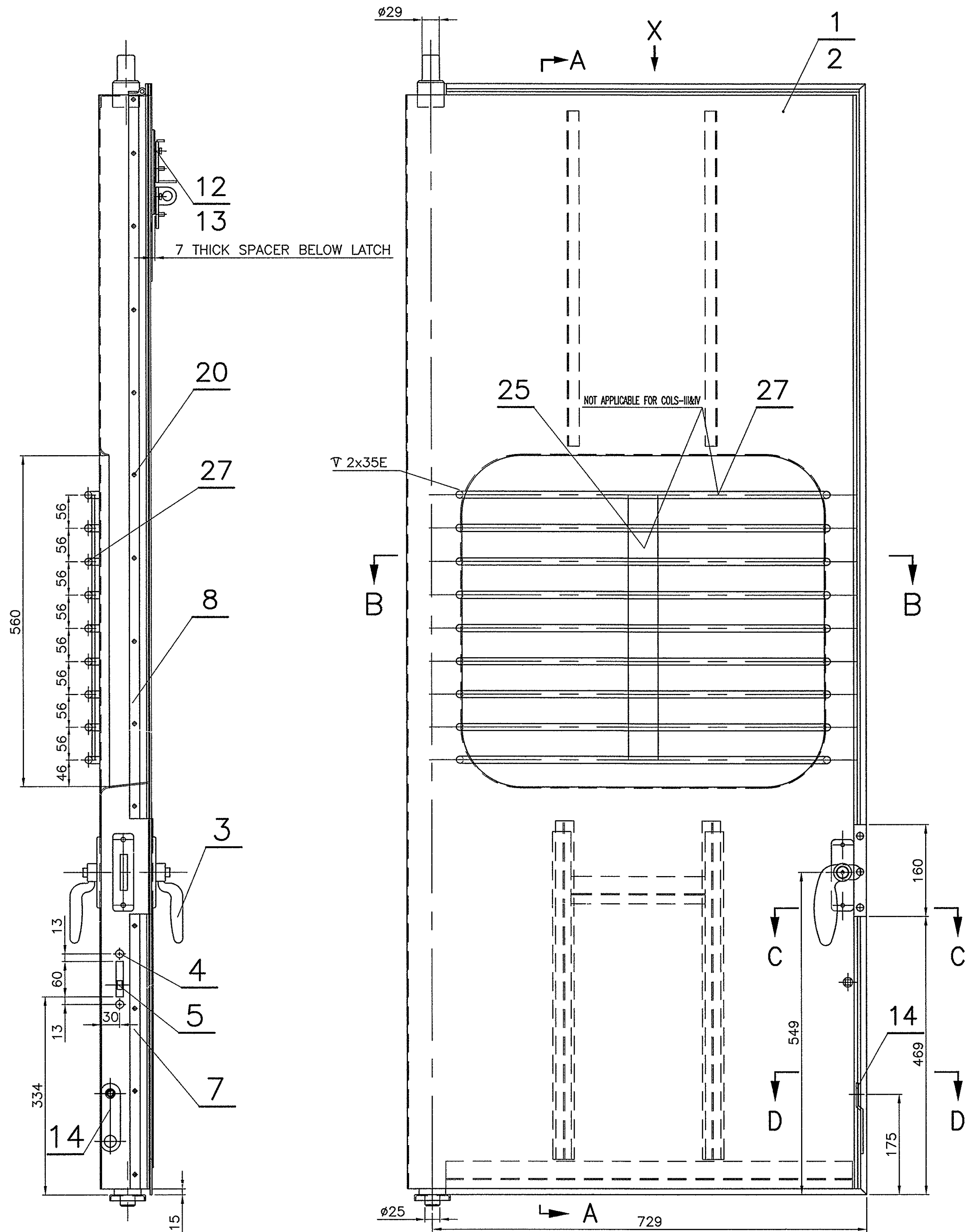
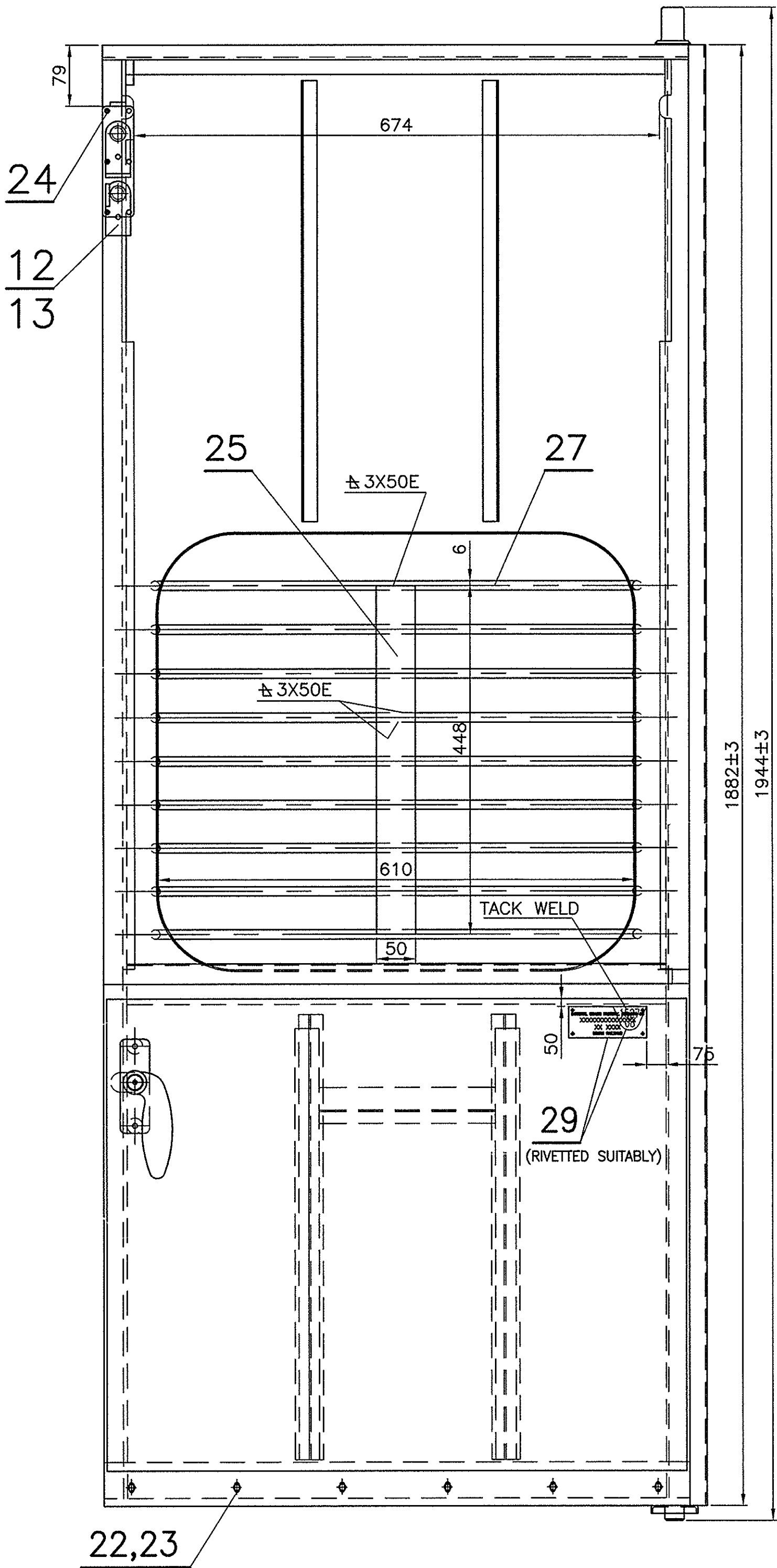


ICF/STD-5-1-002

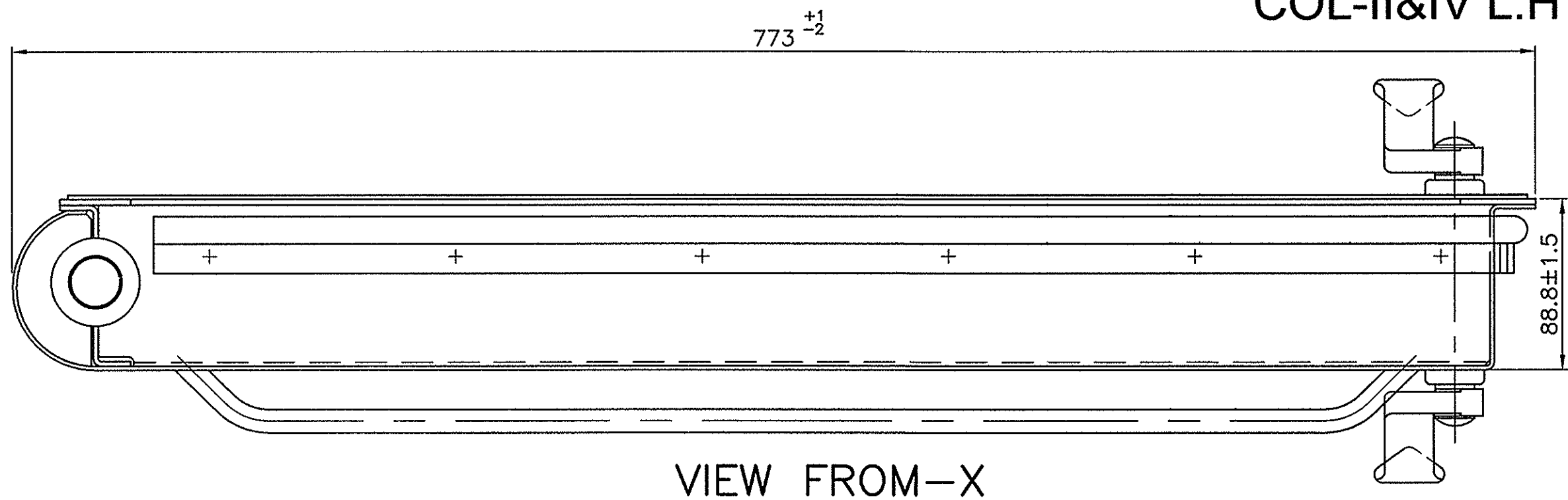
▽ ROUGH MACHINED	① ROUGH CLEANING	ALTERATIONS
▽▽ FINISH MACHINED		
▽▽▽ FINE FINISH MACHINED		



VIEW FROM OUTSIDE
COL-I&III R.H AS DRAWN
COL-II&IV L.H OPPOSITE



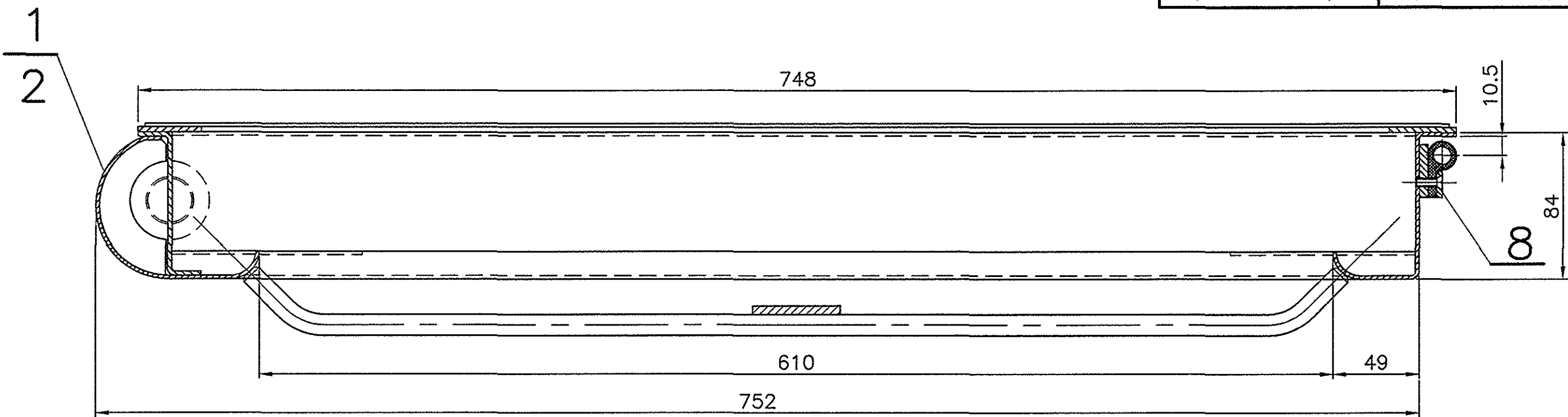
VIEW FROM INSIDE



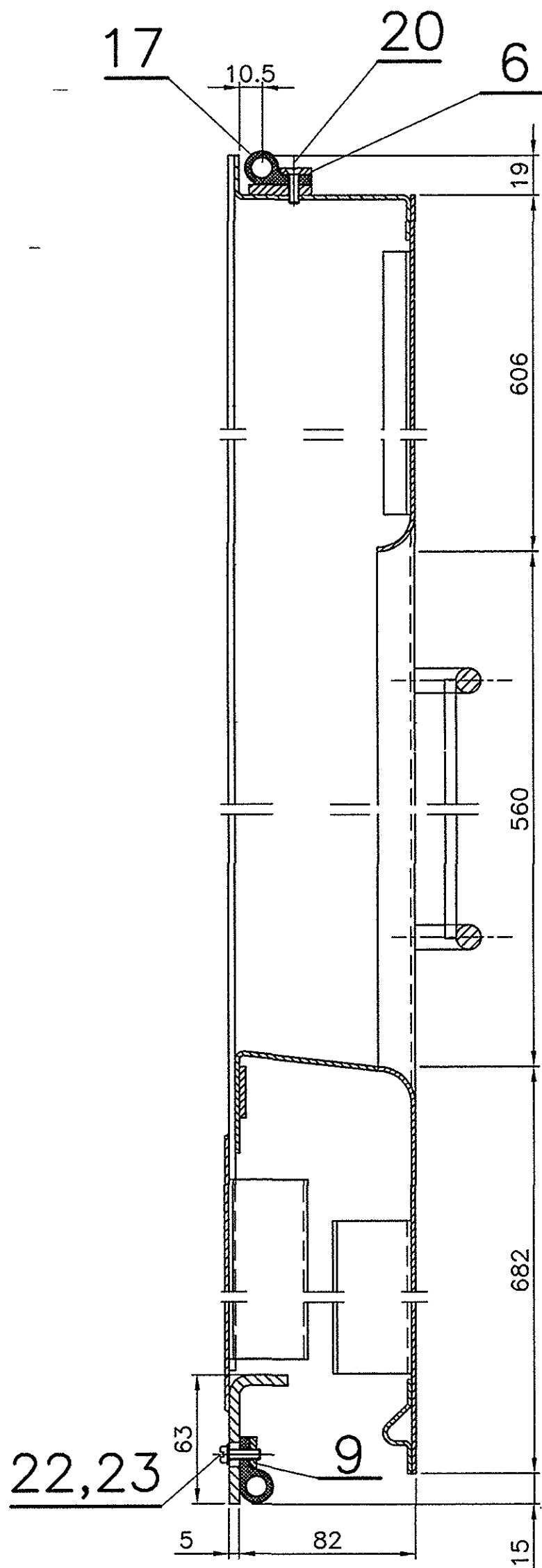
VIEW FROM-X

NO. OFF				DESCRIPTION & DIMENSIONS			ITEM	REF. DRG	MATL. SPECN	WEIGHT/UNIT	REMARKS			
IV	III	II	I	GROUP						SUPERSEDED BY				
				OUTER DOOR ASSY						SUPERSEDES: ICF/STD-5-1-002 ALT s/-				
										SCALE		SSE/D	1:5 CHD	
										1:2.5		ALT	RK.A.SONAWANE	
										1:1		DRN	L.SAJIJKUMAR	
										ALT		r	s	t
ASSEMBLY DRAWINGS				CAD FILE : \\MD-CAD\140\5-1\140 5-1 0021ST00.DWG						INTEGRAL COACH FACTORY CHENNAI-38.				
				DATA CODE NO		INDIAN RAILWAY STANDARDS			SHEET 1 OF 2		ICF/STD-5-1-002			
				140										
				L.H DOOR	R.H DOOR	L.H DOOR	R.H DOOR							
				PER ASSY	PER ASSY	PER ASSY	PER ASSY							
				DMU/DTC4 9-0-902										
				DMU/TC4 9-0-902										
				MEMU/TC2-9-0-902										
				DMU/DPC5 9-0-902										
				MEMU/DMC3-9-0-902										
				-07-2010										

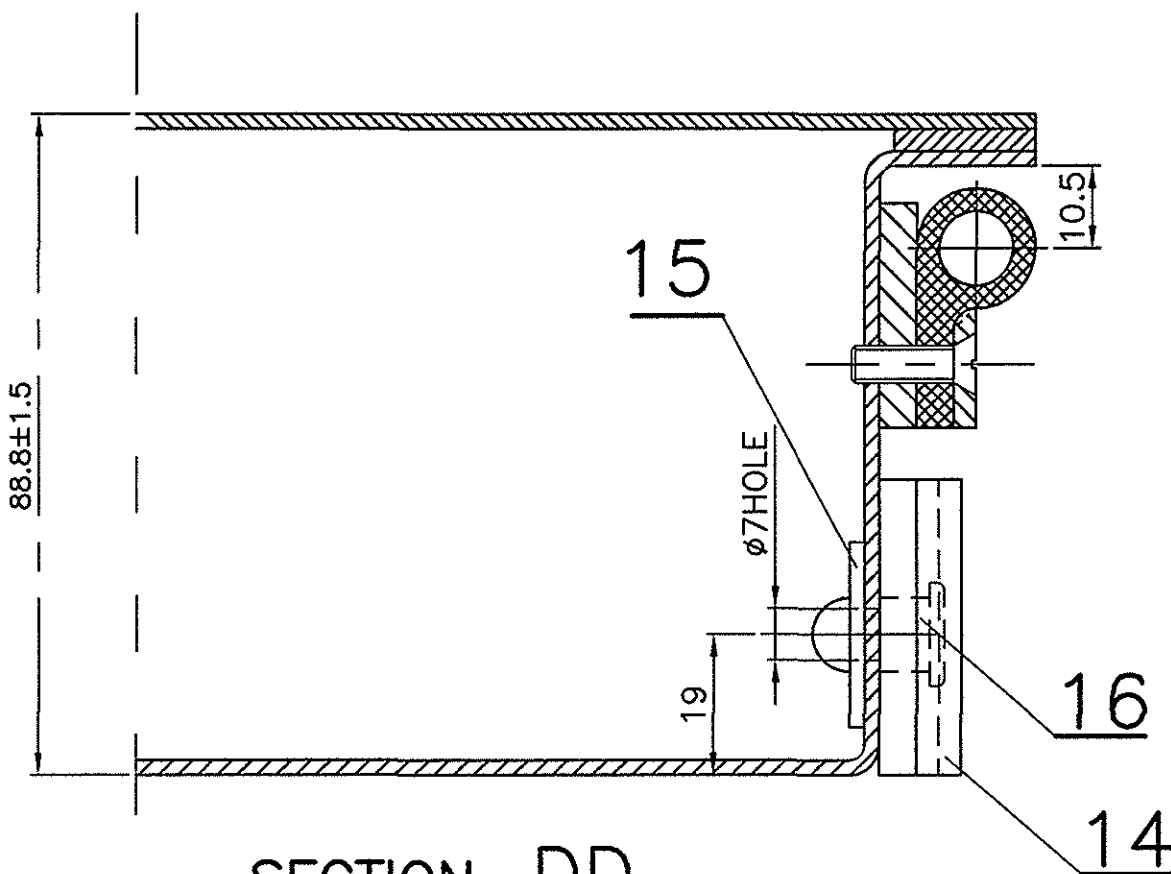
ICF/STD-5-1-002



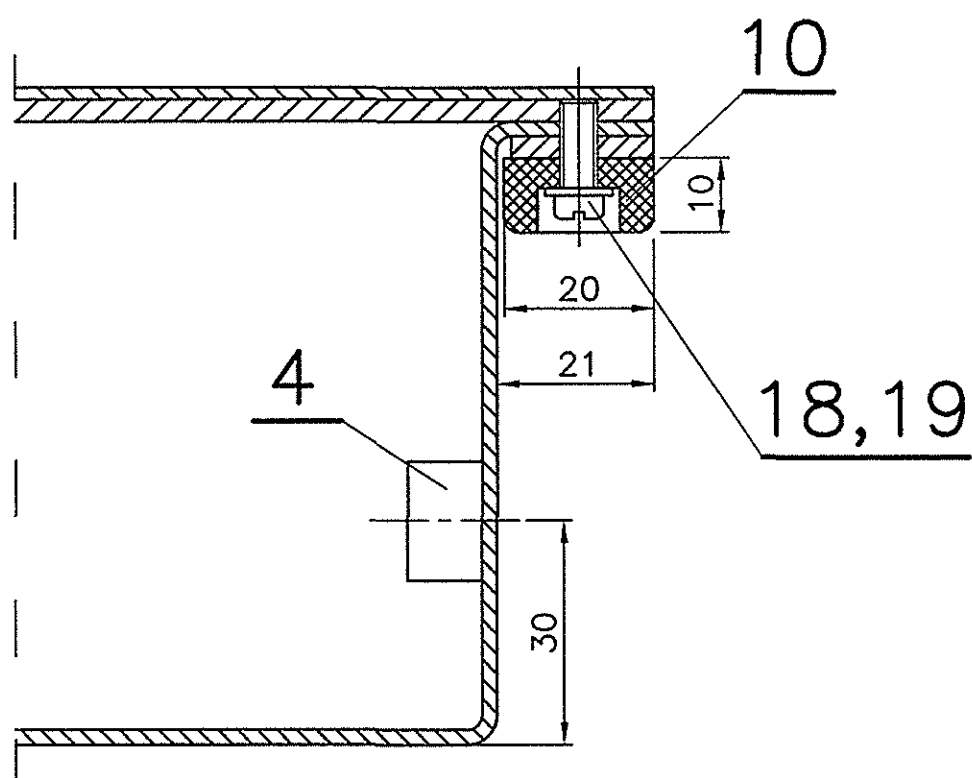
SECTION-BB



SECTION-AA



SECTION-DD



SECTION-CC

(m)	11/2006	(l)	08/2005	(k)	03/2004	(j)	11/2002	(h)	01/2001	(g)	12/2000	(f)	08/2000
COLS-III & IV ADDED.		NOTE-13 & 14 ADDED.		NO.OF WINDOW BARS ALTD FROM 8 TO 9. MATL SPEC UPDATED.LENGTH OF ITEM-25 ALTD FROM 435 TO 448.		ITEM-21 DELETED AND ITEM-30 ADDED. NOTE-3 DELETED.		REF.DRG. FOR ITEM-11 ALTD FROM T-5-1-648 TO ICF/STD 5-1-012 COL-III. DRG REDRAWN AND SHEET-2 ADDED.ASSY DRG NOS UPDATED.		REF.DRG. FOR ITEMS-12&13 ALTD FROM T-5-1-677 COL-I&II TO ICF/STD 5-1-012 COL-I&II RESPLY.		ITEM-29 AND NOTE-12 ADDED. 12-08-2000 Sd/- SME/DSD	
Sd/- SSE/D	Sd/- SME/DSD	Sd/- SSE/D	Sd/- SME/DSD	Sd/- SSE/D	Sd/- SME/DSD	Sd/- SSE/D	Sd/- SME/DSD	Sd/- SSE/D	Sd/- SME/DSD	Sd/- SSE/D	Sd/- SME/DSD	Sd/- SSE/D	Sd/- SME/DSD

NOTE

- COL-I R.H.AS DRAWN
- COL-II. L.H.OPPOSITE.
- ~~COL I&II.APPLICABLE FOR CONVENTIONAL COACHES.~~
-
- ITEMS-12,13 & SIX NO.OF ITEM-24 TO BE SUPPLIED LOOSE.
- OPEN TOLERANCE TO DRG.NO. ICF/STD-9-0-001 SHALL GENERALLY BE FOLLOWED WHEREVER TOLERANCE IS NOT MENTIONED FOR DIMENSIONS.
- COL-I OF THIS DRG SUPEREDES COLS-II&IV OF DRG.NO.T-5-1-672 ALT(x).
- COL-II OF THIS DRG SUPEREDES COLS-II&IV OF DRG.NO.T-5-1-673 ALT(v).
- ~~DOOR ASSY SHOULD BE PAINTED WITH ONE COAT OF ROZ PRIMER TO SPEC:- IS:2074-92 AFTER CLEANING.THICKNESS OF PAINT FILM SHOULD NOT BE LESS THAN 20 MICRONS.~~
- ~~IS:513-1986 GRADE 'D' CAN BE USED AS ALTERNATIVE MATERIAL FOR DOOR-FABRICATION.~~
- ~~THE INNER PORTIONS OF THE OUTER DOOR SHEET,INNER DOOR SHEET BOTTOM PART AND THE DOOR POST TO BE GIVEN THREE COATS OF BITUMINUS EMULSION TO SPEC:IRS P-30 OVER THE COATING OF ROZ PRIMER.THE TOTAL DRY FILM THICKNESS(DFT) SHOULD NOT BE LESS THAN 250 MICRONS.~~
- ITEM-29 SHOULD BE RIVETED SUITABLY TO INNER DOOR SHEET, WHEN DOORS ARE PROCURED FROM TRADE. FOR DOORS MANUFACTURED AT ICF ITEM-29 TO BE MADE FROM CARLINE OFF CUTS AND 4 DIGIT DOOR UNIQUE NUMBER AND YEAR OF MANUFACTURE TO BE PUNCHED FOR EASY IDENTIFICATION OF DOOR IN THE SHOP FLOOR.(EXAMPLE:1527-08)
- ITEMS-25&27 NOT REQUIRED FOR ANGOLA COACHES.
- ITEM-3 TO BE SUPPLIED LOOSE AND ASSEMBLED BEFORE DESPATCH OF SHELL.
- DOOR ASSY SHOULD BE PAINTED WITH HIGH PERFORMANCE ANTICORROSION EPOXY COATING (TWO PACK) TO RDSO SPEC NO.M&C/PCN/123/2006. THE DFT SHALL BE 100 MICRONS FOR OUTSIDE. FOR INNER PORTIONS OF THE DOOR SHEET, INNER DOOR SHEET BOTTOM PART AND DOOR POST, THE DFT SHALL BE 50 MICRONS.
16. STAGE INSPECTION. THE SUPPLIER SHALL OBTAIN CMT APPROVAL FOR ITEMS-1 & 2 (RAW MATERIAL) BEFORE FINAL ASSY.

3	3	3	3	CSK HD.RIVET	#6x22	30	IS:2907-64 TAB-3 FIG.3	IS:740-77 19000			
1	1	1	1	SUPPLIER IDENTIFICATION BOARD		29	ICF/SK 5-1-027				ITEM-1
						28					
-	-	9	9	WINDOW BAR		27	ICF/STD 1-0-012				ITEM-19
						26					
-	-	1	1	FLAT	50x5x448	25	IS:2062-99 Fe 410 WA				KILLED QUALITY
6	6	6	6	CSK.HD.SCREW	M6x20	24	IS:1365-78 4.8-TAB-1&2				NICKEL PLATED
6	6	6	6	CHEESE.HD.SCREW	M5x20	23	IS:1366-82 4.8-TAB-1				NICKEL PLATED
6	6	6	6	SPRING WASHER	M6	22	IS:3063-72 TAB-1,TYPE-B	IS:4072-75 GR-3			GALVD.
						21					
20	20	20	20	CSK.HD.SCREW	M5x16	20	IS:1365-78 4.8-TAB-1&2				NICKEL PLATED
3	3	3	3	CHEESE.HD.SCREW	M4x12	19	IS:1366-82 4.8-TAB-1				GALVD.
3	3	3	3	PLAIN WASHER	4.5	18	IS:2016-67 TAB-2,TYPE-A	IS:737-86 31000-H2			
1	1	1	1	SEALING RUBBER		17	T-5-1-661				
1	1	1	1	PIN		16	T-5-1-104				
1	1	1	1	SQUARE WASHER		15	T-5-1-108				
1	1	1	1	LOCKING PLATE		14	T-5-1-103				ITEM-1
1	-	-	-	SAFETY CATCH WITH LUG FOR PAD LOCKING OF BODY SIDE DOOR		13	ICF/STD 5-1-012				COL-II
-	1	-	-	SAFETY CATCH WITH LUG FOR PAD LOCKING OF BODY SIDE DOOR		12	ICF/STD 5-1-012				COL-I
1	1	1	1	SAFETY CATCH		11	ICF/STD 5-1-012				COL-III
1	1	1	1	DOOR STOP		10	T-5-1-517				
1	1	1	1	PACKING RAIL		9	T-5-1-644				COL-V
1	1	1	1	PACKING RAIL (SIDE TOP)		8	T-5-1-657				
1	1	1	1	PACKING RAIL (SIDE BOTTOM)		7	T-5-1-656				ITEM-1
1	1	1	1	PACKING RAIL (TOP)		6	T-5-1-646				
1	1	1	1	GUARD'S LOCKING ARRGT.		5	T-5-1-659				COL-III
2	2	2	2	SCREWING PIECE		4	T-5-1-660				
1	1	1	1	DOOR LOCK ASSY.		3	T-5-1-109				COL-VI
1	-	1	-	DOOR FRAME ARRGT. L.H.		2	T-5-1-604				COL-IV
-	1	-	-	DOOR FRAME ARRGT. R.H.		1	T-5-1-676				COL-IV
NO. OFF		DESCRIPTION & DIMENSIONS		ITEM	REF. DRG	MATL. SPECN	WEIGHT/UNIT	REMARKS			
IV	III	II	I	GROUP: 5-1 BODY SIDE DOORS				SUPERSEDED BY			
								SUPERSEDES: ICF/STD-5-1-002 ALT s/-			
								SCALE			
								1:5			
								1:2.5			
								1:1			
								ALT			
								r			
								s			
								t			
								INTEGRAL COACH FACTORY CHENNAI-38.			
								ICF/STD-5-1-002			

DMU/DTC4 9-0-902	PER ASSY
DMU/TC4 9-0-902	PER ASSY
MEMU/TC2-9-0-902	PER ASSY
DMU/DPC5 9-0-902	PER ASSY
MEMU/DMC3-9-0-902	PER ASSY

ASSEMBLY DRAWINGS

-07-2010	DATE OF LATEST ALT	DATE OF FIRST ISSUE	AME/SME

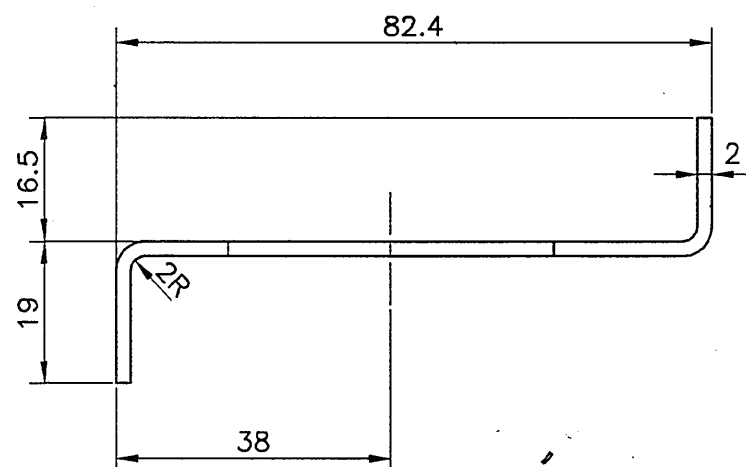
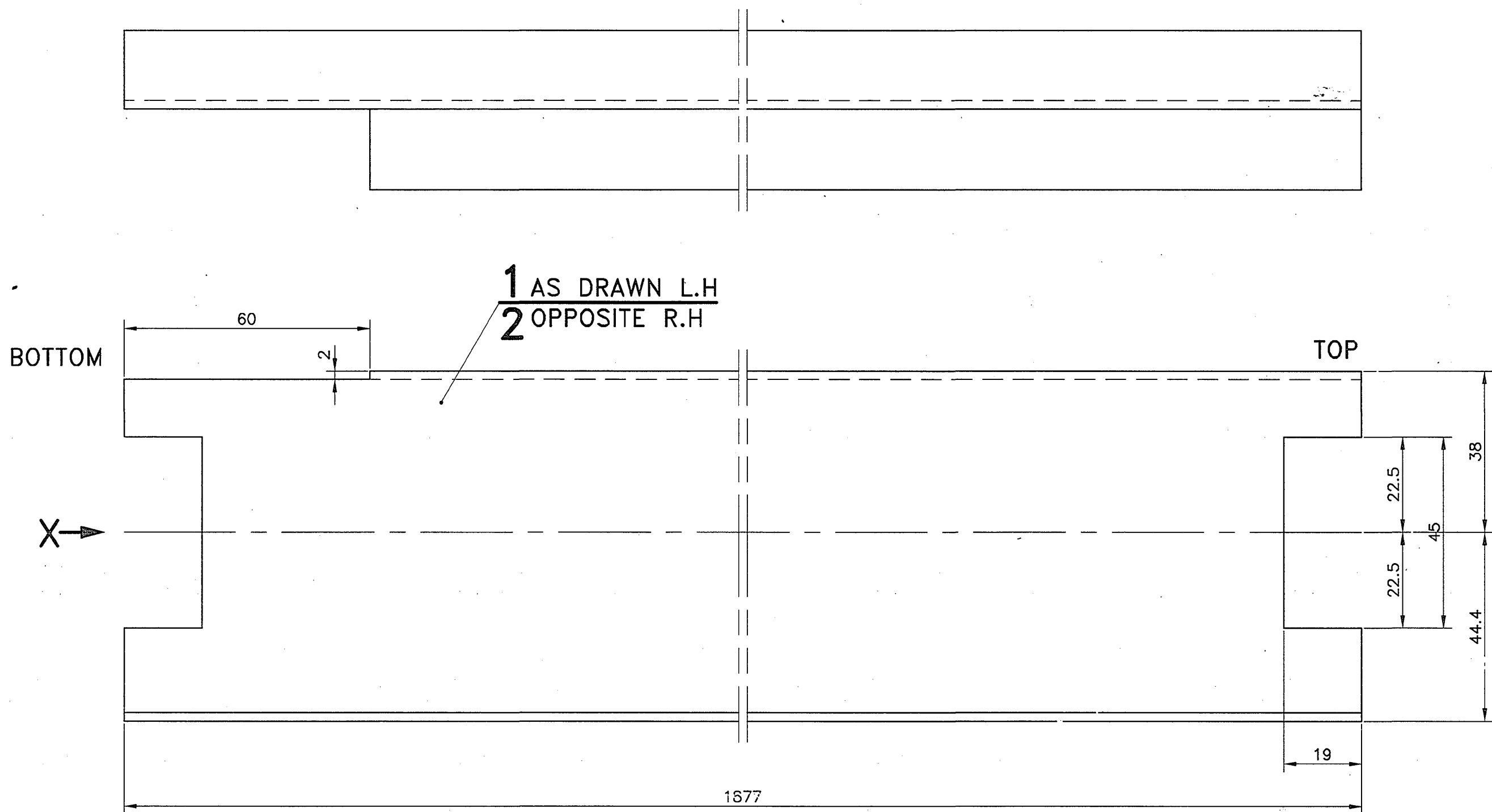
OUTER DOOR ASSY

INDIAN RAILWAY STANDARDS

SHEET 2 OF 2

01	ROUGH CLEANED
18	CHAMFERED
01b	BURRS REMOVED

ALTERATIONS	
⑨	9/2000
CUT-AWAY OF SIZE 19x165 AT THE TOP ELIMINATED. ITEM-2 ADDED.	
-Sd-	19.9.00
SSE/D	SME/DSD



VIEW FROM-X

NOTE:

1. OPEN TOLERANCE TO DRG. No.ICF/STD-9-0-001 SHALL GENERALLY BE FOLLOWED, WHEREVER TOLERANCE IS NOT MENTIONED.

⊗ TLR, MG/T, T(LADIES), F. TCN2, TCN3 CUM TCN2

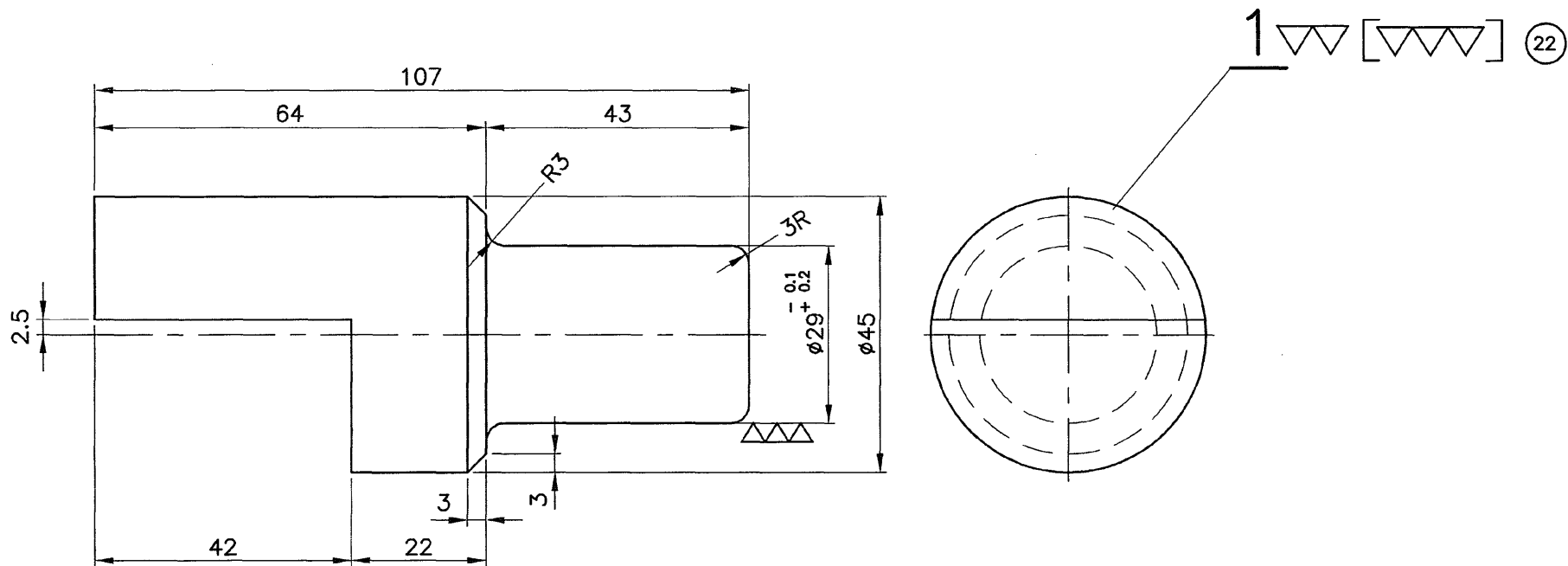
CT-5-1-018
CT-5-1-017
CT-5-1-003
CT-5-1-002
T-5-1-667
T-5-1-628
T-5-1-627
ASSEMBLY DRAWINGS

[illegible]

③ 05/2004 DRG REDRAWN IN CAD. SSE/D	② 07/1982 DRG RETRACED. sd/- 29/07/1982 CDA
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▽ ROUGH MACHINED	① ROUGH CLEANING
▽▽ FINISH MACHINED	⑱ CHAMFERED
▽▽▽ FINE FINISH MACHINED	②② CASE HARDENING

ALTERATIONS 7/14	
⑨ 03/2000	DESIGN FOR ITEM-1 REVISED AND RM SIZE ALTD FROM $\phi 45 \times 88$ TO $\phi 45 \times 107$ AND MAT SPEC UPDATED. NOTE-1 ADDED. JIG & TOOL NOS DELETED.
sd/- 8/3/2000 SSE/D	sd/- 9/3/2000 SME/D



NOTE:

1. CASE HARDENING NOT REQUIRED WHEN NYLON BUSHES ARE USED FOR DOOR BEARING.

☆ BRIGHT STEEL BAR COLD DRAWN TYPE-2 TAB-2 AND Gr-1 (TAB-3) TO IS:9550-80 AND CHEMICAL COMPOSITION TO IS: 1875-92 CLASS-1

3 2		ALT	DATE OF LATEST ALTN	DATE OF FIRST ISSUE	DY/CME/D	SME/DSD	T-5-1-667		NO.OFF	U BEARING JOURNAL $\phi 45 \times 107$		1	☆		
24.05.04			10-02-1967				CT-5-1-018	VI	V	IV	III	II	I	GROUP: BODY SIDE DOOR	
							CT-5-1-017							UPPER BEARING JOURNAL FOR DOOR	
							CT-5-1-003								
							CT-5-1-002								
							T-5-1-628								
							T-5-1-607								
							ASSEMBLY DRAWINGS							CAD FILE: C:\MD-CAD\000\5-1\512SQ03.DWG	
														DATA CODE No. 000	
														INDIAN RAILWAY STANDARDS	
														SHEET 1 OF 1	
														T-5-1-512	

T-5-1-642

② 02/1972
DRG RETRACED.
ed/-
CDA

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

① ROUGH CLEANING
⑩ CHAMFERED
⑫ CASE HARDENING

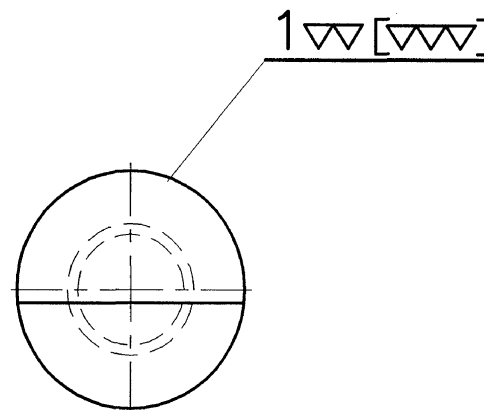
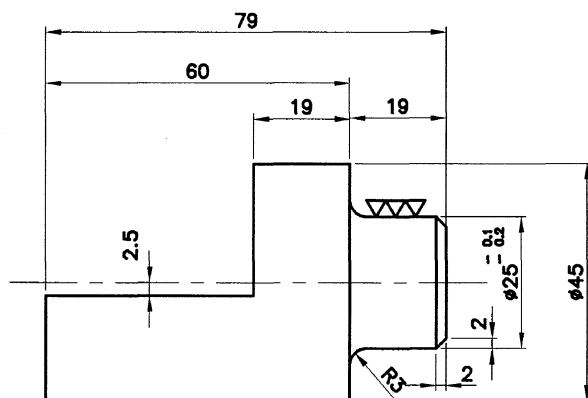
ALTERATIONS 8/14

① 03/2000
DESIGN FOR ITEM-1 REVISED
AND RM SIZE ALTD FROM
Ø45x59 TO Ø45x79 .
JIG & TOOL NOS DELETED.
MAT SPEC UPDATED.
NOTE-1 ADDED.

ed/-8/3/2000 ed/-8/3/2000
SSE/D SME/DSD

① 06/2004
DRG REDRAWN IN CAD. MATL
SPEC FOR ITEM-1 ALTD FROM
IS:7270/ C-14 TO AISI 304.
NOTE-1 DELETED AND NOTE-2
AND COL-IV ADDED.

ed/-8/3/2000 ed/-8/3/2000
SSE/D SME/DSD

**NOTE**

1. CASE HARDENING NOT REQUIRED WHEN NYLON BUSHES ARE
USED FOR DOOR BEARING.

* TLR, MG/T, FT(LADIES), TCN2, TCN3 CUM TCN2

2. जहाँ कहीं आयाम की टालरेंस का उल्लेख न किया गया हो वहाँ सामान्यतः ओपन टालरेंस रेखाचित्र से
संकेत / एसटीडी-9-0-001 के अनुरूप होना चाहिए.

2. OPEN TOLERANCE TO DRG.NO. ICF/STD-9-0-001 SHALL GENERALLY BE FOLLOWED
WHEREVER TOLERANCE IS NOT MENTIONED FOR DIMENSIONS.

* BRIGHT STEEL BAR COLD DRAWN TYPE-2 TAB-2 AND Gr-1 (TAB-3)
TO IS:9550-80 AND CHEMICAL COMPOSITION TO IS: 1875-92 CLASS-1

		1 6 4 8		LOWER BEARING JOURNAL Ø45x79		1	AISI-304			
		NO.OFF		DESCRIPTION & DIMENSIONS		ITEM	REF. DRGS.	MAT. SPEC	WEIGHT/UNIT	REMARKS
		VI V IV III II I		GROUP: BODY SIDE DOORS						
		PER STEEL DOOR		PER COACH		PER COACH		PER COACH		
		T-5-1-667		CT-5-1-018		CT-5-1-017		CT-5-1-003		
		CT-5-1-002		T-5-1-808		T-5-1-827				
		ASSEMBLY DRAWINGS		CAD FILE: C:\MD-CAD\000 5-1 642-SR02.DWG						
		23.06.04		DATE OF LATEST ALT		DATE OF FIRST ISSUE		DY/CME/D		SME/DSD
		2		ALT		DATA CODE No.		INDIAN RAILWAY STANDARDS		SHEET 1 OF 1
										T-5-1-642