


AAK14507

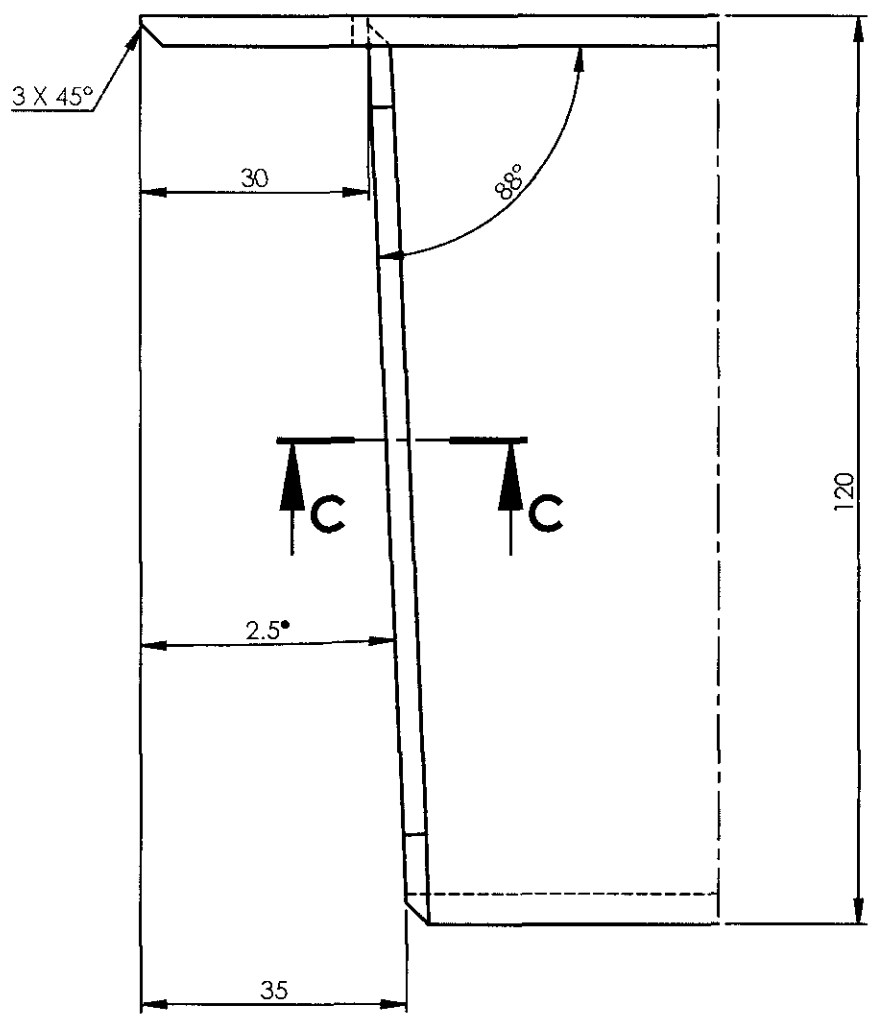
▽ ROUGH MACHINED
▽▽ FINISH MACHINED
▽▽▽ FINE FINISH MACHINED

⑪ ROUGH CLEANED
⑫ BURRS REMOVED
⑬ CHAMFERED

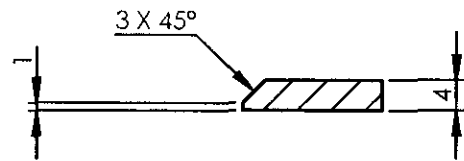
REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



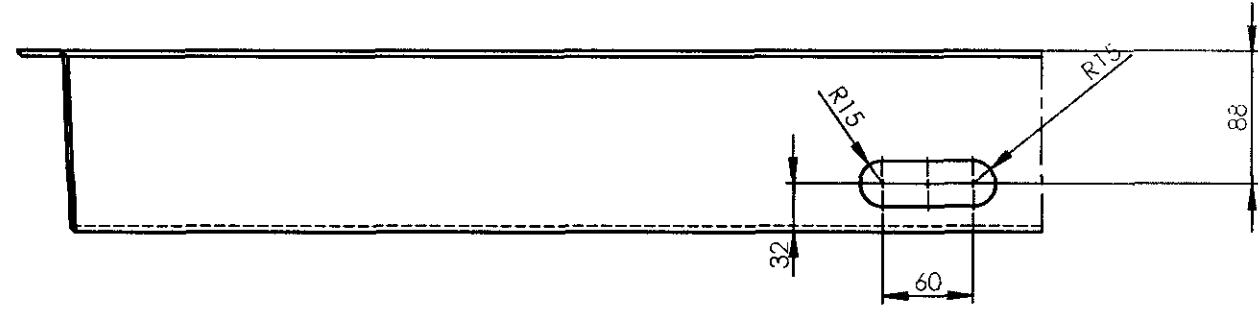
SECTION A-A
SCALE 1 : 2



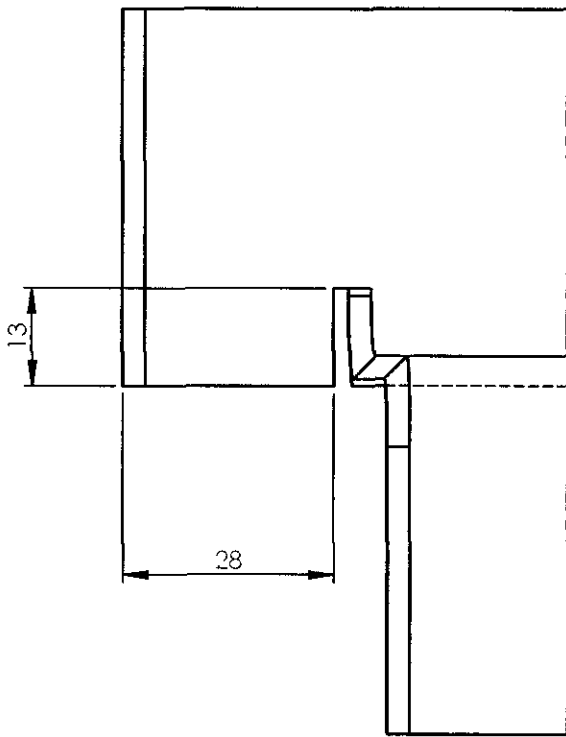
DETAIL B
SCALE 1 : 1



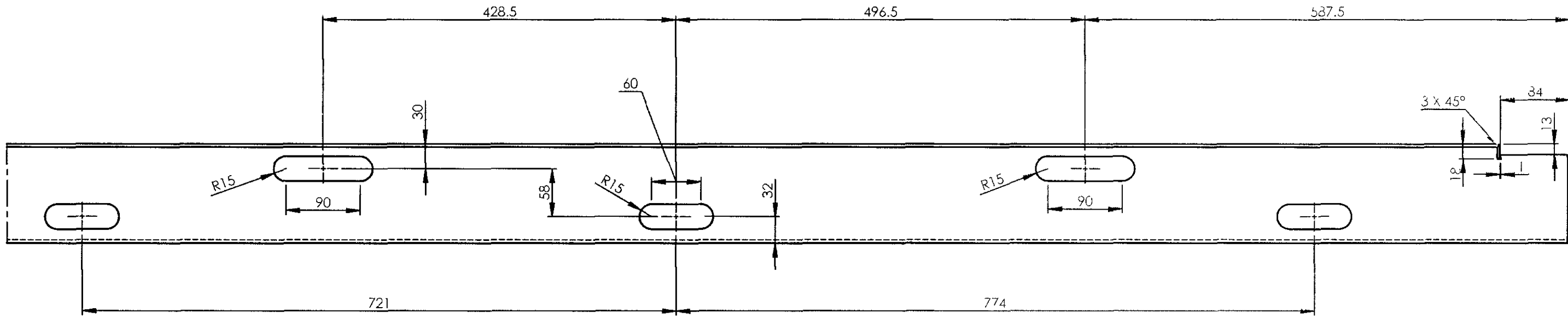
SECTION C-C
SCALE 1 : 1



DETAIL D
SCALE 1 : 5



DETAIL E
SCALE 1 : 1



DETAIL F
SCALE 1 : 5

ISOMETRIC VIEW

ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICF/STD-90-001. 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.

1	ROOF FLANGE(CRF)	4x204x19350	1		RDSO/SPEC C-K201 X2CrNi12	123.48	
QTY	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATLSPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-4 Body Side Walls					SURFACE AREA IN Sq.m:		
ROOF FLANGE(CRF)					SCALE 1:25	DATE	DRN
					ALT	ALTD	DRN
					ALT	ALTD	DRN
					ALT	ALTD	DRN
INDIAN RAILWAY STANDARDS					SHEET 1 OF 1		
INTEGRAL COACH FACTORY, CHENNAI - 600038					AAK14507		
REF.DRG.NO.:					A1		

DATE OF LATEST ALT.	16-08-2025	DATE OF FIRST ISSUE	01-08-2025	AME/ANF
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AAK14508

▽ ROUGH MACHINED

▽ FINISH MACHINED

▽▽ FINE FINISH MACHINED

① ROUGH CLEANED

①b BURRS REMOVED

①8 CHAMFERED

REVISIONS

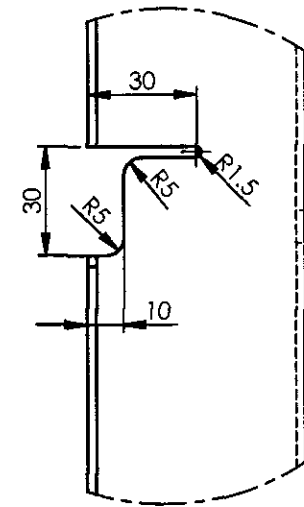
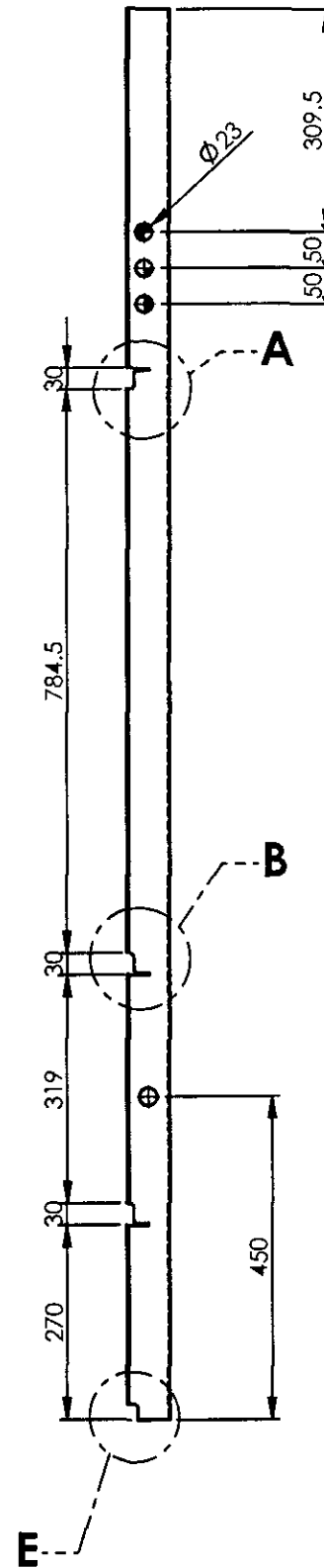
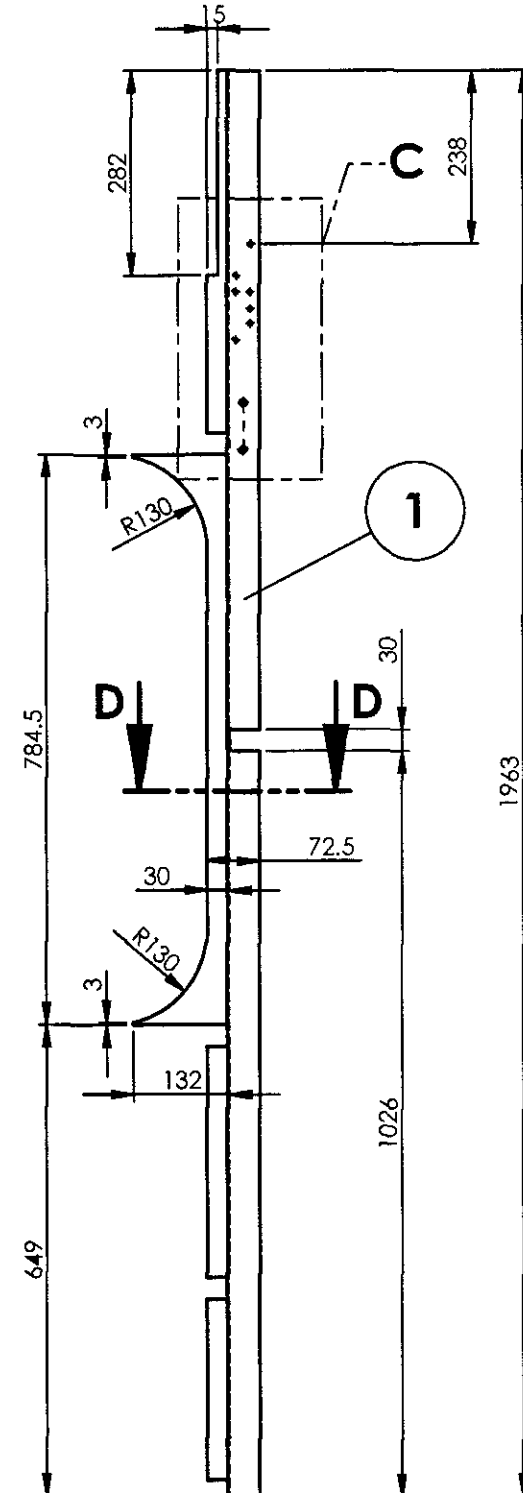
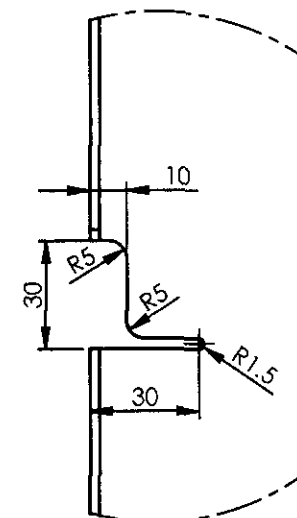
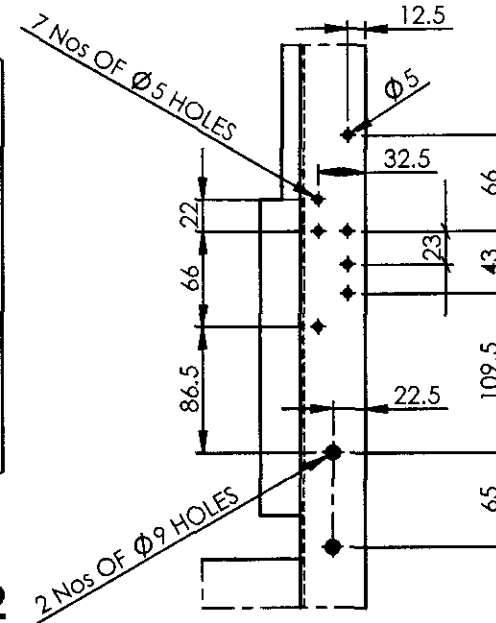
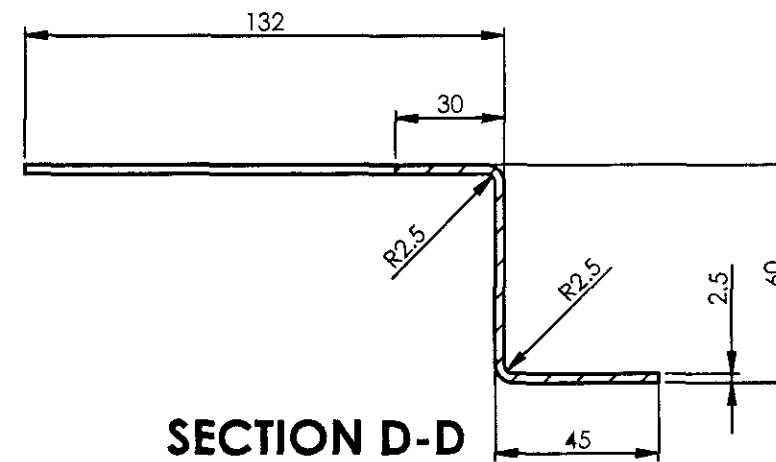
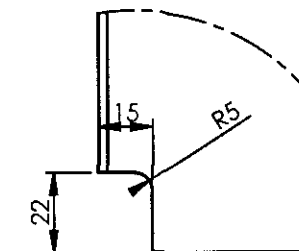
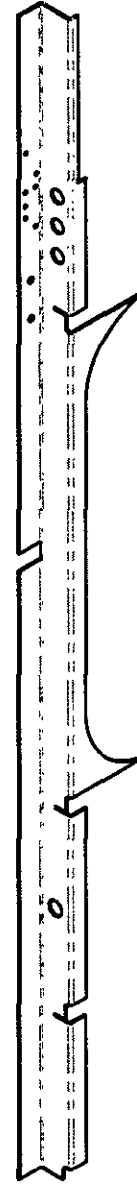
ALT.

ZONE

DESCRIPTION

APPROVED &
DATE

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DETAIL A
SCALE 1 : 2DETAIL B
SCALE 1 : 2DETAIL C
SCALE 1 : 5SECTION D-D
SCALE 1 : 2DETAIL E
SCALE 1 : 2

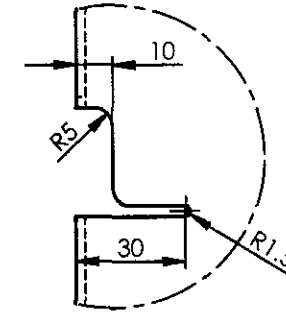
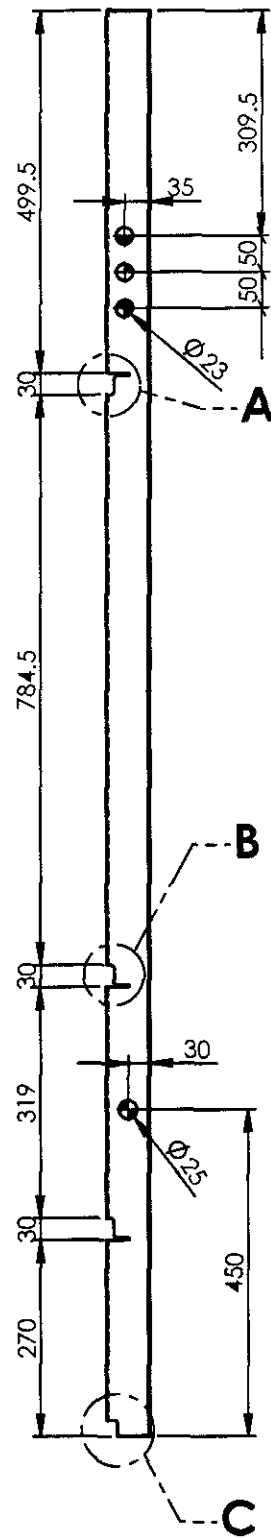
1	PILLAR R.H.	2.5x227.5x1943	1		RDSO SPEC C- K201 X2 Cr Ni 12	4.884	
QTY	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-4 Body Side Walls				SURFACE AREA IN Sq.m.:0.502		WT/ASSY IN Kgs:	
PILLAR R.H.					SCALE	SSE/D	1:20
					ALT.	CHD	
						ALTD	-
						DRN	R. SANTHOSH KUMAR
INDIAN RAILWAY STANDARDS					SHEET 1 OF 1		
INTEGRAL COACH FACTORY, CHENNAI - 600038					AAK14508		
					A3		

REF.DRG.NO.AAH14545

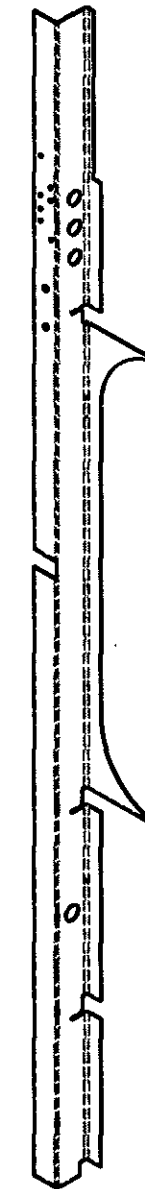
-	16-07-2025	
DATE OF LATEST ALT	DATE OF FIRST ISSUE	AME/SME


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

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



DETAIL B
SCALE 1 : 2



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

AAK14510

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

① ROUGH CLEANED
② BURRS REMOVED
③ CHAMFERED

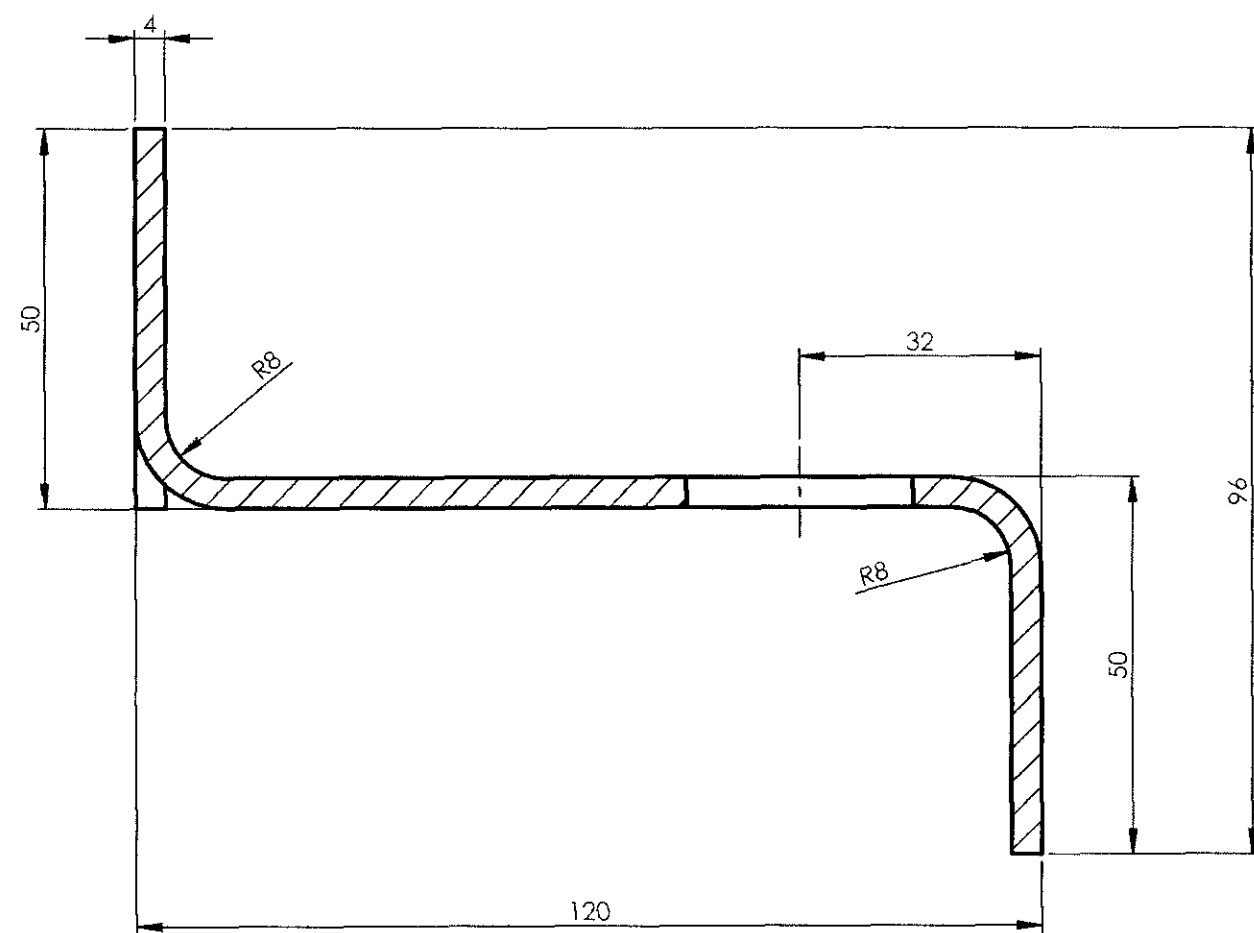
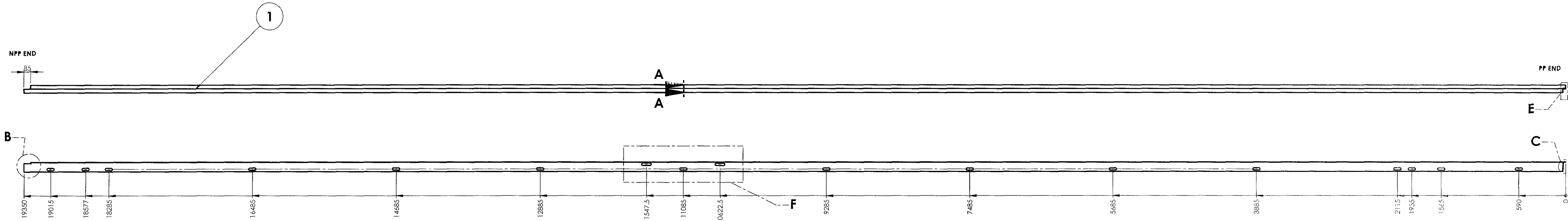
REVISIONS

ALT

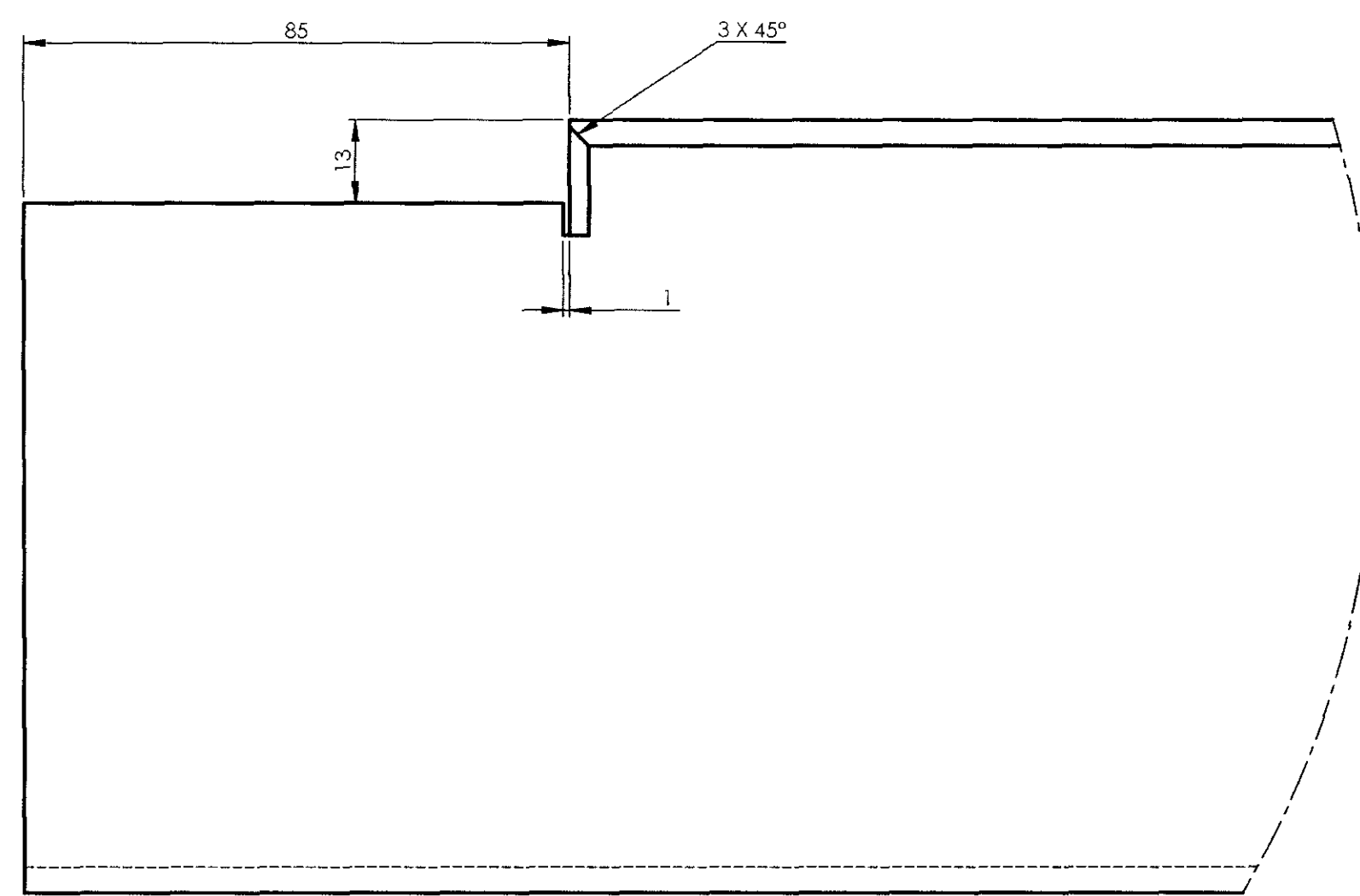
ZONE

DESCRIPTION

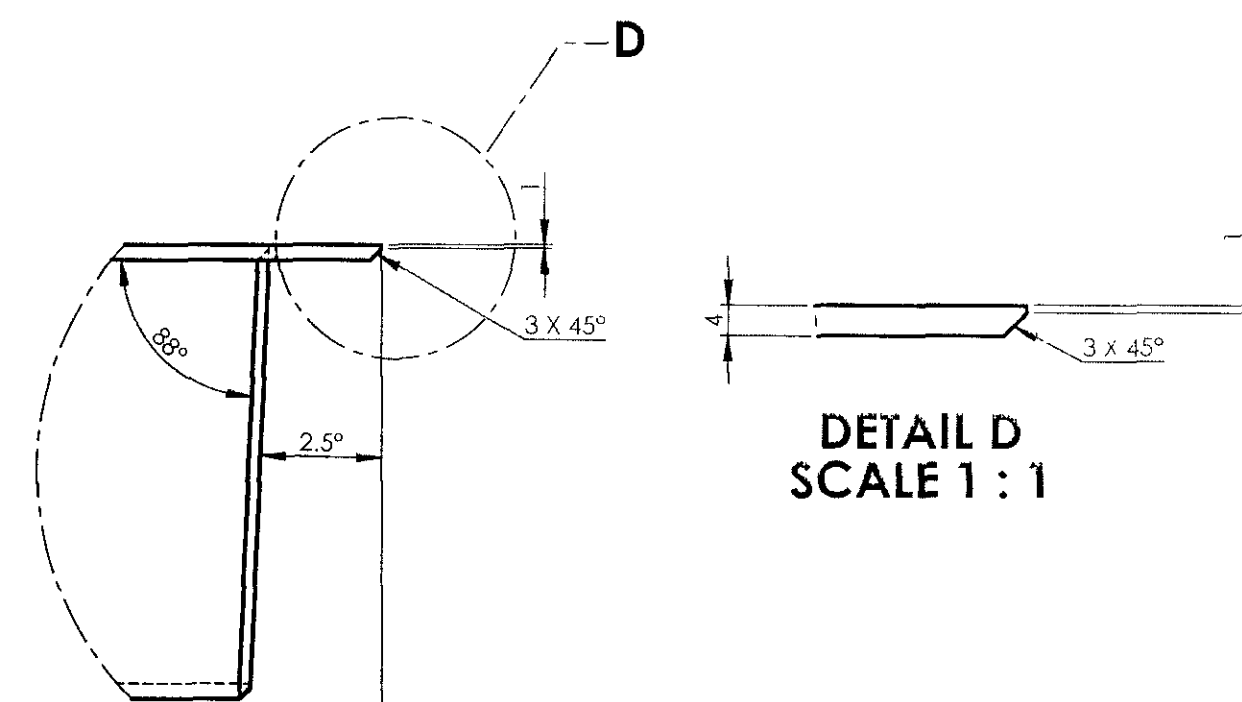
APPROVED & DATE



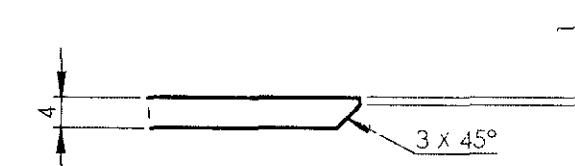
SECTION A-A
SCALE 1 : 1



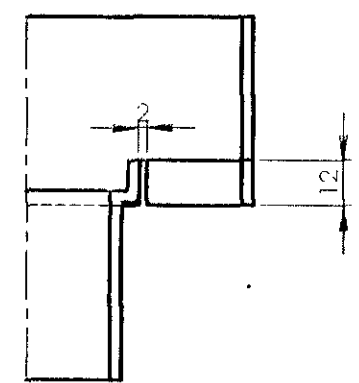
DETAIL B
SCALE 1 : 1



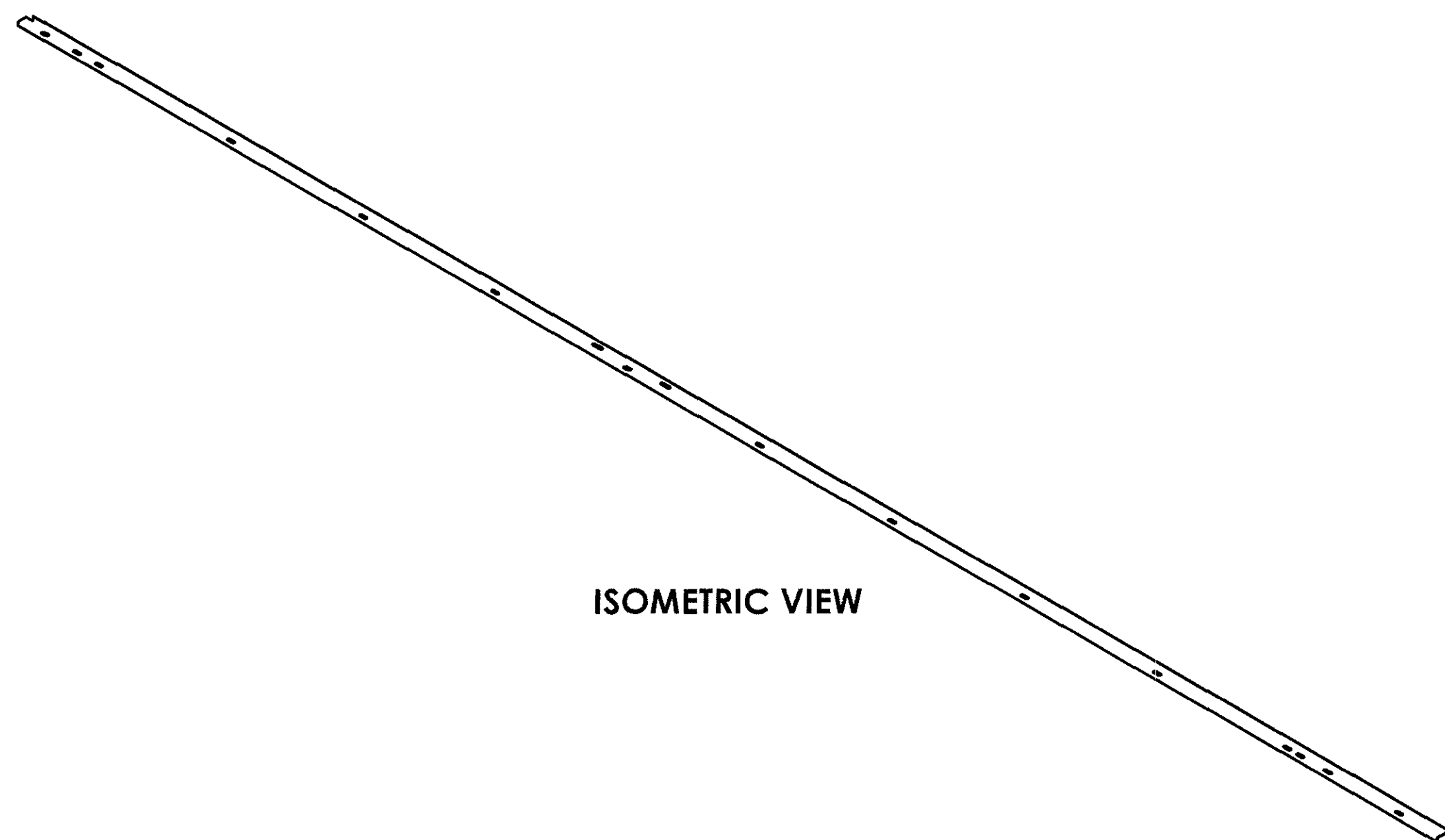
DETAIL C
SCALE 1 : 2



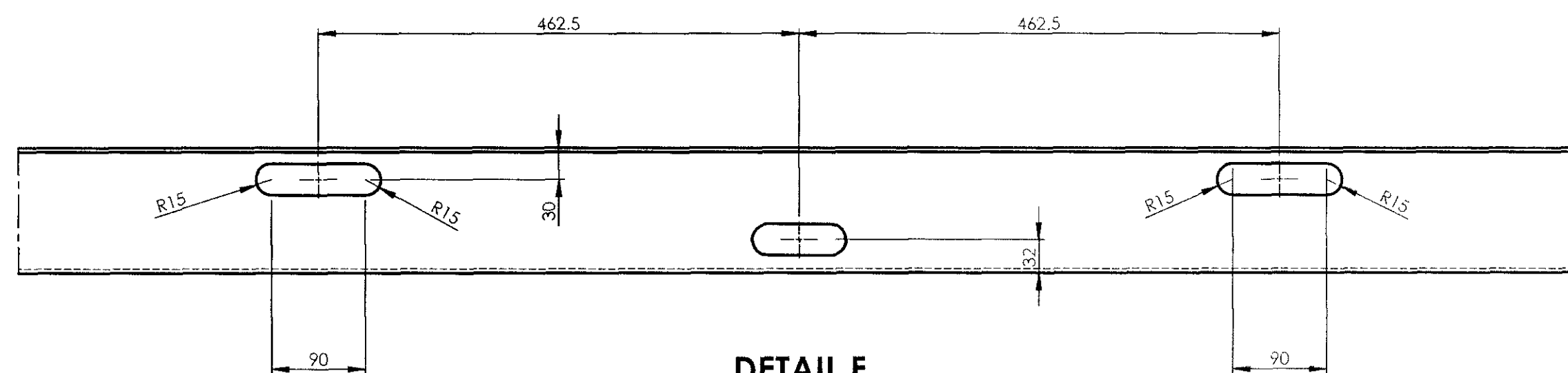
DETAIL D
SCALE 1 : 1



DETAIL E
SCALE 1 : 2



ISOMETRIC VIEW

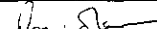
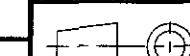


DETAIL F
SCALE 1 : 5

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

REF.DRG.NO.LH14220 Alt C/-

DATE OF LATEST ALT. DATE OF FIRST ISSUE A/E/S/M/E

1	ROOF FLANGE RIGHT (CRF)	4x202x19350	1		RDSO/SPEC C-K201 X2C/NIT2	124.210	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-4 Body Side Walls		SURFACE AREA IN Sq.m.: 7.935			WT/ASSY IN KGS:		
ROOF FLANGE RIGHT (CRF)					SCALE	SSE/D	
					1:25	CHD	
					ALT.	ALTD	-
					-	DRN	-
INDIAN RAILWAY STANDARDS					SHEET		 LWCBAC
INTEGRAL COACH FACTORY, CHENNAI - 600038					1 OF 1		
					AAK14510		A

AAK14513

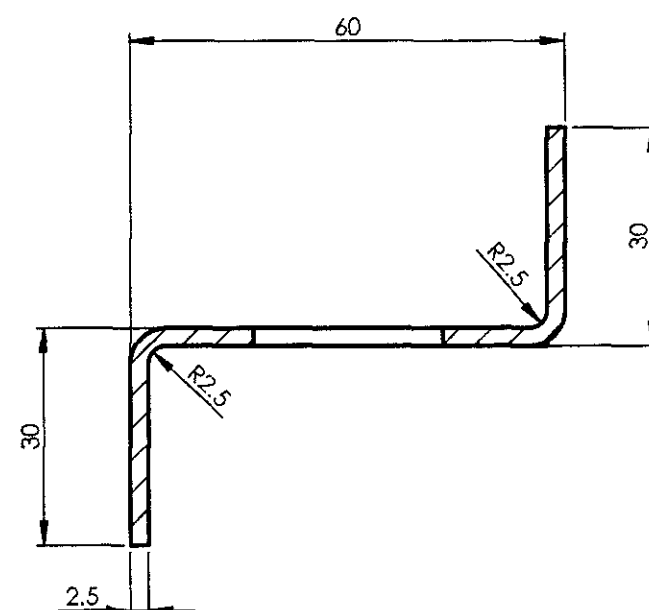
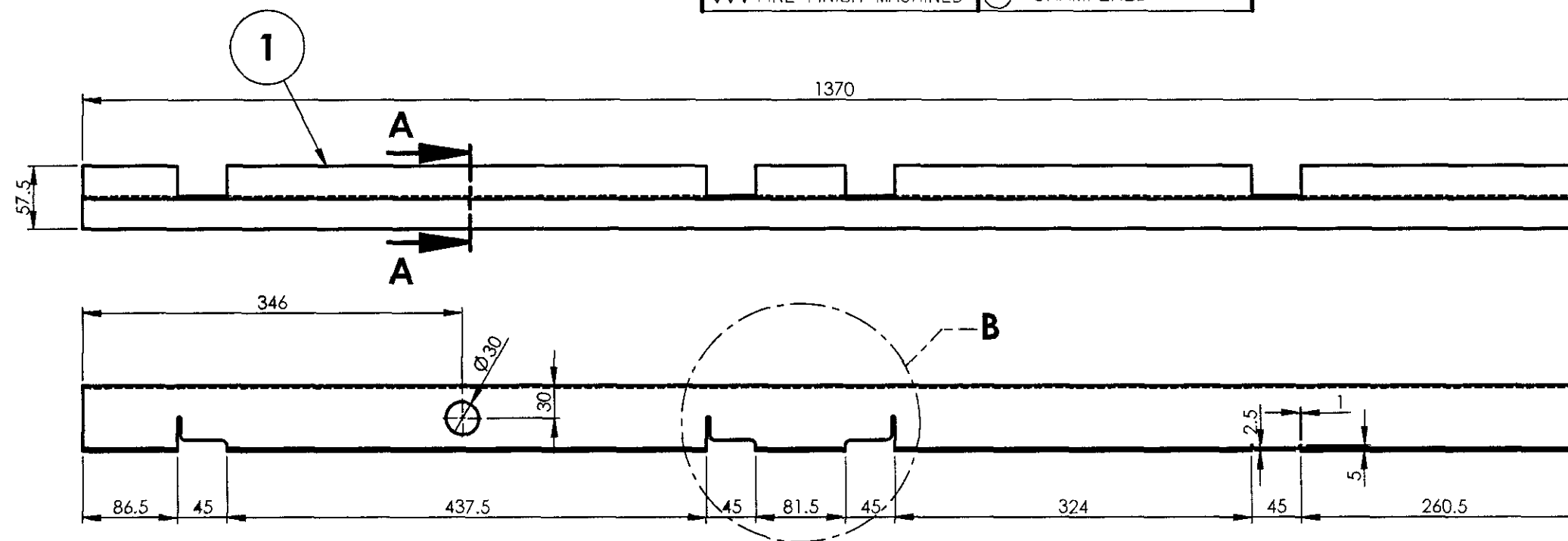
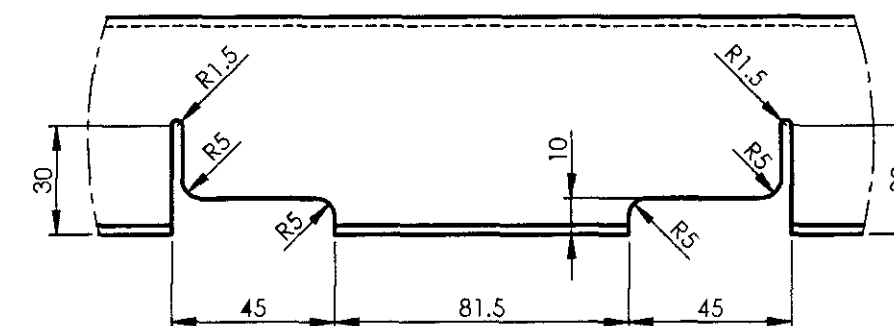
▽ ROUGH MACHINED	① ROUGH CLEANED
▽▽ FINISH MACHINED	①① BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	①①① CHAMFERED

REVISIONS

ALT.

ZONE

DESCRIPTION

APPROVED &
DATESECTION A-A
SCALE 1 : 1DETAIL B
SCALE 1 : 2

1	HORIZONTAL MEMBER	2.5x110x1370	1		RDSO/SPEC C-K201 X2CrNi12	2.922	
QTY	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-4 SIDEWALL ASSEMBLY				SURFACE AREA IN Sq.m.:0.301		WT/ASSY IN Kgs:	
HORIZONTAL MEMBER					SCALE	SSE/D	3D: SANTHOSH KUMAR
					1:5	CHD	2D: KUNTI THAKUR
					ALT.	ALTD	
INDIAN RAILWAY STANDARDS					DRN		
INTEGRAL COACH FACTORY, CHENNAI - 600038					SHEET 1 OF 1	AAK14513	
						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 IS: 813-1986.
WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY

REF.DRG.NO.

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

AAK14514

▽ ROUGH MACHINED

① ROUGH CLEANED

▽▽ FINISH MACHINED

①b BURRS REMOVED

▽▽▽ FINE FINISH MACHINED

①c CHAMFERED

REVISIONS

ALT.

ZONE

DESCRIPTION

APPROVED &
DATE

1

1800

A

A

57.5

949

50

260.5

5

2.5

45

324

45

B

451

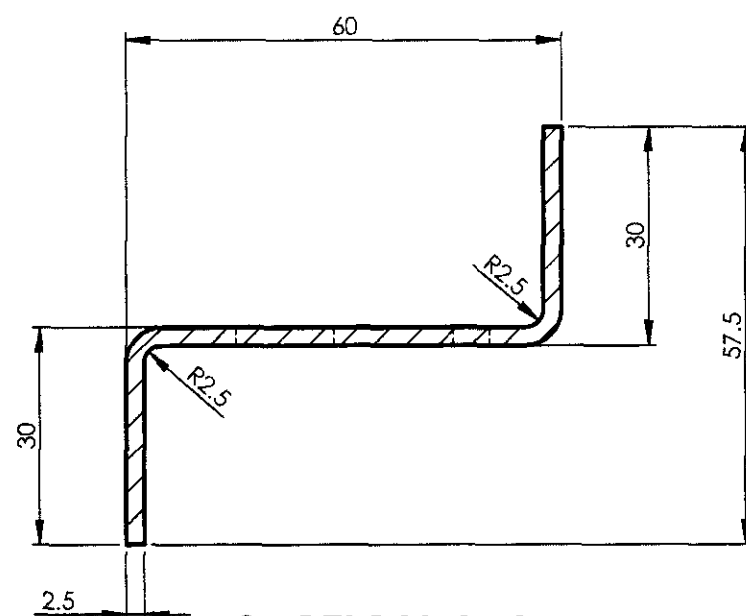
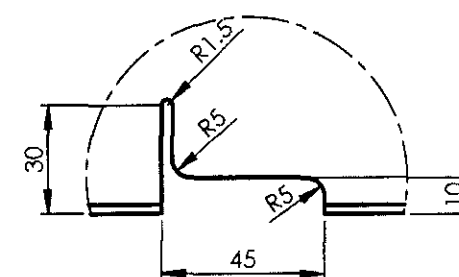
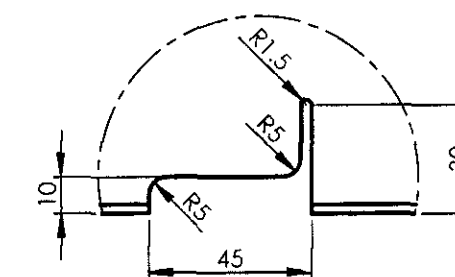
45

C

324

45

260.5

SECTION A-A
SCALE 1 : 1DETAIL B
SCALE 1 : 2DETAIL C
SCALE 1 : 2

1	HORIZONTAL MEMBER	2.5x110x1800	1		RDSO/SPEC C-K201 X2CrNi12	3.869	
QTY	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-4 Body Side Walls				SURFACE AREA IN Sq.m.:0.398		WT/ASSY IN Kgs:	
HORIZONTAL MEMBER					SCALE	SSE/D	
					1:5	CHD	
					ALT.	ALTD	
INDIAN RAILWAY STANDARDS						DRN	3D: R. SANTHOSH KUMAR 2D: KUNTI THAKUR
INTEGRAL COACH FACTORY, CHENNAI - 600039				SHEET 1 OF 1	AAK14514		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.

DATE OF LATEST ALT.

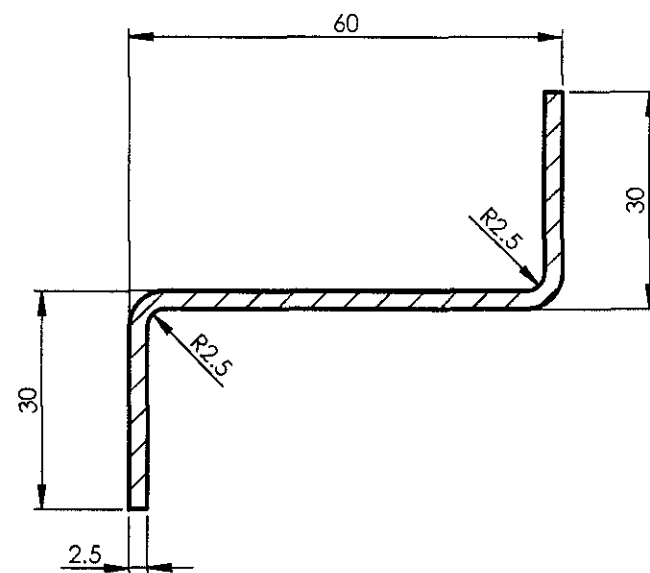
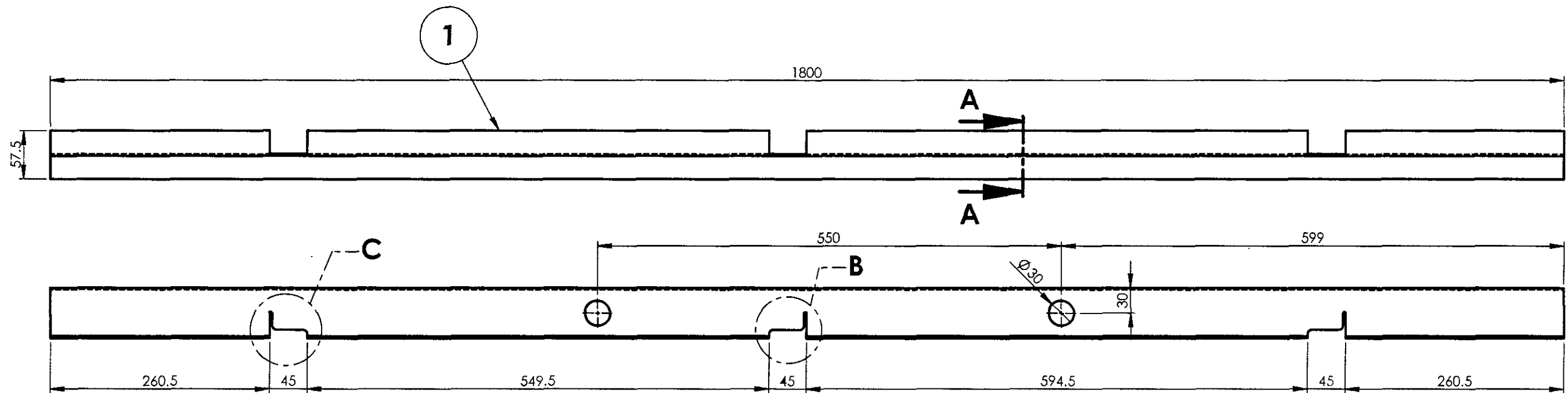
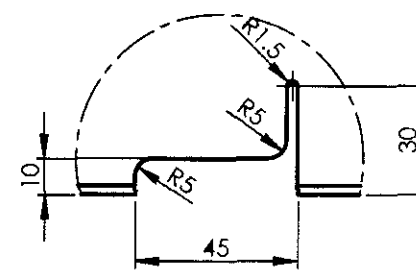
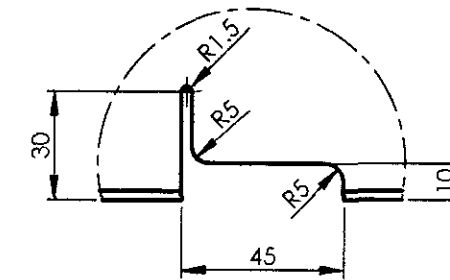
16-07-2025
DATE OF FIRST ISSUE

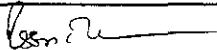
AME/SME

AAK14649

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

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE

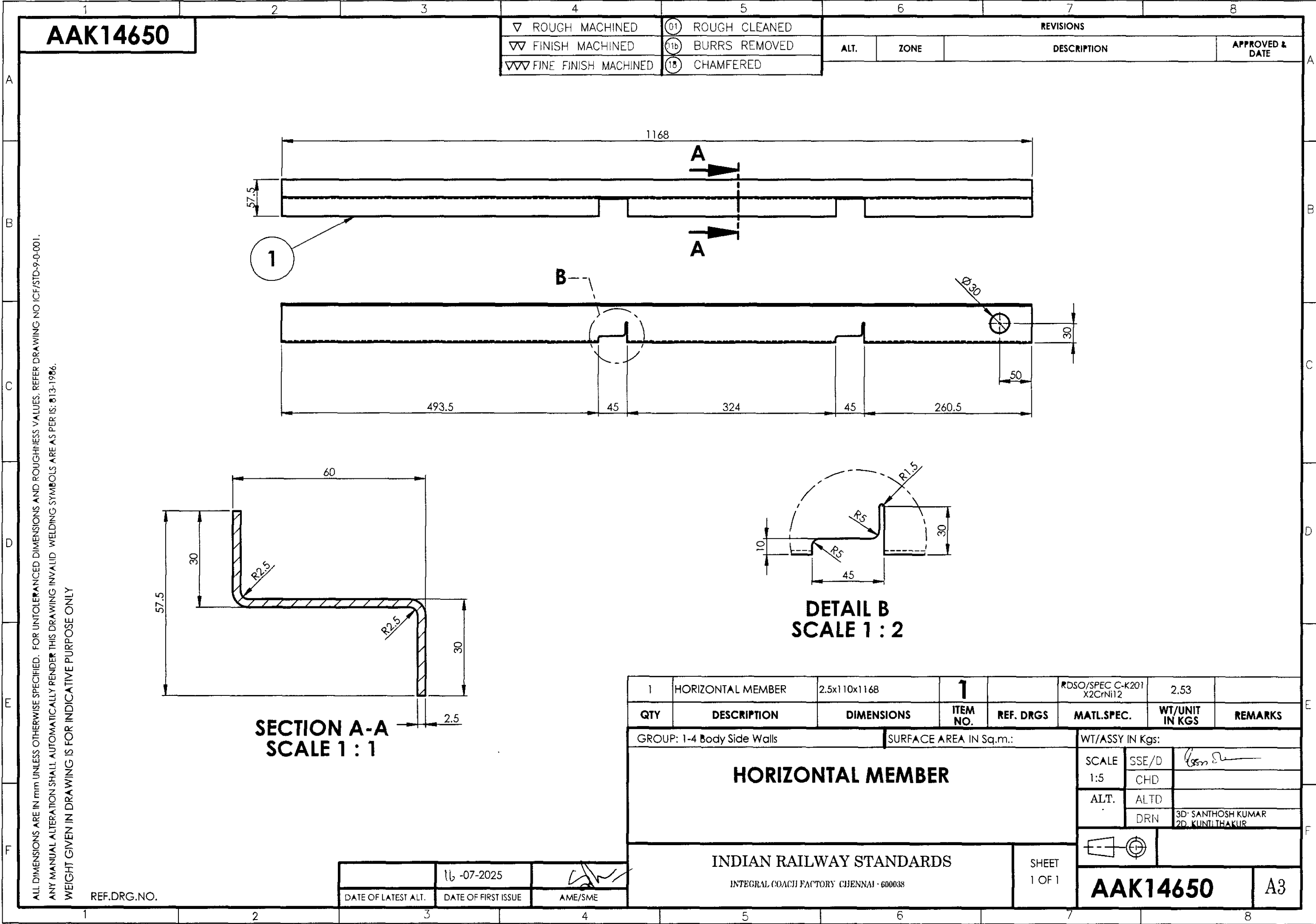
SECTION A-A
SCALE 1 : 1DETAIL B
SCALE 1 : 2DETAIL C
SCALE 1 : 2

1	HORIZONTAL MEMBER	2.5x110x1800	1		RDSO/SPEC C-K201 X2CrNi12	3.895	
QTY	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-4 SIDEWALL ASSEMBLY			SURFACE AREA IN Sq.m.:0.400		WT/ASSY IN Kgs:		
HORIZONTAL MEMBER					SCALE	SSE/D	
					1:5	CHD	
					ALT.	ALTD	
					DRN	3D:R. SANTHOSH KUMR 2D: KUNTI THAKUR	
					INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038		
					AAK14649		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 IS: 813-1986.
WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY

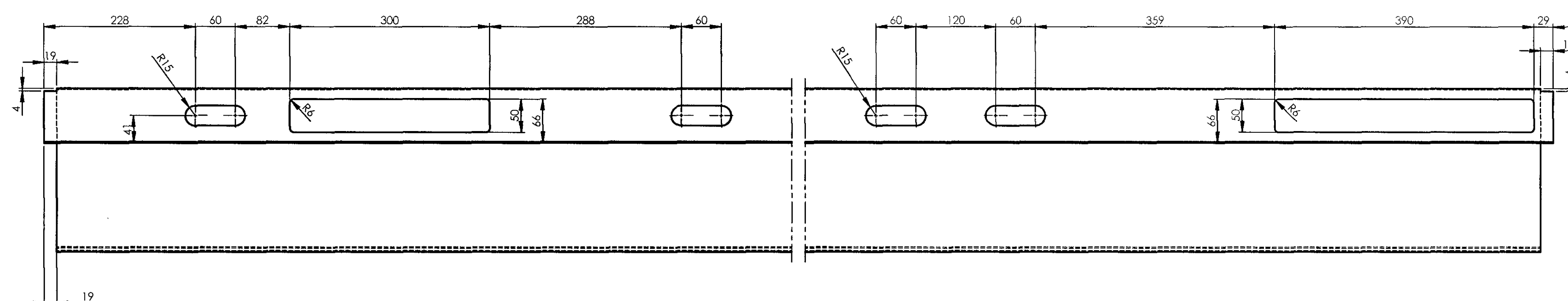
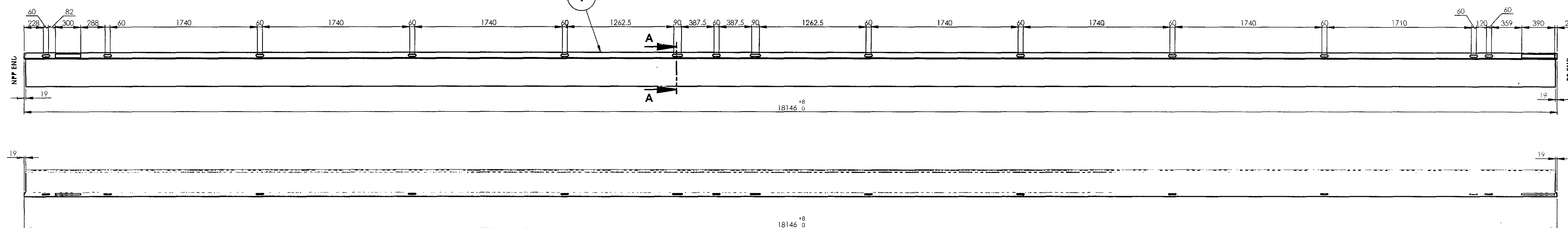
REF.DRG.NO.

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

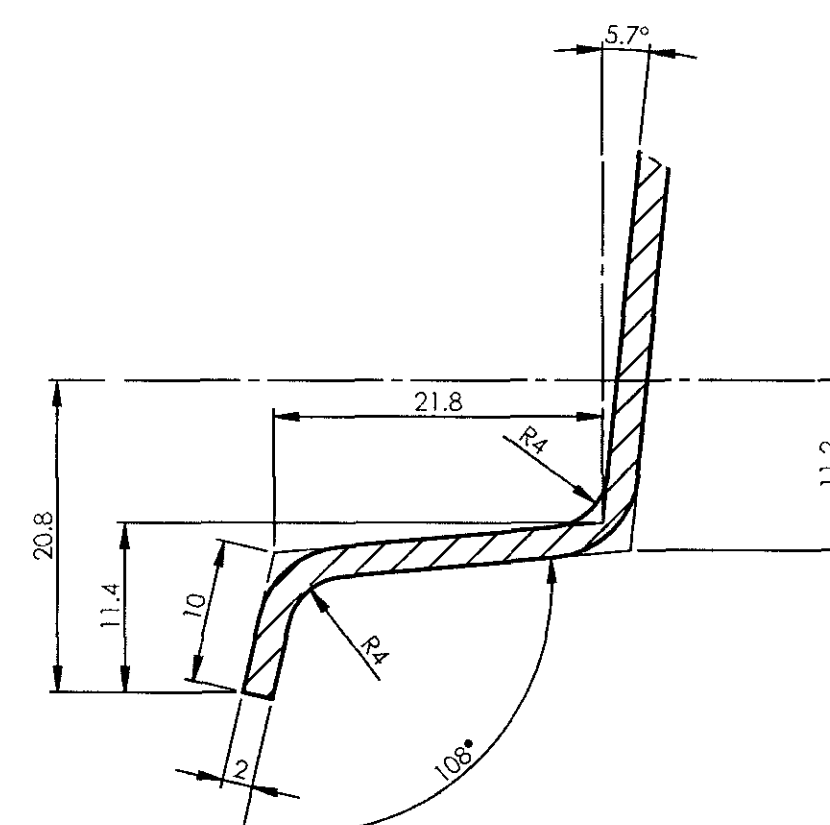


AA.114651

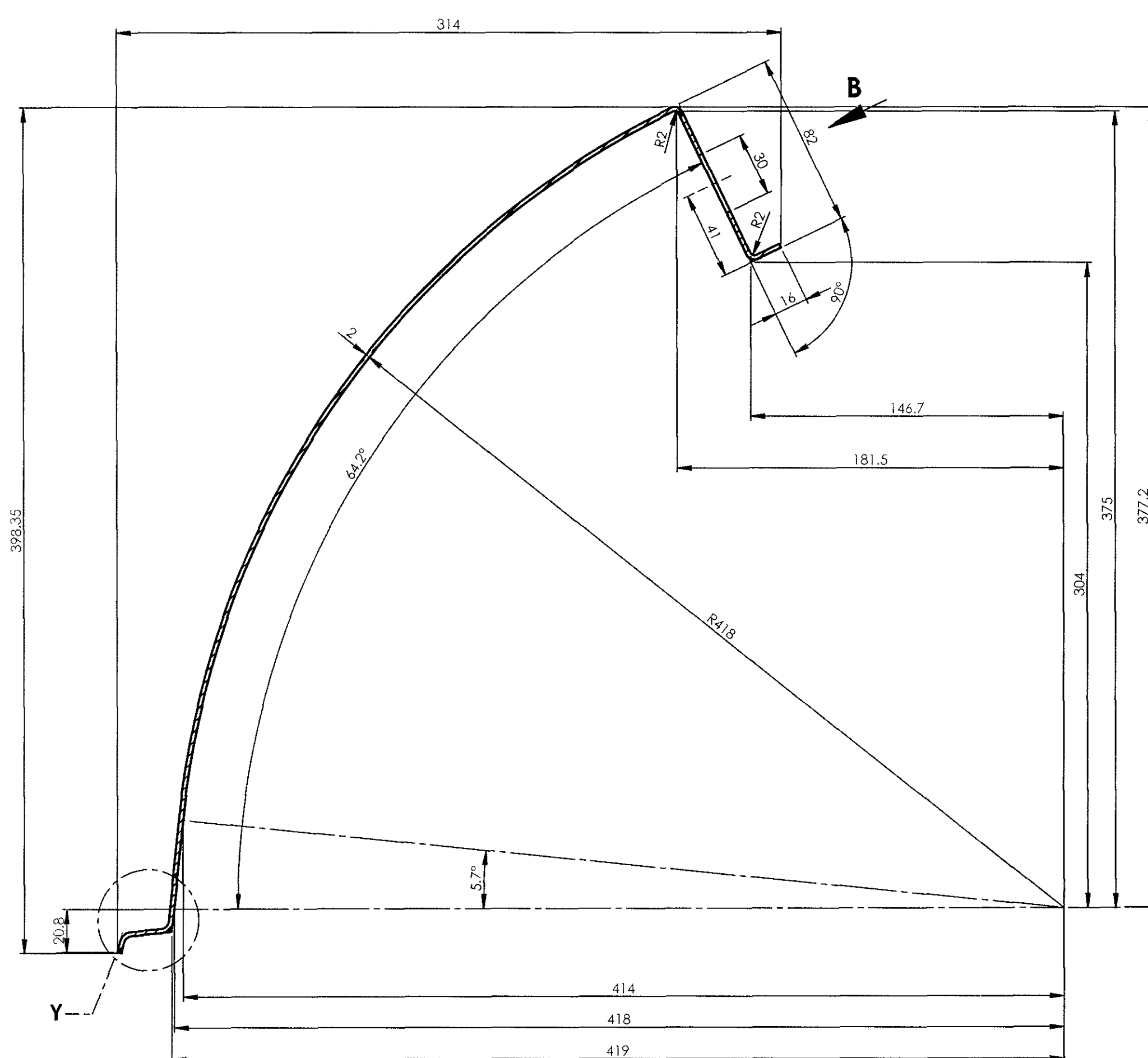
12	13	14	15	16
▽ ROUGH MACHINED	① ROUGH CLEANED	REVISONS		
▽▽ FINISH MACHINED	② BURS REMOVED	ALT.	ZONE	DESCRIPTION
▽▽▽ FINE FINISH MACHINED	③ CHAMFERED	APPROVE DATE		



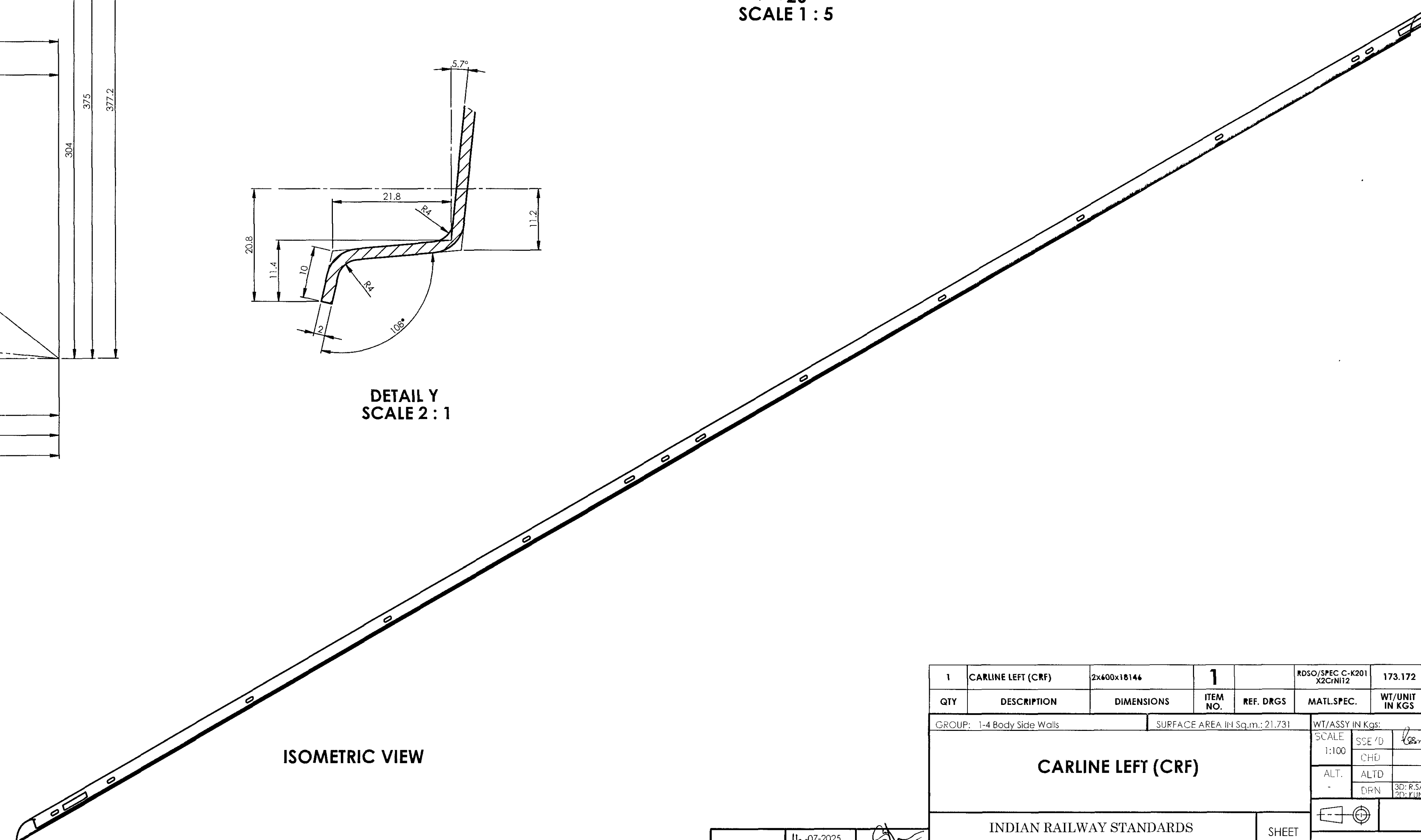
VIEW B
26°
SCALE 1 : 5



DETAIL Y
SCALE 2 : 1



SECTION A-A
SCALE 1:2




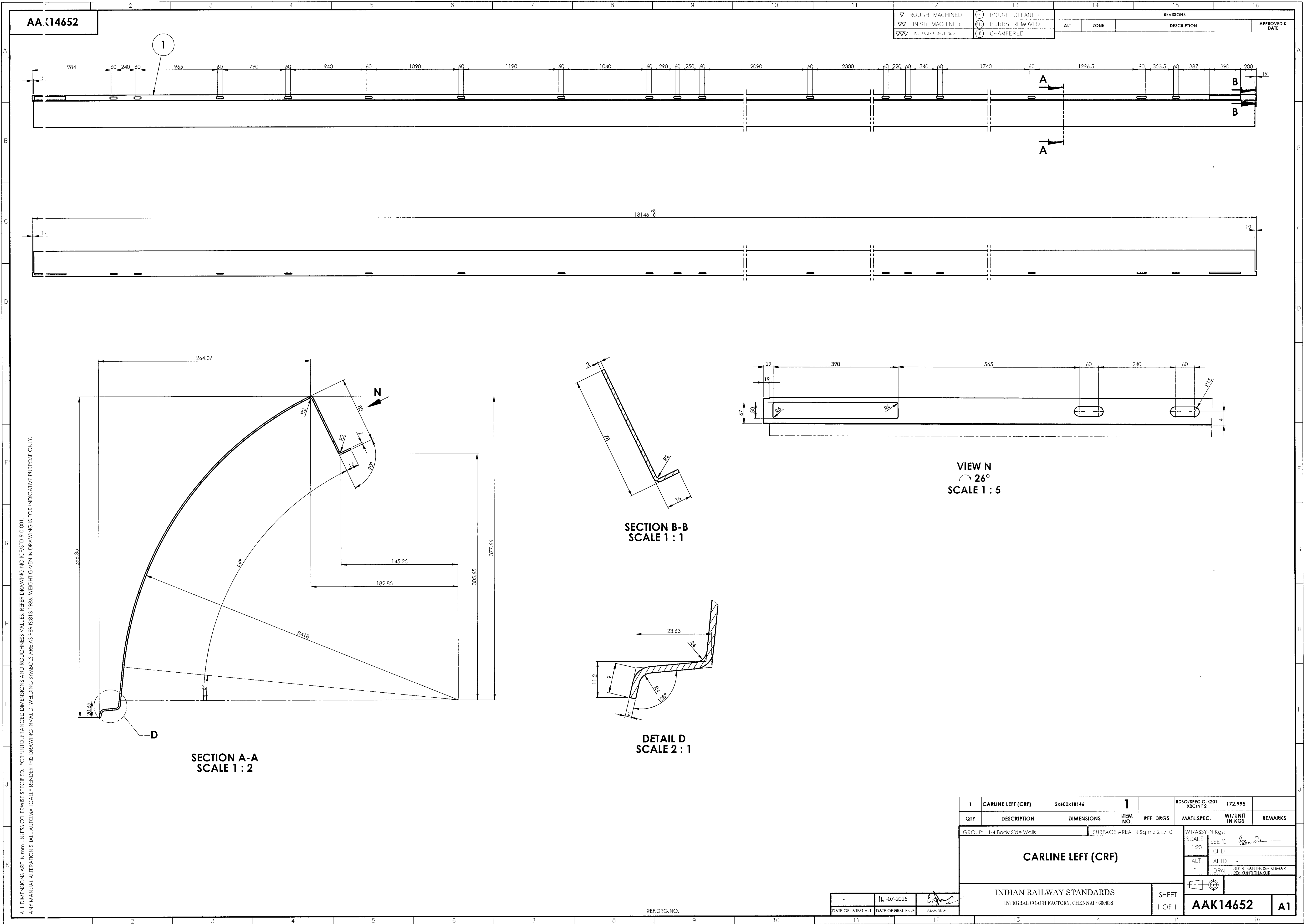
ISOMETRIC VIEW

1	CARLINE LEFT (CRF)	2x600x18146	1		RDSO/SPEC C-K201 X2CNW12	173.172	
QTY	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-4 Body Side Walls		SURFACE AREA IN Sq.m.: 21.731			WT/ASSY IN KGS:		
<div>CARLINE LEFT (CRF)</div>					SCALE	SCE'D	
					1:100	CH'D	
					ALT.	ALTD	
					-	D/RN	
					3D: R.SANTHOSH KUMAR 2D: JUNITI TRACUS		
INDIAN RAILWAY STANDARDS				SHEET			
INTEGRAL COACH FACTORY, CHENNAI - 600038							
				1 OF 1	AAK14651		

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO CFJSTD-9-0-001.
ANY UNWARRANTED ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER IS 813 - 1984. WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY.

REF.DRG.NO.

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



1		2		3		4		5		6		7		8																																																																					
AAK14654				▽ ROUGH MACHINED		01 ROUGH CLEANED		REVISIONS																																																																											
				▽▽ FINISH MACHINED		01b BURRS REMOVED		ALT.		ZONE		DESCRIPTION			APPROVED & DATE																																																																				
				▽▽▽ FINE FINISH MACHINED		18 CHAMFERED																																																																													
<div>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</div> <div><div>1</div><div>1365.5</div><div><div>3</div><div>R3</div><div>50</div><div>20</div></div></div>																																																																																			
<table><tr><td>1</td><td>CHANNEL</td><td>3x78x1365.5</td><td>1</td><td></td><td>RDSO/SPEC CK-201 X2 Cr Ni 12</td><td>2.626</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: 1-4 Body Side Walls</td><td colspan="3">SURFACE AREA IN Sq.m.:0.228</td><td colspan="3">WT/ASSY IN Kgs:</td></tr><tr><td colspan="5" rowspan="3">CHANNEL</td><td>SCALE</td><td>SSE/D</td><td rowspan="2"></td></tr><tr><td>1:2</td><td>CHD</td></tr><tr><td>ALT.</td><td>ALTD</td><td></td></tr><tr><td colspan="5"></td><td>DRN</td><td>R. SANTHOSH KUMAR</td></tr><tr><td colspan="5">INDIAN RAILWAY STANDARDS</td><td colspan="2">SHEET 1 OF 1</td><td></td></tr><tr><td colspan="5">INTEGRAL COACH FACTORY, CHENNAI - 600038</td><td colspan="2"></td><td></td></tr><tr><td colspan="5"></td><td colspan="2">AAK14654</td><td>A3</td></tr></table>																1	CHANNEL	3x78x1365.5	1		RDSO/SPEC CK-201 X2 Cr Ni 12	2.626		QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS	GROUP: 1-4 Body Side Walls		SURFACE AREA IN Sq.m.:0.228			WT/ASSY IN Kgs:			CHANNEL					SCALE	SSE/D		1:2	CHD	ALT.	ALTD							DRN	R. SANTHOSH KUMAR	INDIAN RAILWAY STANDARDS					SHEET 1 OF 1			INTEGRAL COACH FACTORY, CHENNAI - 600038													AAK14654		A3
1	CHANNEL	3x78x1365.5	1		RDSO/SPEC CK-201 X2 Cr Ni 12	2.626																																																																													
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS																																																																												
GROUP: 1-4 Body Side Walls		SURFACE AREA IN Sq.m.:0.228			WT/ASSY IN Kgs:																																																																														
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					DRN	R. SANTHOSH KUMAR																																																																													
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					AAK14654		A3																																																																												
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DATE OF LATEST ALT.		DATE OF FIRST ISSUE		AME/SME																																																																															

1		2		3		4		5		6		7		8																																																																									
AAK14655				▽ ROUGH MACHINED		① ROUGH CLEANED		REVISIONS																																																																															
				▽▽ FINISH MACHINED		①b BURRS REMOVED		ALT.		ZONE		DESCRIPTION			APPROVED & DATE																																																																								
				▽▽▽ FINE FINISH MACHINED		①c CHAMFERED																																																																																	
<div>ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICT/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</div> <div><div>1890</div><div>A</div><div>A</div></div> <div><div>20</div><div>85</div><div>R3</div><div>R3</div><div>3</div></div> <div>SECTION A-A SCALE 1 : 2</div>																																																																																							
<table><tr><td>1</td><td>CHANNEL</td><td>3x113.5x1890</td><td>1</td><td></td><td>RDSO SPEC C-K201 X2 Cr Ni 12</td><td>5.22</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="4">GROUP: 1-4 Body Side Walls</td><td colspan="2">SURFACE AREA IN Sq.m.:</td><td colspan="2">WT/ASSY IN Kgs:</td></tr><tr><td colspan="6">CHANNEL</td><td>SCALE 1:10</td><td>SSE/D CHD</td></tr><tr><td colspan="6"></td><td>ALT.</td><td>ALTD</td></tr><tr><td colspan="6"></td><td>DRN</td><td>R. SANTHOSH KUMAR</td></tr><tr><td colspan="6">INDIAN RAILWAY STANDARDS</td><td colspan="2">SHEET 1 OF 1</td></tr><tr><td colspan="6">INTEGRAL COACH FACTORY, CHENNAI - 600038</td><td colspan="2">AAK14655</td></tr><tr><td colspan="6"></td><td colspan="2">A3</td></tr></table>																1	CHANNEL	3x113.5x1890	1		RDSO SPEC C-K201 X2 Cr Ni 12	5.22		QTY.	DESCRIPTION	DIMENSIONS	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:		CHANNEL						SCALE 1:10	SSE/D CHD							ALT.	ALTD							DRN	R. SANTHOSH KUMAR	INDIAN RAILWAY STANDARDS						SHEET 1 OF 1		INTEGRAL COACH FACTORY, CHENNAI - 600038						AAK14655								A3	
1	CHANNEL	3x113.5x1890	1		RDSO SPEC C-K201 X2 Cr Ni 12	5.22																																																																																	
QTY.	DESCRIPTION	DIMENSIONS	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:																																																																																	
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INTEGRAL COACH FACTORY, CHENNAI - 600038						AAK14655																																																																																	
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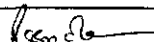

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				▽▽▽ FINE FINISH MACHINED		①8 CHAMFERED																																																																				
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REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



1. 'L' DIMENSION SHALL BE SPECIFIED ONLY IN THE ASSEMBLY DRAWING WHERE IT IS REQUIRED.

1	CHANNEL	3x143.5xL	1		RDSO SPEC C-K201 X2 Cr Ni 12	1.08	
QTY.	DESCRIPTION	DIMENSIONS	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:		
CHANNEL					SCALE	SSE/D	
					1:2	CHD	
					ALT.	ALTD	
						DRN	R. SANTHOSH KUMAR
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1			
					AAK14657		A3

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AAK14658				▽ ROUGH MACHINED		① ROUGH CLEANED		REVISIONS																																																																								
				▽▽ FINISH MACHINED		② BURRS REMOVED		ALT.		ZONE		DESCRIPTION		APPROVED & DATE																																																																		
				▽▽▽ FINE FINISH MACHINED		③ CHAMFERED																																																																										
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				<table><tr><td>1</td><td>CHANNEL</td><td>3x188.5xL</td><td>1</td><td></td><td>RDSO SPEC C-K201 X2 Cr Ni 12</td><td>1.41</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="4">GROUP: 1-4 Body Side Walls</td><td colspan="2">SURFACE AREA IN Sq.m.:</td><td colspan="2">WT/ASSY IN Kgs:</td></tr><tr><td colspan="6" rowspan="4">CHANNEL</td><td>SCALE</td><td>SSE/D</td><td rowspan="2"></td></tr><tr><td>1:2</td><td>CHD</td></tr><tr><td>ALT.</td><td>ALTD</td><td></td></tr><tr><td></td><td>DRN</td><td>R. SANTHOSH KUMAR</td></tr><tr><td colspan="6">INDIAN RAILWAY STANDARDS</td><td colspan="2">SHEET 1 OF 1</td><td colspan="2">AAK14658</td><td colspan="2">A3</td></tr><tr><td colspan="6">INTEGRAL COACH FACTORY, CHENNAI - 600038</td><td colspan="2"></td><td colspan="2"></td><td colspan="2"></td></tr></table>												1	CHANNEL	3x188.5xL	1		RDSO SPEC C-K201 X2 Cr Ni 12	1.41		QTY.	DESCRIPTION	DIMENSIONS	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:		CHANNEL						SCALE	SSE/D		1:2	CHD	ALT.	ALTD			DRN	R. SANTHOSH KUMAR	INDIAN RAILWAY STANDARDS						SHEET 1 OF 1		AAK14658		A3		INTEGRAL COACH FACTORY, CHENNAI - 600038											
1	CHANNEL	3x188.5xL	1		RDSO SPEC C-K201 X2 Cr Ni 12	1.41																																																																										
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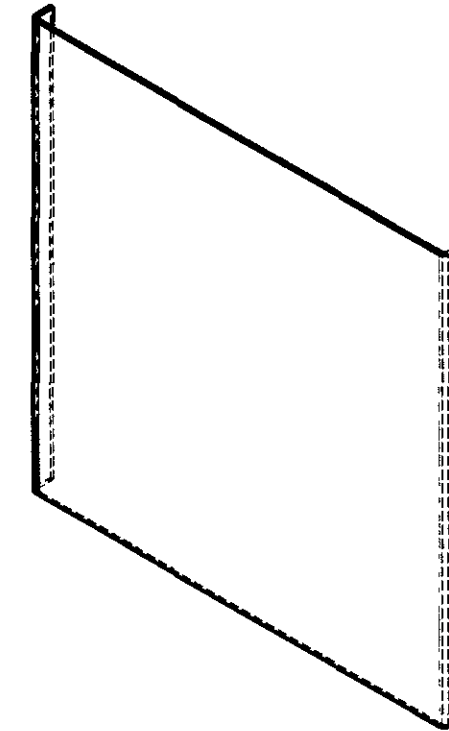
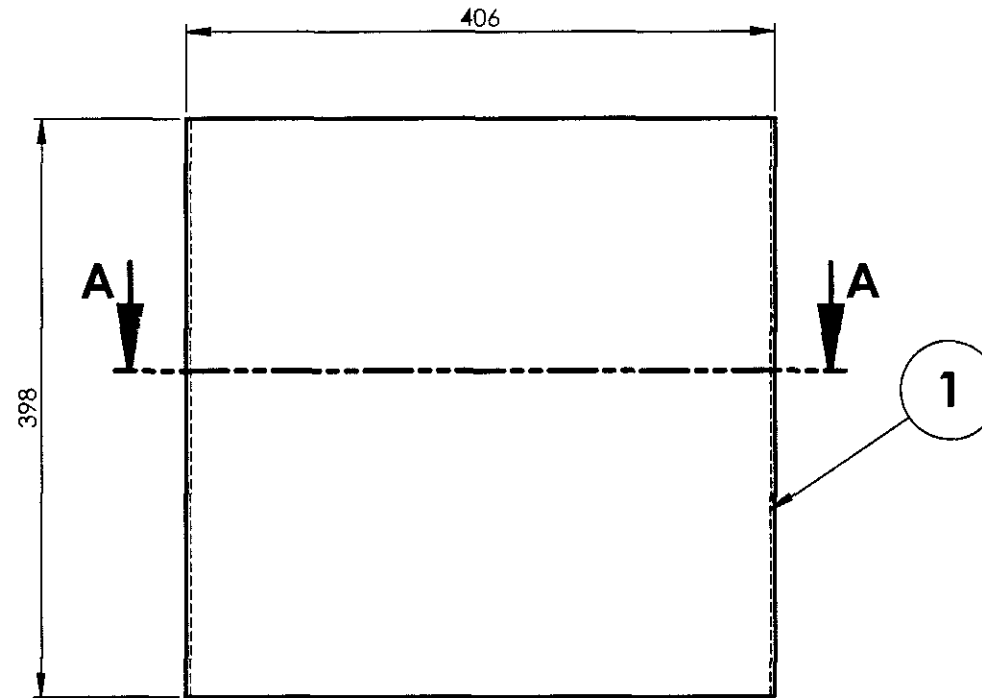
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AAK14750

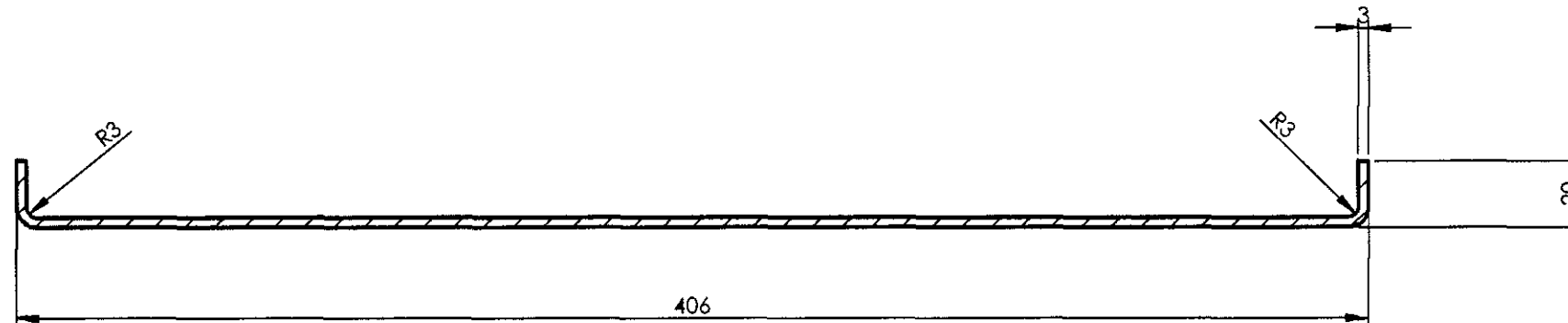
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▽▽ FINISH MACHINED	② BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	③ CHAMFERED

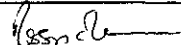
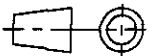
REVISIONS

ALT.	ZONE	DESCRIPTION	APPROVED & DATE
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ISOMETRIC VIEW

SECTION A-A
SCALE 1 : 2

1	CHANNEL	3.00x398x434.5	1		RDSO SPEC C-K201 X2 Cr NI 12	4.17	
QTY.	DESCRIPTION	DIMENSIONS	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:		
CHANNEL					SCALE	SSE/D	
					1:5	CHD	
					ALT.	ALTD	
						DRN	R. SANTHOSH KUMAR
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1			
					AAK14750		A3

AAK14751

▽ ROUGH MACHINED

① ROUGH CLEANED

▽▽ FINISH MACHINED

①b BURRS REMOVED

▽▽▽ FINE FINISH MACHINED

⑱ CHAMFERED

REVISIONS

ALT.

ZONE

DESCRIPTION

APPROVED &
DATE

a

DESIGN OF ITEM-1 REVISED.

gmr

1

989

241.5

32

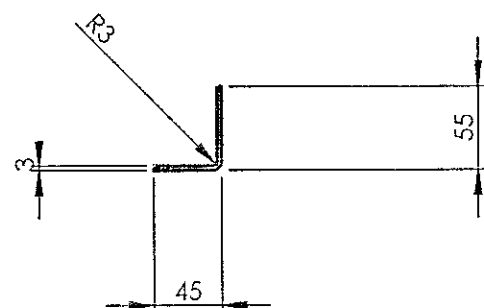
402.5

32

281

35

ISOMETRIC VIEW



REF.DRG.NO.LH14349

5-10-2025

16-07-2025

gmr

DATE OF LATEST ALT.

DATE OF FIRST ISSUE

AME/SME

1

ANGLE

3x94.3x989

1

RDSO SPEC C-
K201 X2 Cr Ni 12

2.20

QTY.

DESCRIPTION

DIMENSIONS

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:

ANGLE

SCALE
1:5SSE/D
CHD

gmr

ALT.
aALTD
DRN

R. SANTHOSH KUMAR

R. SANTHOSH KUMAR

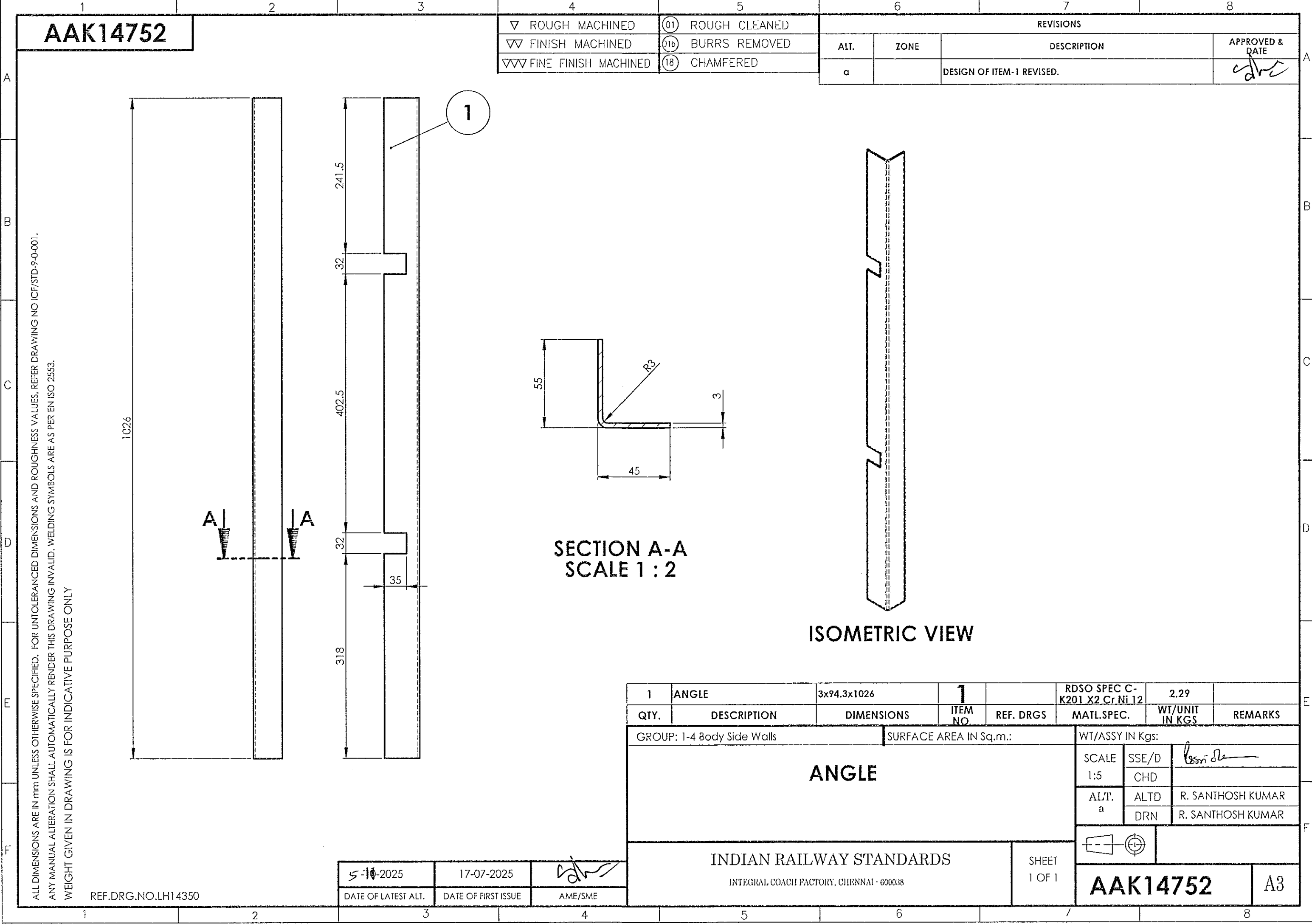
INDIAN RAILWAY STANDARDS

INTEGRAL COACH FACTORY, CHENNAI - 600038

SHEET
1 OF 1

AAK14751


A3



A	
B	
C	
D	
E	
F	

REF.DRG.NO.-

820

1	CHANNEL	3x173.5x820	1		RDSO SPEC C - K201 X2 Cr Ni 12	3.45	
QTY.	DESCRIPTION	DIMENSIONS	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:		
CHANNEL					SCALE	SSE/D	<i>R. Santhosh Kumar</i>
					1:5	CHD	
					ALT.	ALTD	
					DRN	R. SANTHOSH KUMAR	
INDIAN RAILWAY STANDARDS				SHEET 1 OF 1			
INTEGRAL COACH FACTORY, CHENNAI - 600038							
					AAK14753		A3

AAK14753

A3

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AAK14754				▽ ROUGH MACHINED		① ROUGH CLEANED		REVISIONS																																																																													
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AAK14755				▽ ROUGH MACHINED		① ROUGH CLEANED		REVISIONS																																																					
				▽▽ FINISH MACHINED		①b BURRS REMOVED		ALT.		ZONE		DESCRIPTION																																																	
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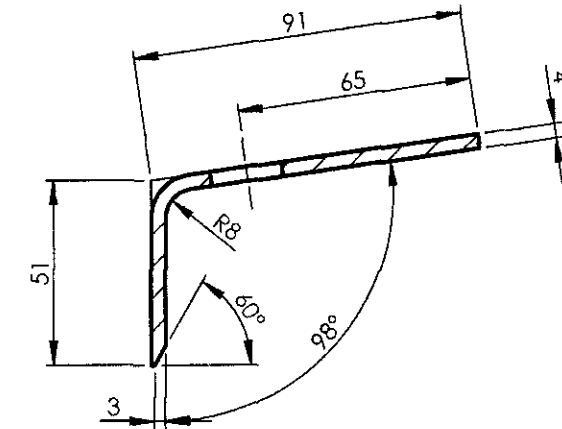
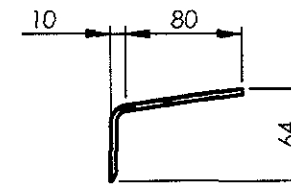
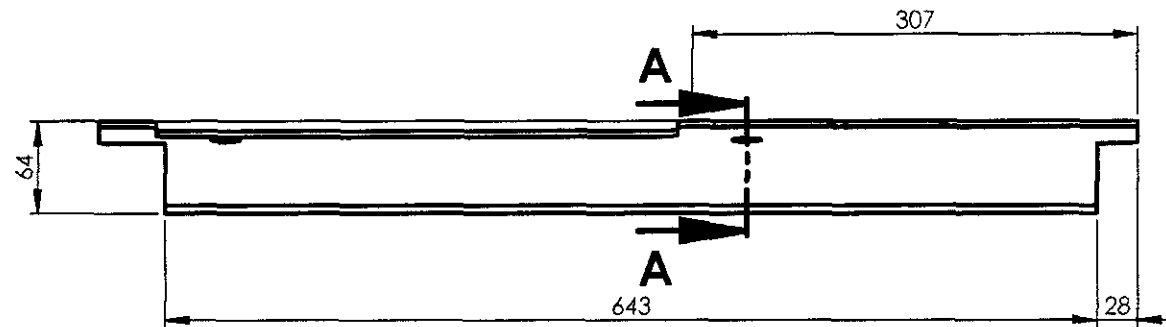
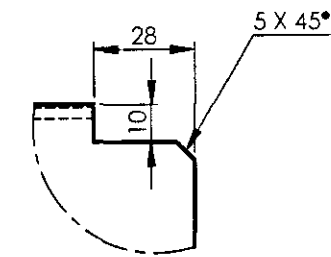
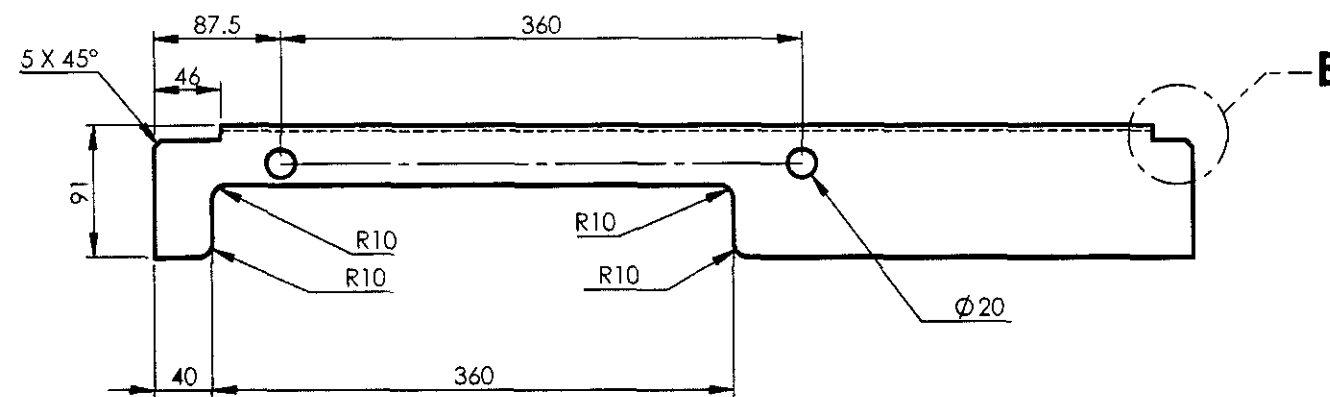
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1		2		3		4		5		6		7		8	
AAK14756				▽ ROUGH MACHINED		① ROUGH CLEANED		REVISIONS							
				▽▽ FINISH MACHINED		② BURRS REMOVED		ALT.		ZONE		DESCRIPTION		APPROVED & DATE	
				▽▽▽ FINE FINISH MACHINED		③ CHAMFERED									
<div><div>335.5</div><div>1</div><div>ISOMETRIC VIEW</div></div>															
<div><div>100</div><div>20</div><div>R3</div></div>															
<div><div>16-07-2025</div><div>DATE OF LATEST ALT.</div><div>DATE OF FIRST ISSUE</div><div>AME/SME</div></div>															
<div><div>INDIAN RAILWAY STANDARDS</div><div>INTEGRAL COACH FACTORY, CHENNAI - 600038</div></div>															
<div><div>1</div><div>ANGLE</div><div>3x114x335.50</div><div>1</div><div>ITEM NO.</div><div>REF. DRGS</div><div>RDSO SPEC C-K201 X2 Cr NI 12</div><div>0.93</div><div>WT/UNIT IN KGS</div><div>REMARKS</div></div>															
<div><div>GROUP: 1-4 Body Side Walls</div><div>SURFACE AREA IN Sq.m.:</div><div>WT/ASSY IN Kgs:</div></div>															
<div><div>ANGLE</div><div>SCALE 1:2</div><div>SSE/D</div><div>CHD</div><div>ALT.</div><div>ALTD</div><div>DRN</div><div>R. SANTHOSH KUMAR</div></div>															
<div><div>INDIAN RAILWAY STANDARDS</div><div>INTEGRAL COACH FACTORY, CHENNAI - 600038</div><div>SHEET 1 OF 1</div><div>AAK14756</div><div>A3</div></div>															

AAK14940

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

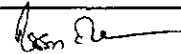
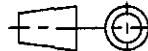
REVISIONS				APPROVED & DATE	
ALT.	ZONE	DESCRIPTION			

SECTION A-A
SCALE 1 : 2DETAIL B
SCALE 1 : 2

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.LH14151

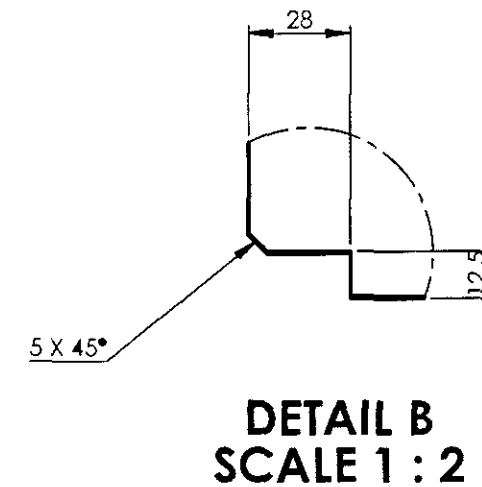
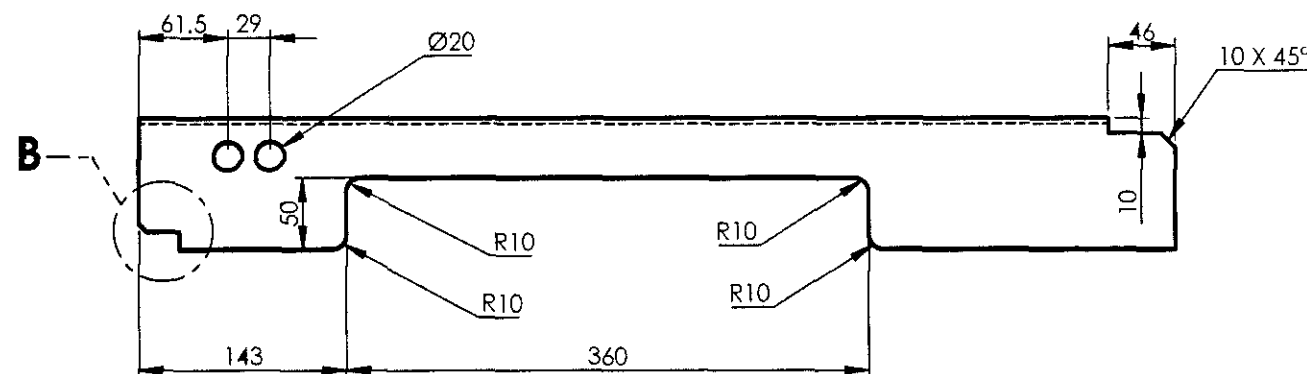
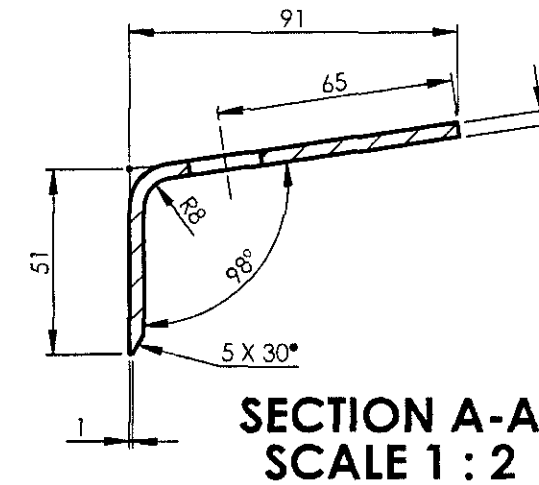
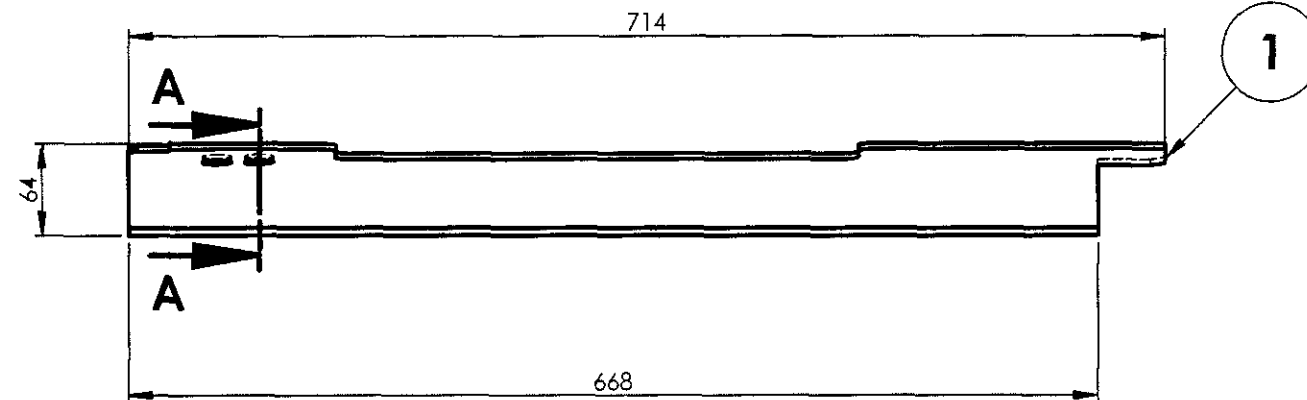
	16-07-2025	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

1	STIFFENING ANGLE - LH	4x135x717	1		RDSO/SPEC C-K201 X2CrNi12	2.350	
QTY	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-4 Body Side Walls		SURFACE AREA IN Sq.m.:0.156			WT/ASSY IN Kgs:		
STIFFENING ANGLE - LH					SCALE	SSE/D	
					1:5	CHD	
					ALT.	ALTD	
						DRN	R. SANTHOSH KUMAR
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038							
SHEET 1 OF 1					AAK14940		A3

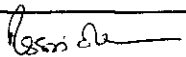
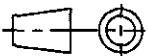
AAK14941

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

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



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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

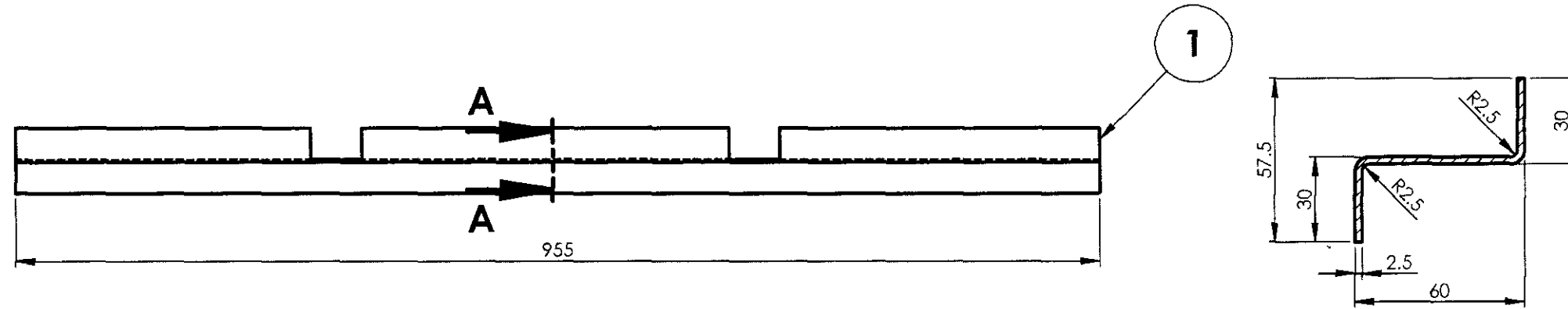
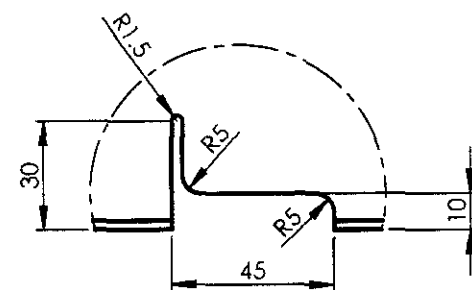
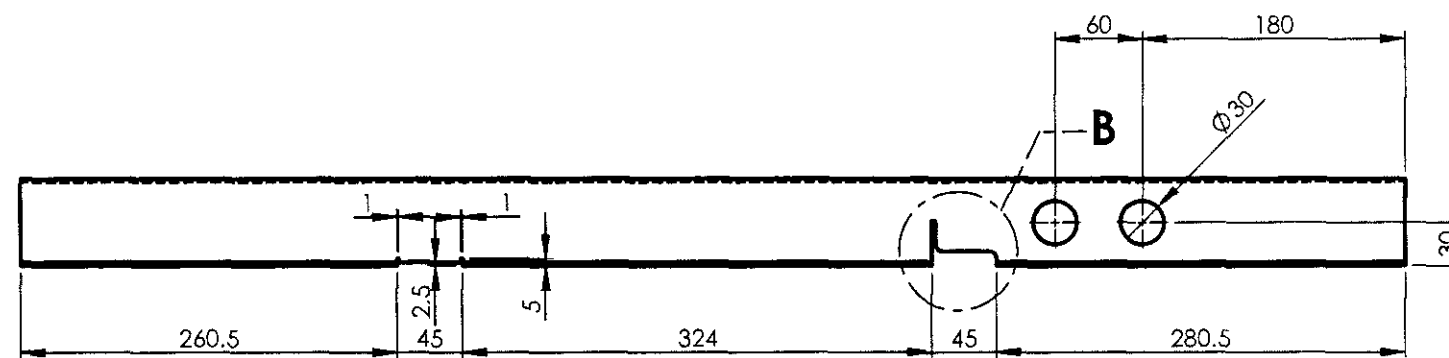
1	STIFFENING ANGLE - RH	4x135x714	1		RDSO/SPEC C- K201 X2CrNi12	2.372	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-4 Body Side Walls		SURFACE AREA IN Sq.m.:0.157			WT/ASSY IN Kgs:		
STIFFENING ANGLE - RH					SCALE	SSE/D	
					1:5	CHD	
					ALT.	ALTD	
						DRN	R. SANTHOSH KUMAR
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1			
					AAK14941		A3

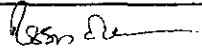
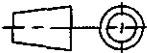
REF.DRG.NO.LH14152 'a'

AAK14942

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

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE

SECTION A-A
SCALE 1 : 2DETAIL B
SCALE 1 : 2

1	HORIZONTAL MEMBER	2.5x110x955	1		RDSO/SPEC C-K201 X2CrNi12	2.05	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-4, SIDEWALL ASSEMBLY.		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
HORIZONTAL MEMBER					SCALE	SSE/D	
					1:5	CHD	
					ALT.	ALTD	
						DRN	R. SANTHOSH KUMAR
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1			
					AAK14942		A3

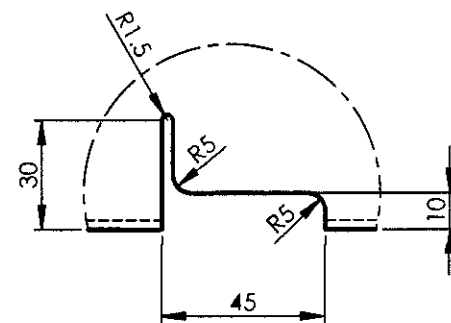
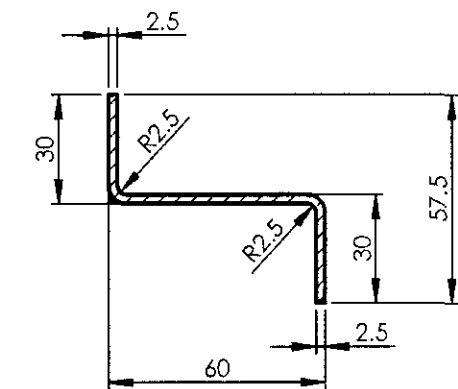
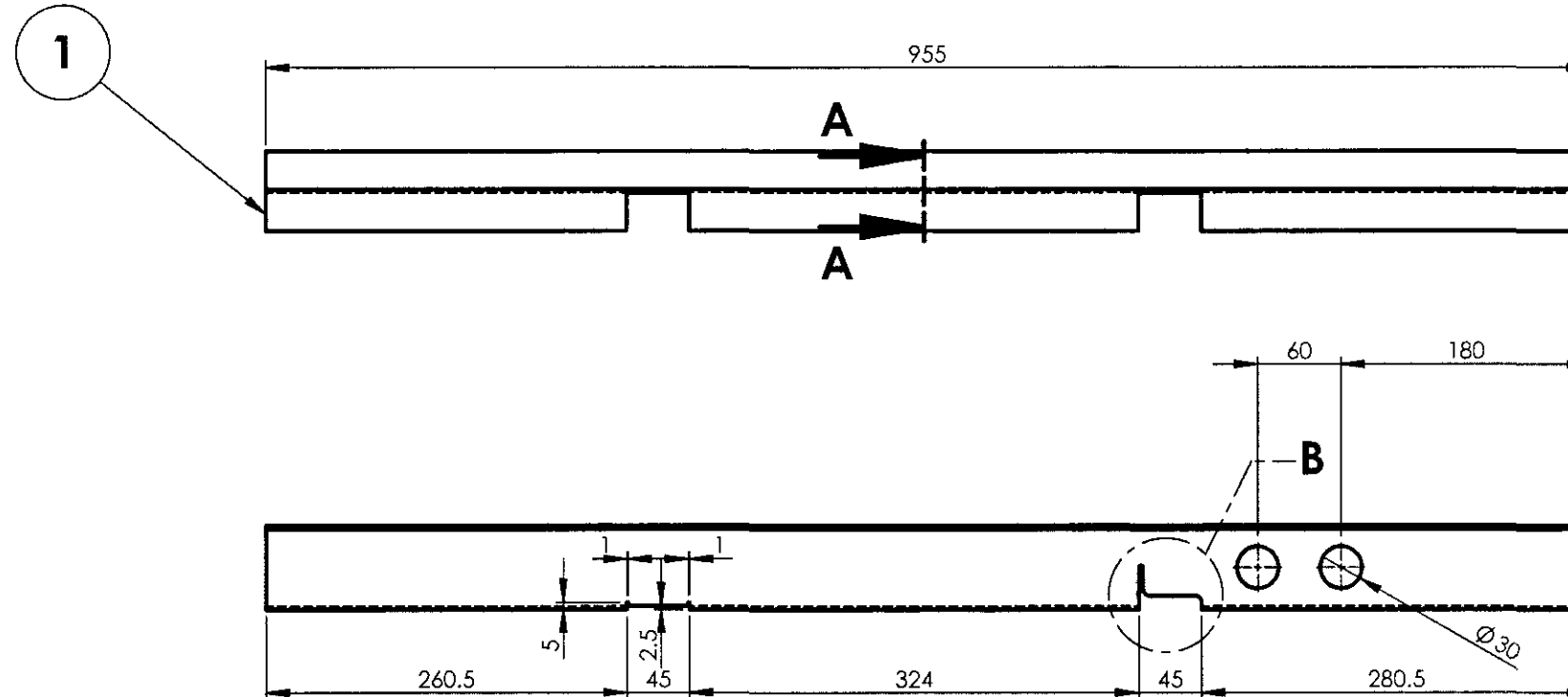
REF.DRG.NO.LE14188 Alt 'b/-'

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AAK14943

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

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



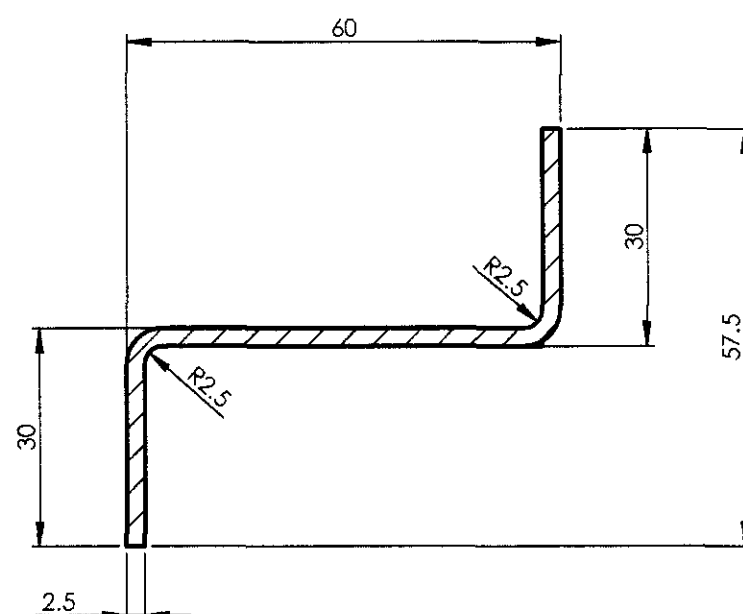
1	HORIZONTAL MEMBER	2.5x110x955	1		RDSO/SPEC C-K201 X2CrNi12	2.05	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-4, SIDEWALL ASSEMBLY.				SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:	
HORIZONTAL MEMBER					SCALE 1:5	SSE/D	
						CHD	
					ALT.	ALTD	
INDIAN RAILWAY STANDARDS						DRN	R. SANTHOSH KUMAR
INTEGRAL COACH FACTORY, CHENNAI - 600038					SHEET 1 OF 1	AAK14943	
						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 IS: 813-1986.
WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY

REF.DRG.NO.LH14190 Alt '-b/-

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

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WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY

[illegible]

Technical drawing of a mechanical part. The part has a vertical section on the left with a height of 30. The base is 45 wide. On the right, there is a horizontal section with a thickness of 10. The part features several fillets: a small one with radius R1.5 at the top left corner of the vertical section, and two larger ones with radius R5 at the top right corner of the vertical section and at the inner corner of the horizontal section. A dashed semi-circle is shown above the part, indicating a larger radius or a different view.

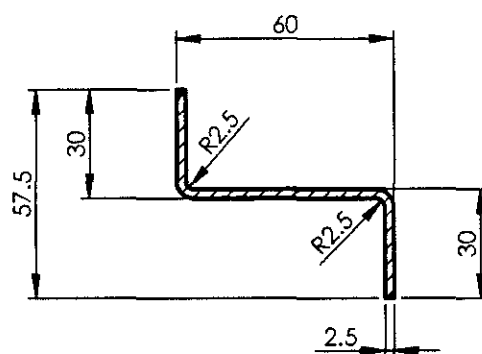
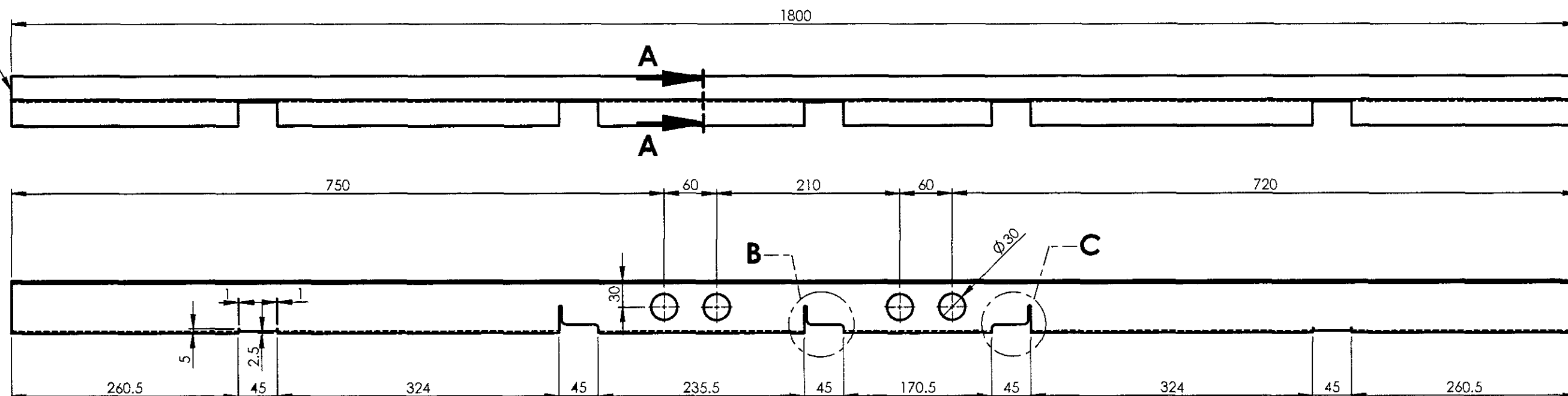
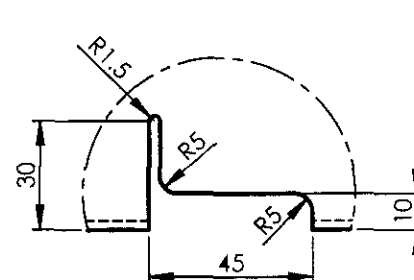
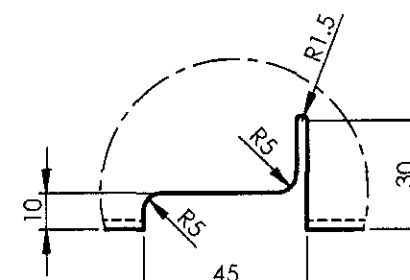
Technical drawing of a mechanical part showing a cross-section. The part has a total width of 45 and a height of 10. It features a semi-circular top profile with a radius of R5. A fillet with a radius of R1.5 is shown at the junction of the top surface and the side wall. A dashed line indicates the original semi-circular profile before the fillet was added.

1	HORIZONTAL MEMBER	2.5x110x1800	1		RDSO/SPEC C- K201 X2CrNi12	3.815	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-4 SIDEWALL ASSEMBLY		SURFACE AREA IN Sq.m.:0.393			WT/ASSY IN Kgs:		
HORIZONTAL MEMBER					SSE/D	[Signature]	
					1:5	CHD	
					ALT.	ALTD	
					DRN	R. SANTHOSH KUMAR	
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1	[Diagram]		
					AAK14944		
					A8		

AAK14945

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

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE

SECTION A-A
SCALE 1 : 2DETAIL B
SCALE 1 : 2DETAIL C
SCALE 1 : 2

1	HORIZONTAL MEMBER	2.5x110x1800	1		RDSO/SPEC C-K201 X2CrNi12	3.82	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-4, SIDEWALL ASSEMBLY.				SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:	
HORIZONTAL MEMBER					SCALE 1:5	SSE/D	
					ALT.	CHD	
						DRN	R. SANTHOSH KUMAR
INDIAN RAILWAY STANDARDS				SHEET 1 OF 1		AAK14945	
INTEGRAL COACH FACTORY, CHENNAI - 600038						A3	

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ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER IS: 813-1986
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REF.DRG.NO.LH14194, Alt 'b/-'

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

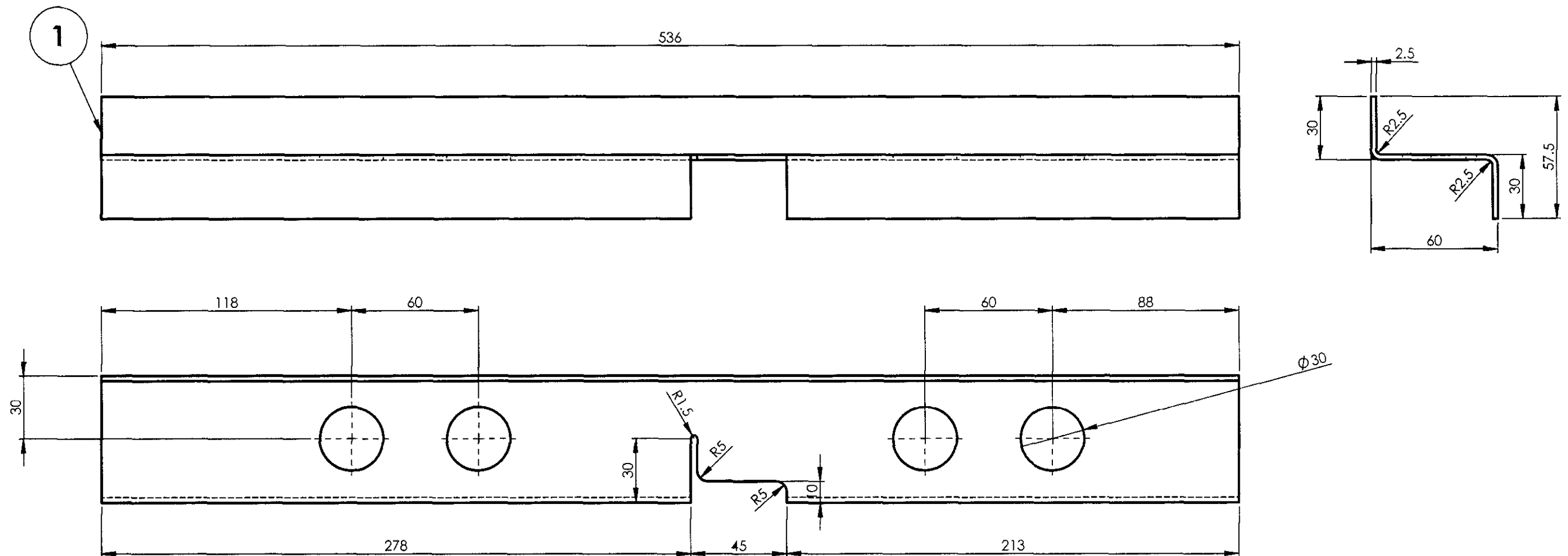
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AAK14946				▽ ROUGH MACHINED		① ROUGH CLEANED		REVISIONS																																																																							
				▽▽ FINISH MACHINED		①b BURRS REMOVED		ALT.		ZONE		DESCRIPTION		APPROVED & DATE																																																																	
				▽▽▽ FINE FINISH MACHINED		⑱ CHAMFERED																																																																									
<div><div>1</div><div><div>323</div><div></div></div><div><div>60</div><div>57.5</div><div>30</div><div>R2.5</div><div>R2.5</div><div>30</div><div>2.5</div></div></div> <div><div>30</div><div><div><div>φ 30</div></div></div><div>83</div><div>60</div></div>																																																																															
<table><tr><td>1</td><td>HORIZONTAL MEMBER</td><td>2.5x110x323</td><td>1</td><td></td><td>RDSO/SPEC C-K201 X2CrNi12</td><td>0.69</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="5">GROUP: 1-4, SIDEWALL ASSEMBLY</td><td colspan="2">SURFACE AREA IN Sq.m.:</td><td>WT/ASSY IN Kgs:</td></tr><tr><td colspan="5">HORIZONTAL MEMBER</td><td>SCALE 1:2</td><td>SSE/D CHD</td><td><div></div></td></tr><tr><td colspan="5"></td><td>ALT.</td><td>ALTD</td><td></td></tr><tr><td colspan="5"></td><td></td><td>DRN</td><td>R. SANTHOSH KUMAR</td></tr><tr><td colspan="5">INDIAN RAILWAY STANDARDS</td><td colspan="2">SHEET 1 OF 1</td><td></td></tr><tr><td colspan="5">INTEGRAL COACH FACTORY, CHENNAI - 600038</td><td colspan="2">AAK14946</td><td>A3</td></tr></table>															1	HORIZONTAL MEMBER	2.5x110x323	1		RDSO/SPEC C-K201 X2CrNi12	0.69		QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS	GROUP: 1-4, SIDEWALL ASSEMBLY					SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:	HORIZONTAL MEMBER					SCALE 1:2	SSE/D CHD	<div></div>						ALT.	ALTD								DRN	R. SANTHOSH KUMAR	INDIAN RAILWAY STANDARDS					SHEET 1 OF 1			INTEGRAL COACH FACTORY, CHENNAI - 600038					AAK14946		A3	
1	HORIZONTAL MEMBER	2.5x110x323	1		RDSO/SPEC C-K201 X2CrNi12	0.69																																																																									
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS																																																																								
GROUP: 1-4, SIDEWALL ASSEMBLY					SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:																																																																								
HORIZONTAL MEMBER					SCALE 1:2	SSE/D CHD	<div></div>																																																																								
					ALT.	ALTD																																																																									
						DRN	R. SANTHOSH KUMAR																																																																								
INDIAN RAILWAY STANDARDS					SHEET 1 OF 1																																																																										
INTEGRAL COACH FACTORY, CHENNAI - 600038					AAK14946		A3																																																																								
<div><div>16-07-2025</div><div>DATE OF LATEST ALT.</div><div>DATE OF FIRST ISSUE</div><div>AME/SME</div></div> <div>REF.DRG.NO.LH14189 Alt -/-</div>																																																																															
1		2		3		4		5		6		7		8																																																																	

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AAK14947

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

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



1	HORIZONTAL MEMBER	2.5x110x536	1		RDSO/SPEC C-K201 X2CrNi12	1.11	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-4, SIDEWALL ASSEMBLY				SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:	
HORIZONTAL MEMBER					SCALE	SSE/D	
					1:2	CHD	
					ALT.	ALTD	
INDIAN RAILWAY STANDARDS						DRN	R. SANTHOSH KUMAR
INTEGRAL COACH FACTORY, CHENNAI - 600048					SHEET 1 OF 1	AAK14947	
						A3	

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REF.DRG.NO.LH14193 'a'

DATE OF LATEST ALT.

16-07-2025

DATE OF FIRST ISSUE

AME/SME

INDIAN RAILWAY STANDARDS

INTEGRAL COACH FACTORY, CHENNAI - 600048

SHEET
1 OF 1

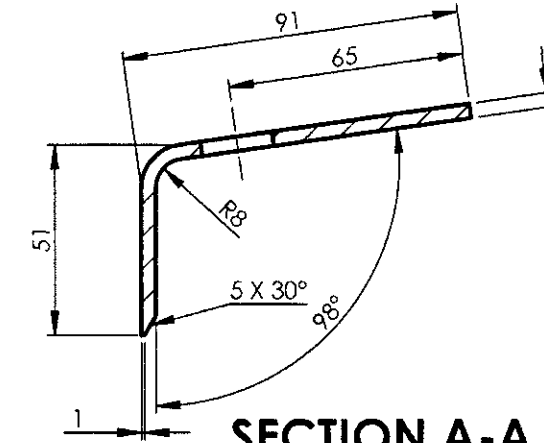
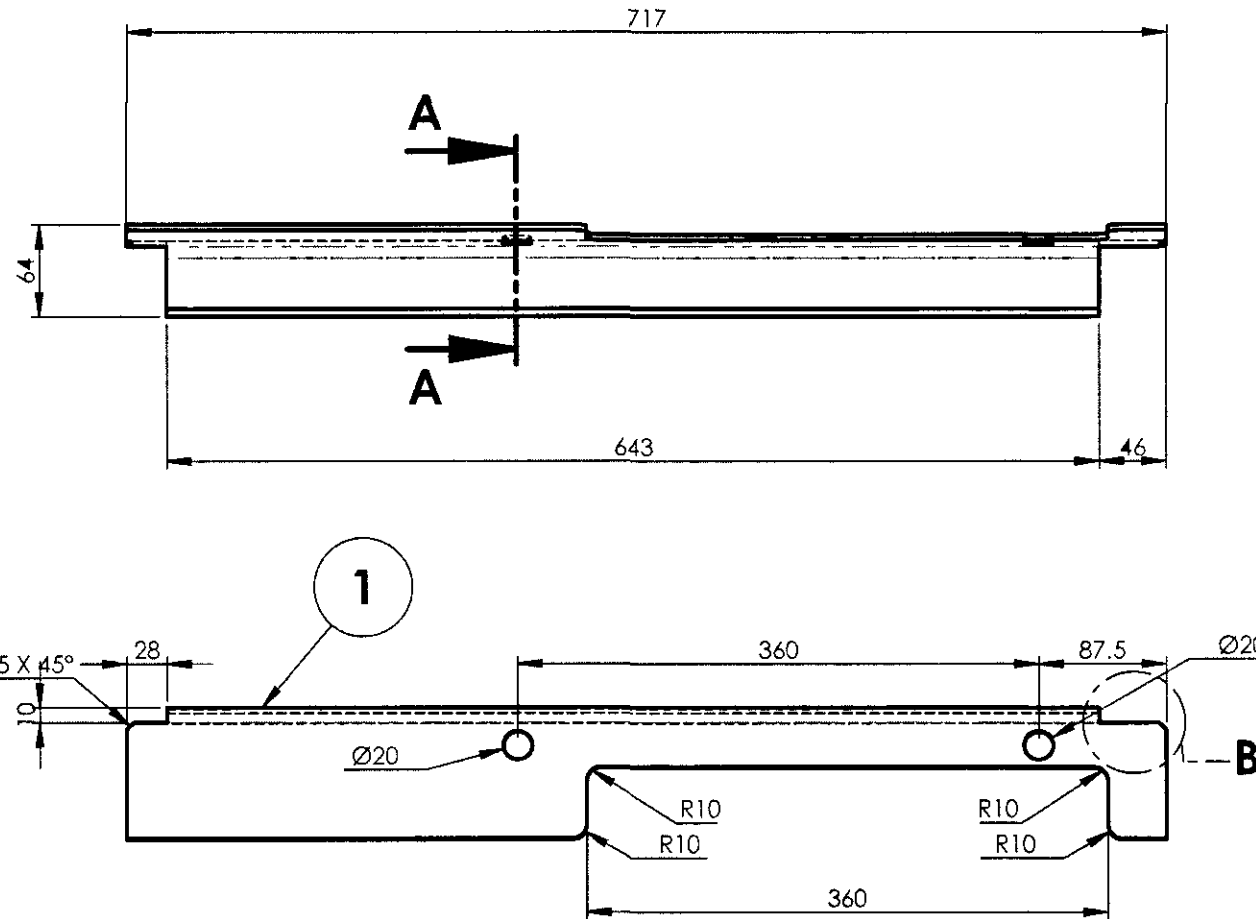
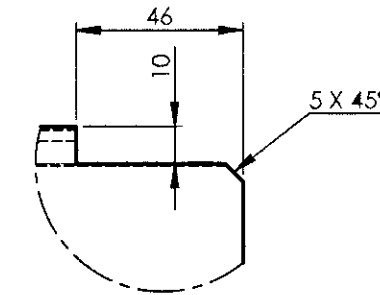
AAK14947

A3

AAK14948

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

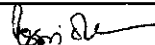
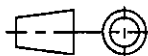
REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE

SECTION A-A
SCALE 1 : 2DETAIL B
SCALE 1 : 2

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

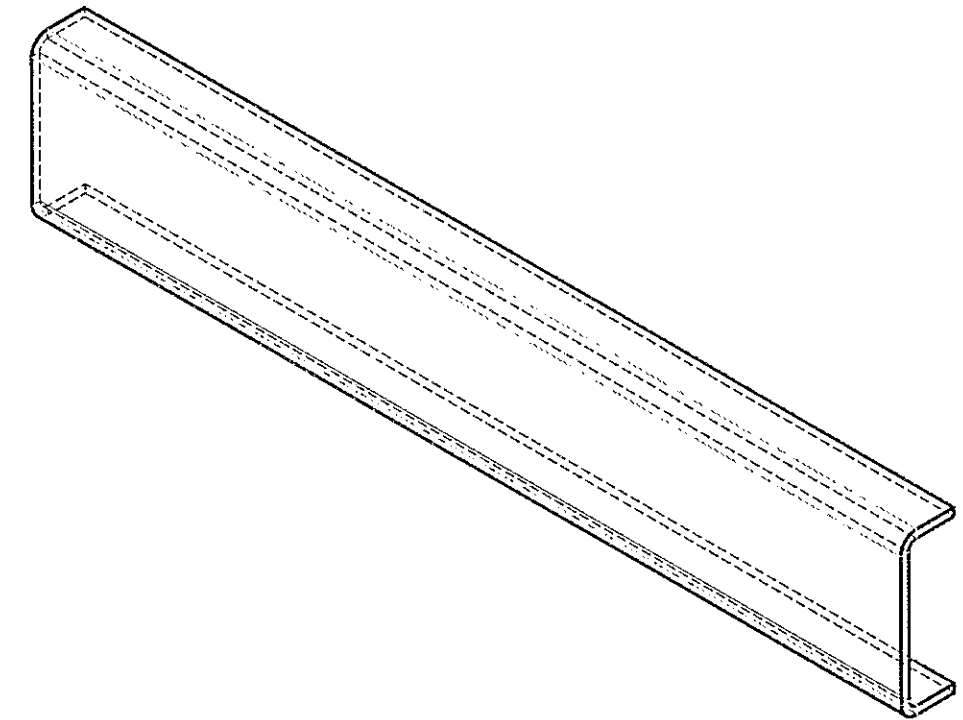
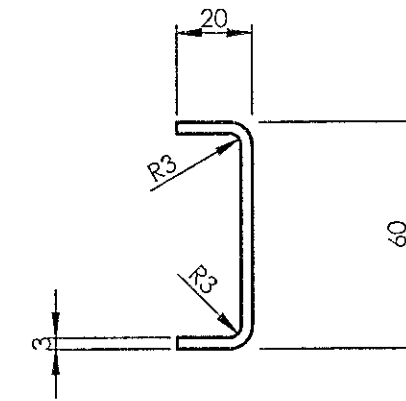
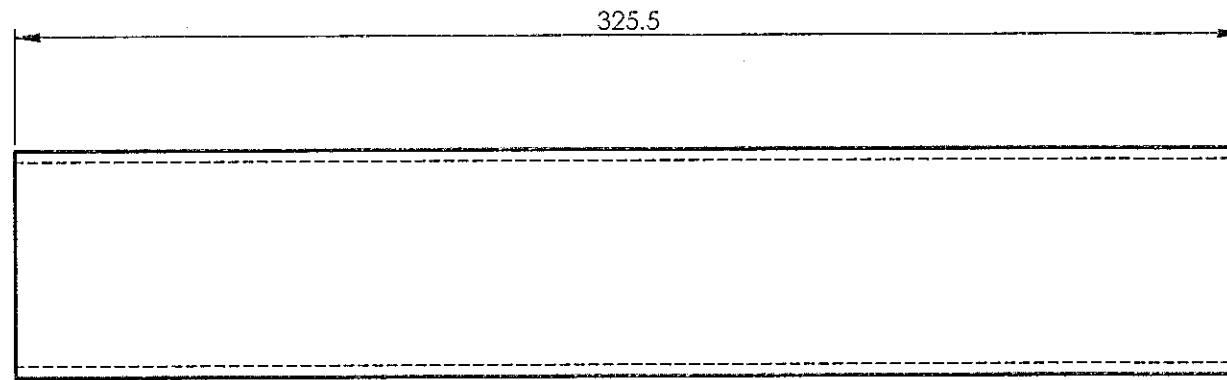
REF.DRG.NO.LH14153

DATE OF LATEST ALT.	16-07-2025	AME/SME
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1	STIFFENING ANGLE - RH	4x135x717	1		RDSO/SPEC C- K201 X2CrNi12	2.350	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-4 Body Side Walls		SURFACE AREA IN Sq.m.:0.156			WT/ASSY IN Kgs:		
STIFFENING ANGLE - RH					SCALE	SSE/D	
					1:5	CHD	
					ALT.	ALTD	
						DRN	R. SANTHOSH KUMAR
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038							
					SHEET 1 OF 1		AAK14948

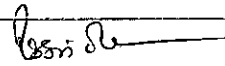
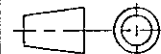
▽ ROUGH MACHINED	① ROUGH CLEANED
▽▽ FINISH MACHINED	①b BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	⑧ CHAMFERED

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



REF.DRG.NO.-

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

1	CHANNEL	3x88x325.5	1		RDSO SPEC C- K201 X2 Cr Ni 12	0.70	
QTY.	DESCRIPTION	DIMENSIONS	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:		
CHANNEL				SCALE	SSE/D		
				1:2	CHD		
				ALT.	ALTD	R. SANTHOSH KUMAR	
					DRN		
INDIAN RAILWAY STANDARDS				SHEET 1 OF 1			A3
INTEGRAL COACH FACTORY, CHENNAI - 600038							
				AAL14268			

1		2		3		4		5		6		7		8		
AAL14270				▽ ROUGH MACHINED		① ROUGH CLEANED		REVISIONS								
				▽▽ FINISH MACHINED		② BURRS REMOVED		ALT.		ZONE		DESCRIPTION			APPROVED & DATE	
				▽▽▽ FINE FINISH MACHINED		③ CHAMFERED										
A				B												
B				C												
C				D												
D				E												
E				F												
F																

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

NOTE:

1. 'L' DIMENSION SPECIFIED ONLY IN THE ASSEMBLY DRAWING WHERE IT IS REQUIRED.

1	BACKPIECE	3x17xL	1		RDSO SPEC C-K201 X2 Cr Ni 12	0.04					
QTY.	DESCRIPTION	DIMENSIONS	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:				
BACKPIECE					SCALE 1:1	SSE/D CHD					
					ALT.	ALTD					
										DRN	R. SANTHOSH KUMAR
INDIAN RAILWAY STANDARDS				SHEET 1 OF 1		A3					
INTEGRAL COACH FACTORY, CHENNAI - 600038						AAL14270					
REF.DRG.NO.		DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME							
		5-10-2025									

1		2		3		4		5		6		7		8	
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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 S13-1986. WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY



01	ROUGH CLEANED
01b	BURRS REMOVED
18	CHAMFERED


REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE
a		LOCATING DIMENSION FOR ITEMS-9,10 & 11 ADDED. WELDING OF ITEM-2 WITH ITEM-1 INTRODUCED IN SECTION-BB.	-Sd-
b		ITEM-9,10 & 11 DELETED. MANDATORY ALLOWANCES AND WELDING NOTATIONS ADDED.	-sd-
c		ITEM-3 DELETED. ITEM-12 ADDED	-sd-
d		WELDING DETAILS ALTERED FOR ITEM-5, 6 & 7	-sd-
e		ITEM-13 ADDED AND LOCATING DIMENSION OF ITEMS-6,8 & 12 ALTD.	-sd-
f		VIEWS UPDATED AS PER CHANGES IN ITEM - 2.	-sd-
g		VIEWS UPDATED AS PER CHANGES IN ITEM - 1.	-sd-
h		NOTE-4 ADDED.	



z2 1963

1. ALL WELD SPATTERS SHALL BE GROUND.
2. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
3. ALL WELDINGS SHALL BE TIG WELDING UNLESS OTHERWISE SPECIFIED.
4. ALTERNATIVELY AISI 304 / SS 304 (X02Cr19Ni10) / IS 6911 (X04Cr19Ni9) ARE ALSO ACCEPTABLE.

	FLAT FOR DOOR	5x50x60	13		RD50/SPEC C-K201 X5 Cr Ni 18 10	0.120	
3	WEB		12	AAB14289		0.42	
+	FLAT FOR PARTITION		11	AAA14805		0.168	
+	FLAT FOR PARTITION		10	AAA14804		1.999	
+	FLAT FOR PARTITION		9	AAA14803		0.638	
1	FLAT FOR DOOR		8	AAA14798		0.021	
1	FLAT FOR DOOR		7	AAA14796		0.840	
1	FLAT FOR DOOR		6	AAA14797		1.379	
3	SUPPORT		5	AAA14402		0.416	
2	BACK PIECE		4	AAA14398		0.075	
+	WEB		3	AAA14401		0.201	
1	DOOR PILLAR FLANGE		2	AAA14400		3.573	
1	DOOR POST LEFT		1	AAA14399		11.545	
QTY.	DESCRIPTION	DIMENSION	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS

GROUP. 14	SURFACE AREA IN Sq.m.: 2.205		WT/ASSY IN Kgs:	
DOOR POST LEFT			SCALE 1:5	SSE/D CHD
			ALT h	ALTD RAVI
			DRN	K.Sethuraman
				
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038		SHEET 1 OF 1	SSA14024	



11-02-2026	09-01-2013	<i>[Signature]</i>
DATE OF LATEST ALT	DATE OF FIRST ISSUE	AME/SME

INDIAN RAILWAY STANDARDS
INTEGRAL COACH FACTORY, CHENNAI - 600038

SHEET
1 OF 1

SSA14024

A2

SSA14025

2

3

1

4

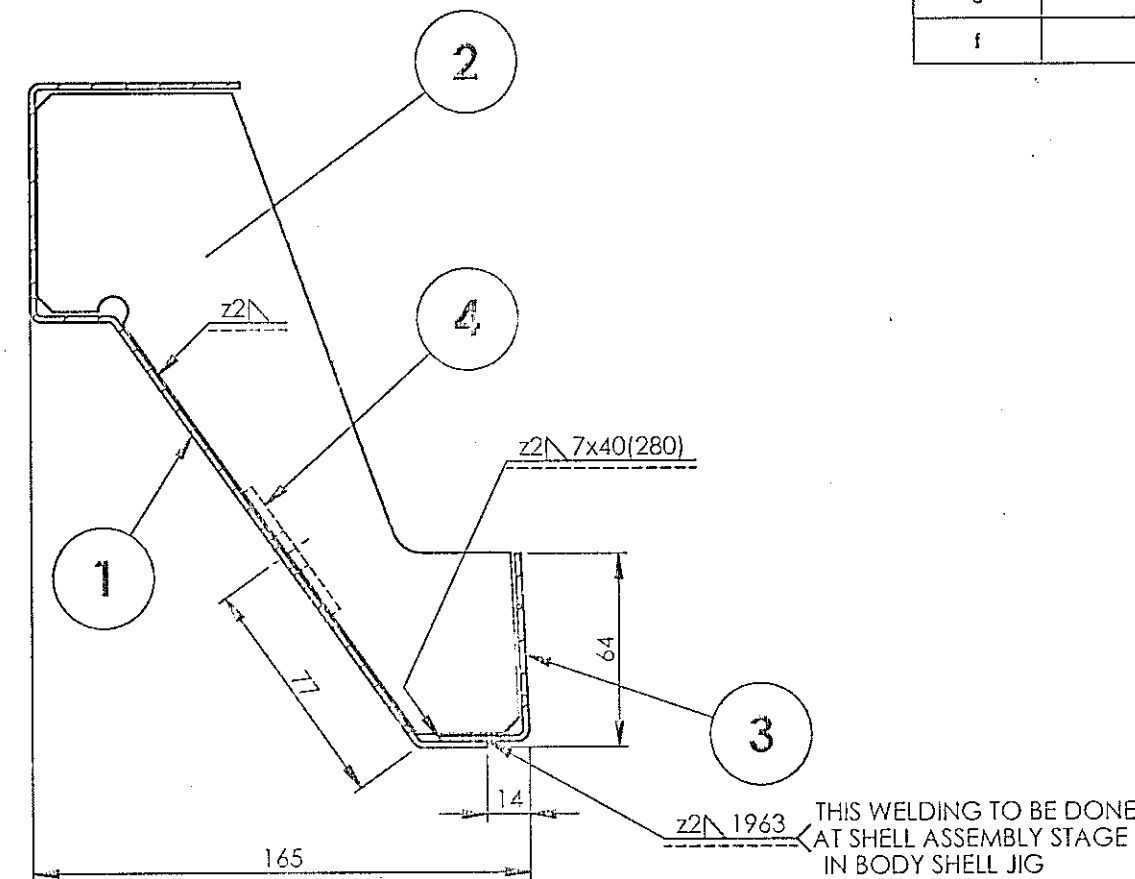
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▽ ROUGH MACHINED
▽▽ FINISH MACHINED
▽▽▽ FINE FINISH MACHINED

01 ROUGH CLEANED
010 BURRS REMOVED
06 CHAMFERED

REVISIONS

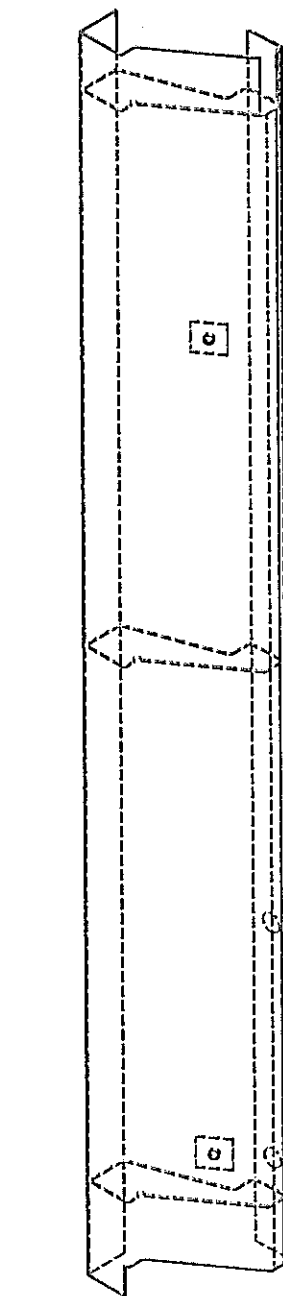
ALT.	ZONE	DESCRIPTION	APPROVED & DATE
a		LOCATING DIMENSION FOR ITEMS-5,6 & 7 ADDED.WELDING OF ITEM-3 WITH ITEM-1 INTRODUCED.	-Sd-
b		ITEMS-2,5, 6 & 7 DELETED.MANDATORY ALLOWANCES, WELDING NOTATIONS AND ITEM-8 ADDED.	-Sd-
c		ITEM-8 DELETED. ITEM-2 RECALLED.	-Sd-
d		LOCATING DIMENSION OF ITEM-2 ALTD.	-Sd-
e		VIEWS UPDATED AS PER CHANGES IN ITEM-3.	-Sd-
f		VIEWS UPDATED AS PER CHANGES IN ITEM-1.	-Sd-



SECTION A-A
SCALE 1 : 2.5

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.
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.



ISOMETRIC VIEW

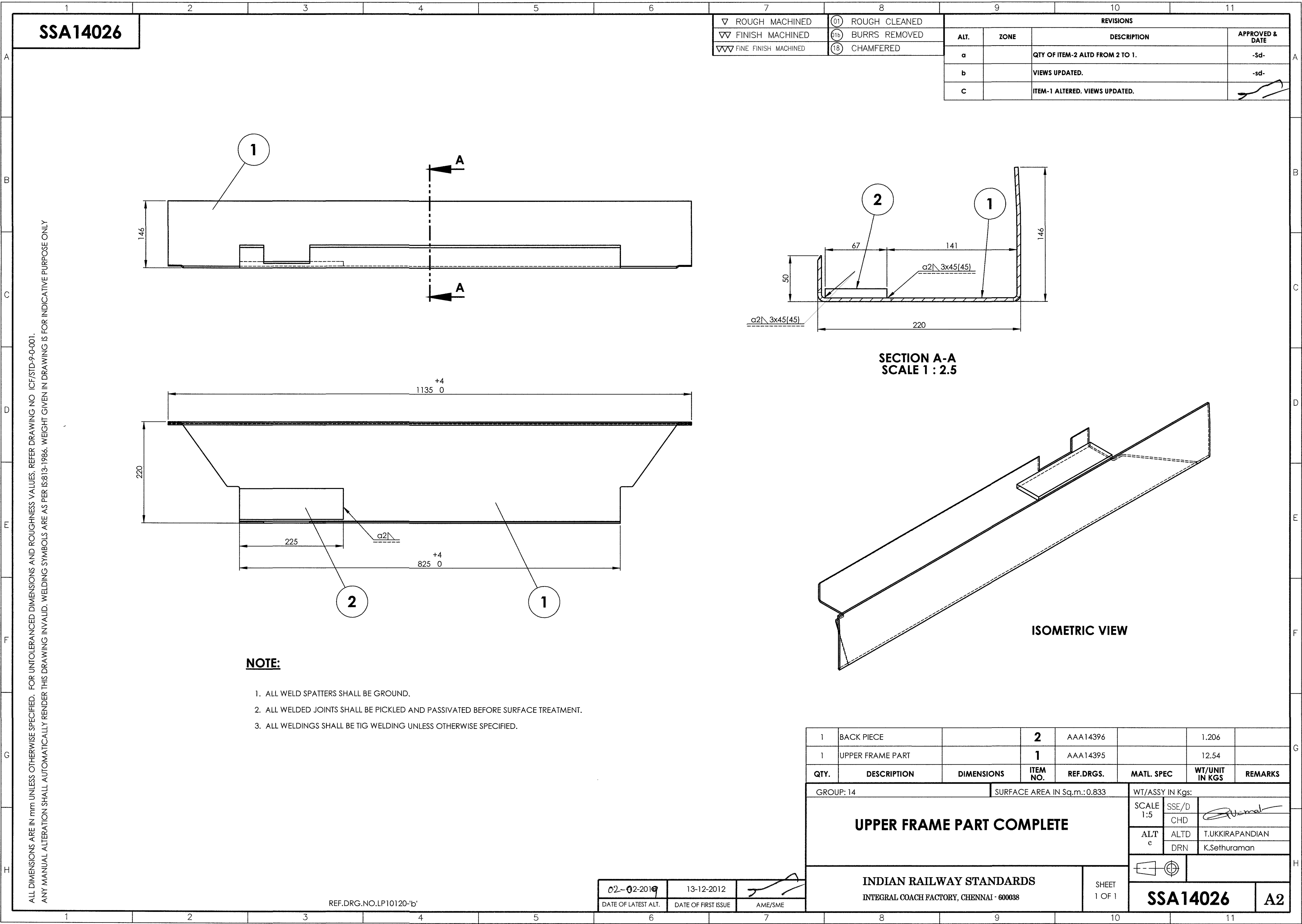
3	WEB		8	AAA14289		0.43	
1	FLAT FOR PARTITION		7	AAA14803		0.638	
1	FLAT FOR PARTITION		6	AAA14804		1.999	
1	FLAT FOR PARTITION		5	AAA14805		0.168	
2	BACK PIECE		4	AAA14398		0.075	
1	ANGLE FOR DOOR POST		3	AAA14393		2.729	
3	WEB		2	AAA14401		0.41	
1	DOOR POST RIGHT		1	AAA14392		11.545	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MAT.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-4			SURFACE AREA IN Sq.m.: 1.899		WT/ASSY IN Kgs:		
DOOR POST R.H				SCALE 1:5	SSE/D		
				ALT f	CHD		
				ALT f	DRN		
INDIAN RAILWAY STANDARDS				SHEET 1 OF 1		SSA14025	
INTEGRAL COACH FACTORY, CHENNAI - 600038						A2	

23-01-2026	09-01-2013	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	A.M.E./S.M.E.

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

MANDATORY MANUFACTURING ALLOWANCES.

REF.DRG.NO.LP10115-G



SSA14026

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

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE
a		QTY OF ITEM-2 ALTD FROM 2 TO 1.	-sd-
b		VIEWS UPDATED.	-sd-
c		ITEM-1 ALTERED. VIEWS UPDATED.	

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. WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY

NOTE:

1. ALL WELD SPATTERS SHALL BE GROUND.
2. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
3. ALL WELDINGS SHALL BE TIG WELDING UNLESS OTHERWISE SPECIFIED.

1	BACK PIECE		2	AAA14396		1.206	
1	UPPER FRAME PART		1	AAA14395		12.54	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL. SPEC	WT/UNIT IN KGS	REMARKS
GROUP: 14				SURFACE AREA IN Sq.m.: 0.833		WT/ASSY IN Kgs:	
UPPER FRAME PART COMPLETE					SCALE 1:5	SSE/D	
					CHD		
					ALT c	ALTD	T.UKKIRAPANDIAN
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038					DRN		K.Sethuraman
					SHEET 1 OF 1		
						SSA14026	A2

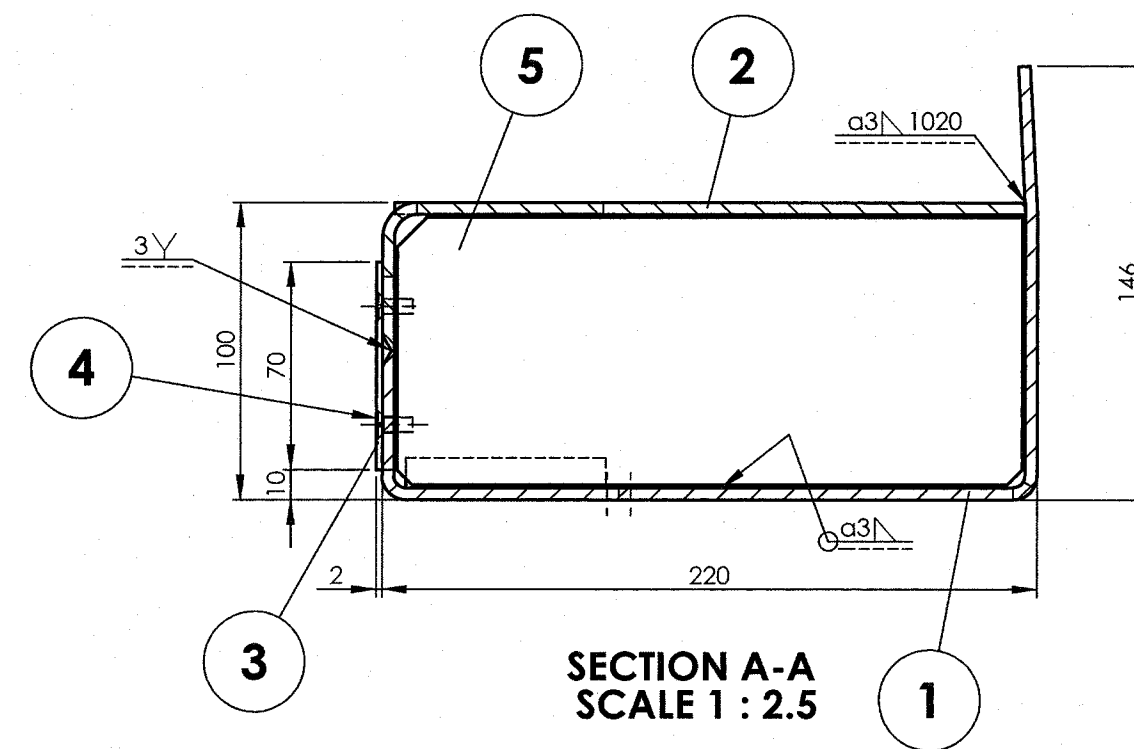
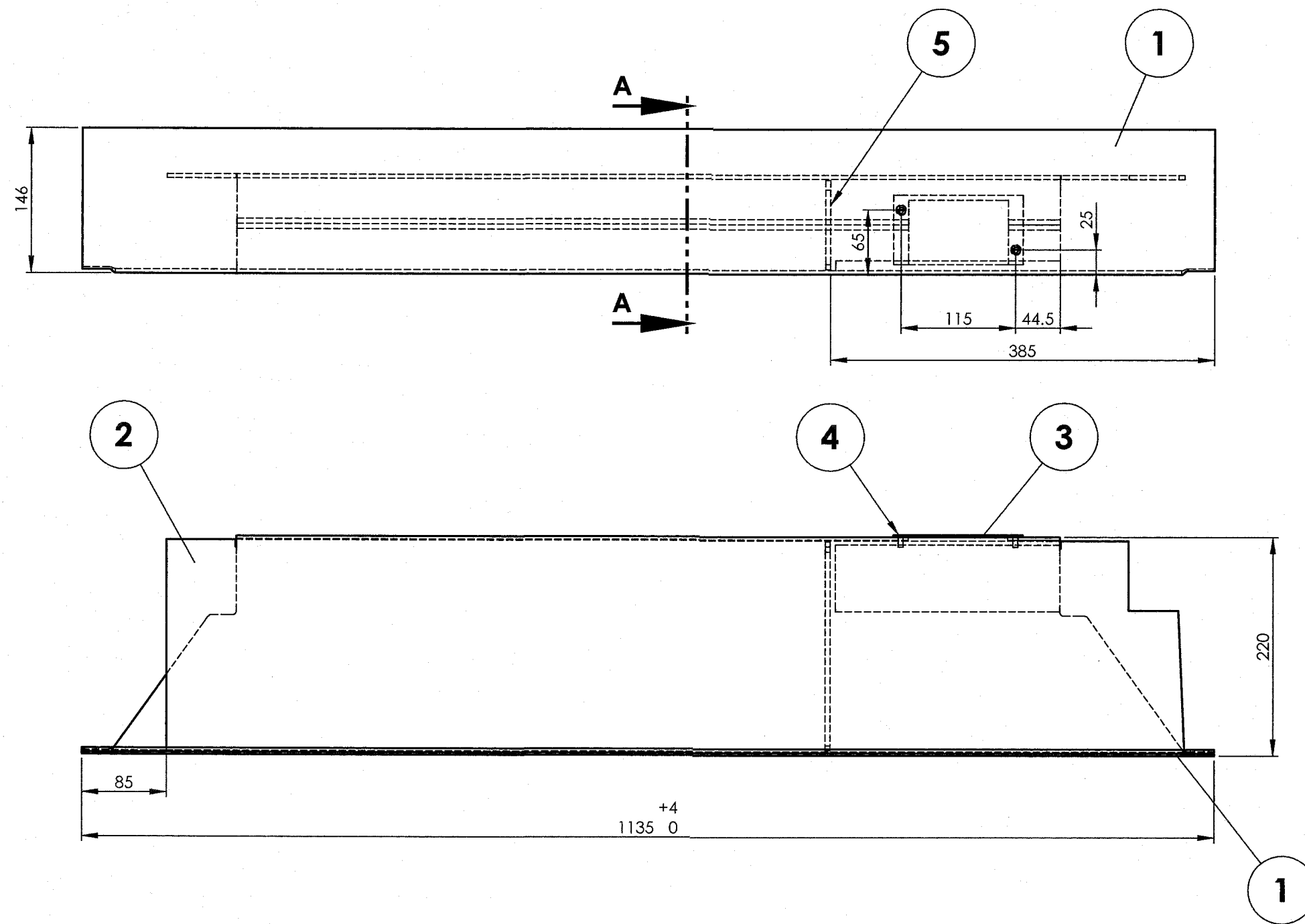
02-02-2019	13-12-2012	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

REF.DRG.NO.LP10120-'b'

SSA14027

▽ ROUGH MACHINED	① ROUGH CLEANED
▽▽ FINISH MACHINED	①① BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	①①① CHAMFERED

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE
a		DRG VIEWS UPDATED.	-Sd-
b		ITEMS-4,5 & WELDING NOTE ADDED. VIEWS UPDATED.	-Sd-
c		ITEM-2 ALTERED. ITEM-3 RM SIZE ALTD. M5 CSK SCREW PITCH ALTD TO 115mm. ITEM-5 ADDED AND VIEWS UPDATED.	



NOTE:

1. ALL WELD SPATTERS SHALL BE GROUND.
2. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
3. 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.

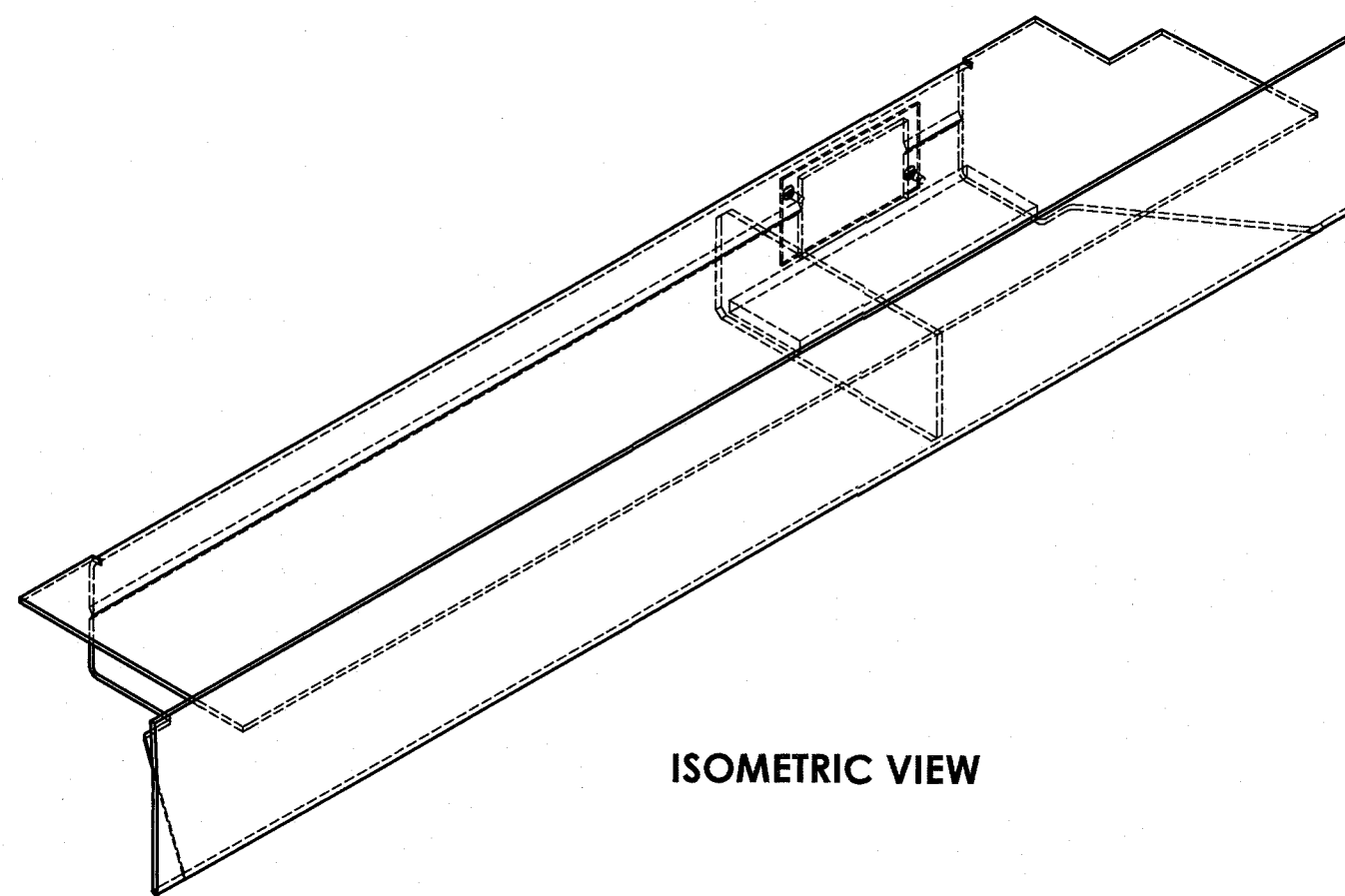
ALL NDT (RT/UT/MPT/DPT) SHALL BE PERFORMED BY PERSONNEL CERTIFIED ACCORDING TO ISO-9712/ASNT/ISNT LEVEL-2 AND SHALL BE DOCUMENTED.

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

* THE PERCENTAGES EXPRESSED, REFER TO THE TOTAL LENGTH TO BE EXAMINED FOR ONE GIVEN WELD. THUS: -100% MEANS: TESTING THE ENTIRE LENGTH OF THE WELD AND ON ALL THE PIECES BUILT.

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

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



ISOMETRIC VIEW

REF.DRG.NO.LP10118-'a'

02-02-2019	09-01-2013	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

1	RIB		5	AAE14185		0.75	
2	COUNTER SUNK FLAT HEAD SCREW	M5x12- A2-70	4	IS: 1365			
1	CLOSING PLATE	2x70x130	3		RDSO/SPEC C- K201 X2CrNi12	0.15	
1	UPPER FRAME PART		2	AAA14397		7.861	
1	UPPER FRAME PART		1	SSA14026		13.749	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS

GROUP: 1-4 SIDE WALL ASSY.

SURFACE AREA IN Sq.m.: 1.396

WT/ASSY IN Kgs:

UPPER FRAME COMPLETE

SCALE 1:5	SSE/D CHD	
ALT c	ALTD DRN	T.Ukkirapandian K.Sethuraman

INDIAN RAILWAY STANDARDS
INTEGRAL COACH FACTORY, CHENNAI - 600038

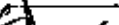
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1 OF 1

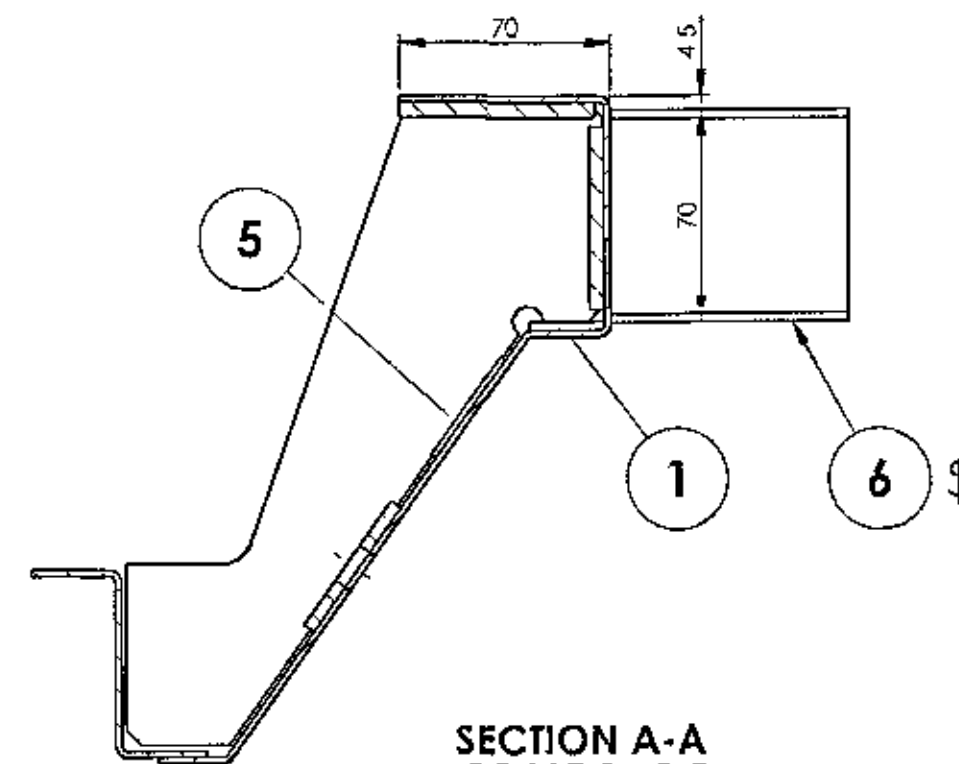
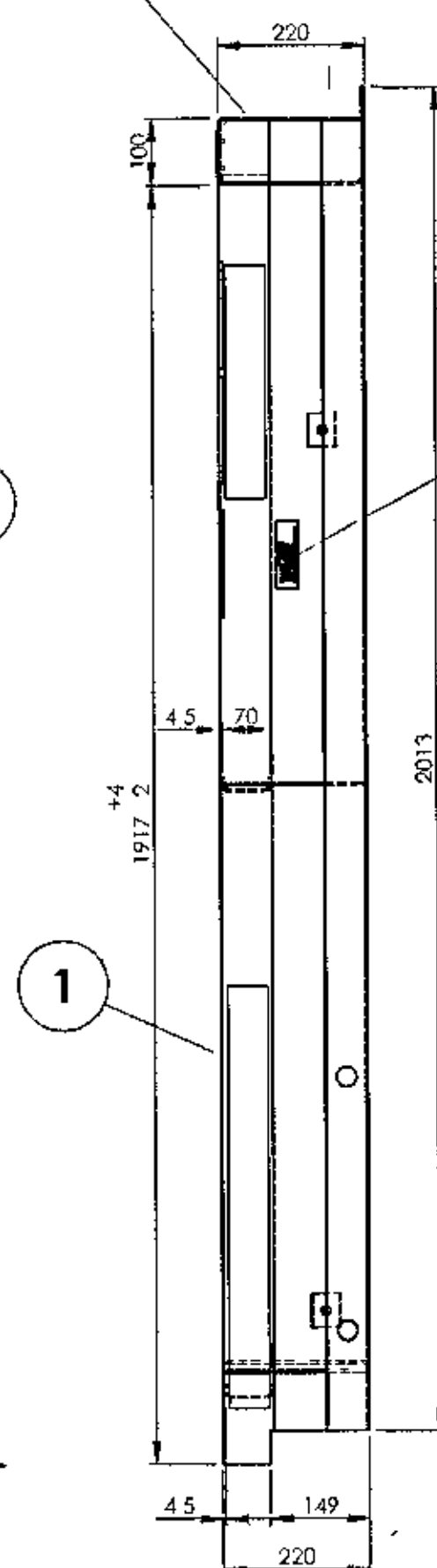
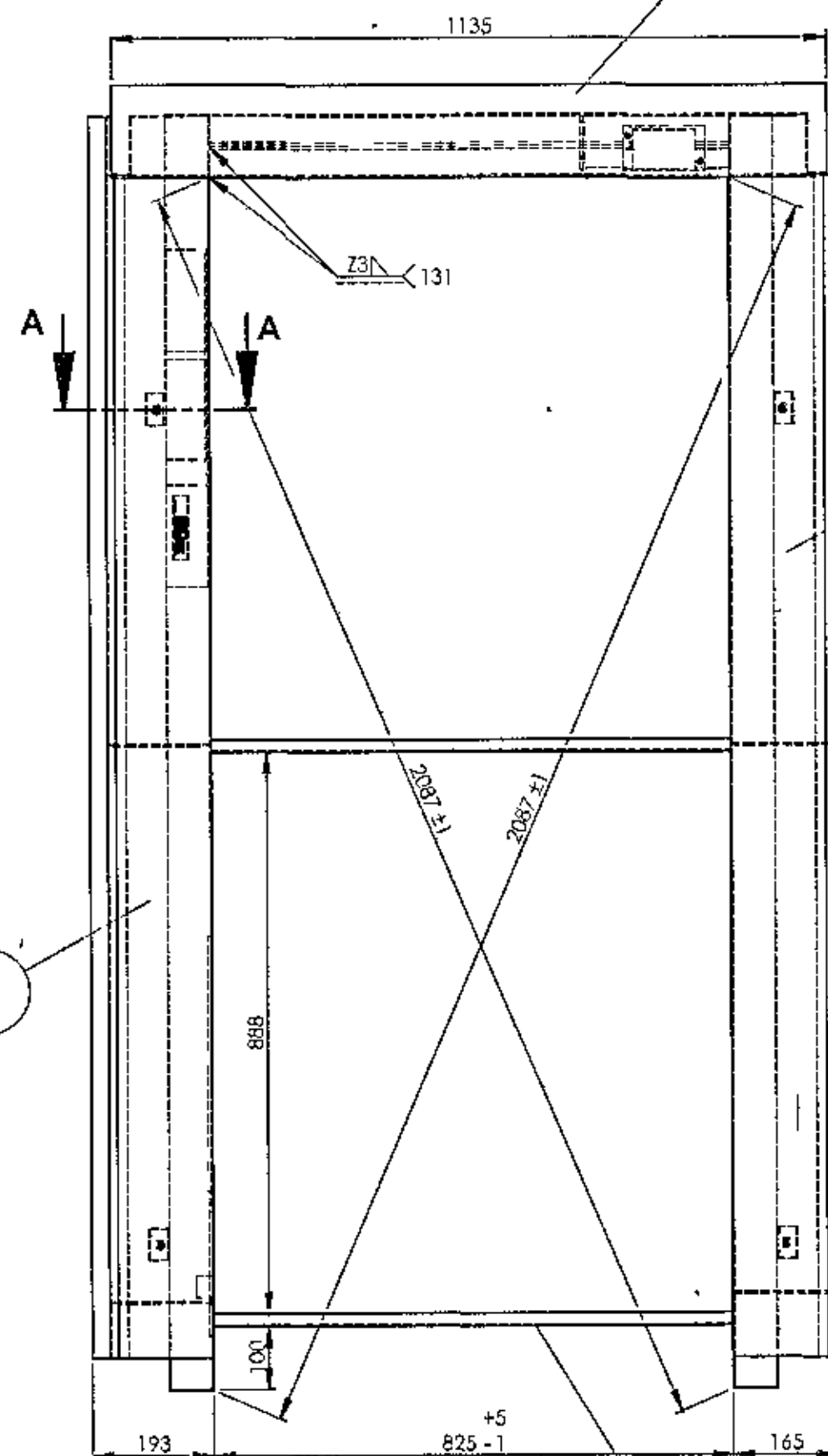
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A2

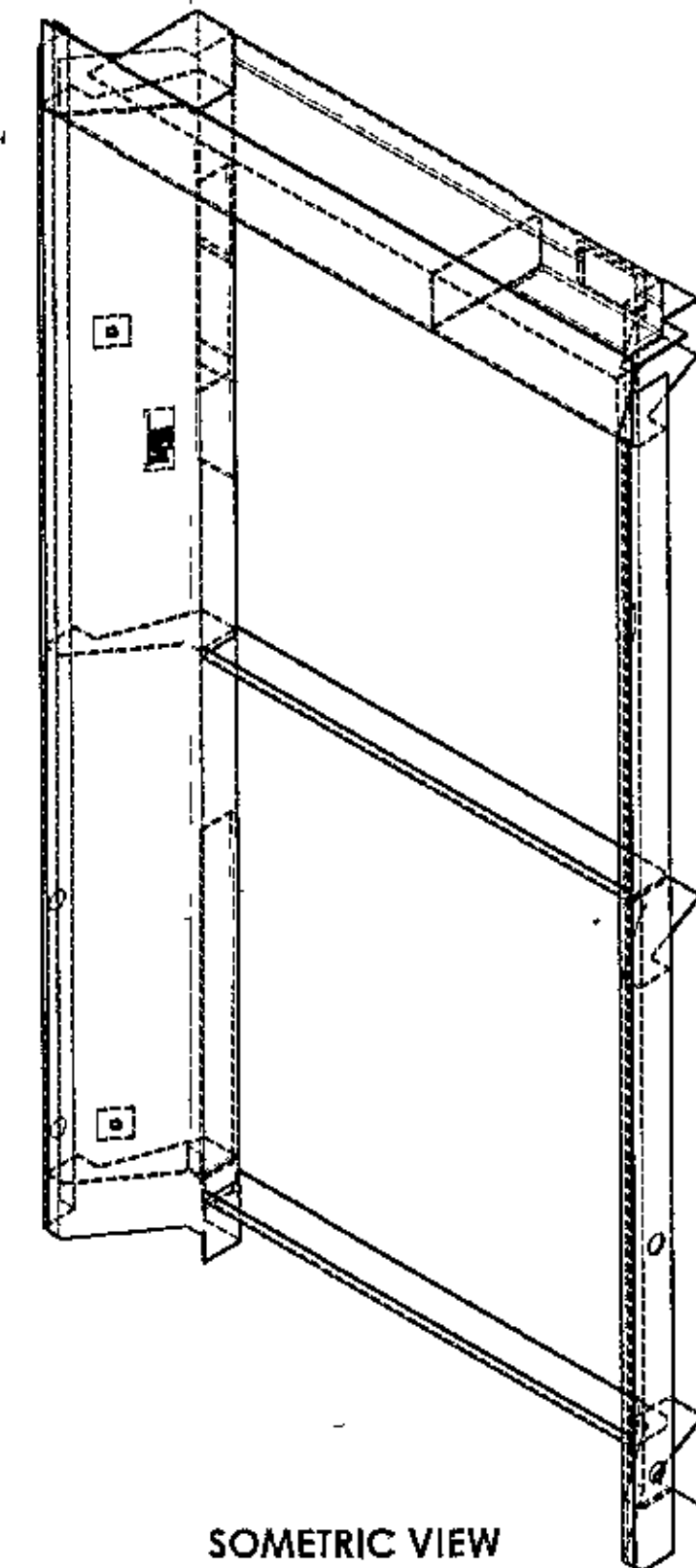
SSA14028

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

REVISIONS			
ALT	ZONE	DESCRIPTION	APPROVED & DATE
c		DRG VIEWS UPDATED	sd
d		NOTES REVISED	-sd-
e		VIEWS UPDATED AS PER CHANGES IN ITEM 1 & 2	sd
f		ITEM-4 DELETED ITEM-6 ADDED NOTE-11 AND VIEWS UPDATED	

SECTION A-A
SCALE 1 : 2.5**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 FINISHED ASSEMBLY SHALL BE APPLIED WITH (AIRLESS SPRAY) ECO FRIENDLY WATER BASED MODIFIED EPOXY ZINC PHOSPHATE ETCH PRIMER TO ICF/MD/SPEC-231 LATEST REVISION
- 10 ITEM-5 (NAME PLATE) SHALL BE WELDED OR RIVETED AT SUITABLE LOCATION AS SHOWN IN THE DRAWING IF PROCURED FROM TRADE
- 11 ITEM-6 (DUMMY ITEM) SHALL BE TACK WELDED AND TO BE REMOVED IN SHELL ASSEMBLY STAGE
- 12 PROFILE OF DOOR CUT OUT ASSY TO BE CHECKED USING TEMPLATE TO DRAWING NO J&T/T-1504/01 LATEST REVISION



ISOMETRIC VIEW

2	CHANNEL		6	AA14041		1,983	
1	NAME PLATE FOR SUPPLIER IDENTIFICATION		5	AAA51072		0.063	
3	ANGLE		4	AAA14806		1.099	
1	UPPER FRAME COMPLETE		3	SSA14027		22.511	
1	DOOR POST R.H		2	SSA14025		15.666	
1	DOOR POST LEFT		1	SSA14024		20.125	
QTY	DESCRIPTION	DIMENSIONS	ITEM NO	REF DRGS	MATL	WT/UNIT IN KGS	REMARKS

GROUP 1.4 SURFACE AREA IN Sq m 5.851

WT/ASSY IN Kgs

DOOR CUT OUT ASSEMBLY

SCALE 1:10

SSE/D

CHD

ALT f

ALT g

DRN

T Ukkirapandian

K Sethuraman

INDIAN RAILWAY STANDARDS

INTEGRAL COACH FACTORY, CHENNAI 600038

SHEET 1 OF 1

SSA14028**A2**

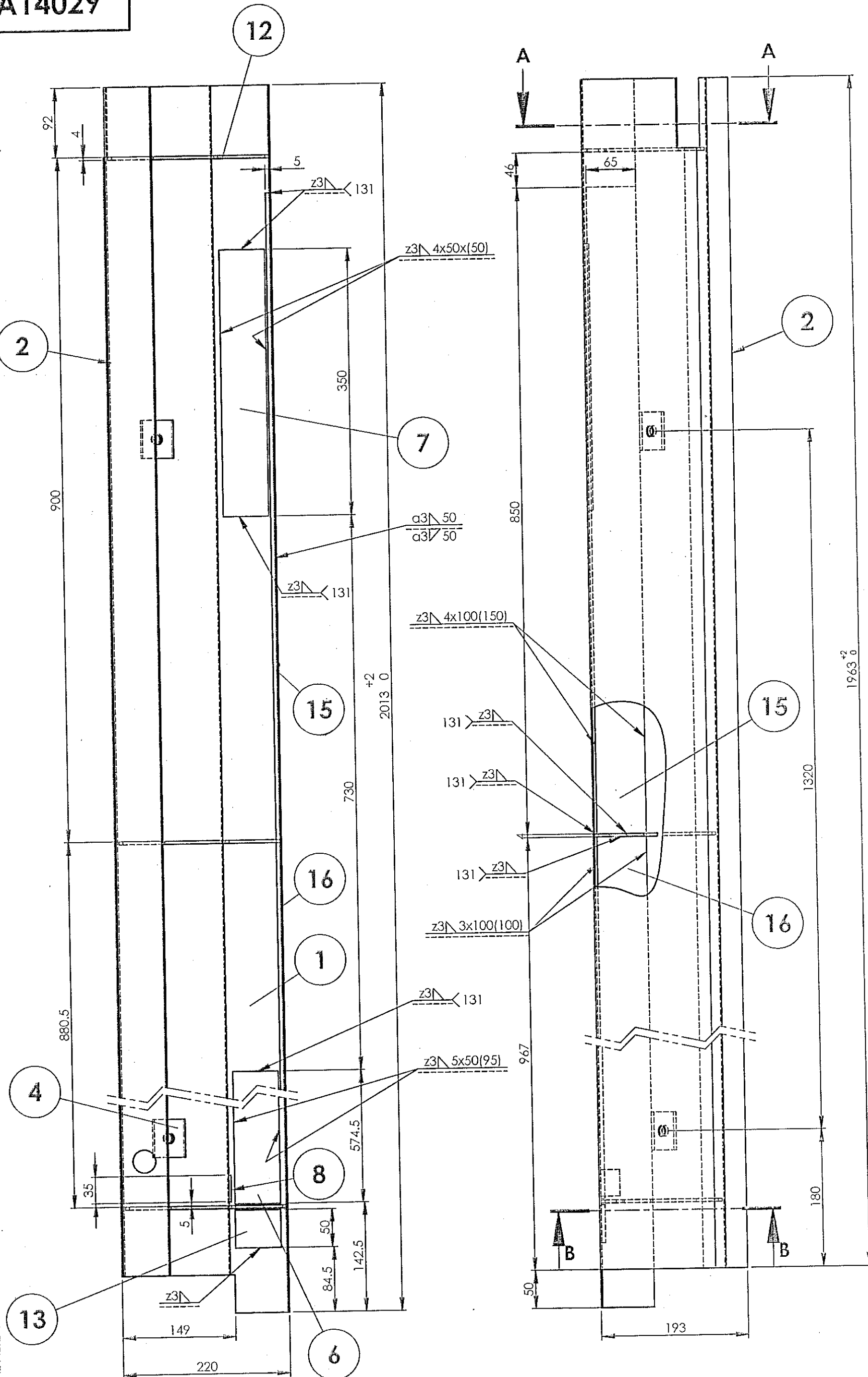
03-03-2026	09-01-2013	
DATE OF LATEST ALT	DATE OF ISSUE	AME/SM

REF DRG NO LP10112 ALT f

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.


SSA14029

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.

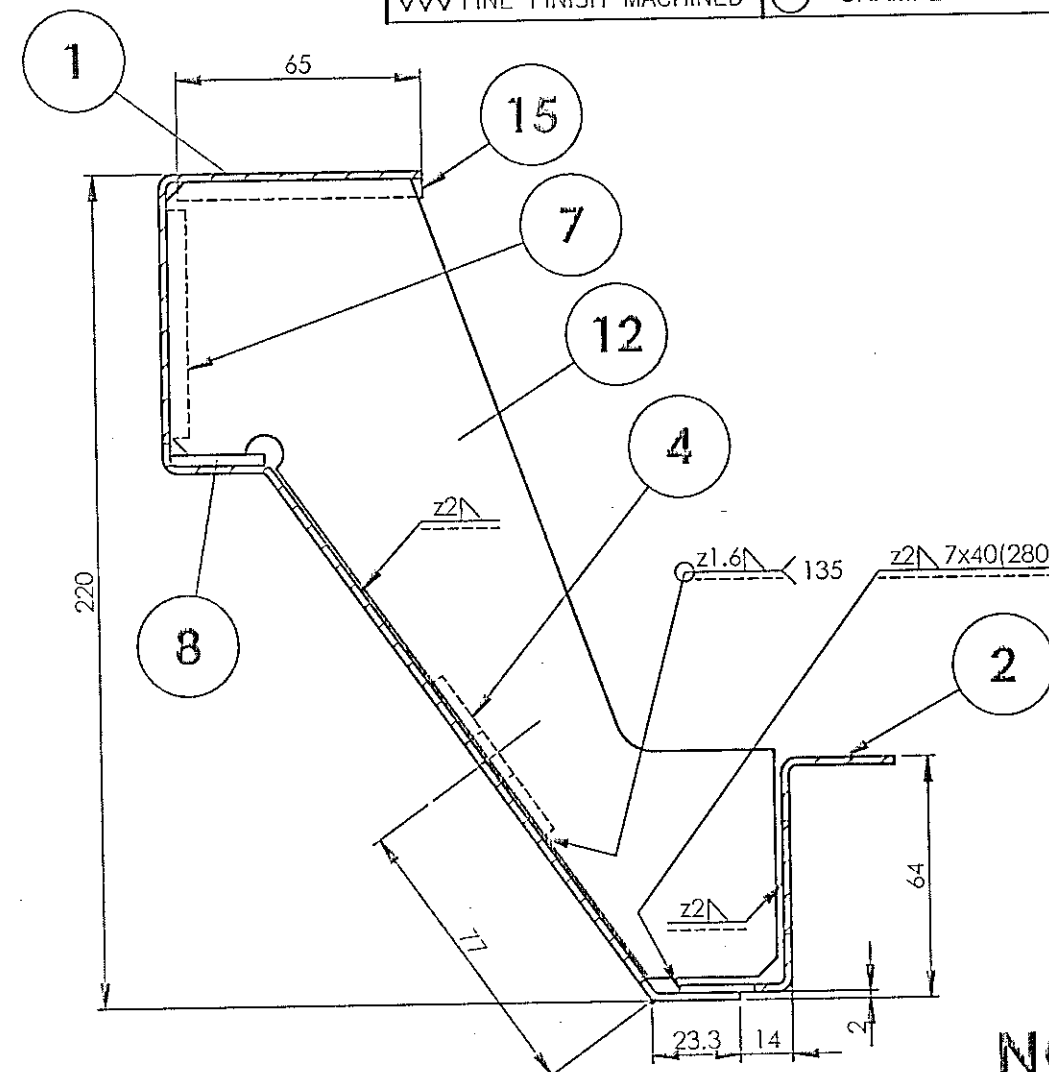
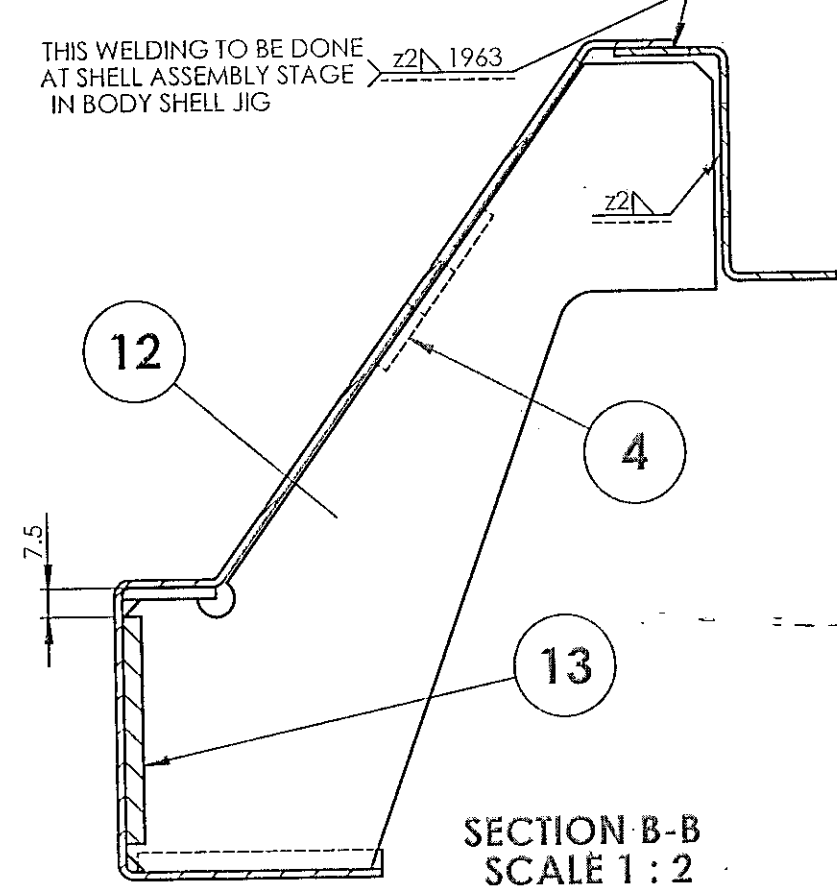


REF.DRG.NO.LP10128-'g'

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

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE
j		VIEWS UPDATED AS PER CHANGES IN ITEM-2.	-sd-
k		ITEM-14 DELETED. ITEM-15 & 16 ADDED. VIEWS UPDATED AS PER CHANGES IN ITEM-1.	

THIS WELDING TO BE DONE AT SHELL ASSEMBLY STAGE IN BODY SHELL JIG

SECTION A-A
SCALE 1:2SECTION B-B
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 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. ALTERNATIVELY AISI-304/SS-304 (X02Cr19Ni10)/IS:6911(X04Cr19Ni9) ALSO ACCEPTABLE.

QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL	WT/UNIT IN KGS	REMARKS
1	BACK PIECE	5x65x500	16		RDSO SPEC C-K201 X5 Cr Ni 18 10	1.30	
1	BACK PIECE	5x65x850	15		RDSO SPEC C-K201 X5 Cr Ni 18 10	2.21	
2	BACK PIECE	5x65x400	14		RDSO SPEC C-K201 X5 Cr Ni 18 10	1.04	
1	FLAT FOR DOOR	5x50x60	13		RDSO/SPEC C-K201 X5 Cr Ni 18 10	0.120	
3	WEB		12	AAA14289		0.42	
+	FLAT FOR PARTITION		11	AAA14805		0.168	
+	FLAT FOR PARTITION		10	AAA14804		1.999	
+	FLAT FOR PARTITION		9	AAA14803		0.638	
1	FLAT FOR DOOR		8	AAA14798		0.021	
1	FLAT FOR DOOR		7	AAA14796		0.840	
1	FLAT FOR DOOR		6	AAA14797		1.379	
3	SUPPORT		5	AAA14402		0.416	
2	BACK PIECE		4	AAA14398		0.075	
+	WEB		3	AAA14401		0.201	
1	DOOR PILLAR FLANGE		2	AAA14405		3.581	
1	DOOR POST RIGHT		1	AAA14392		11.545	

GROUP: 1-4 SURFACE AREA IN Sq.m.: 2.327 WT/ASSY IN Kgs:

DOOR POST RIGHT

INDIAN RAILWAY STANDARDS
INTEGRAL COACH FACTORY, CHENNAI - 600038

SHEET
1 OF 1**SSA14029****A2**

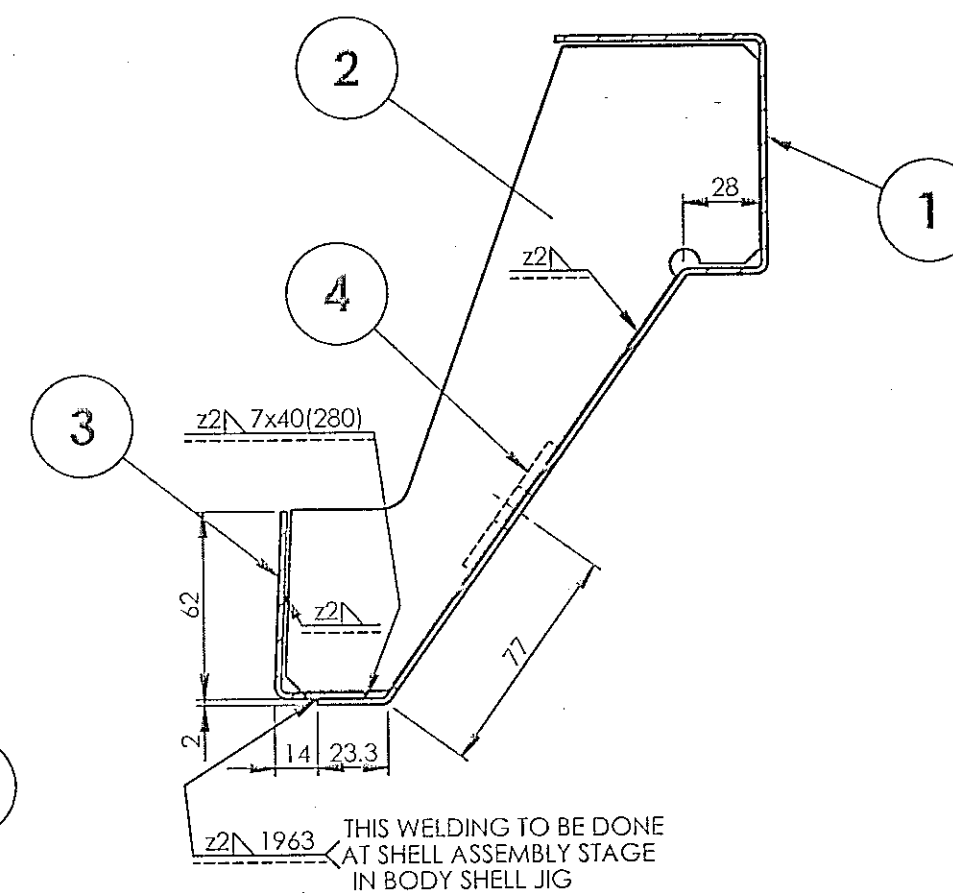
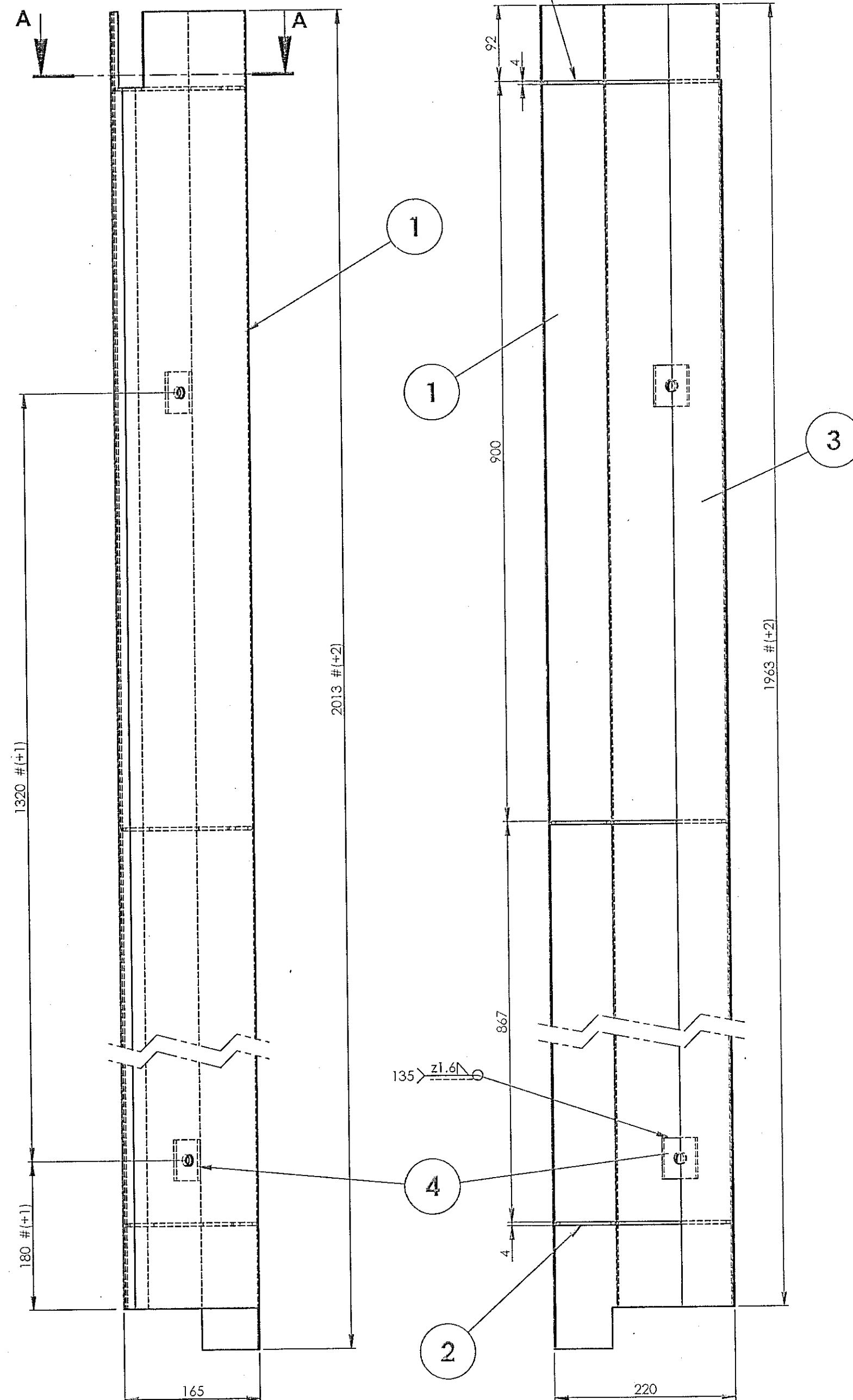
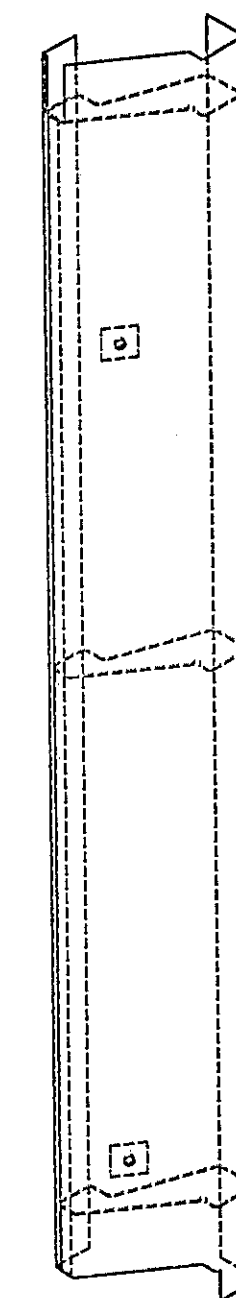
23-01-2026	13-12-2012	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

SSA14030

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

REVISIONS

ALT.	ZONE	DESCRIPTION	APPROVED & DATE
a		LOCATING DIMENSION FOR ITEMS-5,6&7 ADDED.WELDING OF ITEM-3 WITH ITEM-1 INTRODUCED.	-sd-
b		ITEM-2,5,6 & 7 DELETED.MANDATORY ALLOWANCES, WELDING NOTATIONS AND ITEM-8 ADDED.	-sd-
c		ITEM-8 DELETED, ITEM-2 RECALLED.	-sd-
d		LOCATING DIMENSION OF ITEM-2 ALTD.	-sd-
e		VIEWS UPDATED AS PER CHANGES IN ITEM-1. NOTE UPDATED.	<i>sd</i>

SECTION A-A
SCALE 1:2.5

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 SPATERS 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.

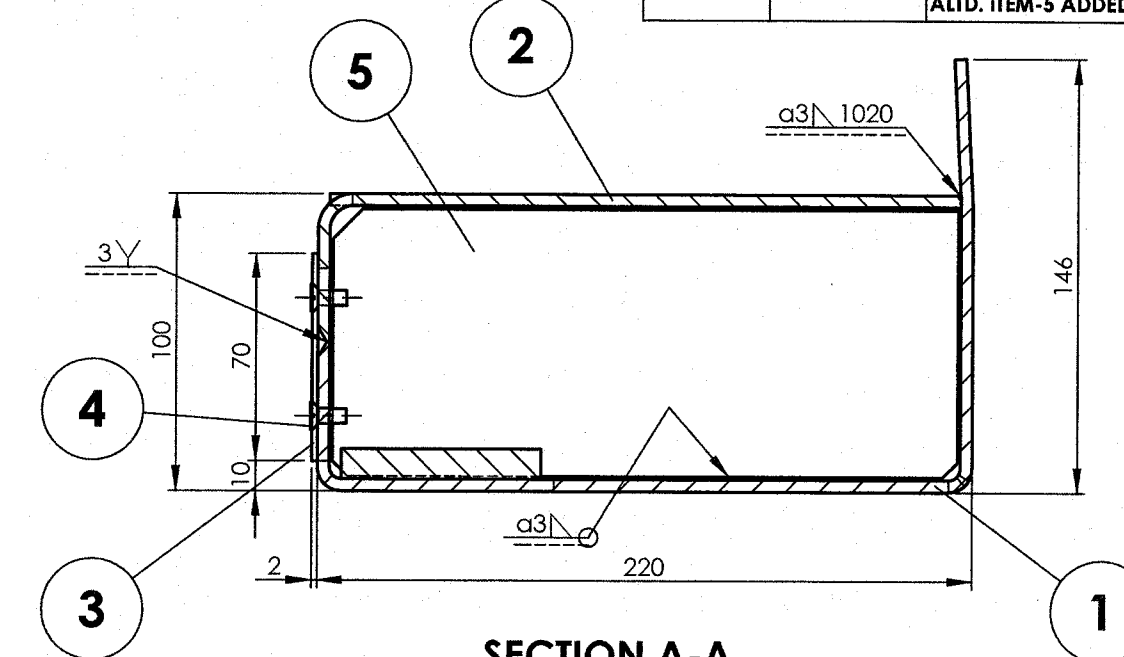
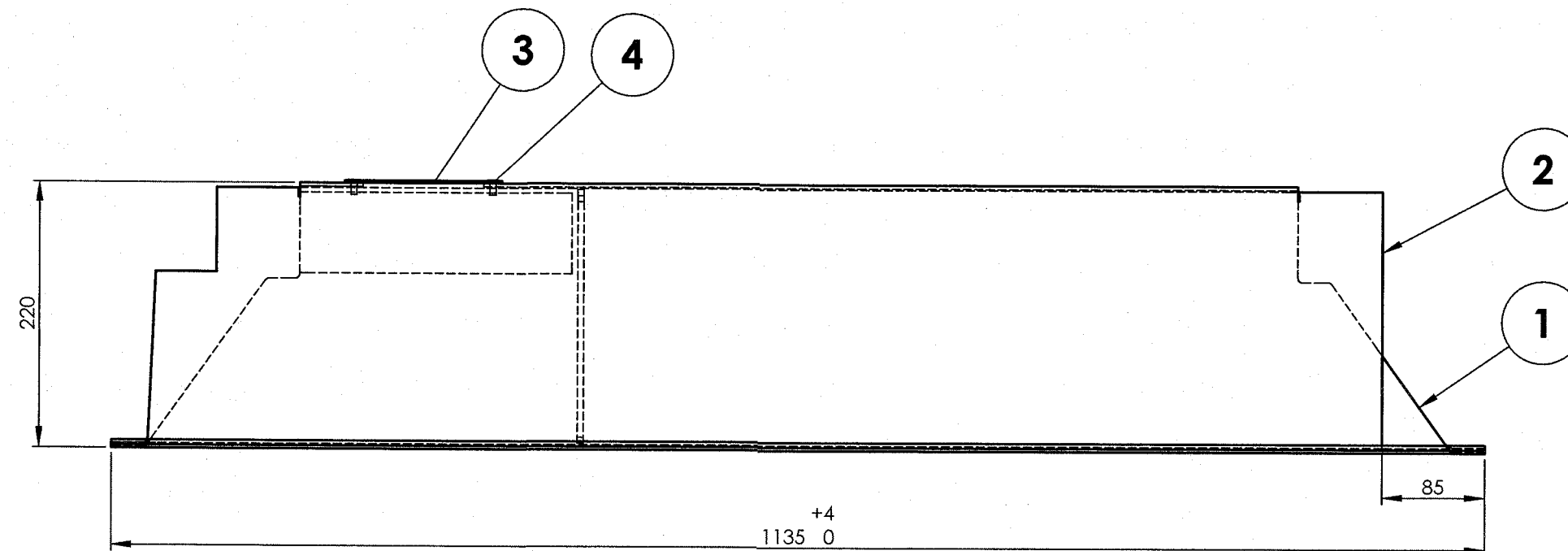
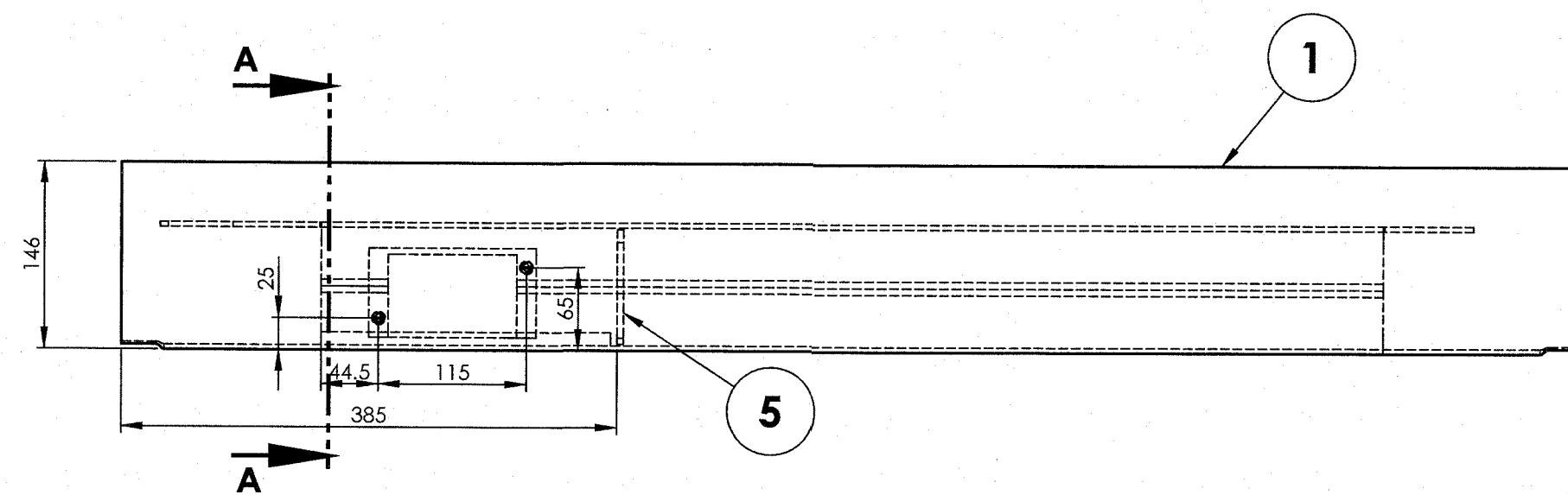
3	WEB		8	AA14289		0.43	
+	FLAT FOR PARTITION		7	AAA14805		0.168	
+	FLAT FOR PARTITION		6	AAA14804		1.999	
+	FLAT FOR PARTITION		5	AAA14803		0.638	
2	BACK PIECE		4	AAA14398		0.075	
1	ANGLE FOR DOOR POST		3	AAA14403		2.752	
3	WEB		2	AAA14401		0.41	
1	DOOR POST LEFT		1	AAA14399		11.545	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MAT.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-4				SURFACE AREA IN Sq.m.: 1.901		WT/ASSY IN Kgs:	
DOOR POST LEFT COMPLETE				SCALE 1:5	SSE/D	CHD	<i>ss</i>
				ALT e	ALTD	DRN	T.Ukkirapandian
							K.Sethuraman
INDIAN RAILWAY STANDARDS				SHEET 1 OF 1		SSA14030	
INTEGRAL COACH FACTORY, CHENNAI - 600038						A2	
23-01-2026	13-12-2012						
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME					

SSA14031

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

REVISIONS

ALT.	ZONE	DESCRIPTION	APPROVED & DATE
a		REF DRG OF ITEM-1 REVISED.	-sd-
b		ITEMS-3,4 & WELDING NOTE ADDED.VIEWS UPDATED.	-sd-
c		ITEM-2 ALTERED. ITEM-3 RM SIZE ALTD. M5 CSK SCREW PITCH ALTD. ITEM-5 ADDED AND VIEWS UPDATED.	

SECTION A-A
SCALE 1 : 2.5

NOTE:

1. ALL WELD SPATTERS SHALL BE GROUND.
2. ALL WELDED JOINTS SHALL BE PICKLED AND PASSIVATED BEFORE SURFACE TREATMENT.
3. 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.

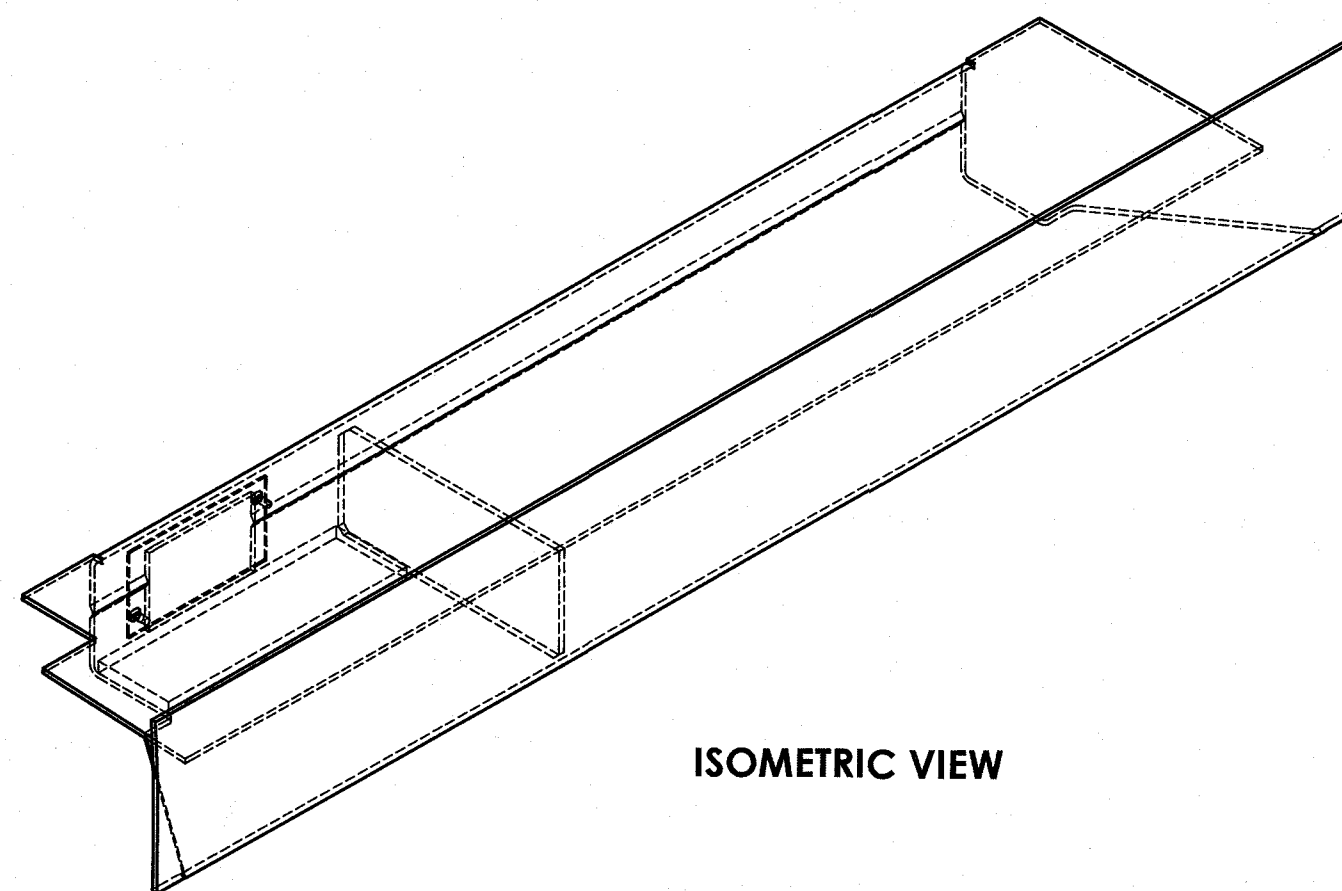
ALL NDT (RT/UT/MPT/DPT) SHALL BE PERFORMED BY PERSONNEL CERTIFIED ACCORDING TO ISO-9712/ASNT/ISNT LEVEL-2 AND SHALL BE DOCUMENTED.

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

* THE PERCENTAGES EXPRESSED, REFER TO THE TOTAL LENGTH TO BE EXAMINED FOR ONE GIVEN WELD. THUS: -100% MEANS: TESTING THE ENTIRE LENGTH OF THE WELD AND ON ALL THE PIECES BUILT.

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

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



ISOMETRIC VIEW

REF.DRG.NO.LP101119-'a'

02-02-2019	13-12-2012	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

1	RIB		5	AAE14185	RDSO/SPEC C-K201 X2CrNi12	0.75		
2	COUNTER SUNK FLAT HEAD SCREW	M5x12- A2-70	4	IS: 1365				
1	CLOSING PLATE	2x70x130	3			0.15		
1	UPPER FRAME PART		2	AAA14404		7.860		
1	UPPER FRAME PART		1	SSA14033		13.749		
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF.DRGS.	MATL. SPEC	WT/UNIT IN KGS	REMARKS	
GROUP: 14			SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
UPPER FRAME COMPLETE						SCALE 1:5	SSE/D	
							CHD	
						ALT c	ALTD	T.UKKIRAPANDIAN
							DRN	K.Sethuraman
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1				
					SSA14031			
						A2		