
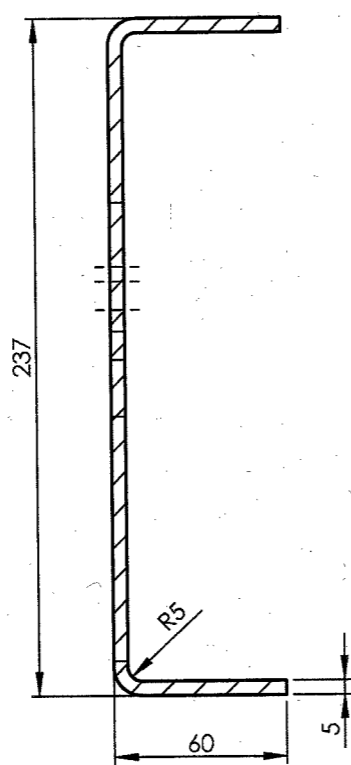
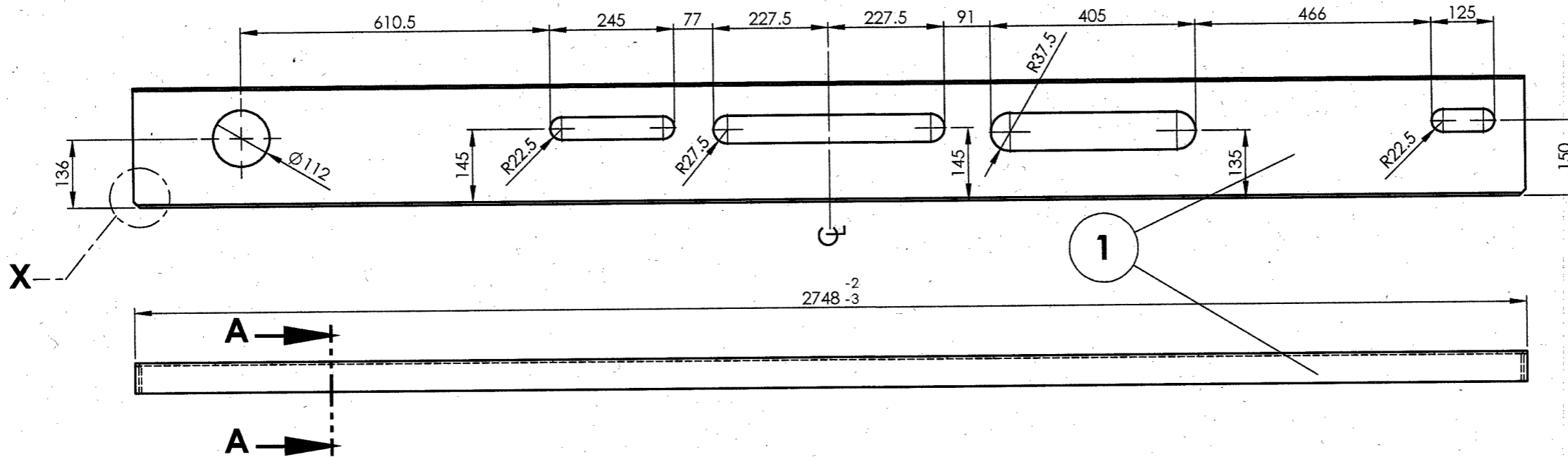


AAD11154

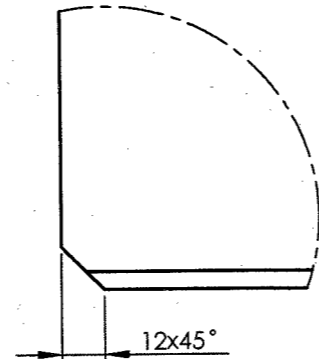
▽ ROUGH MACHINED
▽ FINISH MACHINED
▽▽ FINE FINISH MACHINED

① ROUGH CLEANED
①b BURRS REMOVED
⑱ CHAMFERED

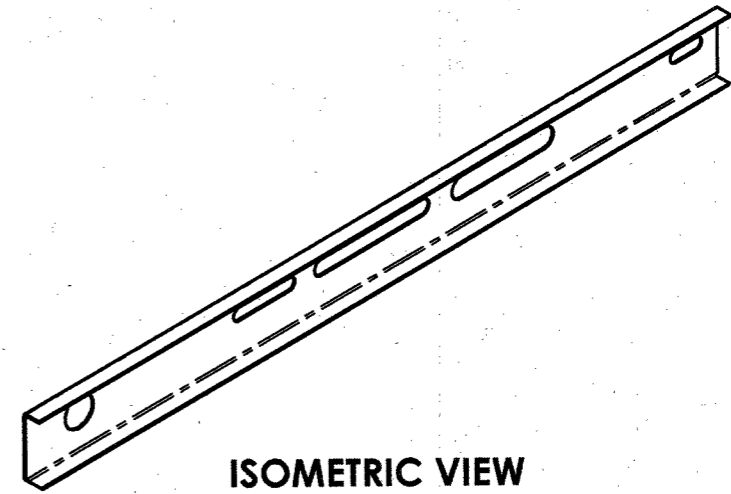
REVISIONS				APPROVED & DATE
ALT.	ZONE	DESCRIPTION		
a		DIAMETER OF HOLE ALTERED FROM 97 TO 112.		



**SECTION A-A
SCALE 1 : 2.5**



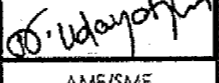
**DETAIL X
SCALE 1 : 2**

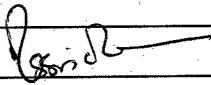



ISOMETRIC VIEW

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.

23-03-2018	28-09-2017	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

1	CROSS MEMBER	5x337x2748	1		IRS M-41-1997	33.58	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
CROSS MEMBER					SCALE	SSE/D	
					1:10	CHD	
					ALT.	ALTD	V.S.SRIDHARAN
					a	DRN	K.SETHURAMAN
INDIAN RAILWAY STANDARDS							
INTEGRAL COACH FACTORY, CHENNAI - 600038					SHEET 1 OF 1		AAD11154
							A3

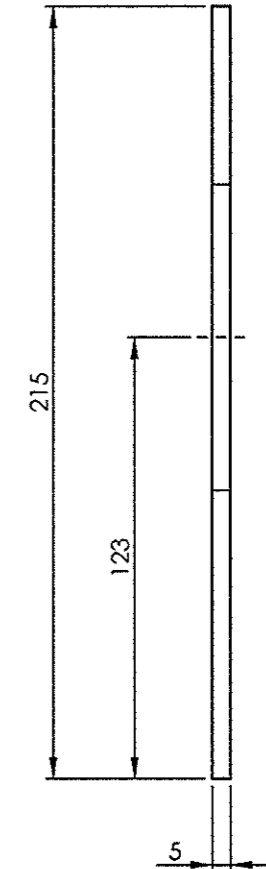
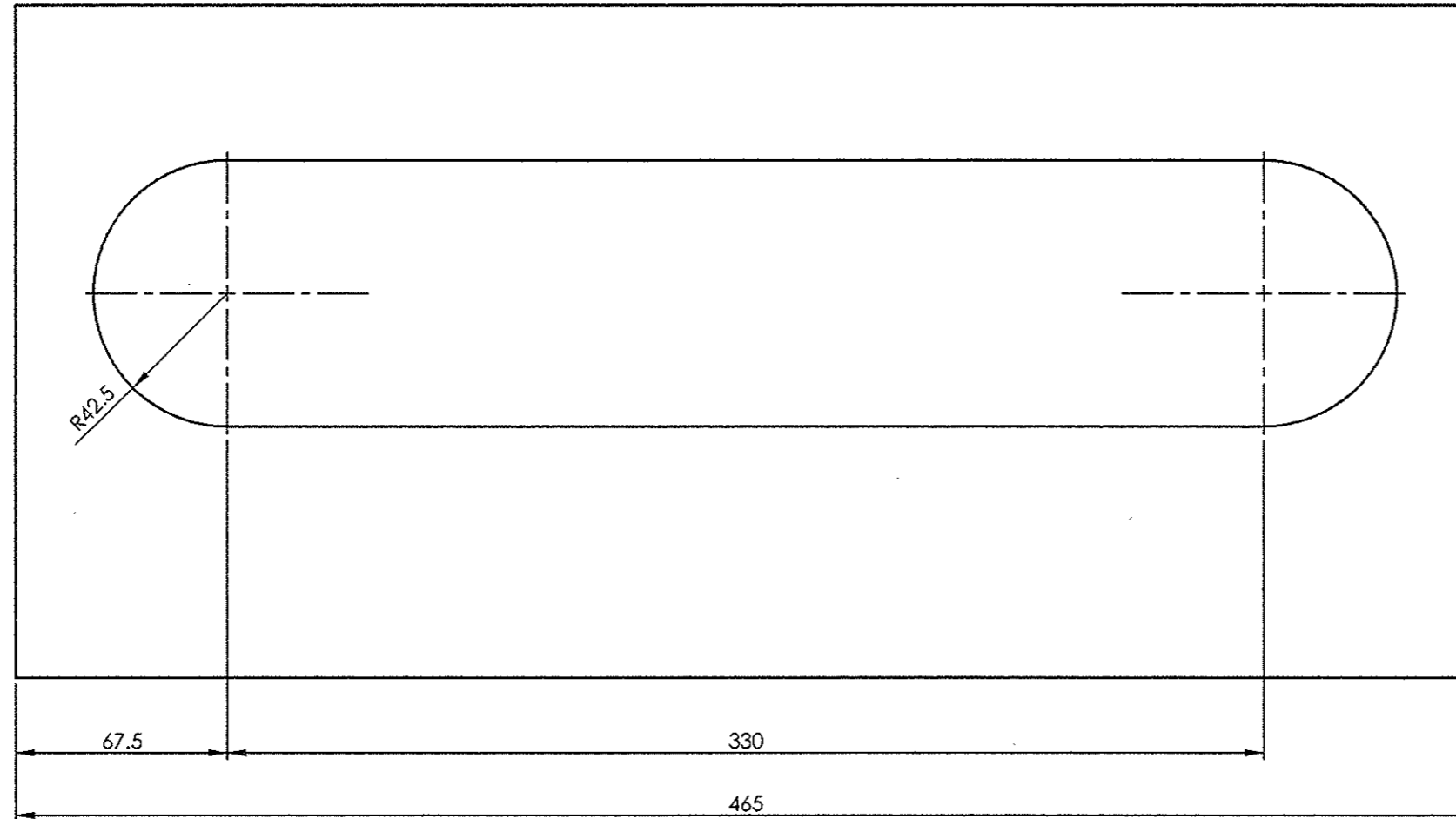
1		2		3		4		5		6		7		8																																																																				
AAD11155				▽ ROUGH MACHINED		① ROUGH CLEANED		REVISIONS																																																																										
				▽▽ FINISH MACHINED		② BURRS REMOVED		ALT.		ZONE		DESCRIPTION		APPROVED & DATE																																																																				
				▽▽▽ FINE FINISH MACHINED		③ CHAMFERED																																																																												
<div><div>1</div><div><div><div>483</div><div><div>1</div><div>5</div><div>5</div><div>76</div><div>6X45°</div><div>5</div></div></div><div><div>60</div><div>R5</div><div>60</div><div>5</div></div></div></div>																																																																																		
<table><tr><td>1</td><td>ANGLE</td><td>5x110x483</td><td>1</td><td></td><td>IRS M-41-1997</td><td>1.95</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: 1-1</td><td colspan="3">SURFACE AREA IN Sq.m.:</td><td colspan="3">WT/ASSY IN Kgs:</td></tr><tr><td colspan="5" rowspan="4">ANGLE</td><td>SCALE 1:2</td><td>SSE/D</td><td rowspan="2">Kunli Thokur</td></tr><tr><td colspan="2">CHD</td></tr><tr><td>ALT.</td><td>ALTD</td><td></td></tr><tr><td colspan="2">DRN</td><td></td></tr><tr><td colspan="5">INDIAN RAILWAY STANDARDS</td><td colspan="2">SHEET 1 OF 1</td><td>AAD11155</td><td>A3</td></tr><tr><td colspan="5">INTEGRAL COACH FACTORY, CHENNAI - 600038</td><td colspan="2"></td><td colspan="2"></td></tr><tr><td colspan="2"></td><td>20-10-2017</td><td colspan="4"></td><td colspan="2"></td></tr></table>																1	ANGLE	5x110x483	1		IRS M-41-1997	1.95		QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS	GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:			ANGLE					SCALE 1:2	SSE/D	Kunli Thokur	CHD		ALT.	ALTD		DRN			INDIAN RAILWAY STANDARDS					SHEET 1 OF 1		AAD11155	A3	INTEGRAL COACH FACTORY, CHENNAI - 600038											20-10-2017						
1	ANGLE	5x110x483	1		IRS M-41-1997	1.95																																																																												
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS																																																																											
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:																																																																													
ANGLE					SCALE 1:2	SSE/D	Kunli Thokur																																																																											
					CHD																																																																													
					ALT.	ALTD																																																																												
					DRN																																																																													
INDIAN RAILWAY STANDARDS					SHEET 1 OF 1		AAD11155	A3																																																																										
INTEGRAL COACH FACTORY, CHENNAI - 600038																																																																																		
		20-10-2017																																																																																

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

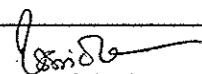
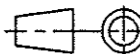
AAD11157

▽ ROUGH MACHINED	③ ROUGH CLEANED
▽▽ FINISH MACHINED	③⑤ BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	③⑧ CHAMFERED

REVISIONS				APPROVED & DATE	
ALT.	ZONE	DESCRIPTION			




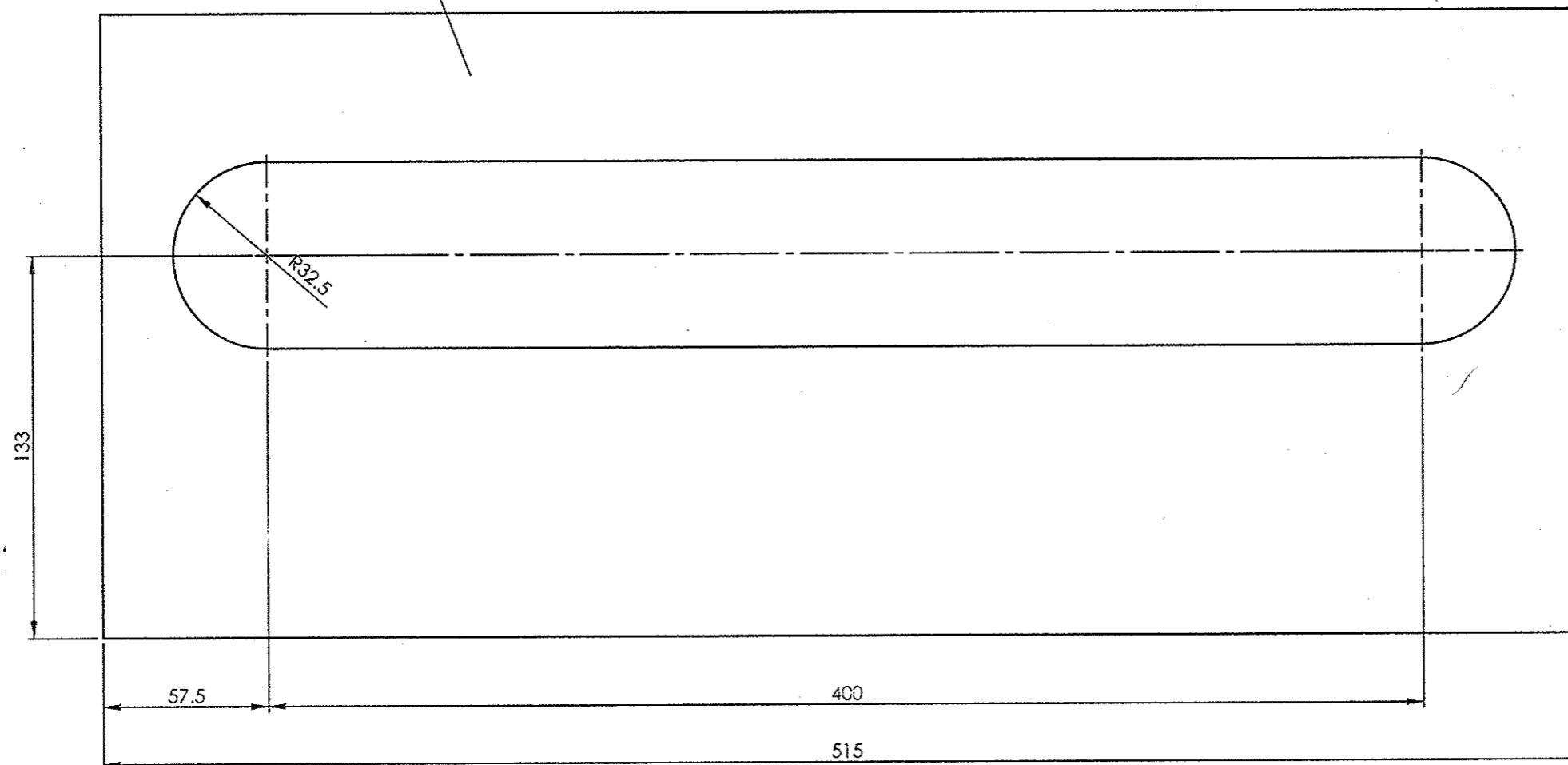
ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICF/STD-9-0-001.
ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER IS: 813-1986.
WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY

1	PLATE	5x215x465	1		IRS M-41-1997	2.60	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
PLATE					SCALE	SSE/D	
					1:2	CHD	
					ALT.	ALTD	
					DRN	K.SETHURAMAN	
							
INDIAN RAILWAY STANDARDS				SHEET			
INTEGRAL COACH FACTORY, CHENNAI - 600038				1 OF 1		AAD11157	
						A3	

AAD11158

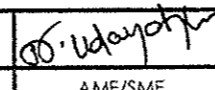
▽ ROUGH MACHINED	⊖ ROUGH CLEANED
▽▽ FINISH MACHINED	⊖⊖ BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	⊖⊖⊖ CHAMFERED

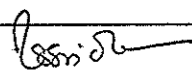
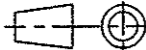
REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE
a		VERTICAL LOCATING DIMENSION OF SLOOTED HOLE ALTERED FROM 135 TO 133.	



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

20-10-2017	28-09-2017	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

1	PLATE	5x217x515	1		IRS M-41-1997	3.24	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
PLATE					SCALE	SSE/D	
					1:5	CHD	
					ALT.	ALTD	V.S.SRIDHARAN
					a	DRN	Kunti Thakur
INDIAN RAILWAY STANDARDS							
INTEGRAL COACH FACTORY, CHENNAI - 600038					SHEET 1 OF 1		AAD11158
							A3

AAD11160

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

REVISIONS

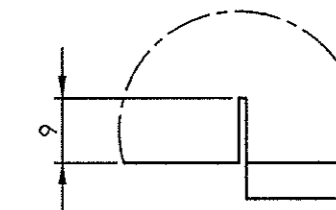
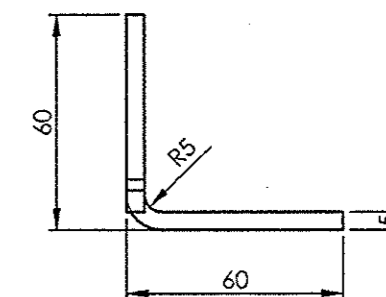
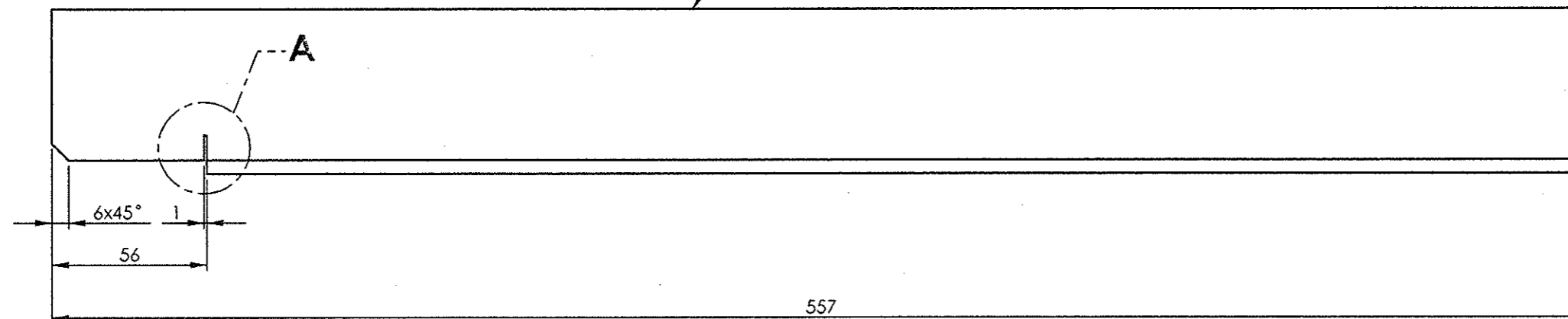
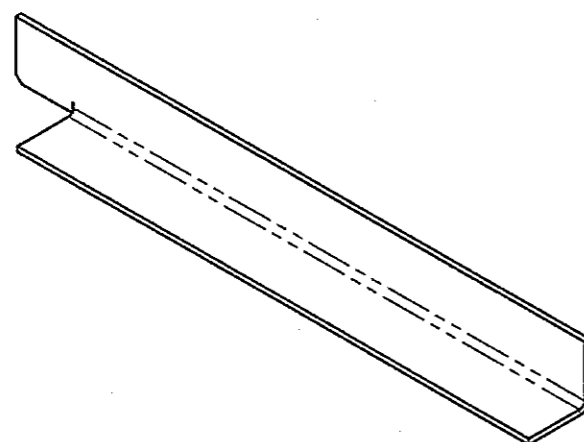
ALT.

ZONE

DESCRIPTION

APPROVED &
DATE

1

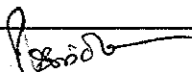
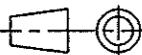
DETAIL A
SCALE 1 : 1

ISOMETRIC VIEW

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

REF.DRG.NO.

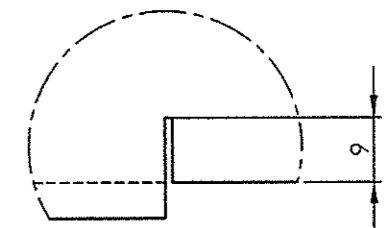
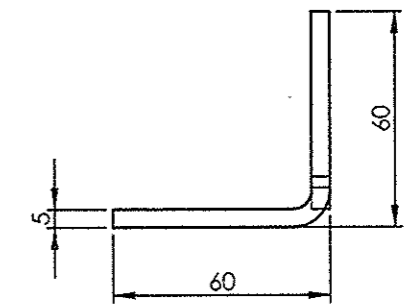
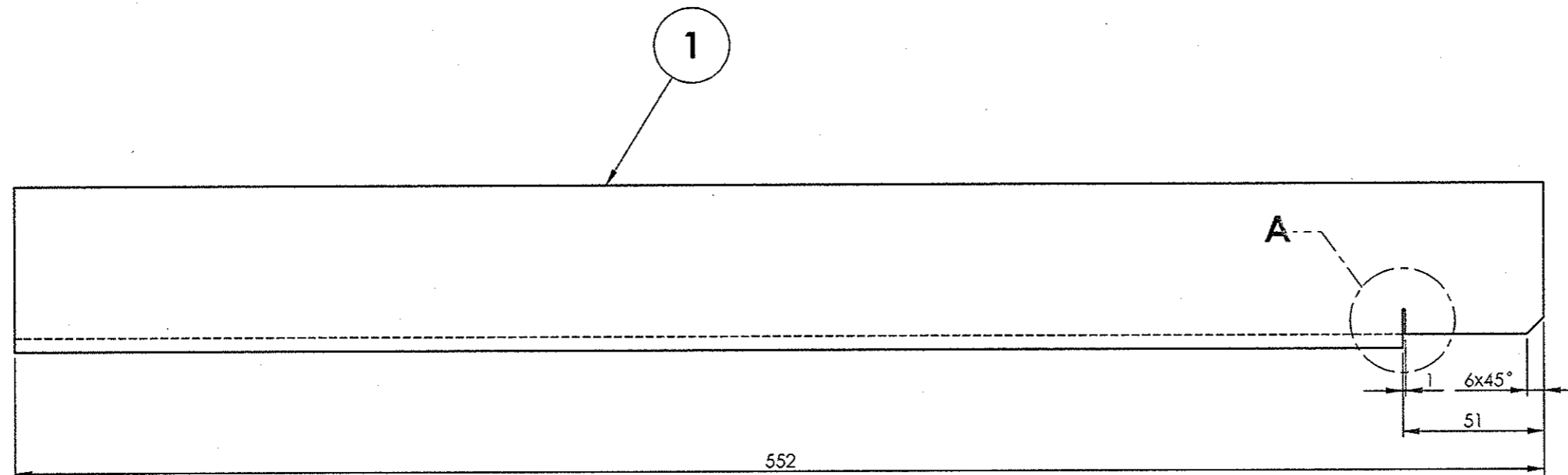
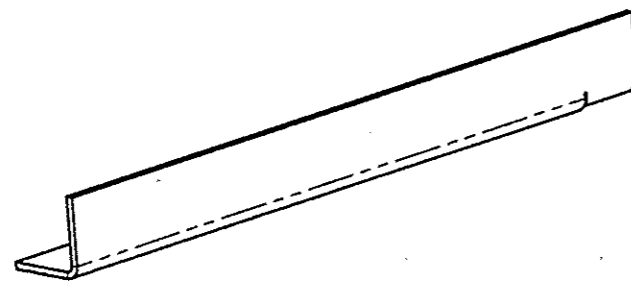
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DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

1	ANGLE	5x110x557	1		IRS M-41-1997	2.32		
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS	
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:			
ANGLE					SCALE	SSE/D		
					1:2	CHD		
					ALT.	ALTD		
						DRN	K.SETHURAMAN	
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038								
					SHEET 1 OF 1		AAD11160	A3

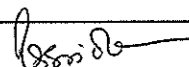
AAD11161

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

REVISIONS				APPROVED & DATE	
ALT.	ZONE	DESCRIPTION			

DETAIL A
SCALE 1 : 1

ISOMETRIC VIEW

1	ANGLE	5x110x552	1		IRS M-41-1997	2.31	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
ANGLE					SCALE	SSE/D	
					1:2	CHD	
					ALT.	ALTD	
						DRN	K.SETHURAMAN
					INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038		
A3							
					AAD11161		A3

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REF.DRG.NO.

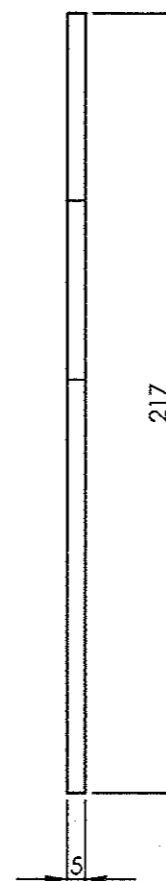
	28-09-2017	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

1		2		3		4		5		6		7		8	
AAD11162				▽ ROUGH MACHINED		③ ROUGH CLEANED		REVISIONS							
				▽▽ FINISH MACHINED		④ BURRS REMOVED		ALT.		ZONE		DESCRIPTION		APPROVED & DATE	
				▽▽▽ FINE FINISH MACHINED		⑧ CHAMFERED									
<div><div><div><div><div><div></div><div>1</div></div><div><div>6x45°</div><div>51</div><div>1</div></div><div>552</div></div></div><div><div>ISOMETRIC VIEW</div><div></div></div></div><div><div>DETAIL A</div><div>SCALE 1 : 1</div></div></div>															
<div><div><div><div><div>1</div><div>ANGLE</div><div>5x110x552</div><div>1</div><div>ITEM NO.</div><div>IRS M-41-1997</div><div>2.31</div><div></div></div><div><div>QTY.</div><div>DESCRIPTION</div><div>DIMENSIONS</div><div>REF. DRGS</div><div>MATL.SPEC.</div><div>WT/UNIT IN KGS</div><div>REMARKS</div></div></div><div><div>GROUP: 1-1</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>K.SETHURAMAN</div></div><div><div>INDIAN RAILWAY STANDARDS</div><div>INTEGRAL COACH FACTORY, CHENNAI - 600038</div><div>SHEET 1 OF 1</div><div>AAD11162</div><div>A3</div></div></div></div>															
REF.DRG.NO.		DATE OF LATEST ALT.		DATE OF FIRST ISSUE		AME/SME									
28-09-2017		28-09-2017		28-09-2017		28-09-2017									

1		2		3		4		5		6		7		8																																																												
AAD11180				▽ ROUGH MACHINED		① ROUGH CLEANED		REVISIONS																																																																		
				▽▽ FINISH MACHINED		② BURRS REMOVED		ALT.		ZONE		DESCRIPTION		APPROVED & DATE																																																												
				▽▽▽ FINE FINISH MACHINED		③ CHAMFERED																																																																				
<div><div><div>1</div><div>240</div><div>79.5</div><div>455</div><div>150</div><div>R20</div><div>R27.5</div><div>138</div><div>547</div><div>2748⁺²₋₃</div></div><div><div>12X45°</div><div>237</div><div>R5</div><div>80</div><div>5</div></div></div>																																																																										
<div><table><tr><td>1</td><td>CHANNEL</td><td>5x377x2748</td><td>1</td><td></td><td>IRS M-41-1997</td><td>39.67</td><td></td></tr><tr><td>QTY.</td><td>DESCRIPTION</td><td>DIMENSIONS</td><td>ITEM NO.</td><td>REF. DRGS</td><td>MATL. PEC.</td><td>WT/UNIT IN KGS</td><td>REMARKS</td></tr><tr><td colspan="2">GROUP: 1-1</td><td colspan="2">SURFACE AREA IN Sq.m.:</td><td colspan="4">WT/ASSY IN Kgs:</td></tr><tr><td colspan="4" rowspan="4">CHANNEL</td><td>SCALE</td><td>SSE/D</td><td colspan="2">1:5</td></tr><tr><td>ALT.</td><td>CHD</td><td colspan="2"></td></tr><tr><td>ALT.</td><td>ALTD</td><td colspan="2"></td></tr><tr><td>DRN</td><td colspan="2">Kunli Thokur</td></tr><tr><td colspan="4">INDIAN RAILWAY STANDARDS</td><td colspan="2">SHEET 1 OF 1</td><td colspan="2">A3</td></tr><tr><td colspan="4">INTEGRAL COACH FACTORY, CHENNAI - 600038</td><td colspan="2"></td><td colspan="2"></td></tr></table></div>																1	CHANNEL	5x377x2748	1		IRS M-41-1997	39.67		QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL. PEC.	WT/UNIT IN KGS	REMARKS	GROUP: 1-1		SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:				CHANNEL				SCALE	SSE/D	1:5		ALT.	CHD			ALT.	ALTD			DRN	Kunli Thokur		INDIAN RAILWAY STANDARDS				SHEET 1 OF 1		A3		INTEGRAL COACH FACTORY, CHENNAI - 600038							
1	CHANNEL	5x377x2748	1		IRS M-41-1997	39.67																																																																				
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL. PEC.	WT/UNIT IN KGS	REMARKS																																																																			
GROUP: 1-1		SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:																																																																						
CHANNEL				SCALE	SSE/D	1:5																																																																				
				ALT.	CHD																																																																					
				ALT.	ALTD																																																																					
				DRN	Kunli Thokur																																																																					
INDIAN RAILWAY STANDARDS				SHEET 1 OF 1		A3																																																																				
INTEGRAL COACH FACTORY, CHENNAI - 600038																																																																										
<div><div>20-10-2017</div><div>20-10-2017</div></div>																																																																										

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REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE

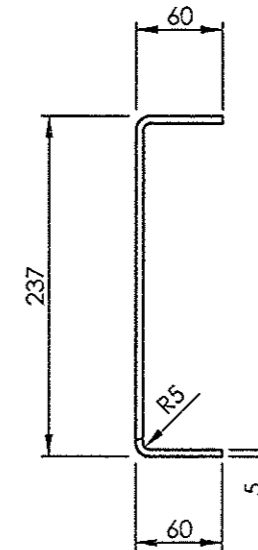
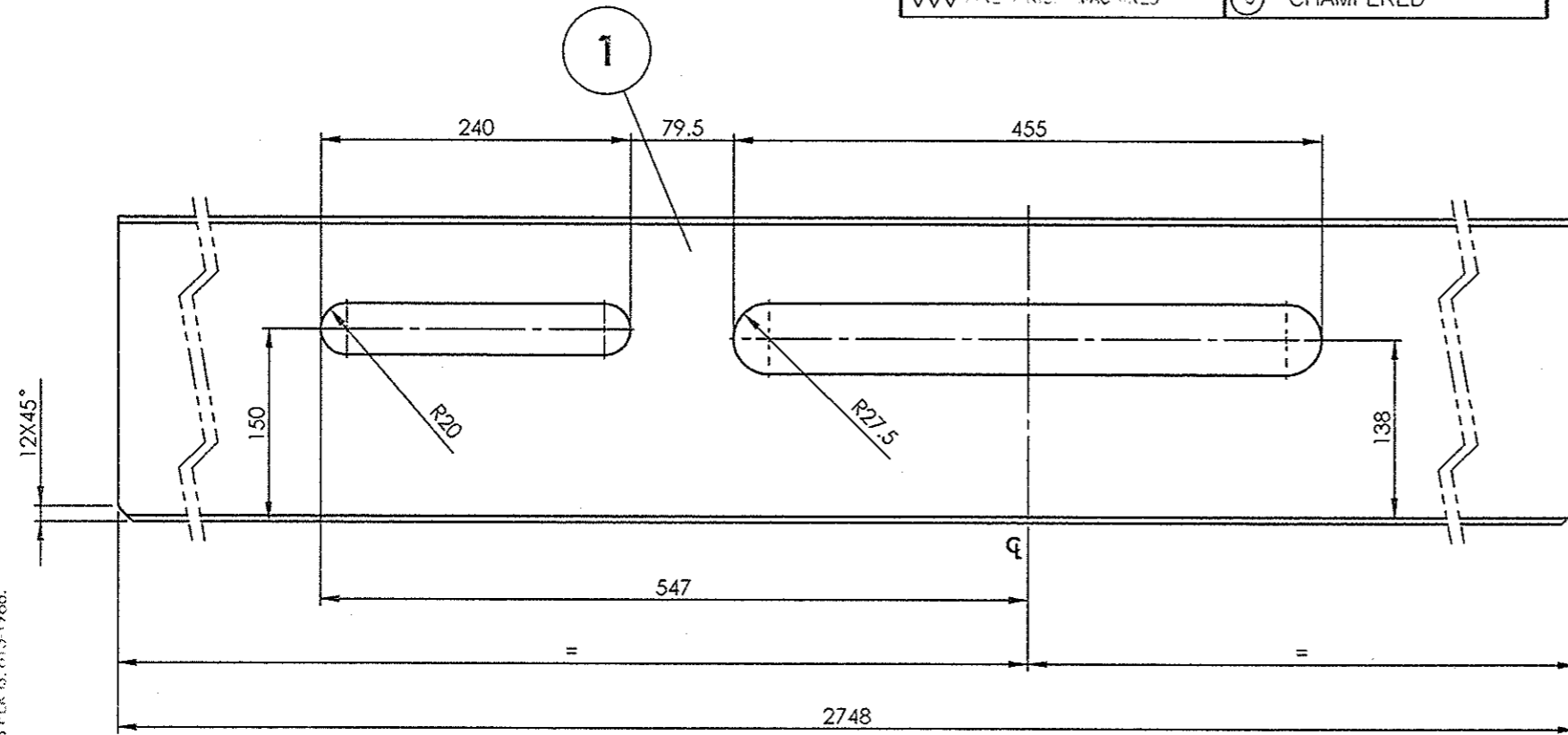


REF.DRG.NO. 574-1-1-011/Item-14

AAD11182

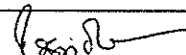
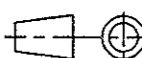
▽ ROUGH MACHINED	① ROUGH CLEANED
▽▽ FINISH MACHINED	② BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	③ CHAMFERED

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



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

1	CHANNEL	5x337x2748	1		IRS M-41-1997	35.37	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:5	CHD	
					ALT.	ALTD	
						DRN	Kunli Thokur
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1			
					AAD11182		A3

1		2		3		4		5		6		7		8																																																																
AAD11183				▽ ROUGH MACHINED		① ROUGH CLEANED		REVISIONS																																																																						
				▽▽ FINISH MACHINED		② BURRS REMOVED		ALT.		ZONE		DESCRIPTION		APPROVED & DATE																																																																
				▽▽▽ FINE FINISH MACHINED		③ CHAMFERED																																																																								
<div><div><div>1</div><div>455</div><div>79.5</div><div>240</div><div>143</div><div>R27.5</div><div>R20</div><div>150</div><div>547</div><div>2748⁻³₋₂</div></div><div><div>60</div><div>237</div><div>R5</div><div>60</div><div>5</div></div></div>																																																																														
<table><tr><td>1</td><td>CHANNEL</td><td>5x337x2748</td><td>1</td><td></td><td>IRS M-41-1997</td><td>35.37</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: 1-1</td><td colspan="2">SURFACE AREA IN Sq.m.:</td><td colspan="4">WT/ASSY IN Kgs:</td></tr><tr><td colspan="4" rowspan="3">CHANNEL</td><td>SCALE</td><td>SSE/D</td><td colspan="2">Kunti Thakur</td></tr><tr><td>1:5</td><td>CHD</td><td colspan="2"></td></tr><tr><td>ALT.</td><td>ALTD</td><td colspan="2"></td></tr><tr><td colspan="4"></td><td>DRN</td><td colspan="2"></td></tr><tr><td colspan="4">INDIAN RAILWAY STANDARDS</td><td colspan="2">SHEET 1 OF 1</td><td colspan="2">A3</td></tr><tr><td colspan="4">INTEGRAL COACH FACTORY, CHENNAI - 600038</td><td colspan="2"></td><td colspan="2"></td></tr></table>																1	CHANNEL	5x337x2748	1		IRS M-41-1997	35.37		QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS	GROUP: 1-1		SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:				CHANNEL				SCALE	SSE/D	Kunti Thakur		1:5	CHD			ALT.	ALTD							DRN			INDIAN RAILWAY STANDARDS				SHEET 1 OF 1		A3		INTEGRAL COACH FACTORY, CHENNAI - 600038							
1	CHANNEL	5x337x2748	1		IRS M-41-1997	35.37																																																																								
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS																																																																							
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				1:5	CHD																																																																									
				ALT.	ALTD																																																																									
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INDIAN RAILWAY STANDARDS				SHEET 1 OF 1		A3																																																																								
INTEGRAL COACH FACTORY, CHENNAI - 600038																																																																														
<div><div>20-10-2017</div><div>INDIAN RAILWAY STANDARDS</div><div>INTEGRAL COACH FACTORY, CHENNAI - 600038</div><div>SHEET 1 OF 1</div><div>AAD11183</div><div>A3</div></div>																																																																														

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

AAD11184

▽ ROUGH MACHINED

① ROUGH CLEANED

▽▽ FINISH MACHINED

② BURRS REMOVED

▽▽▽ FINE FINISH MACHINED

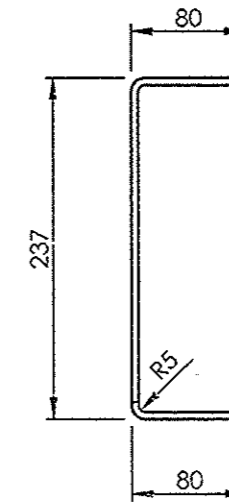
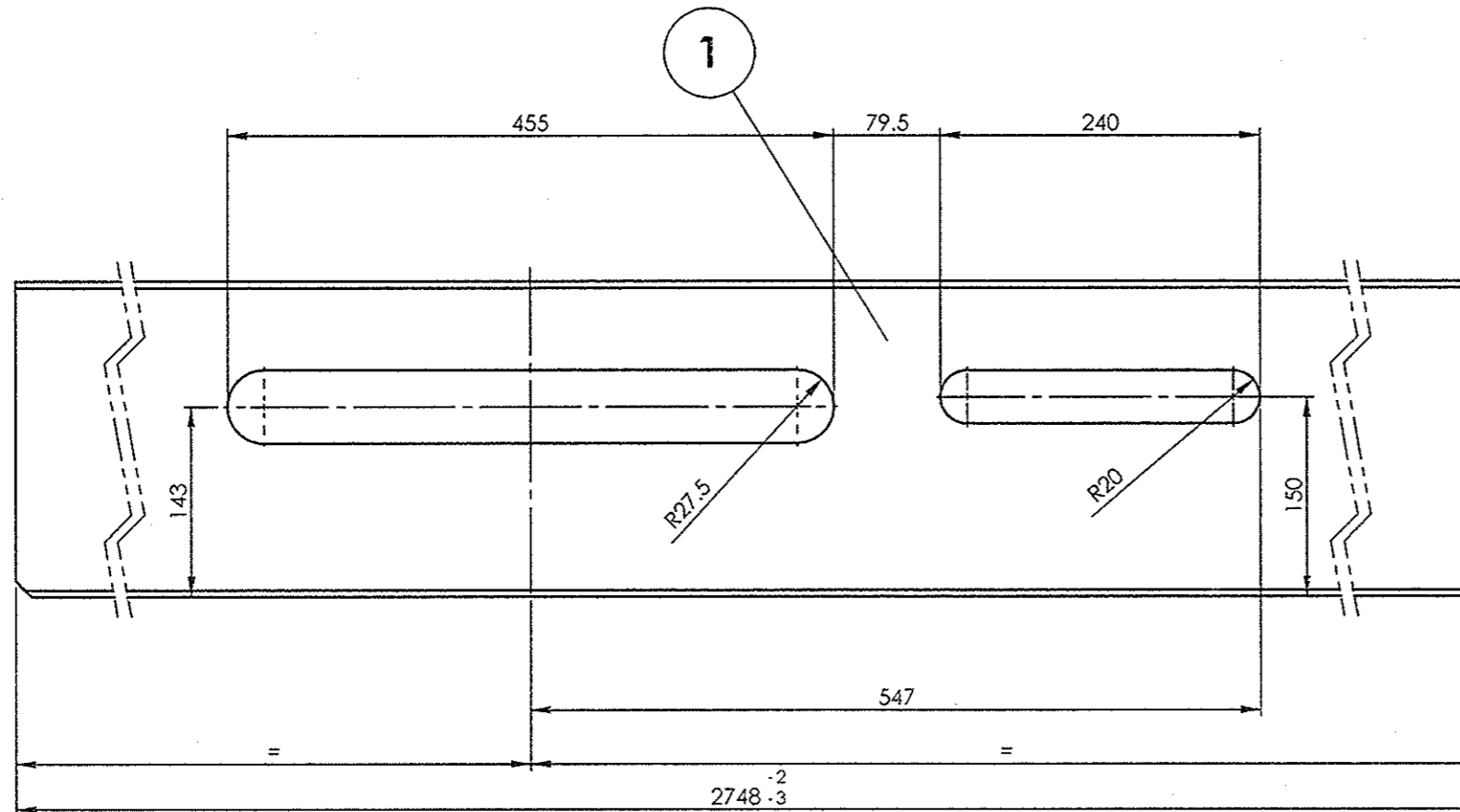
③ CHAMFERED

REVISIONS

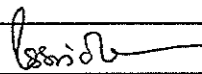
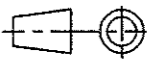
ALT.

ZONE

DESCRIPTION

APPROVED &
DATE

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

1	CHANNEL	5x377x2748	1		IRS M-41-1997	39.67	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:5	CHD	
					ALT.	ALTD	
						DRN	Kunti Thakur
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038							
					SHEET 1 OF 1		AAD11184

1		2		3		4		5		6		7		8																																																											
AAD11185				▽ ROUGH MACHINED		⊖ ROUGH CLEANED		REVISIONS																																																																	
				▽▽ FINISH MACHINED		⊖⊖ BURRS REMOVED		ALT.		ZONE		DESCRIPTION		APPROVED & DATE																																																											
				▽▽▽ FINE FINISH MACHINED		⊖⊖⊖ CHAMFERED																																																																			
<div><div>1</div><div><div><div>5</div><div>6X45°</div><div>76</div><div>5</div><div>1</div><div>5</div><div>483</div></div><div><div>60</div><div>R5</div><div>60</div><div>5</div></div></div></div>																																																																									
<table><tr><td>1</td><td>ANGLE</td><td>5x110x483</td><td>1</td><td></td><td>IRS M-41-1997</td><td>1.95</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: 1-1</td><td colspan="2">SURFACE AREA IN Sq.m.:</td><td>WT/ASSY IN Kgs:</td></tr><tr><td colspan="5" rowspan="4">ANGLE</td><td>SCALE</td><td>SSE/D</td><td rowspan="2"></td></tr><tr><td>1:5</td><td>CHD</td></tr><tr><td>ALT.</td><td>ALTD</td><td></td></tr><tr><td></td><td>DRN</td><td>Kunti Thokur</td></tr><tr><td colspan="5">INDIAN RAILWAY STANDARDS</td><td colspan="2">SHEET 1 OF 1</td><td>AAD11185</td><td>A3</td></tr><tr><td colspan="5">INTEGRAL COACH FACTORY, CHENNAI - 600038</td><td colspan="2"></td><td></td><td></td></tr></table>																1	ANGLE	5x110x483	1		IRS M-41-1997	1.95		QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS	GROUP: 1-1					SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:	ANGLE					SCALE	SSE/D		1:5	CHD	ALT.	ALTD			DRN	Kunti Thokur	INDIAN RAILWAY STANDARDS					SHEET 1 OF 1		AAD11185	A3	INTEGRAL COACH FACTORY, CHENNAI - 600038								
1	ANGLE	5x110x483	1		IRS M-41-1997	1.95																																																																			
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS																																																																		
GROUP: 1-1					SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:																																																																		
ANGLE					SCALE	SSE/D																																																																			
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INTEGRAL COACH FACTORY, CHENNAI - 600038																																																																									

20-10-2017

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20-10-2017

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

AAD11186

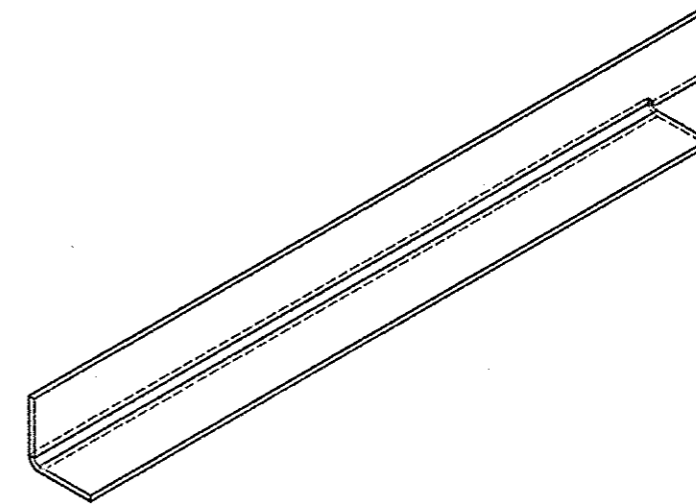
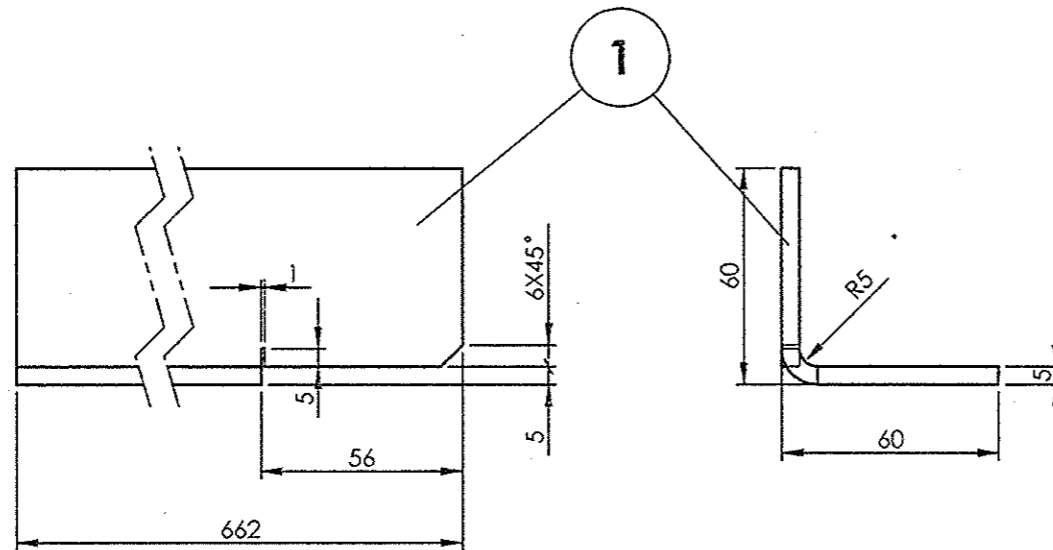
▽ ROUGH MACHINED	① ROUGH CLEANED
▽▽ FINISH MACHINED	② BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	③ CHAMFERED

REVISIONS

ALT.

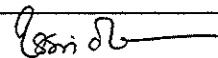
ZONE

DESCRIPTION

APPROVED &
DATE

ISOMETRIC VIEW

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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1	ANGLE	5x110x662	1		IRS M-41-1997	2.78		
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS	
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:			
ANGLE					SCALE	SSE/D		
					1:2	CHD		
					ALT.	ALTD		
						DRN	Kunfi Thokur	
					INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038			

1		2		3		4		5		6		7		8																																																											
AAD11187				▽ ROUGH MACHINED		① ROUGH CLEANED		REVISIONS																																																																	
				▽▽ FINISH MACHINED		② BURRS REMOVED		ALT.		ZONE		DESCRIPTION		APPROVED & DATE																																																											
				▽▽▽ FINE FINISH MACHINED		③ CHAMFERED																																																																			
<div><div><div>1</div><div><div><div>5</div><div>56</div><div>662</div></div><div><div>5</div><div>5</div><div>5</div><div>6X45°</div></div></div></div><div><div>60</div><div>R5</div><div>60</div><div>5</div></div></div>																																																																									
<div><table><tr><td>1</td><td>ANGLE</td><td>5x110x662</td><td>1</td><td></td><td>IRS M-41-1997</td><td>2.78</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: 1-1</td><td colspan="2">SURFACE AREA IN Sq.m.:</td><td colspan="4">WT/ASSY IN Kgs:</td></tr><tr><td colspan="5" rowspan="4">ANGLE</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>Kunti Thakur</td></tr><tr><td colspan="5">INDIAN RAILWAY STANDARDS</td><td colspan="2">SHEET 1 OF 1</td><td>AAD11187</td><td>A3</td></tr><tr><td colspan="5">INTEGRAL COAC FACTORY, CHENNAI - 600038</td><td colspan="2"></td><td></td><td></td></tr></table></div>																1	ANGLE	5x110x662	1		IRS M-41-1997	2.78		QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS	GROUP: 1-1		SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:				ANGLE					SCALE	SSE/D		1:2	CHD	ALT.	ALTD			DRN	Kunti Thakur	INDIAN RAILWAY STANDARDS					SHEET 1 OF 1		AAD11187	A3	INTEGRAL COAC FACTORY, CHENNAI - 600038								
1	ANGLE	5x110x662	1		IRS M-41-1997	2.78																																																																			
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS																																																																		
GROUP: 1-1		SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:																																																																					
ANGLE					SCALE	SSE/D																																																																			
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INDIAN RAILWAY STANDARDS					SHEET 1 OF 1		AAD11187	A3																																																																	
INTEGRAL COAC FACTORY, CHENNAI - 600038																																																																									
<div><div>20-10-2017</div><div></div></div>																																																																									

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AAD11189				▽ ROUGH MACHINED		① ROUGH CLEANED		REVISIONS																																																															
				▽▽ FINISH MACHINED		② BURRS REMOVED		ALT.		ZONE		DESCRIPTION		APPROVED & DATE																																																									
				▽▽▽ FINE FINISH MACHINED		③ CHAMFERED																																																																	
<div><div>1</div><div><div><div><div><div><div>497</div></div><div><div>76</div></div><div><div>5</div></div><div><div>5</div></div><div><div>1</div></div><div><div>6X45°</div></div><div><div>5</div></div></div></div><div><div><div>60</div></div><div><div>60</div></div><div><div>R5</div></div><div><div>5</div></div></div></div></div></div>																																																																							
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1	ANGLE	5x110x497	1		IRS M-41-1997	2.01																																																																	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS																																																																
GROUP: 1-1		SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:																																																																			
ANGLE				SCALE	SSE/D																																																																		
				1:2	CHD																																																																		
				ALT.	ALTD	Kunti Thakur																																																																	
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INDIAN RAILWAY STANDARDS				SHEET 1 OF 1		A3																																																																	
INTEGRAL COACH FACTORY, CHENNAI - 600038																																																																							
<div><div>20-10-2017</div><div></div></div>																																																																							

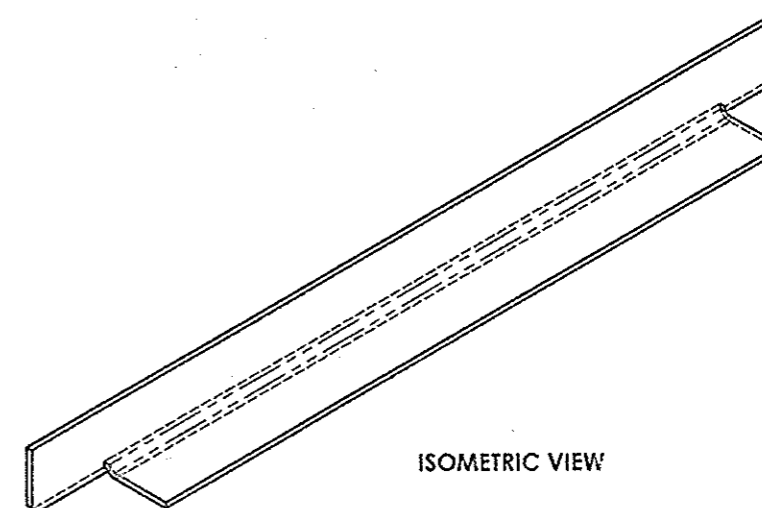
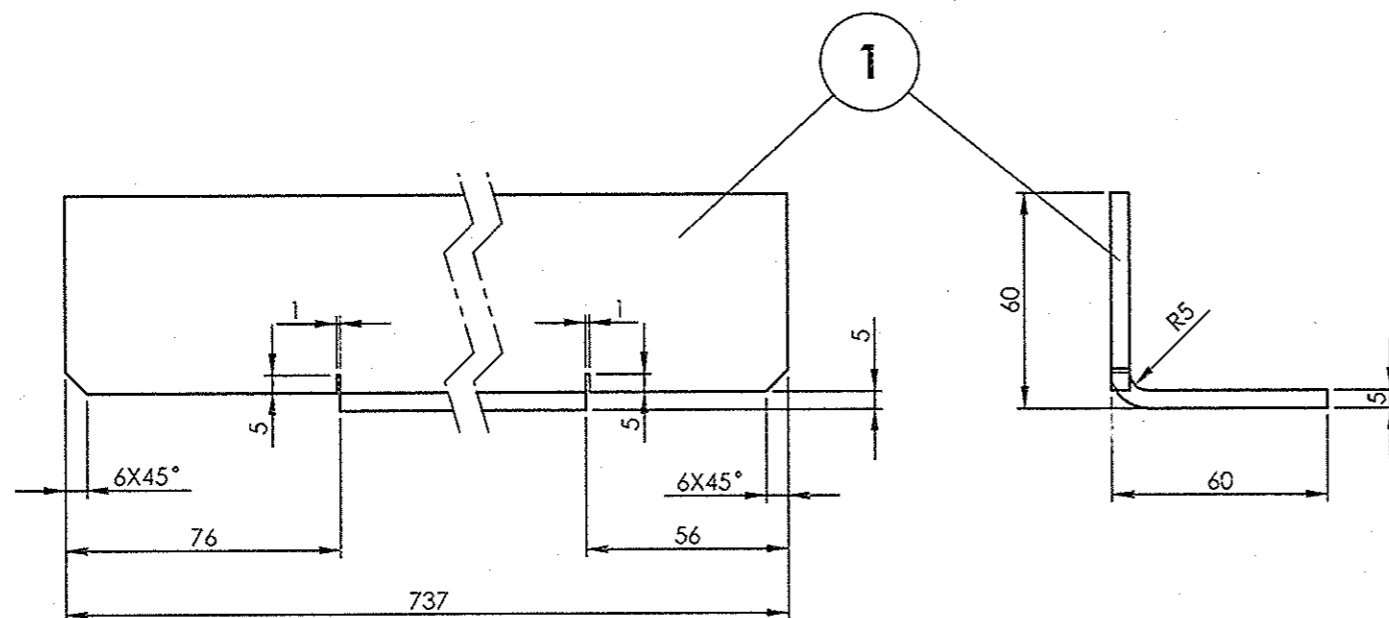
DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICE/SID 9-0-001.
MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER IS: 813-1986.
RIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY

AAD11190

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

REVISIONS

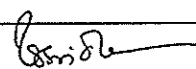
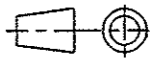
ALT.	ZONE	DESCRIPTION	APPROVED & DATE
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ISOMETRIC VIEW

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1	ANGLE	5x110x737	1		IRS M-41-1997	2.94	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1			SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:		
ANGLE					SCALE	SSE/D	
					1:2	CHD	
					ALT.	ALTD	
						DRN	Kunti Thakur
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038							
					SHEET 1 OF 1		AAD11190

1		2		3		4		5		6		7		8	
AAD11191						▽ ROUGH MACHINED		⊖ ROUGH CLEANED		REVISIONS					
						▽▽ FINISH MACHINED		⊖⊖ BURRS REMOVED		ALT.		ZONE		DESCRIPTION	
						▽▽▽ FINE FINISH MACHINED		⊖⊖⊖ CHAMFERED						APPROVED & DATE	

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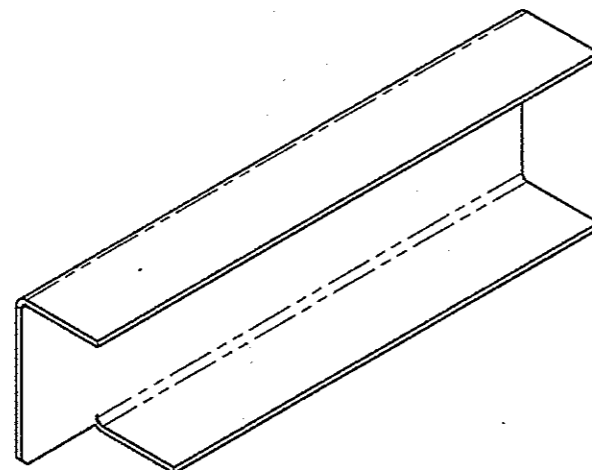
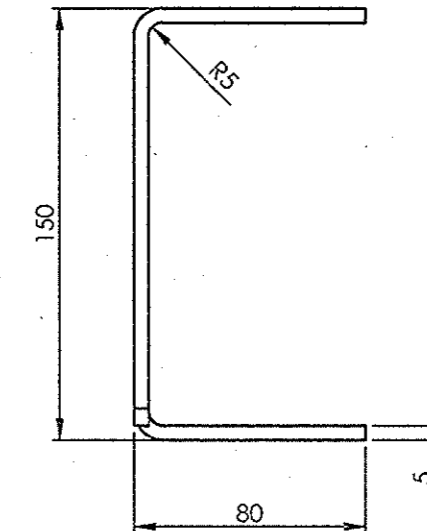
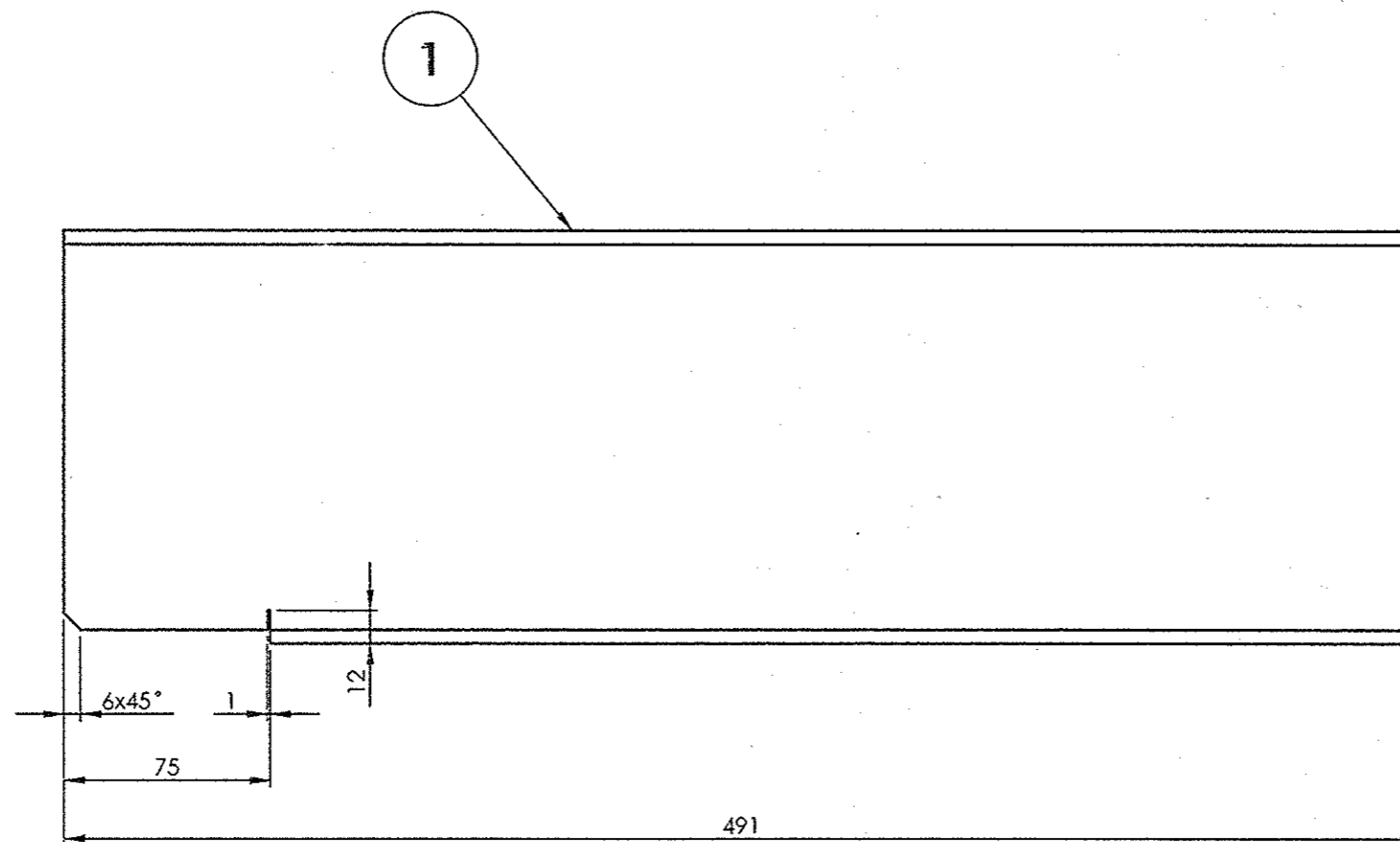
ISOMETRIC VIEW

1	ANGLE	5x110x727	1		IRS M-41-1997	2.92	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1		SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:			
ANGLE					SCALE	SSE/D	
					1:2	CHD	
					ALT.	ALTD	Kunti Thakur
						DRN	
INDIAN RAILWAY STANDARDS					SHEET 1 OF 1		
INTEGRAL COACH FACTORY, CHENNAI - 600038							
20-10-2017				AAD11191		A3	

AAD11193

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

REVISIONS				
ALT.	ZONE	DESCRIPTION		APPROVED & DATE

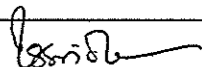
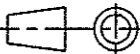


ISOMETRIC VIEW

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.

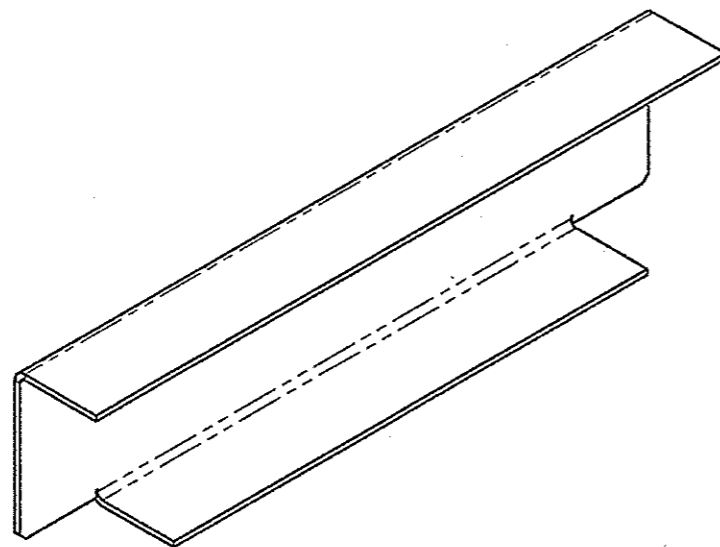
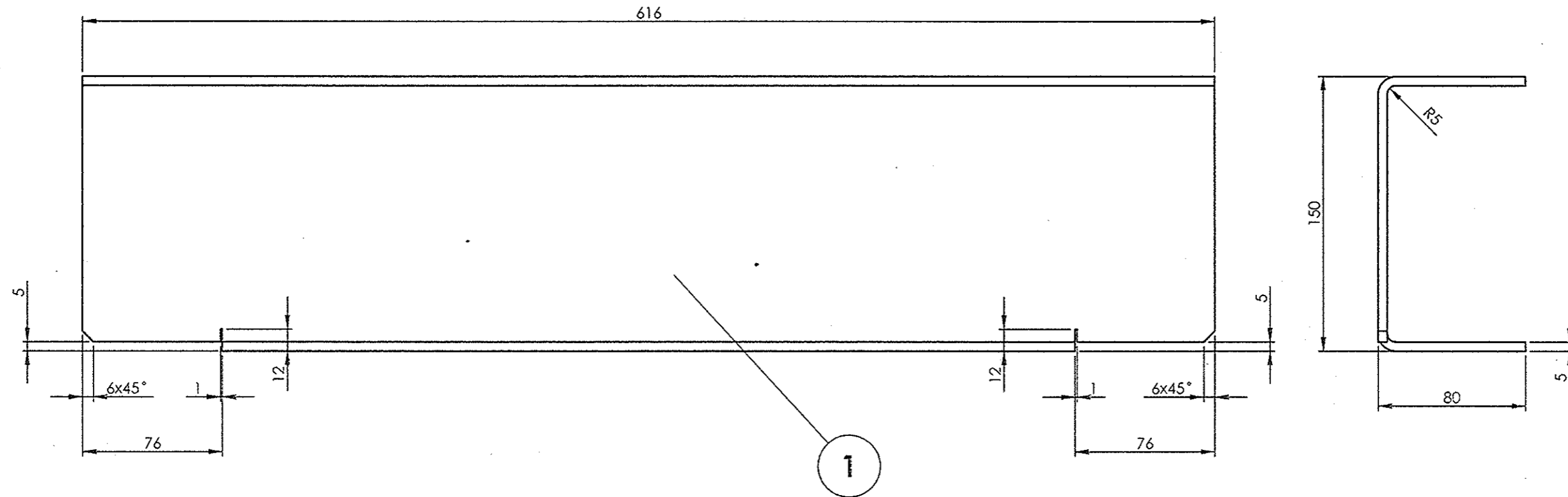
	23 -10-2017	<i>[Signature]</i>
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

1	CHANNEL	5x290x491	1		IRS M-41-1997	5.430	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: UNDER FRAME		SURFACE AREA IN Sq.m.:0.285			WT/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:2.5	CHD	
					ALT.	ALTD	
						DRN	K.Sethuraman
INDIAN RAILWAY STANDARDS							
INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1		AAD11193	
						A3	

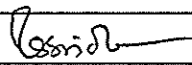
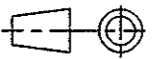
AAD11194

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

REVISIONS				APPROVED & DATE	
ALT.	ZONE	DESCRIPTION			



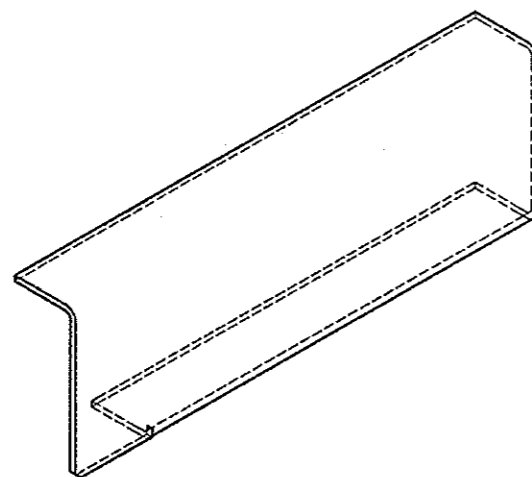
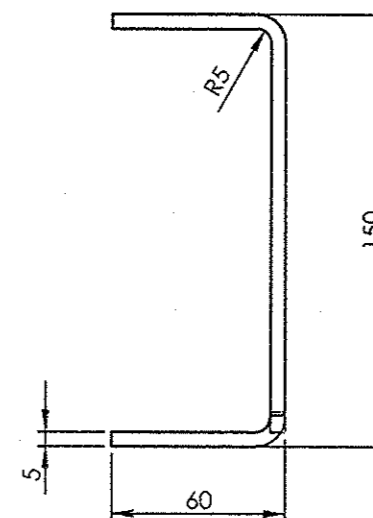
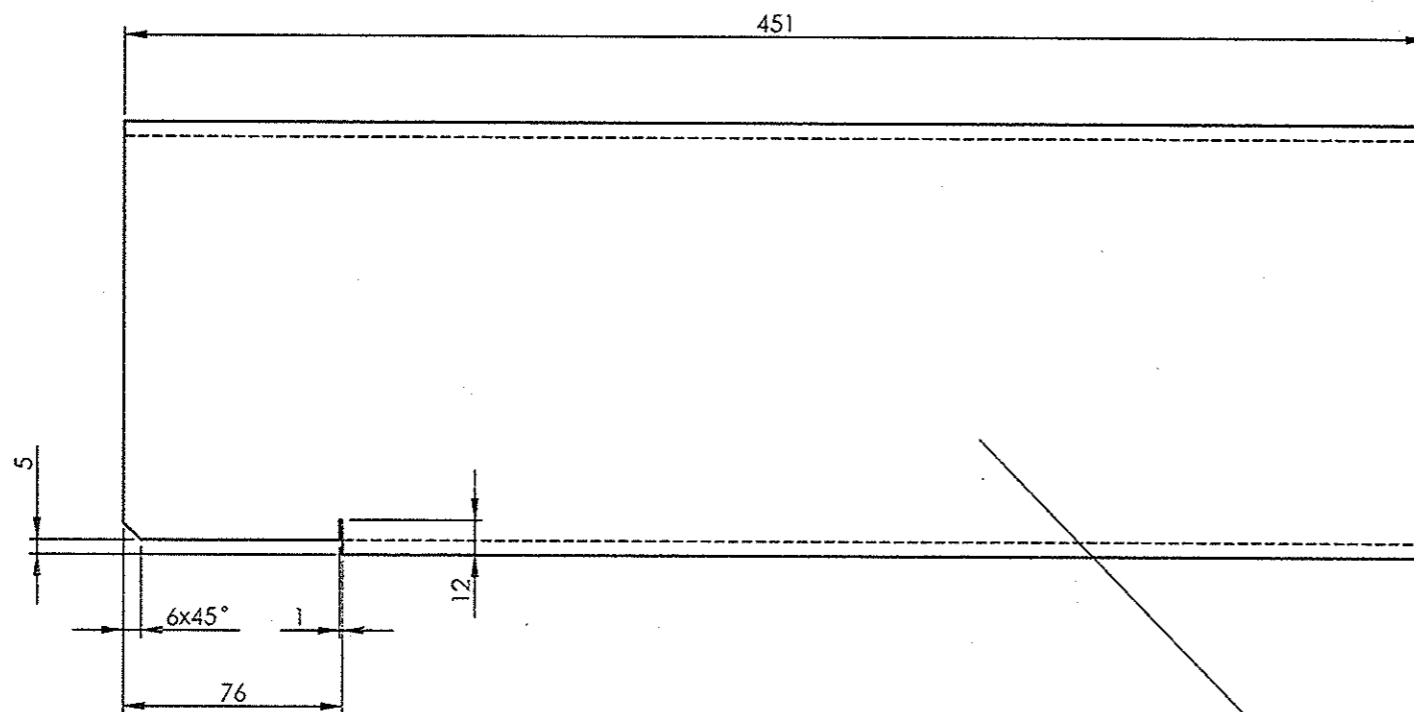
ISOMETRIC VIEW

1	CHANNEL	5x290x616	1		IRS M-41-1997	6.638	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: UNDER FRAME		SURFACE AREA IN Sq.m.:0.347			WT/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:2.5	CHD	
					ALT.	ALTD	
						DRN	K.Sethuraman
							
INDIAN RAILWAY STANDARDS				SHEET			
INTEGRAL COACH FACTORY, CHENNAI - 600038				1 OF 1			
AAD11194						A3	

AAD11195

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

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE

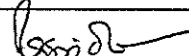
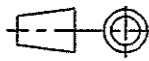


ISOMETRIC VIEW

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

REF.DRG.NO.

DATE OF LATEST ALT.	23-10-2017	AME/SME
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1	CHANNEL	5x250x451	1		IRS M-41-1997	4.318	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: UNDER FRAME		SURFACE AREA IN Sq.m.:0.227			WT/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:2.5	CHD	
					ALT.	ALTD	
						DRN	K.Sethuraman
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038							
					SHEET 1 OF 1		
					AAD11195		A3

AAD11196

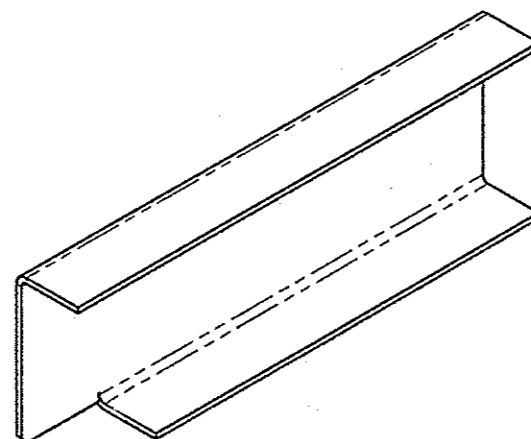
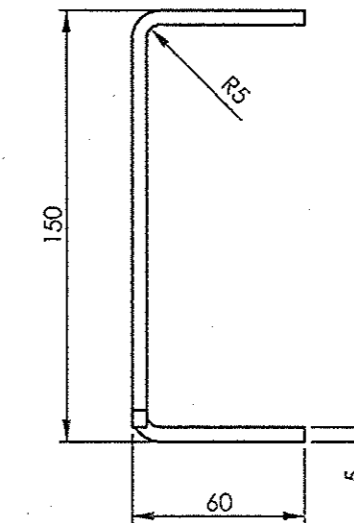
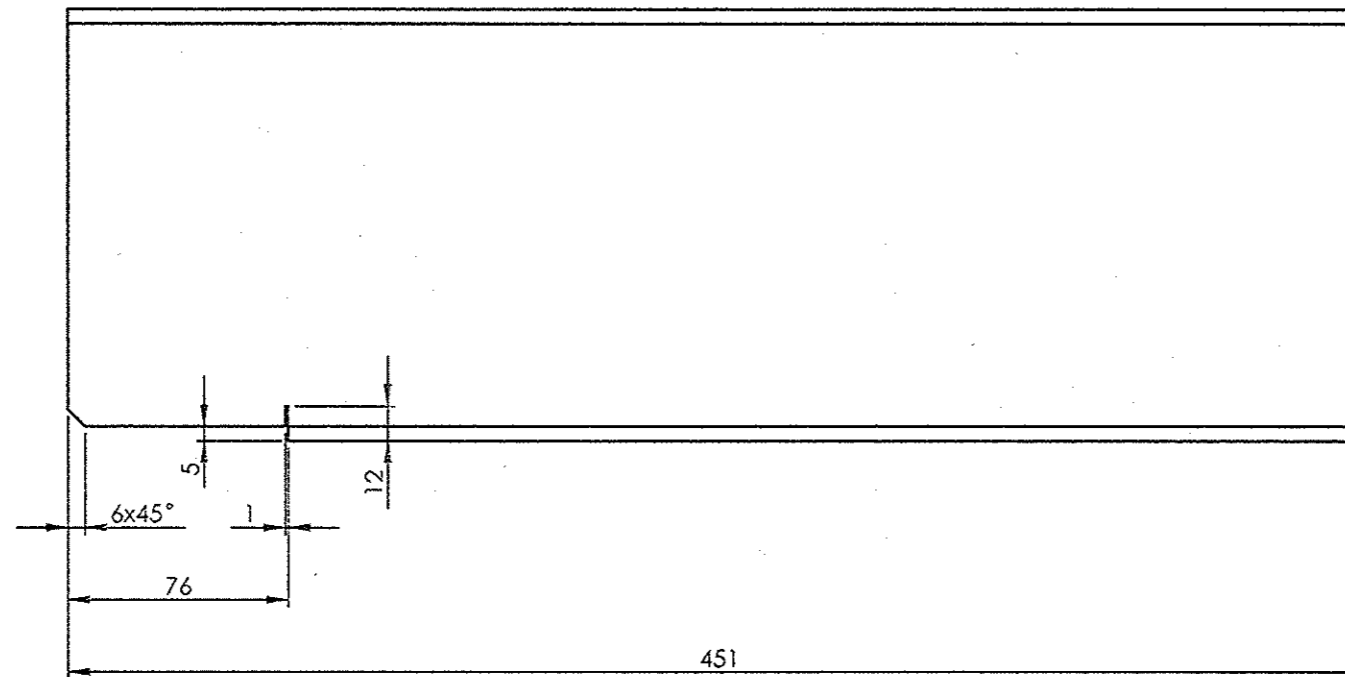
▽ ROUGH MACHINED	① ROUGH CLEANED
▽▽ FINISH MACHINED	② BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	③ CHAMFERED

REVISIONS

ALT.

ZONE

DESCRIPTION

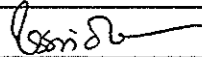
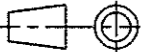
APPROVED &
DATE

ISOMETRIC VIEW

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

REF.DRG.NO.

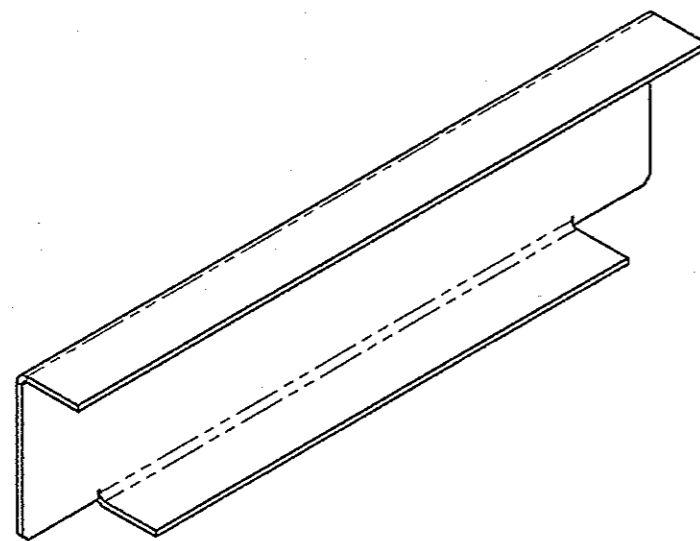
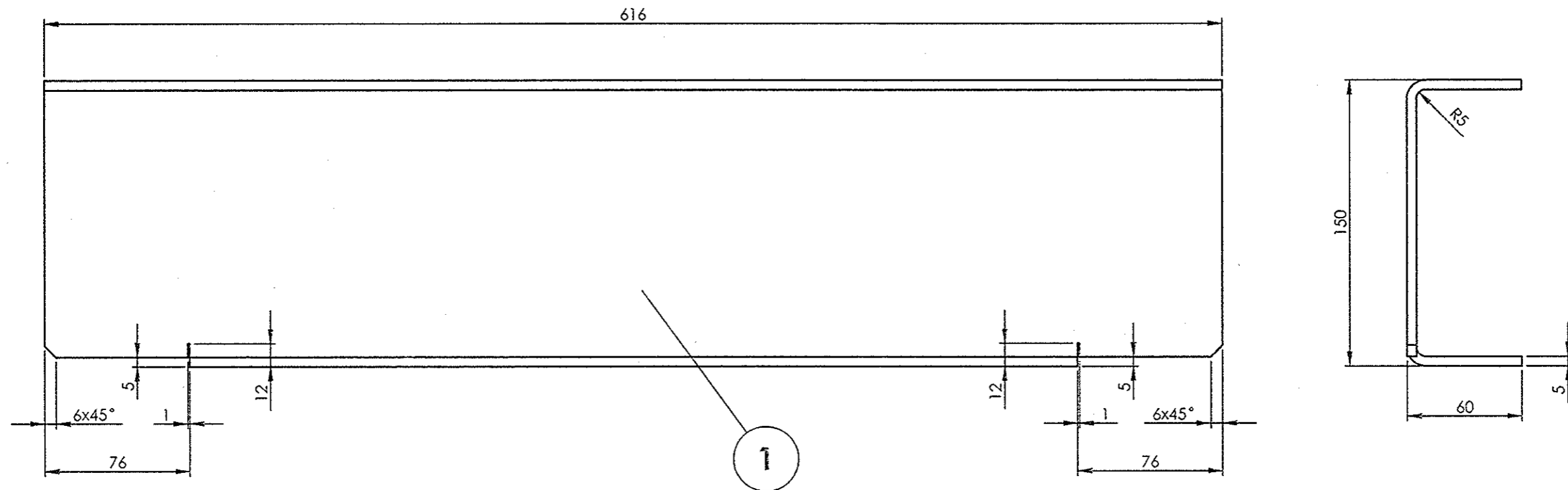
DATE OF LATEST ALT.	23-10-2017	AME/SME
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1	CHANNEL	5x250x451	1		IRS M-41-1997	4.318	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: UNDER FRAME		SURFACE AREA IN Sq.m.:0.227			WT/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:2.5	CHD	
					ALT.	ALTD	
						DRN	K.Sethuraman
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1			
					AAD11196		A3

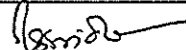

AAD11197

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

REVISIONS				APPROVED & DATE	
ALT.	ZONE	DESCRIPTION			



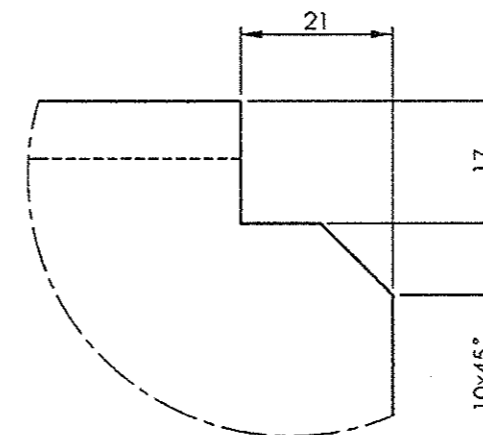
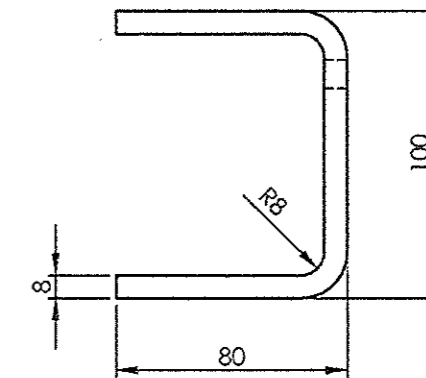
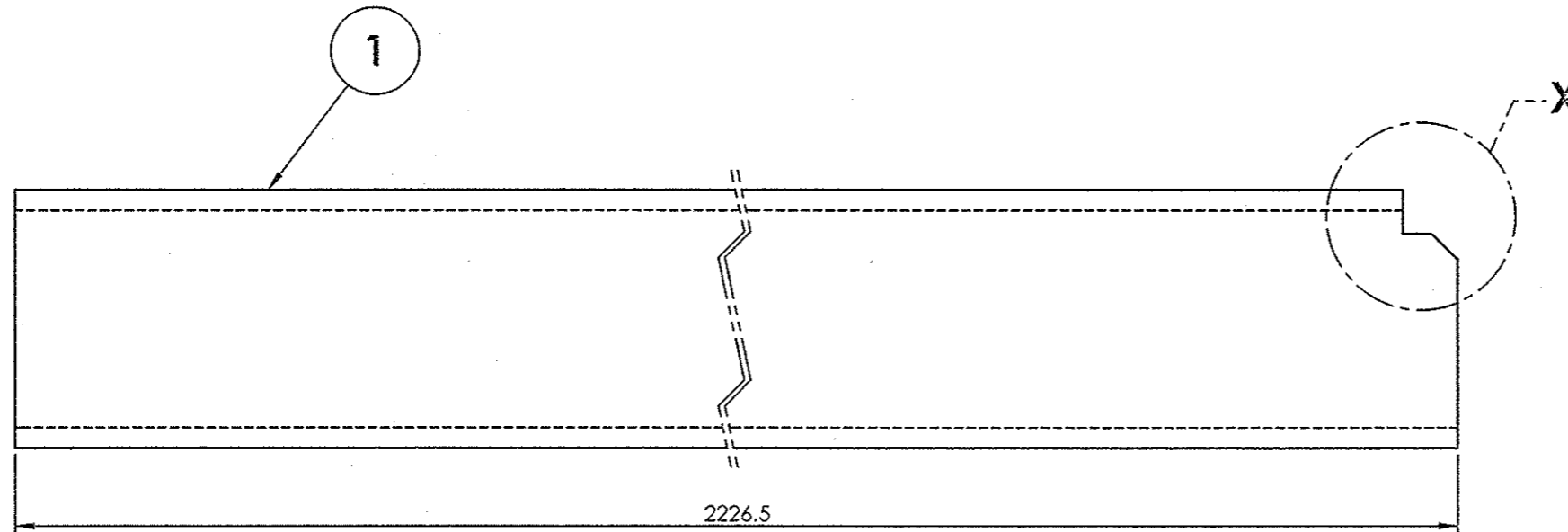
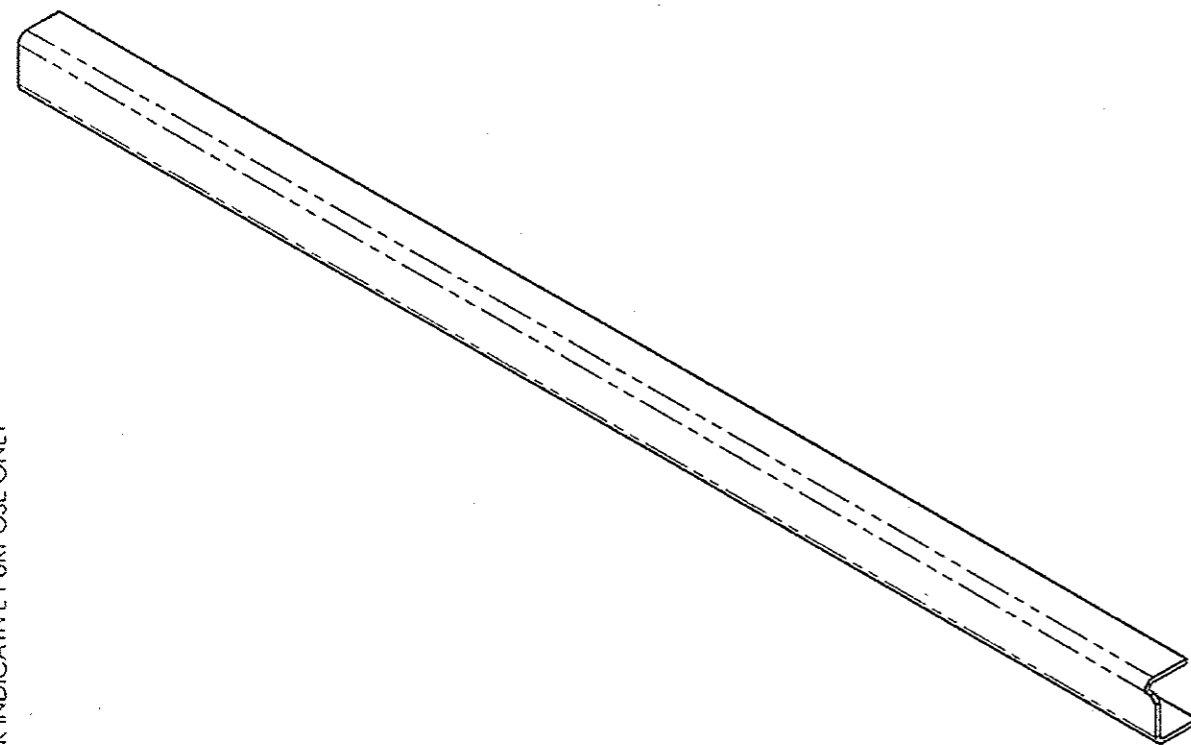
ISOMETRIC VIEW

1	CHANNEL	5x250x616	1		IRS M-41-1997	5.790	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: UNDER FRAME			SURFACE AREA IN Sq.m.:0.304		WT/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:2.5	CHD	
					ALT.	ALTD	
					DRN	K.Sethuraman	
							
INDIAN RAILWAY STANDARDS				SHEET 1 OF 1			
INTEGRAL COACH FACTORY, CHENNAI - 600038					AAD11197		
					A3		

AAD11198

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

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE

DETAIL X
SCALE 1 : 1

ISOMETRIC VIEW

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

1	CHANNEL	8x228x2226.5	1		IRS M-41-1997	32.56	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:2.5	CHD	
					ALT.	ALTD	
						DRN	K.SETHURAMAN
INDIAN RAILWAY STANDARDS							
INTEGRAL COACH FACTORY, CHENNAI - 600035					SHEET 1 OF 1	AAD11198	
							A3

20-10-2017

INDIAN RAILWAY STANDARDS

INTEGRAL COACH FACTORY, CHENNAI - 600035

SHEET
1 OF 1

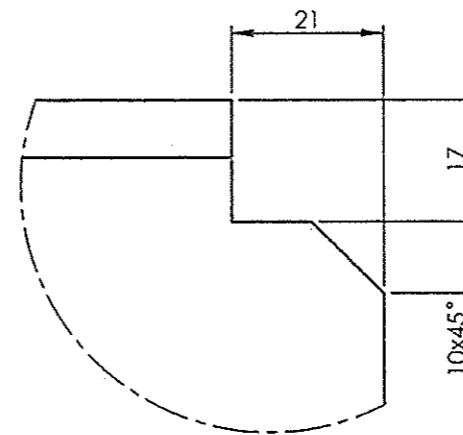
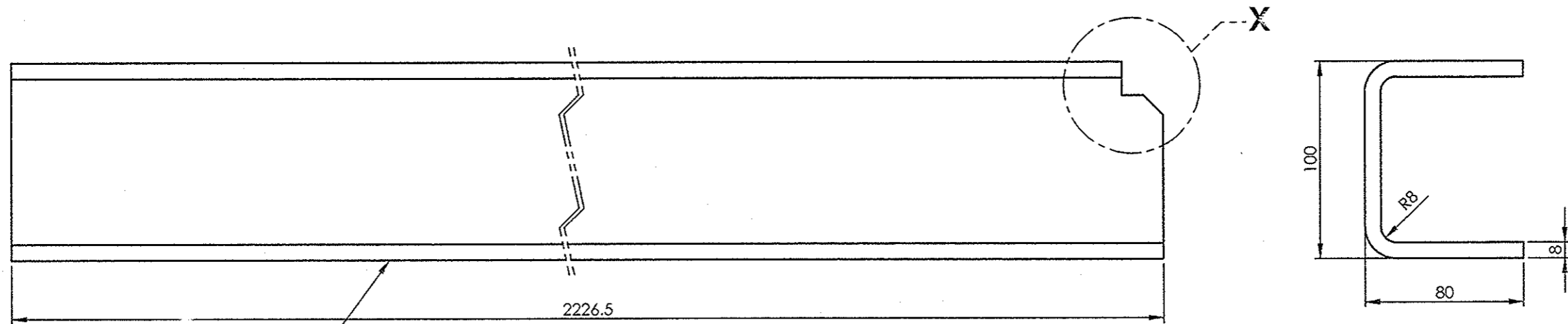
AAD11198

A3

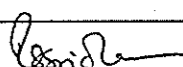
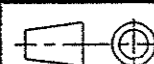
AAD11199

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

REVISIONS				APPROVED & DATE	
ALT.	ZONE	DESCRIPTION			

DETAIL X
SCALE 1 : 1

ISOMETRIC VIEW

1	CHANNEL	8x228x2226.5	1		IRS M-41-1997	32.56	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:2.5	CHD	
					ALT.	ALTD	
						DRN	K.SETHURAMAN
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038							
					SHEET 1 OF 1		AAD11199

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

	20-10-2017	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

AAD11204

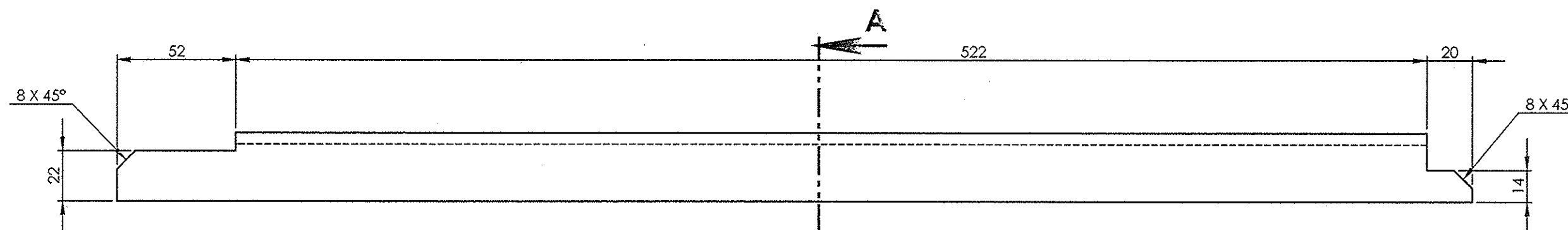
▽ ROUGH MACHINED	① ROUGH CLEANED
▽ FINISH MACHINED	② BURRS REMOVED
▽ FINE FINISH MACHINED	③ CHAMFERED

REVISIONS

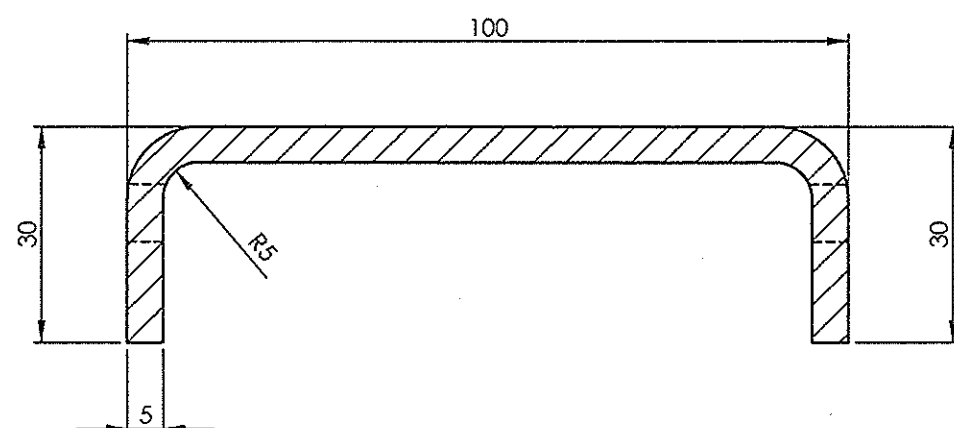
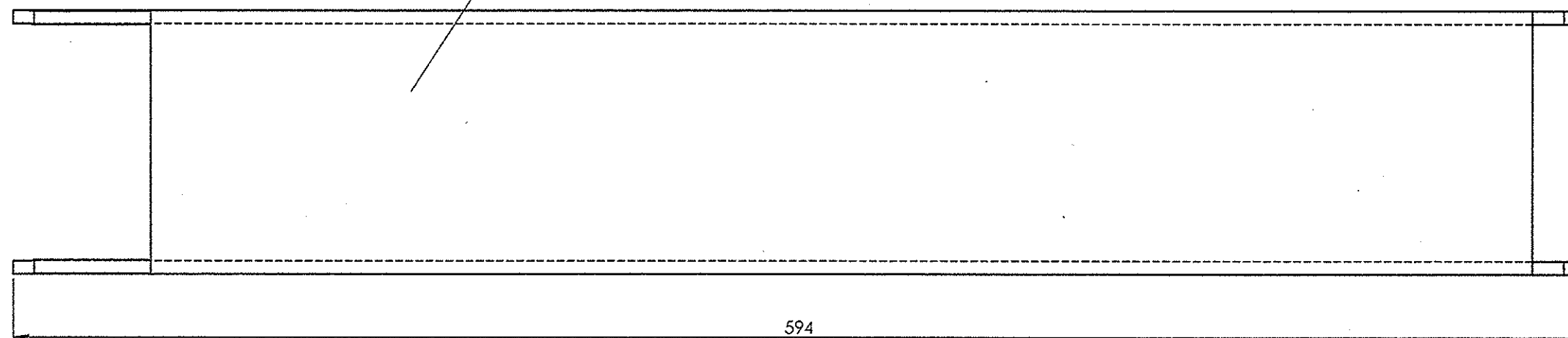
ALT.

ZONE

DESCRIPTION

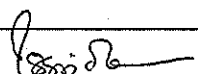

APPROVED &
DATE

1

SECTION A-A
SCALE 1 : 1

REF.DRG.NO.-

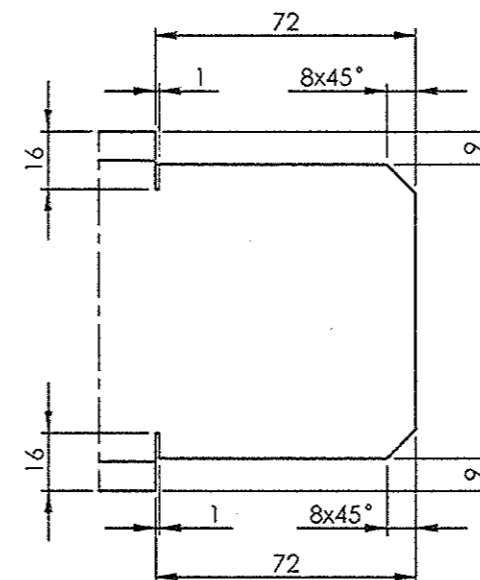
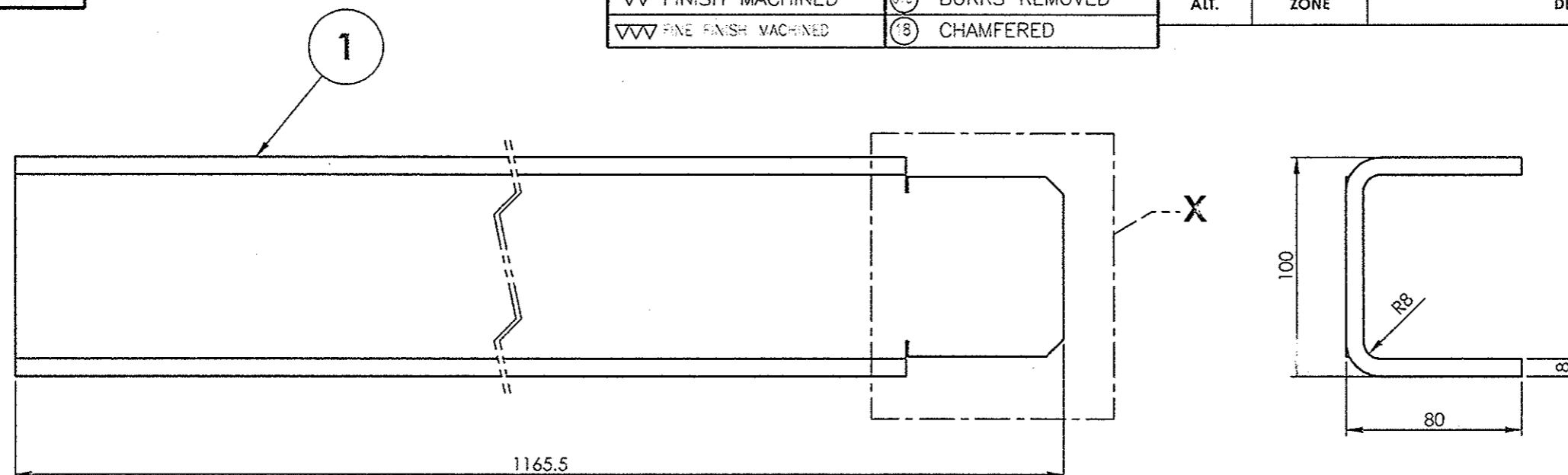
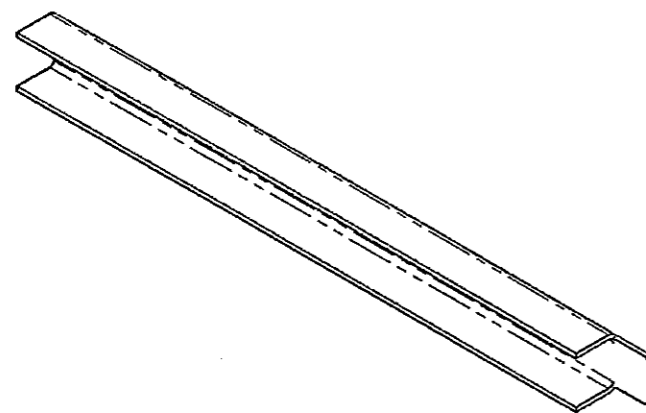
-	03-10-2017	<i>[Signature]</i>
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

1	CHANNEL	8x140x594	1		IRS M-41-1997	3.05		
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS	
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:			
CHANNEL					SCALE	SSE/D		
					1:2	CHD		
					ALT.	ALTD		
						DRN	P.MURUGAN	
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038								
					SHEET 1 OF 1		AAD11204	A3

AAD11205

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

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE

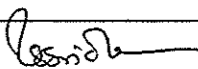
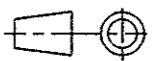
DETAIL X
SCALE 1:2

ISOMETRIC VIEW

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.

	20-10-2017	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AMEASME

1	CHANNEL	8x228x1165.5	1		IRS M-41-1997	16.41	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:2.5	CHD	
					ALT.	ALTD	
						DRN	K.SETHURAMAN
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1			
					AAD11205		A3

AAD11206

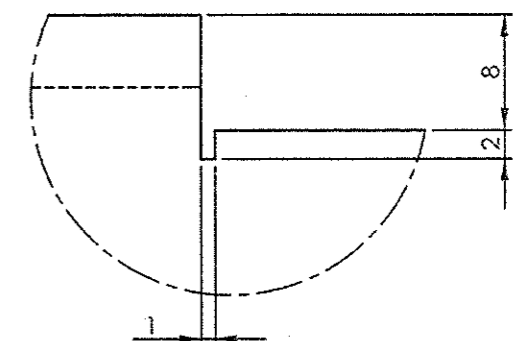
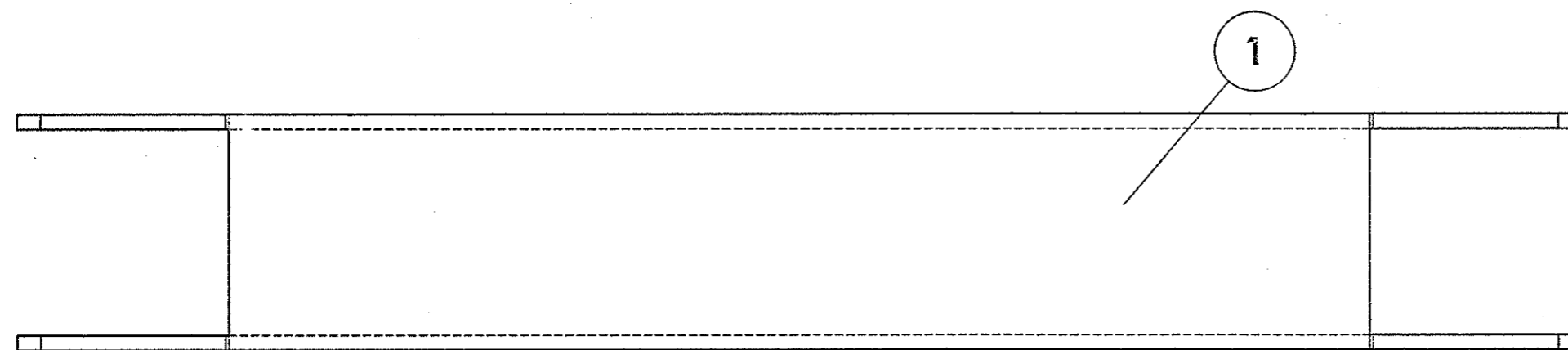
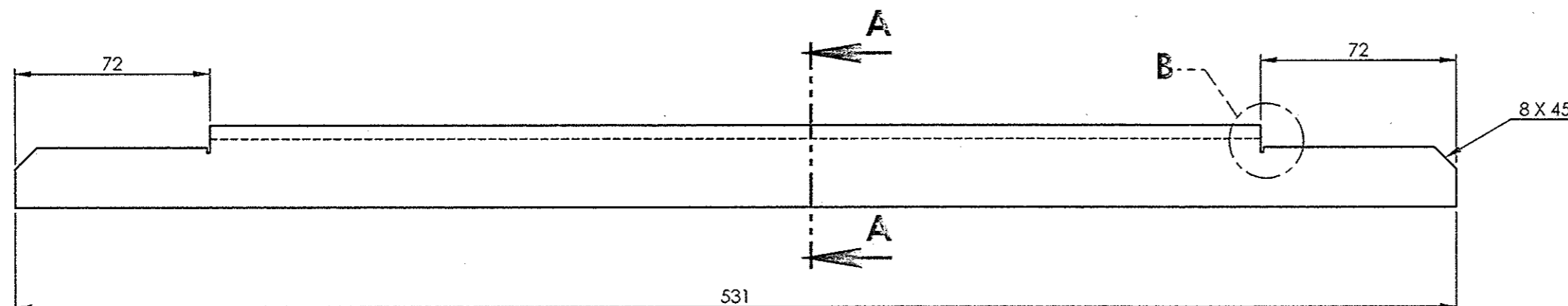
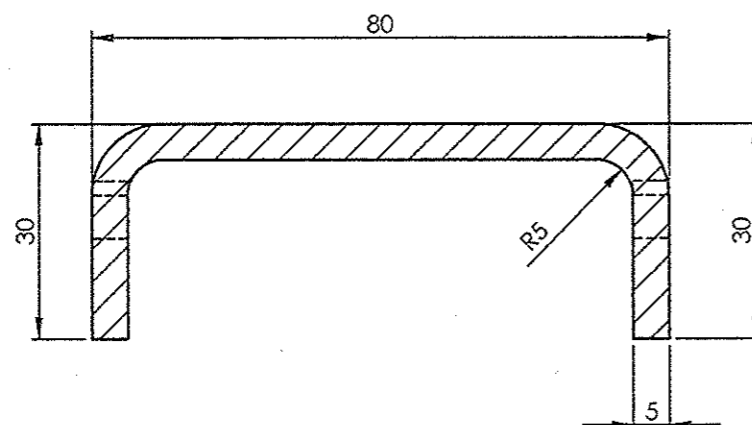
▽ ROUGH MACHINED	① ROUGH CLEANED
▽▽ FINISH MACHINED	② BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	③ CHAMFERED

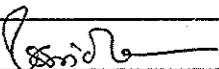
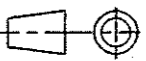
REVISIONS

ALT.

ZONE

DESCRIPTION

APPROVED &
DATEDETAIL B
SCALE 2 : 1SECTION A-A
SCALE 1 : 1

1	CHANNEL	5x120x531	1		IRS M-41-1997	2.12	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:2	CHD	
					ALT.	ALTD	
						DRN	K.SETHURAMAN
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1			
					AAD11206		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.185-1-1-004/ITEM-20

DATE OF LATEST ALT.

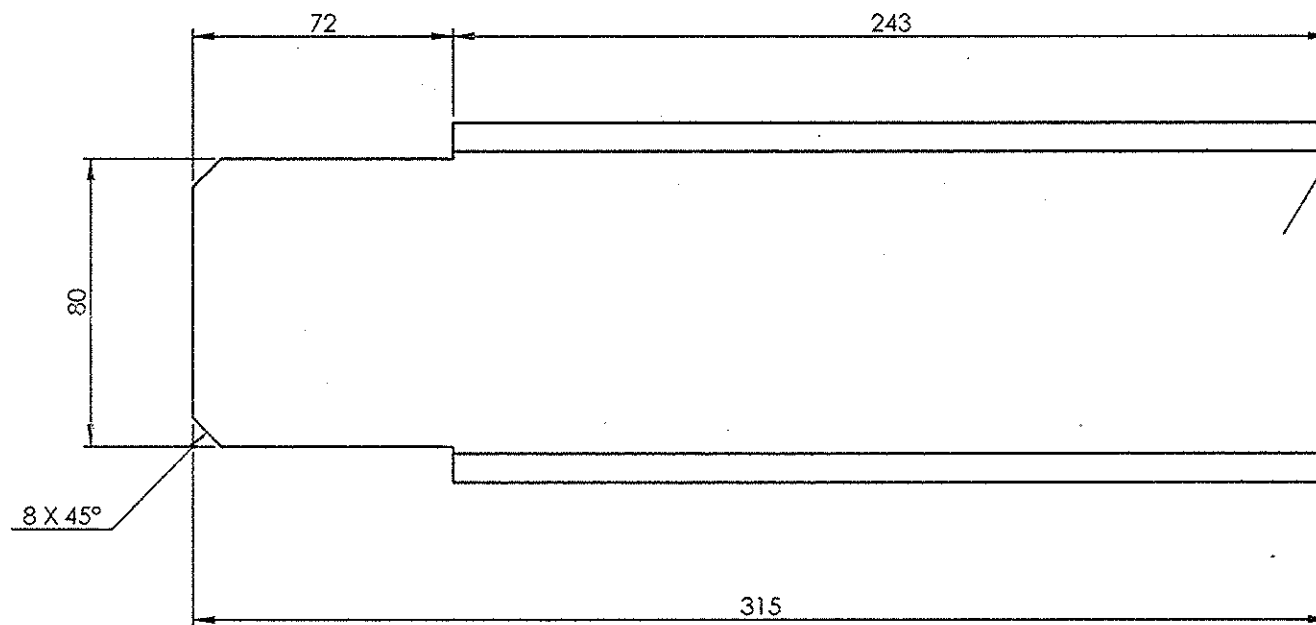
20-10-2017
DATE OF FIRST ISSUE

AME/SME

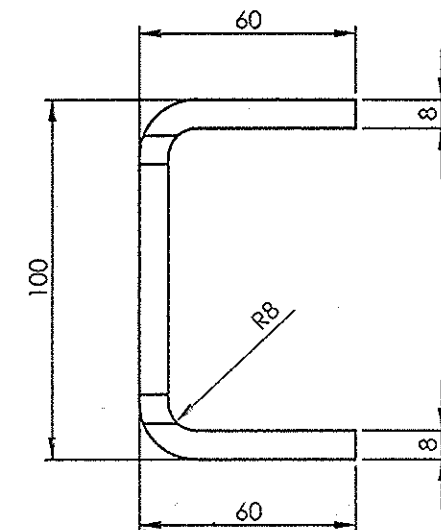
AAD11207

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

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



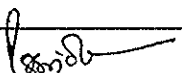
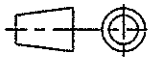
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ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICE/STD-9-0-001.
ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER IS: 813:1986.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

REF.DRG.NO.-

03-10-2017	03-10-2017	AME/SME
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

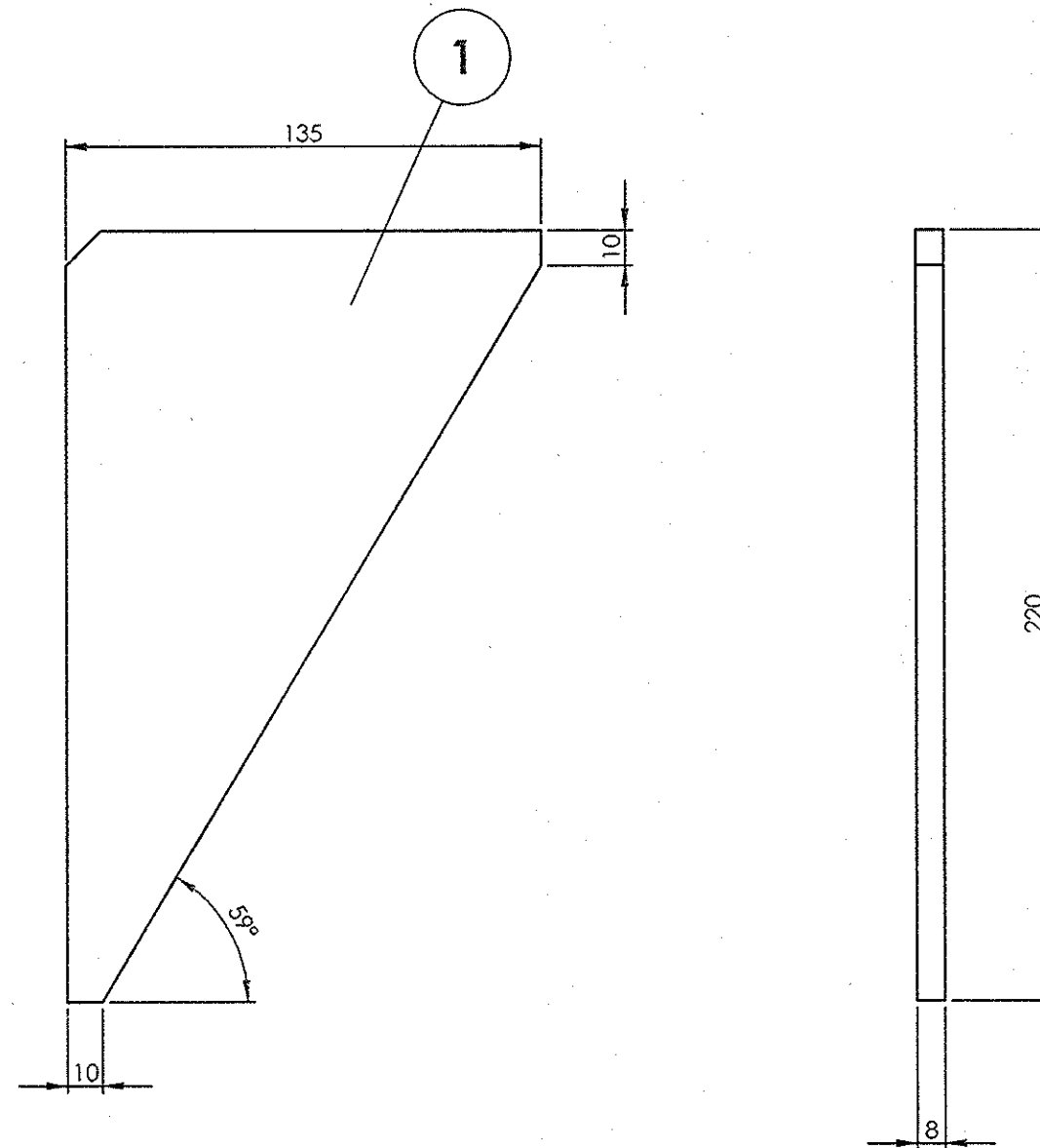
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QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS	
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:			
CHANNEL					SCALE	SSE/D		
					1:2	CHD		
					ALT.	ALTD		
						DRN	P.MURUGAN	
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038								
					SHEET 1 OF 1		AAD11207	A3

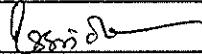
AAD11208

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

REVISIONS

ALT.	ZONE	DESCRIPTION	APPROVED & DATE
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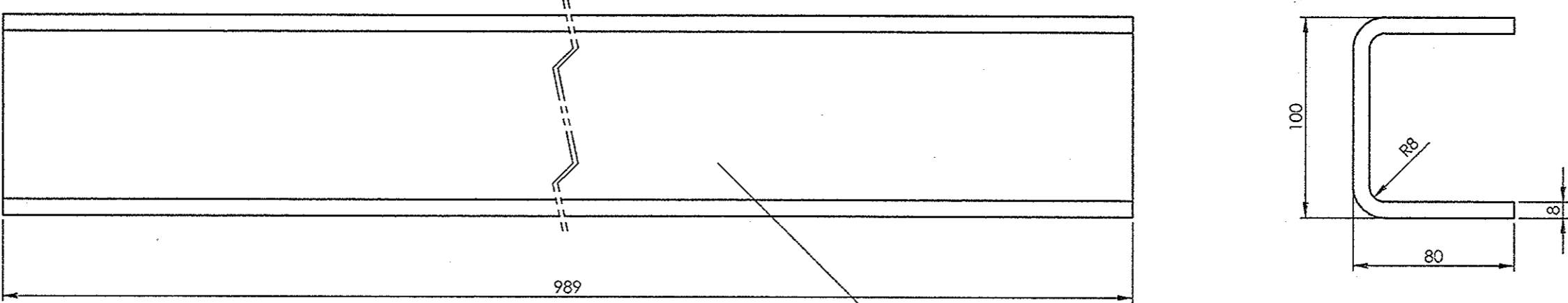
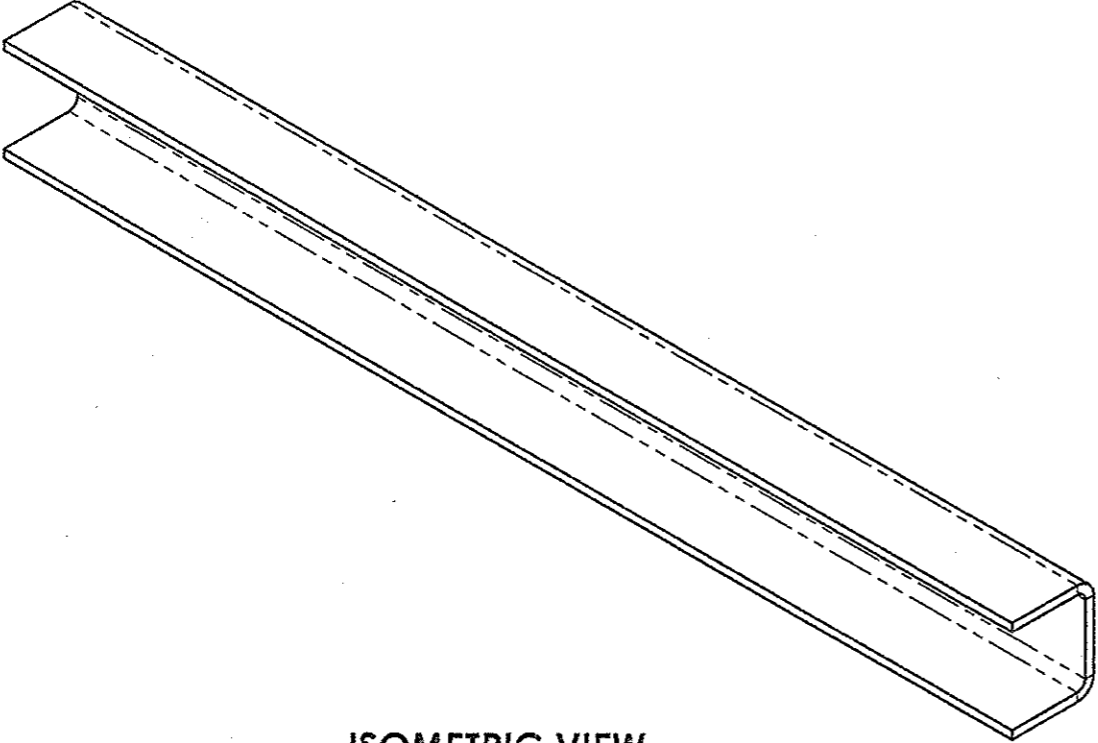


1	RIB	8x135x220	1		IRS M-41-1997	1.04		
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS	
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:			
RIB					SCALE	SSE/D		
					1:2	CHD		
					ALT.	ALTD		
						DRN	P.MURUGAN	
					INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038			

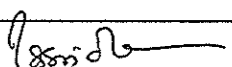
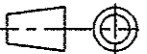
ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICE/SID 9-0-001.
ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER IS: 813-1986.
WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY

REF.DRG.NO.531-1-1-010, ITEM-15

	03-10-2017	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

1		2		3		4		5		6		7		8		
AAD11209				▽ ROUGH MACHINED		① ROUGH CLEANED		REVISIONS								
				▽▽ FINISH MACHINED		② BURRS REMOVED		ALT.		ZONE		DESCRIPTION			APPROVED & DATE	
				▽▽▽ FINE FINISH MACHINED		③ CHAMFERED										
																
																
ISOMETRIC VIEW																
REF.DRG.NO.																
DATE OF LATEST ALT.																
DATE OF FIRST ISSUE																
AME/SME																
INDIAN RAILWAY STANDARDS																
INTEGRAL COACH FACTORY, CHENNAI - 600038																
SHEET 1 OF 1																
AAD11209																
A3																

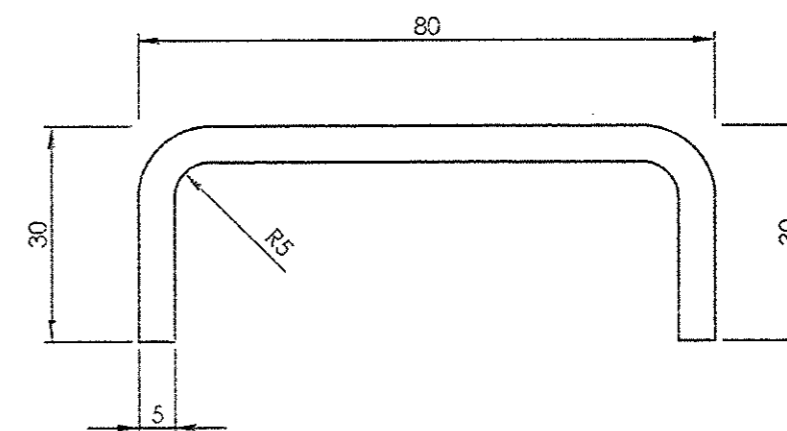
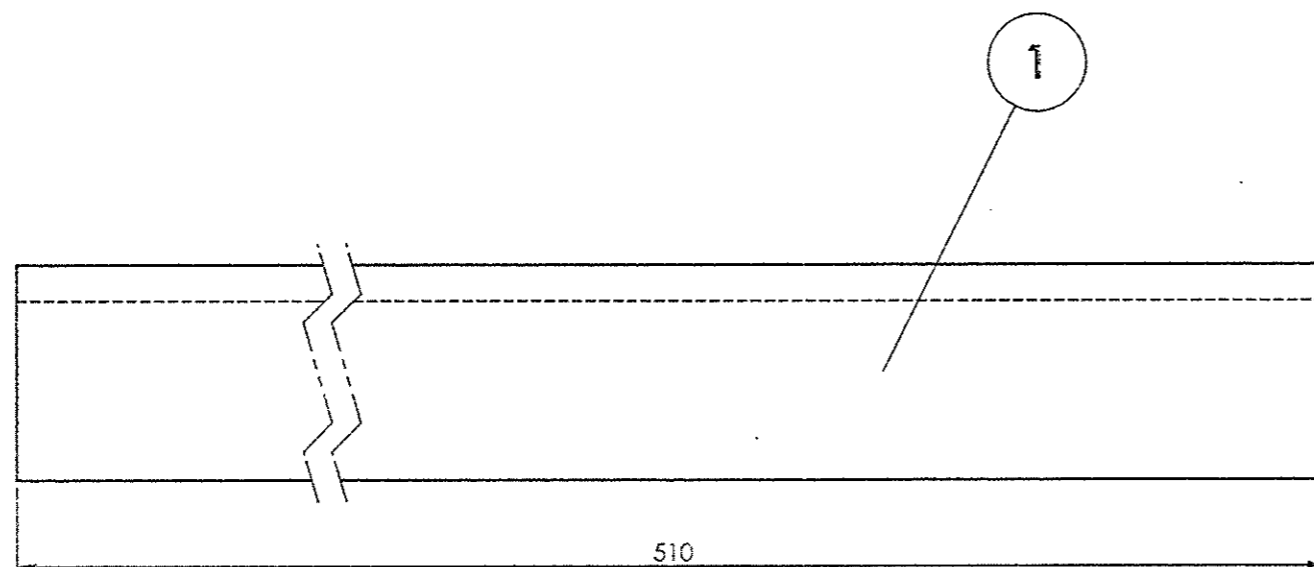
ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICF/STD-9-0-001.
ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER IS: 813 1986.
WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY

1	CHANNEL	8x228x989	1		IRS M-41-1997	14.51	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1			SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:2.5	CHD	
					ALT.	ALTD	
						DRN	
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1			
					AAD11209		
					A3		

AAD11210

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

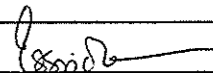
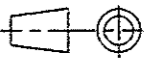
REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



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WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY

REF.DRG.NO.185-1-1-004/ITEM-21

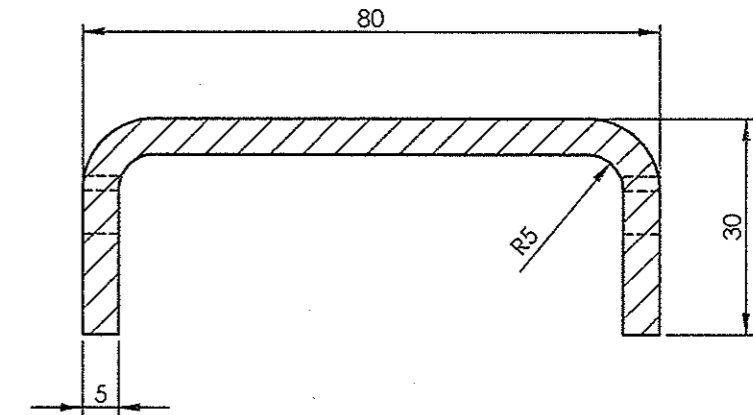
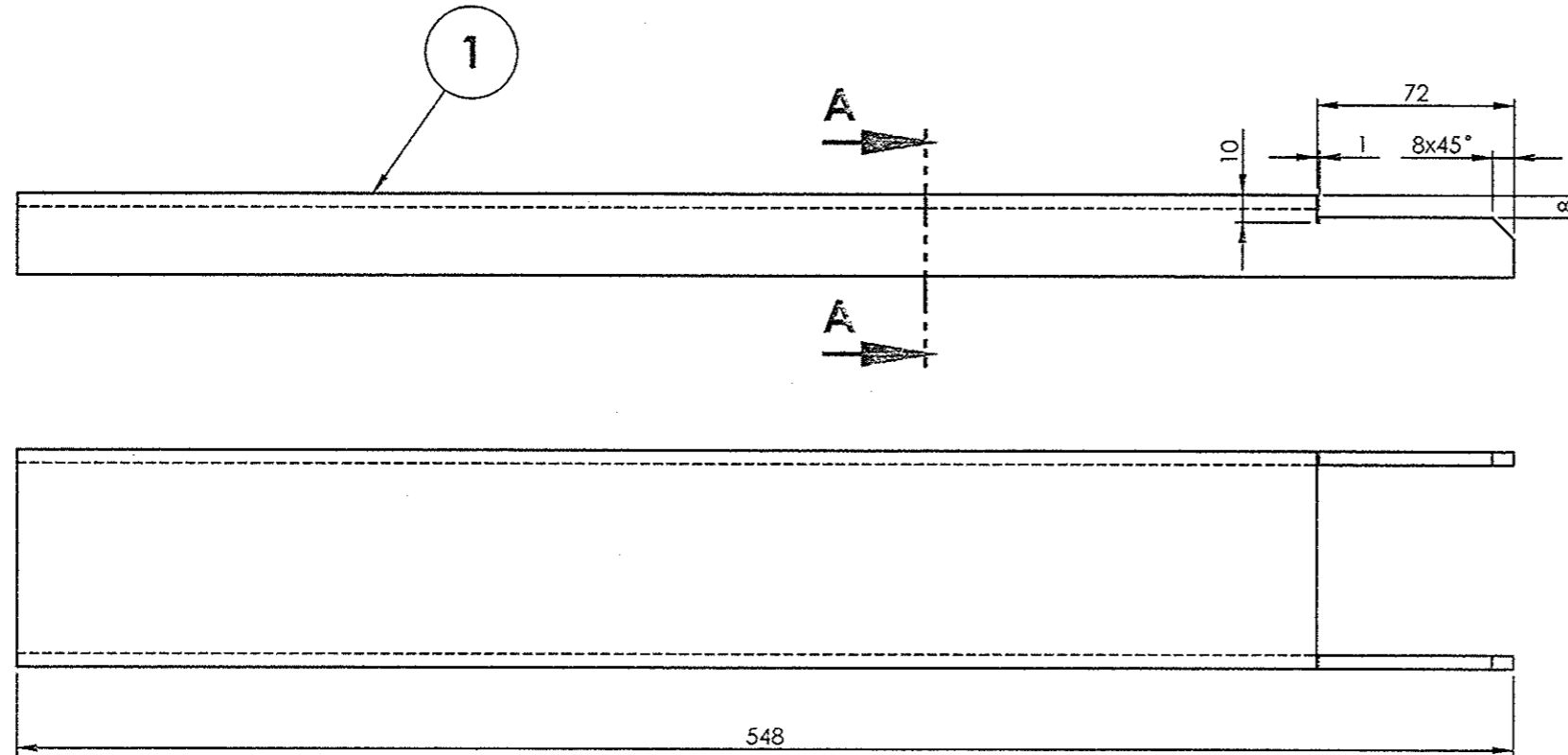
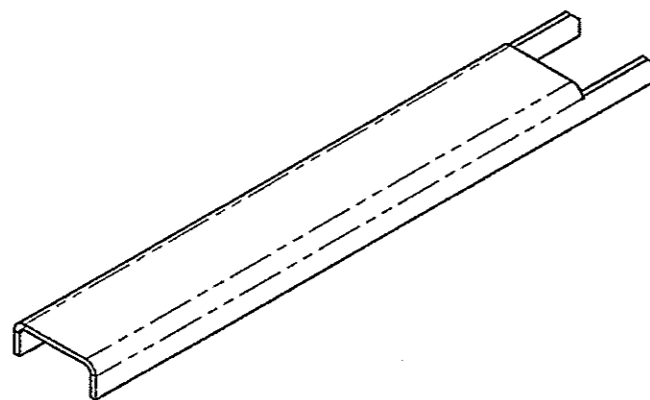
	10 -10-2017	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

1	CHANNEL	5x120x510	1		IRS M-41-1997	2.47	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:1	CHD	
					ALT.	ALTD	
						DRN	K.SETHURAMAN
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600036				SHEET 1 OF 1			
					AAD11210		A3

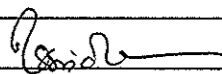
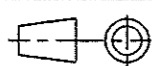
AAD11211

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

REVISIONS				APPROVED & DATE	
ALT.	ZONE	DESCRIPTION			

SECTION A-A
SCALE 1 : 1

ISOMETRIC VIEW

1	CHANNEL	5x120x548	1		IRS M-41-1997	2.43	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:2.5	CHD	
					ALT.	ALTD	
						DRN	K.SETHURAMAN
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1			
					AAD11211		A3

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

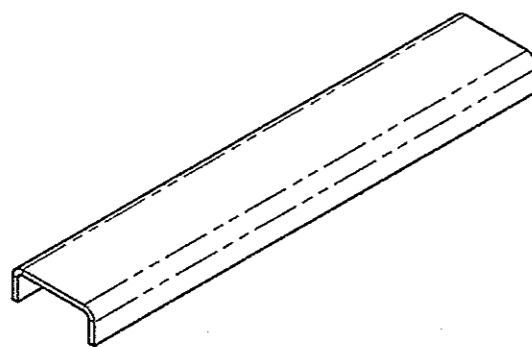
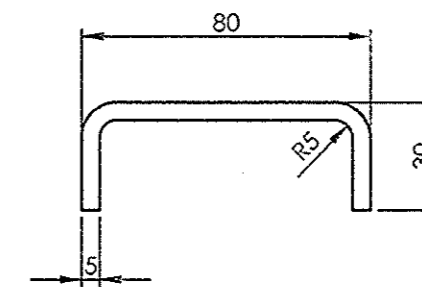
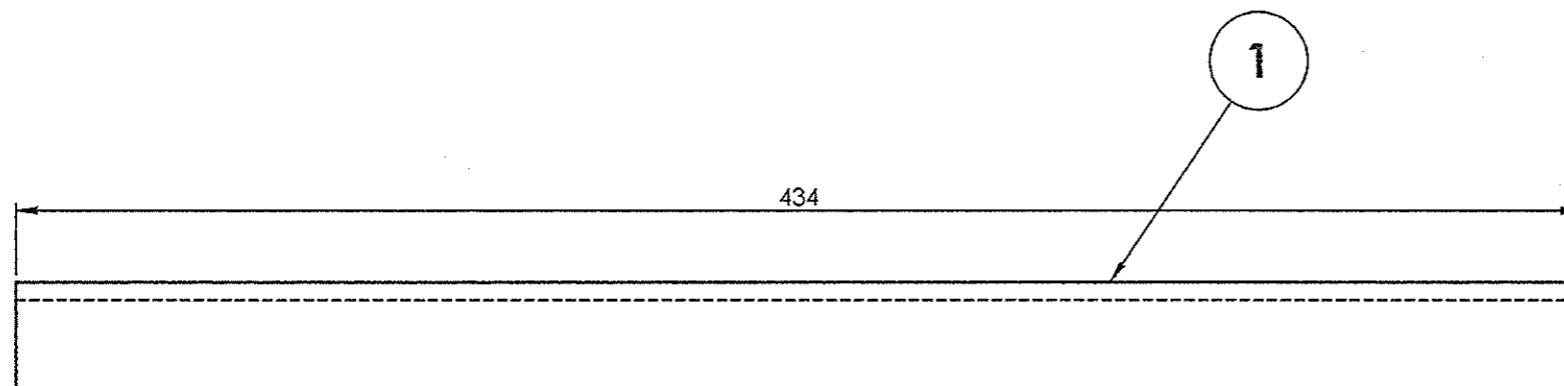
REF.DRG.NO.185-1-1-004/ITEM-21

20-10-2017		
DATE OF LATE . ALT.	DATE OF FIRST ISSUE	AME/SME

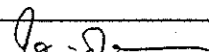
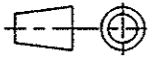
AAD11212

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

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



ISOMETRIC VIEW

1	CHANNEL	5x120x434	1		IRS M-41-1997	2.10	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:2	CHD	
					ALT.	ALTD	
						DRN	K.SETHURAMAN
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1			
					AAD11212		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

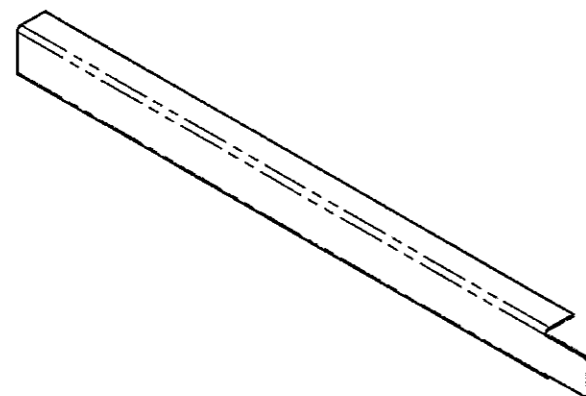
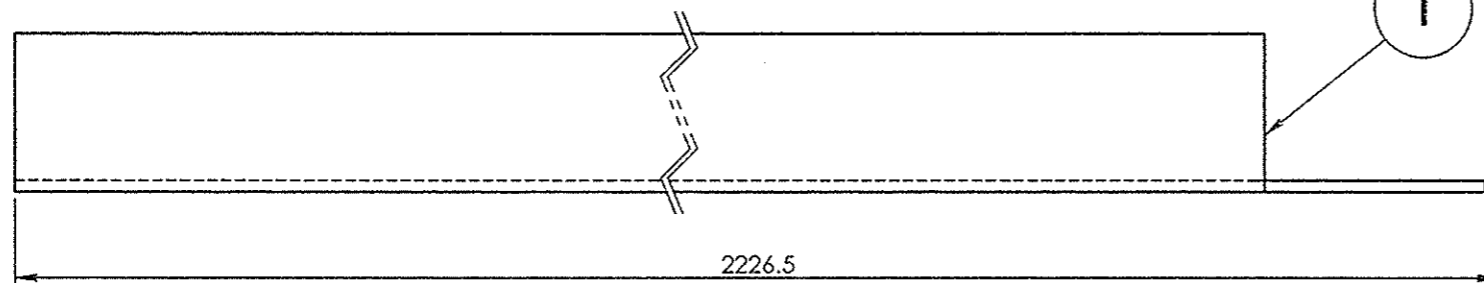
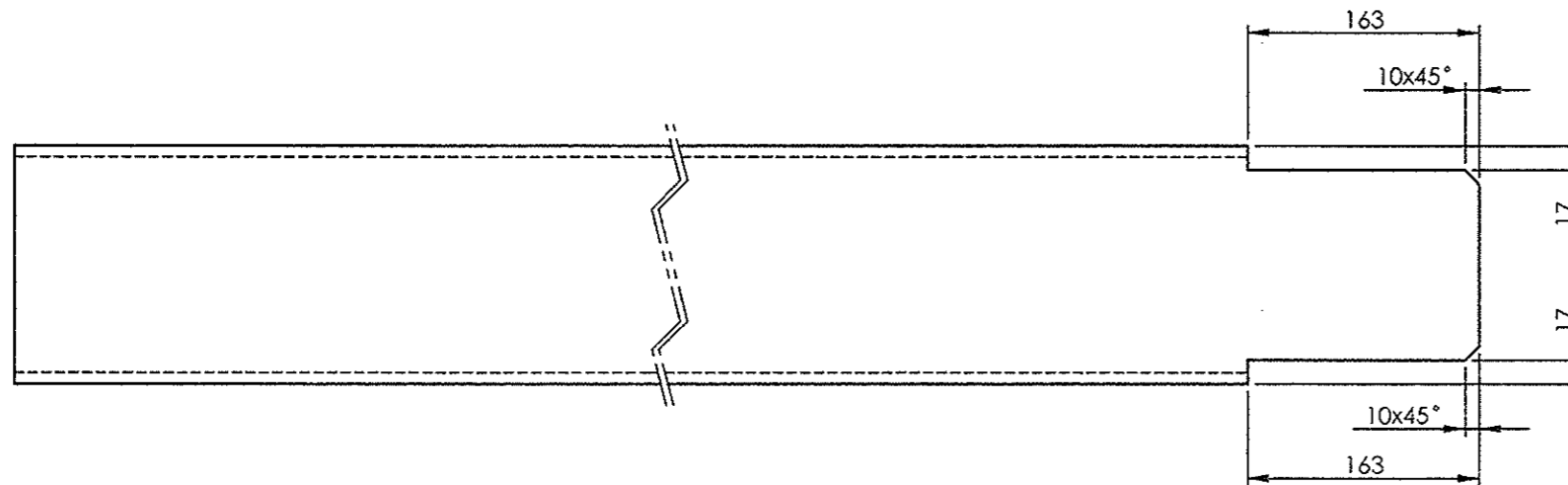
REF.DRG.NO.185-1-1-004/ITEM-22

	20-10-2017	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

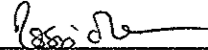
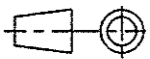
AAD11213

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

REVISIONS				APPROVED & DATE	
ALT.	ZONE	DESCRIPTION			



ISOMETRIC VIEW

1	DOORWAY STIFFENER	10x357x2226.5	1		IRS M-41-1997	48.24	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: UNDER FRAME			SURFACE AREA IN Sq.m.:		V.T/ASSY IN Kgs:		
DOORWAY STIFFENER					SCALE	SSE/D	
					1:5	CHD	
					ALT.	ALTD	
						DRN	K.SETHURAMAN
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038							
					SHEET 1 OF 1	AAD11213	
							A3

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WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY


REF.DRG.NO.

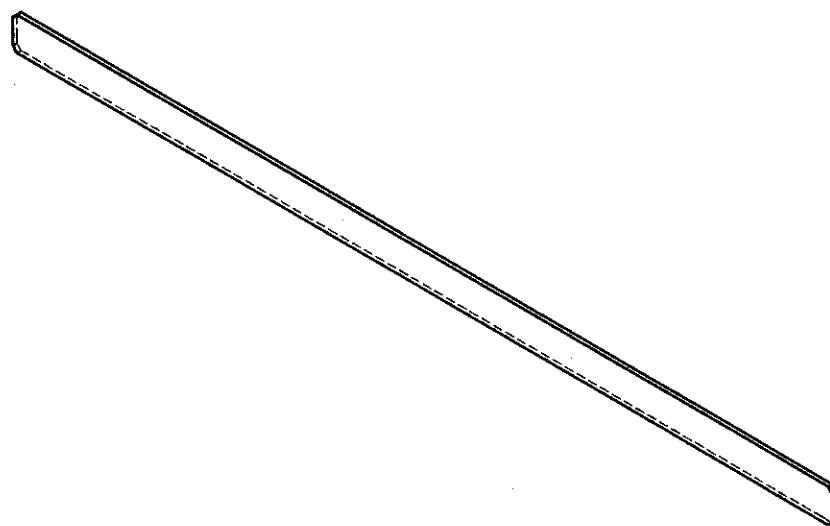
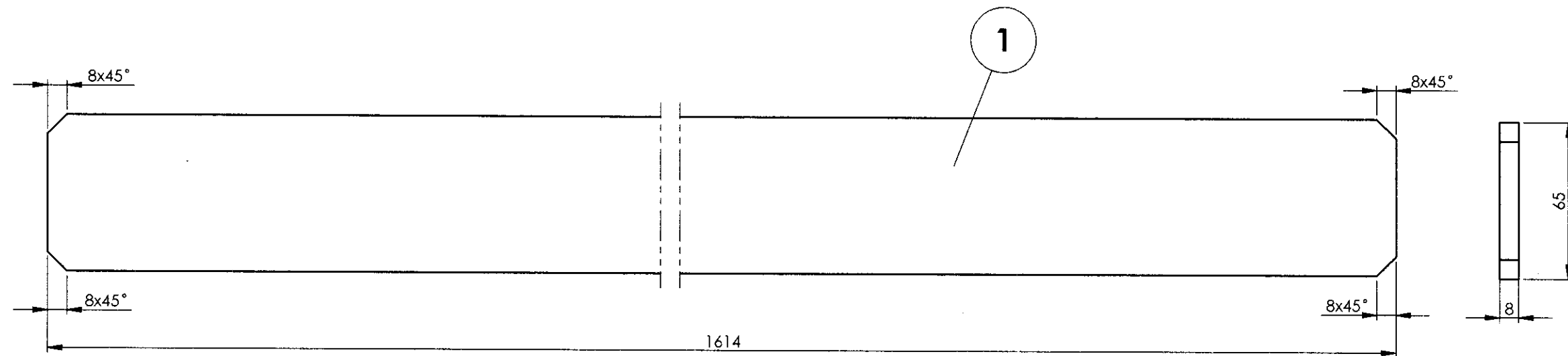
	20-10-2017	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

1		2		3		4		5		6		7		8																																																									
AAD11214				▽ ROUGH MACHINED		① ROUGH CLEANED		REVISIONS																																																															
				▽▽ FINISH MACHINED		② BURRS REMOVED		ALT.		ZONE		DESCRIPTION			APPROVED & DATE																																																								
				▽▽▽ FINE FINISH MACHINED		③ CHAMFERED																																																																	
<div>ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICT/SID-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</div> <div><div>1</div><div><div><div>2322</div><div>8x45°</div></div><div><div>67</div><div>8</div></div></div></div>																																																																							
<table><tr><td>1</td><td>SUPPORT PLATE</td><td>8x67x2322</td><td>1</td><td></td><td>IRS M-41-1997</td><td>9.77</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: UNDER FRAME</td><td colspan="2">SURFACE AREA IN Sq.m.:</td><td colspan="2">WT/ASSY IN Kgs:</td></tr><tr><td colspan="5" rowspan="4">SUPPORT PLATE</td><td>SCALE</td><td>SSE/D</td><td rowspan="2"></td></tr><tr><td>1:2.5</td><td>CHD</td></tr><tr><td>ALT.</td><td>ALTD</td><td></td></tr><tr><td></td><td>DRN</td><td>K.SETHURAMAN</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">AAD11214</td><td>A3</td></tr></table>																1	SUPPORT PLATE	8x67x2322	1		IRS M-41-1997	9.77		QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS	GROUP: UNDER FRAME				SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:		SUPPORT PLATE					SCALE	SSE/D		1:2.5	CHD	ALT.	ALTD			DRN	K.SETHURAMAN	INDIAN RAILWAY STANDARDS					SHEET 1 OF 1			INTEGRAL COACH FACTORY, CHENNAI - 600038					AAD11214		A3
1	SUPPORT PLATE	8x67x2322	1		IRS M-41-1997	9.77																																																																	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS																																																																
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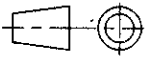
AAD11215

▽ ROUGH MACHINED	① ROUGH CLEANED
▽▽ FINISH MACHINED	⑩ BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	⑧ CHAMFERED

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE
a	.	CHAMFER ADDED AND R.M. SIZE REVISED.	



ISOMETRIC VIEW

1	SUPPORT PLATE	8x65x1614	1		IRS M-41-1997	6.58	
Default	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1			SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:		
SUPPORT PLATE					SCALE	SSE/D	
					1:2	CHD	
					ALT.	ALTD	SURESH KUMAR.S
					a	DRN	P.MURUGAN
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038							
					SHEET 1 OF 1		
					AAD11215		A3

20-10-2019	03-10-2017	<i>[Signature]</i>
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

REF.DRG.NO.

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

AAD11216

▽ ROUGH MACHINED

▽▽ FINISH MACHINED

▽▽▽ FINE FINISH MACHINED

① ROUGH CLEANED

①b BURRS REMOVED

⑱ CHAMFERED

REVISIONS

ALT.

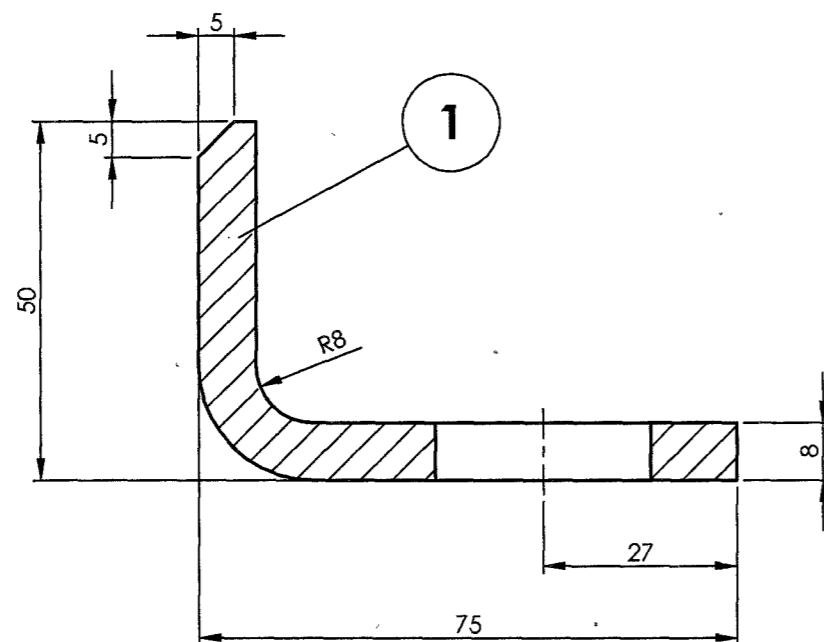
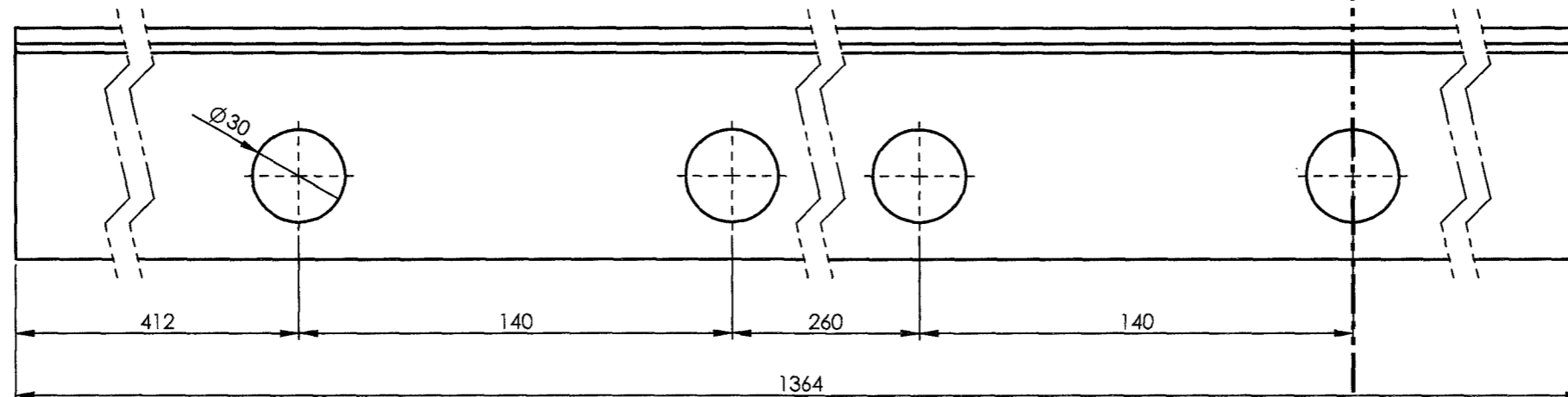
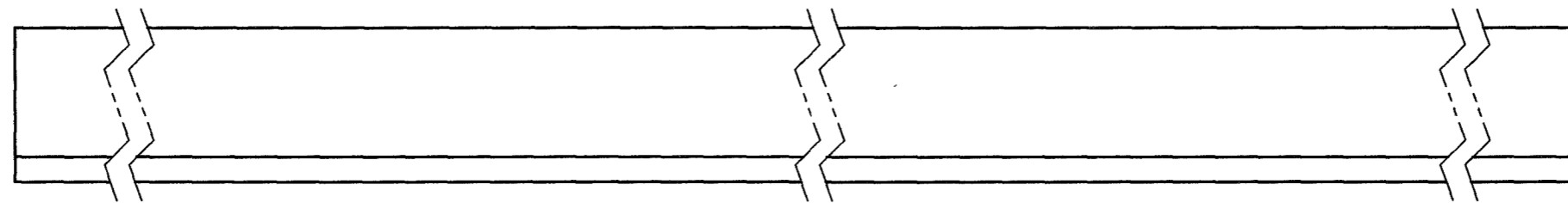
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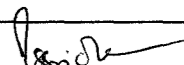
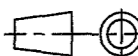
DESCRIPTION

APPROVED &
DATE

a

LOCATING DIMENSION OF Ø 30 HOLES REVISED.

SECTION A-A
SCALE 1 : 1

1	DOOR WAY ANGLE	8x109x1364	1		IRS M-41-1997	9.27	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: UNDER FRAME		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
DOOR WAY ANGLE					SCALE	SSE/D	
					1:2	CHD	
					ALT. a	ALTD	M.SIVAKUMAR
						DRN	K.SETHURAMAN
INDIAN RAILWAY STANDARDS							
INTEGRAL COACH FACTORY, CHENNAI - 600038					SHEET 1 OF 1		AAD11216
							A3

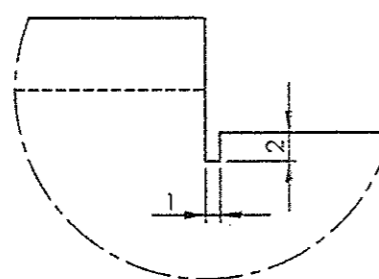
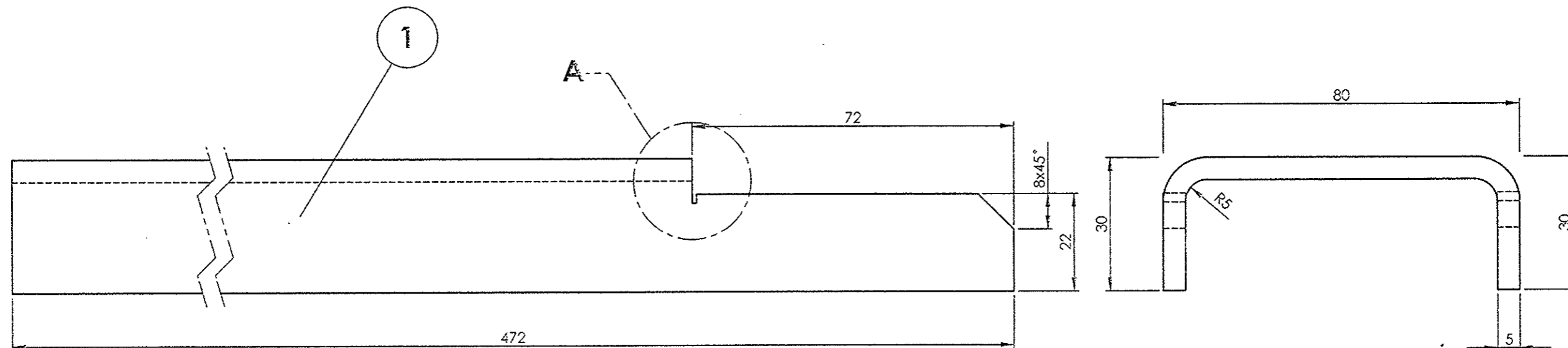
ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICF/STD-9-0-001.
ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER IS: 813-1986.
WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY

REF.DRG.NO.

AAD11217

▽ ROUGH MACHINED	⑨ ROUGH CLEANED
▽▽ FINISH MACHINED	⑩ BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	⑪ CHAMFERED

REVISIONS				APPROVED & DATE	
ALT.	ZONE	DESCRIPTION			



DETAIL A
SCALE 2 : 1

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO IC/STD 9-0-001.
ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER IS: 813-1986.
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REF.DRG.NO.185-1-1-004/ITEM-22

DATE OF LATEST ALT.	10-10-2017	AME/SMET
DATE OF FIRST ISSUE		

1	CHANNEL	5x120x472	1		IRS M-41-1997	2.06	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1			SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:1	CHD	
					ALT.	ALTD	
						DRN	P.MURUGAN
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038							
					SHEET 1 OF 1		AAD11217

AAD11220

▽ ROUGH MACHINED

▽▽ FINISH MACHINED

▽▽▽ FINE FINISH MACHINED

① ROUGH CLEANED

② BURRS REMOVED

③ CHAMFERED

REVISIONS

ALT.

ZONE

DESCRIPTION

APPROVED &
DATE

a

R.M. SIZE CORRECTED IN BOM.

A

B

C

D

E

F

6 X 45°

1

1515

A

A

X

249

1

115°

R10

98

10

SECTION A-A
SCALE 1 : 2.5

ISOMETRIC VIEW

DETAIL X
SCALE 1 : 2

6x45°

REF.DRG.NO.


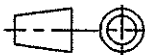

14-11-2017

DATE OF LATEST ALT.

17-10-2017

DATE OF FIRST ISSUE

AME/SME

1	COVER SHEET	10x360x1515	1		IRS M-41-1997	42.69	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: UNDER FRAME			SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:		
COVER SHEET					SCALE 1:5	SSE/D	
						CHD	
					ALT. a	ALTD	
						DRN	K.SETHURAMAN
							
							
INDIAN RAILWAY STANDARDS				SHEET 1 OF 1	AAD11220		A3
INTEGRAL COACH FACTORY, CHENNAI - 600038							

AAD11223

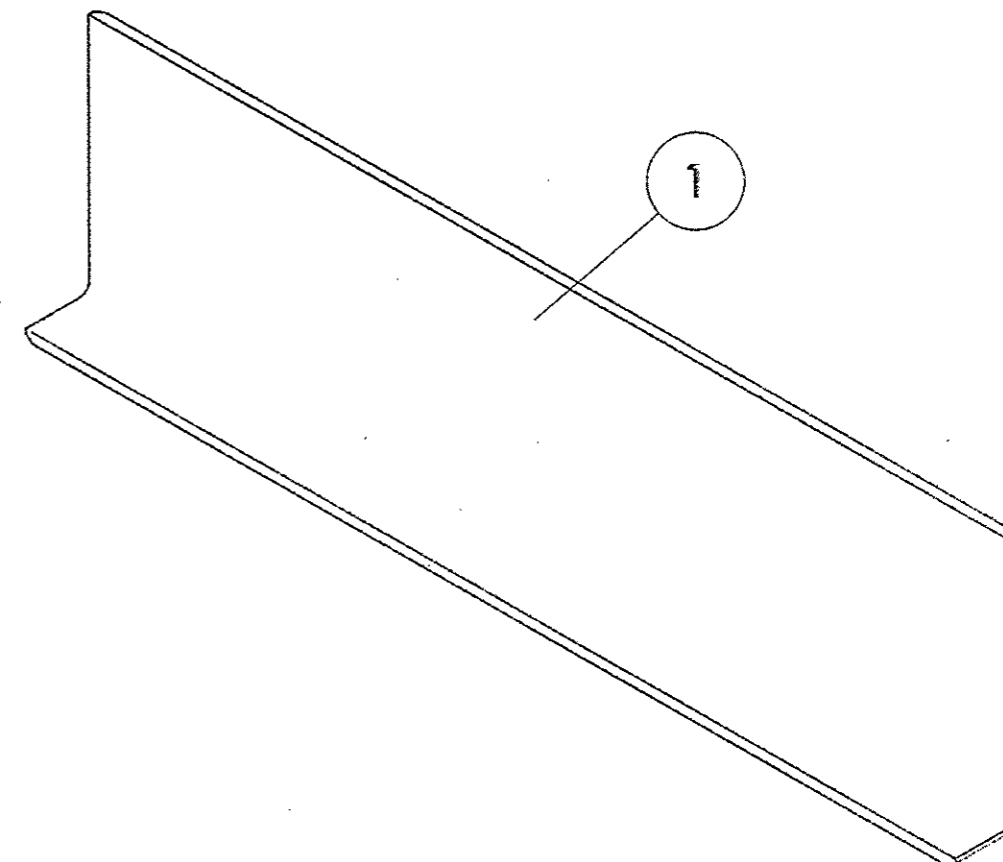
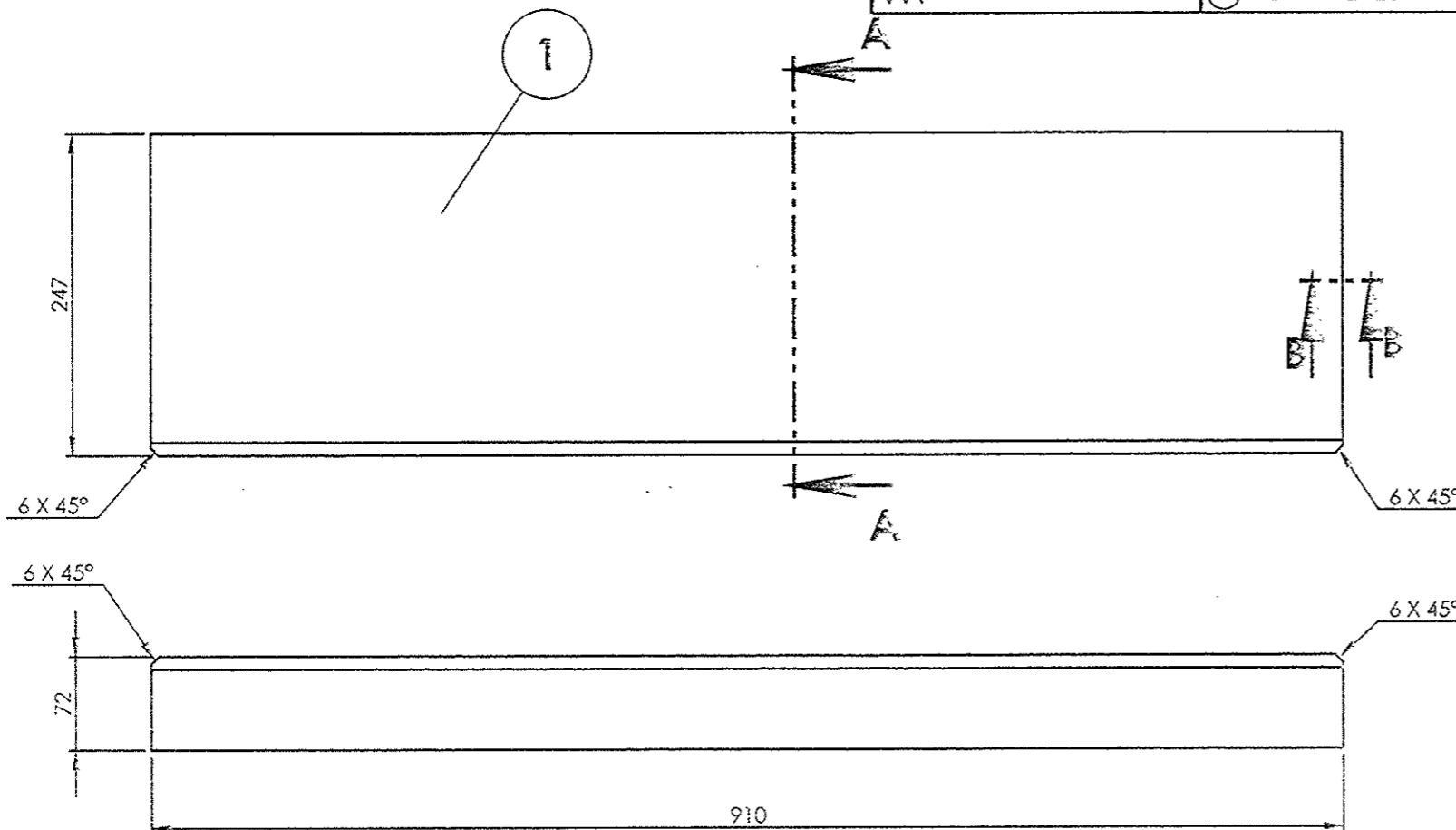
▽ ROUGH MACHINED	③ ROUGH CLEANED
▽▽ FINISH MACHINED	④ BURRS REMOVED
▽▽▽ FINE FINISH VACUUMED	⑤ CHAMFERED

REVISIONS

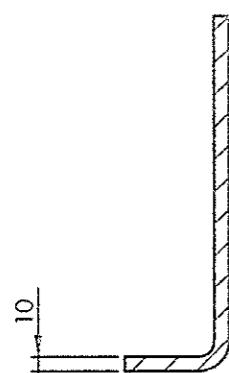
ALT.

ZONE

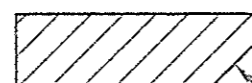
DESCRIPTION

APPROVED &
DATE

ISOMETRIC VIEW



SECTION A-A



6 X 45°

SECTION B-B
SCALE 1:1

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOUCHED 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.

10 -10-2017

DATE OF LATEST ALT.

DATE OF FIRST ISSUE

AME/SME

INDIAN RAILWAY STANDARDS

INTEGRAL COACH FACTORY, CHENNAI - 600036

SHEET
1 OF 1

AAD11223

A3

1	ANGLE	10x303x910	1		IRS M-41-1997	21.53	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: UNDER FRAME		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
ANGLE					SCALE	SSE/D	
					1:5	CHD	
					ALT.	ALTD	
						DRN	K.SETHURAMAN
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600036							
					SHEET 1 OF 1		AAD11223

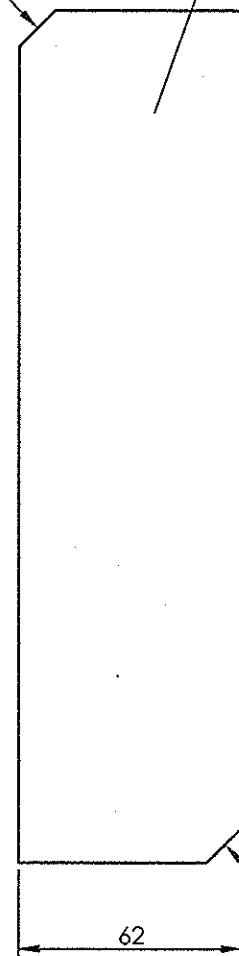
AAD11228

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

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE

10 X 45°

1



62

10 X 45°

237

8

1	RIB	8x62x237	1		IRS M-41-1997	0.92			
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS		
GROUP: 1-1		SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:					
FLAT					SCALE	SSE/D	<i>P. Murugan</i>		
					1:2	CHD			
					ALT.	ALTD			
						DRN	P.MURUGAN		
INDIAN RAILWAY STANDARDS					SHEET 1 OF 1				
INTEGRAL COACH FACTORY, CHENNAI - 600038					AAD11228				
					A3				

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

03-10-2017

DATE OF FIRST ISSUE

AME/SME

INDIAN RAILWAY STANDARDS

INTEGRAL COACH FACTORY, CHENNAI - 600038

SHEET
1 OF 1

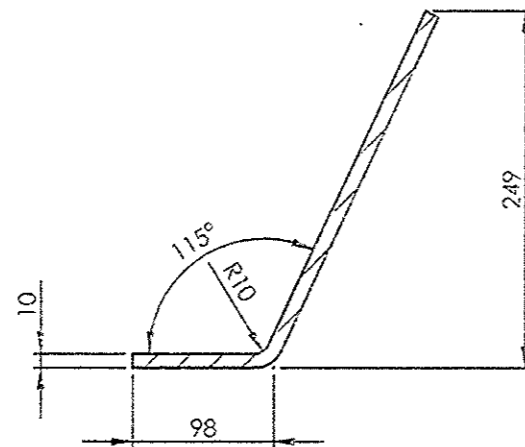
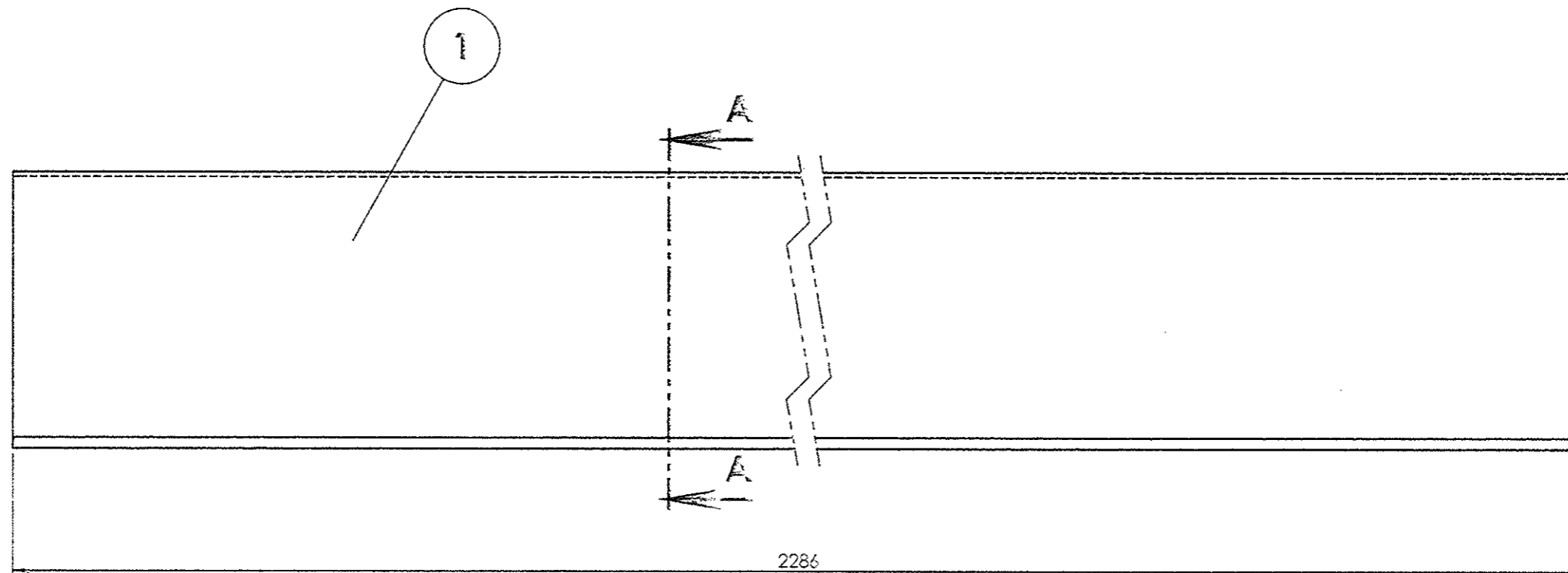
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A3

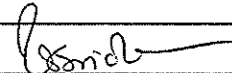
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▽ ROUGH MACHINED	⊖ ROUGH CLEANED
▽▽ FINISH MACHINED	⊖⊖ BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	⊖⊖⊖ CHAMFERED

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE

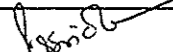
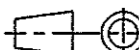


SECTION A-A

1	ANGLE	10x360x2286	1		IRS M-41-1997	64.56	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: UNDER FRAME		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
ANGLE					SCALE	SSE/D	
					1:5	CHD	
					ALT.	ALTD	
					DRN	P.MURUGAN	
					INDIAN RAILWAY STANDARDS		
INTEGRAL COACH FACTORY, CHENNAI - 600035							
					AAD11229		A3


1		2		3		4		5		6		7		8																	
AAD11230						▽ ROUGH MACHINED		⊖ ROUGH CLEANED		REVISIONS																					
						▽▽ FINISH MACHINED		⊖⊖ BURRS REMOVED		ALT.		ZONE		APPROVED & DATE																	
						▽▽▽ FINE FINISH MACHINED		⊖⊖⊖ CHAMFERED		DESCRIPTION																					
<div><div>1</div><div></div></div> <div><p>NOTE:</p><p>1. THE TUBE SHALL BE MADE BY WELDING PROCESS.</p></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 IS: 813-1986. WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY																															
REF.DRG.NO.		17-10-2017		DATE OF LATEST ALT.		DATE OF FIRST ISSUE		AME/SME		INDIAN RAILWAY STANDARDS																					
										INTEGRAL COACH FACTORY, CHENNAI - 600038																					
										SHEET 1 OF 1																					
										A3																					
										AAD11230																					

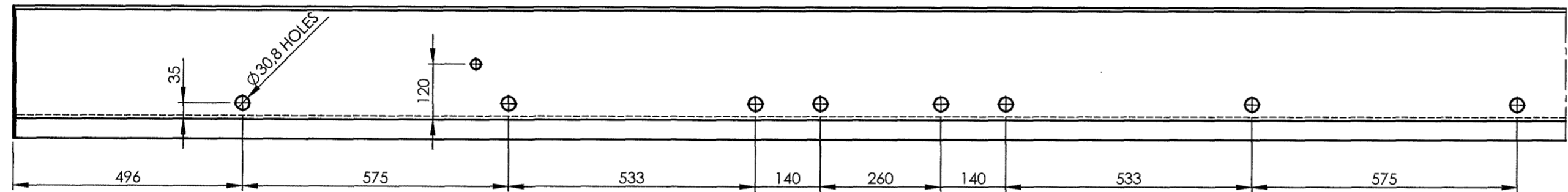
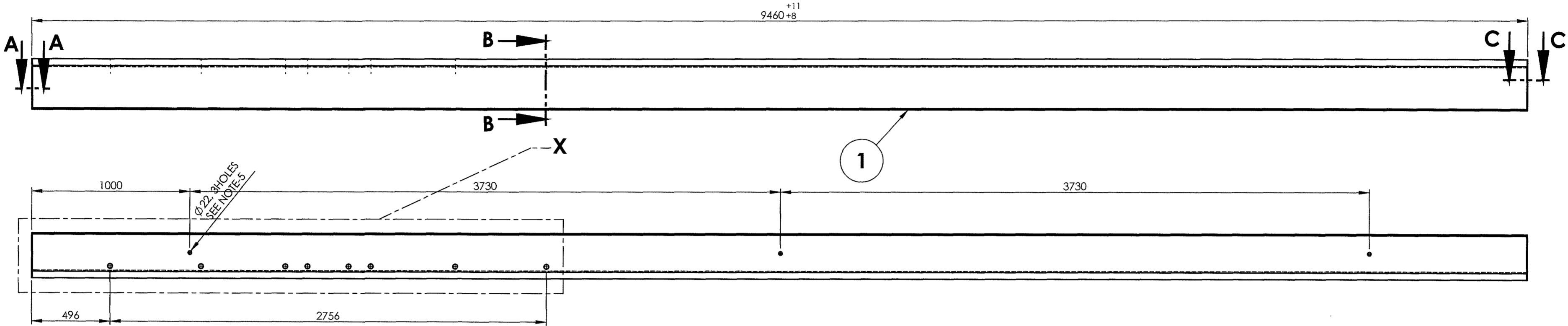
1. THE TUBE SHALL BE MADE BY WELDING PROCESS.

1	STEEL TUBE	Ø28 (OD)x260	1		AIISI-304	0.34	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: UNDERFRAME		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
STEEL TUBE					SCALE	SSE/D	
					1:1	CHD	
					ALT.	ALTD	
						DRN	K.Sethuraman
INDIAN RAILWAY STANDARDS				SHEET 1 OF 1			
INTEGRAL COACH FACTORY, CHENNAI - 600038					AAD11230		A3

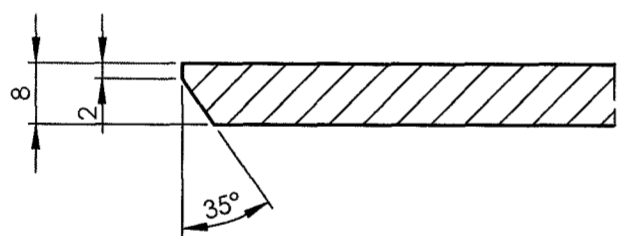
AAD11232

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

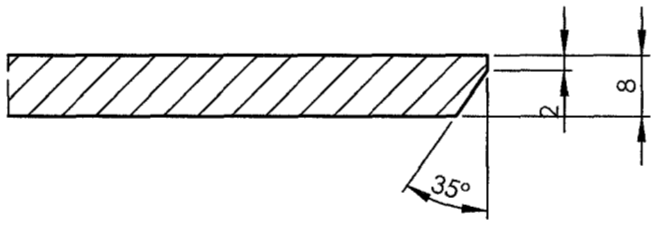
REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE
a		LOCATING DIMENSION OF Ø 30 HOLES REVISED.	



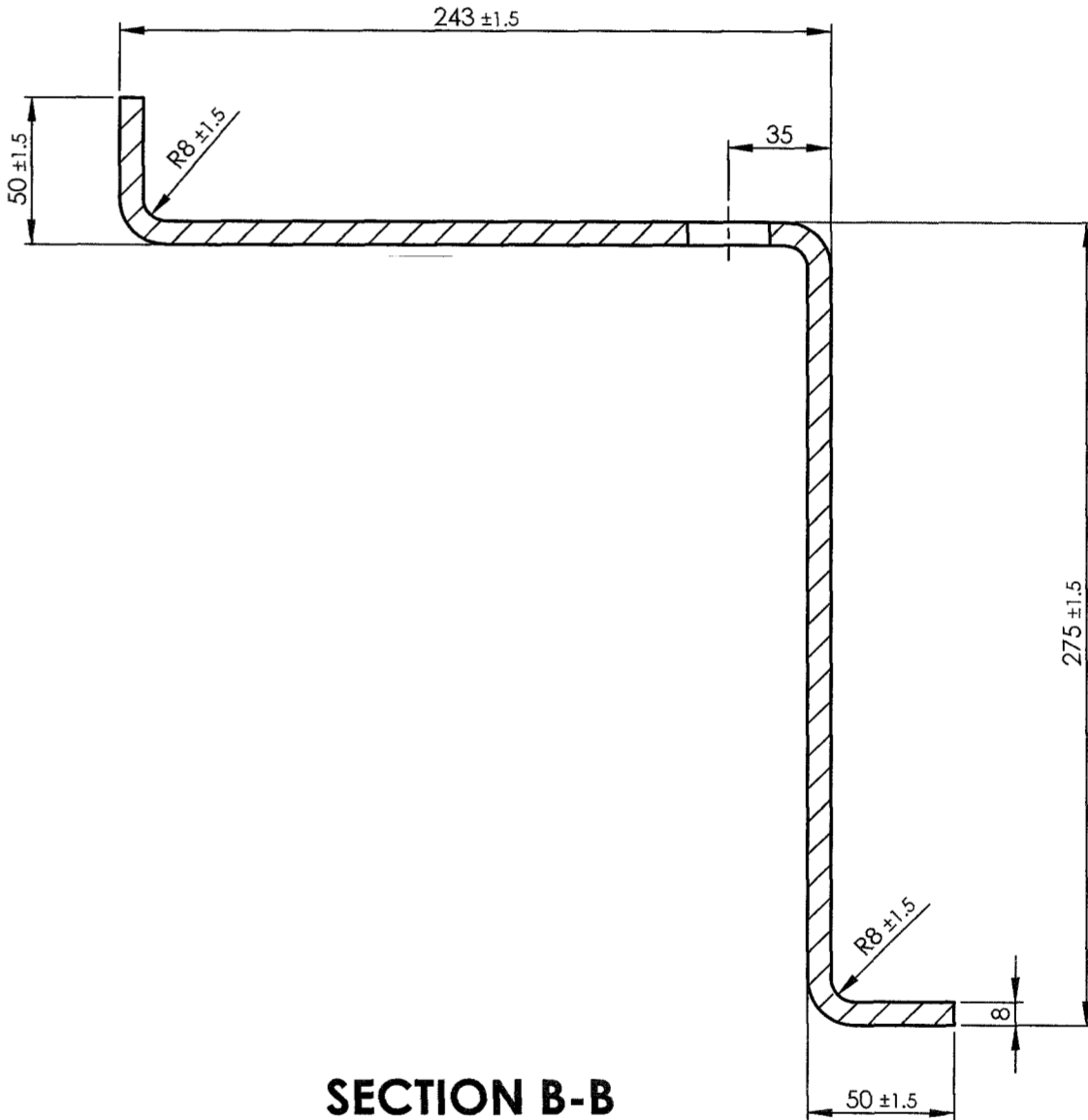
DETAIL X
SCALE 1 : 10



SECTION A-A
SCALE 1 : 1



SECTION C-C
SCALE 1 : 1



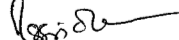

SECTION B-B
SCALE 1 : 2.5

NOTE:

- # 1. SHRINKAGE ALLOWANCE HAS BEEN CONSIDERED IN THE TOLERANCE GIVEN FOR LENGTH(L).
2. THE FINISHED PRODUCT SHALL CONFIRM TO IRS M41-1997 MATERIAL SPECIFICATION.
- \$ 3. PUNCHING TO BE DONE IN 6mm HEIGHT AS SHOWN BELOW ON SOLE BAR
- xxx -MANUFACTURER'S INITIAL
- xx / xx -MONTH & YEAR OF MANUFACTURER.
4. FOR OUTSOURCED LONGITUDINAL BEAMS SUITABLE PLATE TREATMENT (OR) GRIT BLASTING (OR) SAND BLASTING (OR) PICKLING TO BE DONE AND PAINTED WITH TWO COATS OF RED OXIDE ZINC CROMATE PRIMER ON BOTH SIDES TO SPEC. IS:2074-92 TO A DFT OF MINIMUM 35 MICRONS WITH SMOOTH AND MATT FINISH.
5. 3 NOS. HOLES OF Ø22 PROVIDED FOR LIFTING THE LONGITUDINAL BEAM USING EYE BOLT.

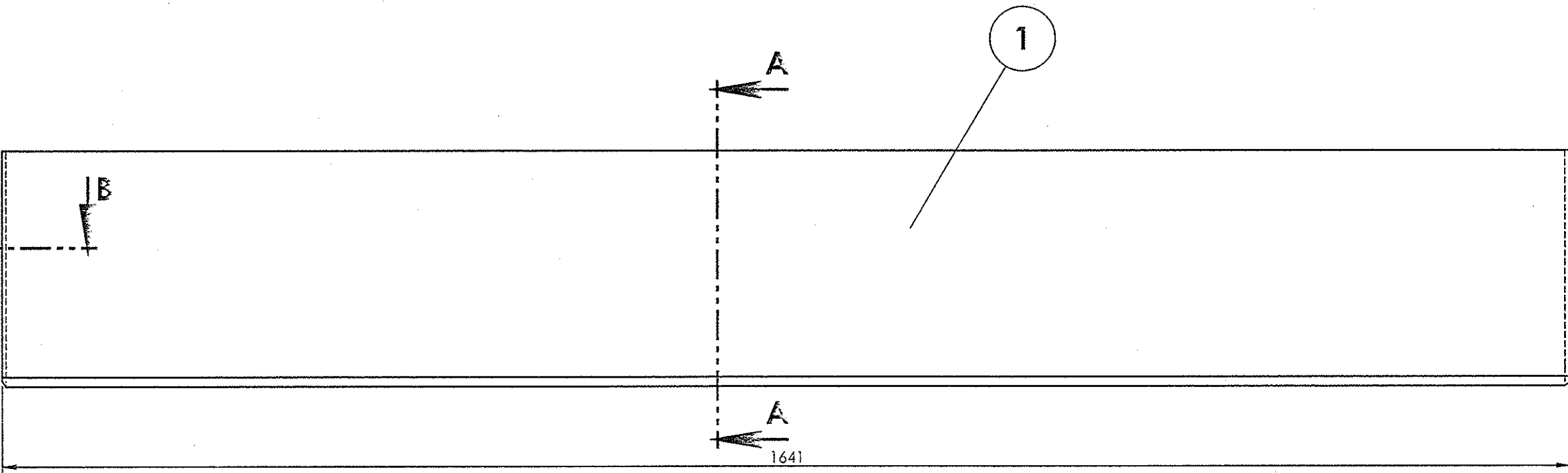
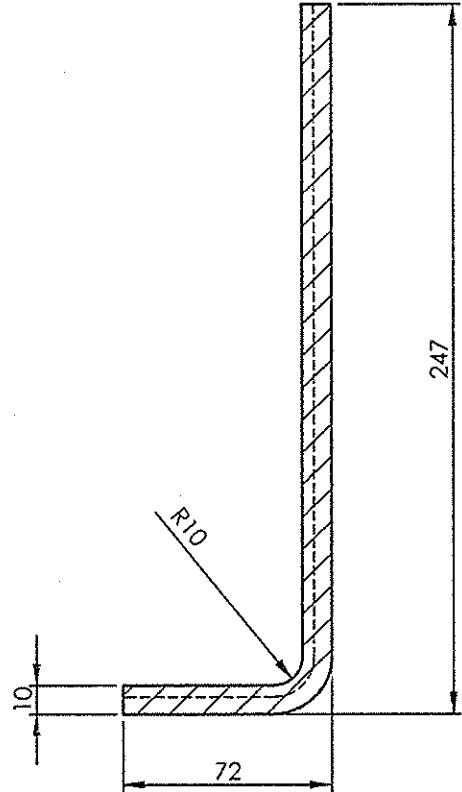
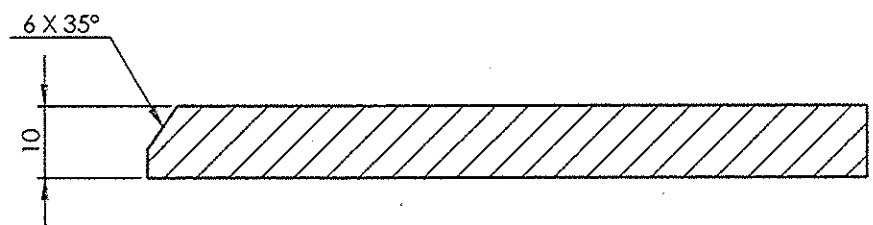
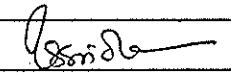
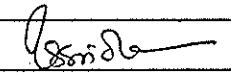
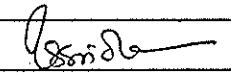
TOLERANCE:

1. BOW / CAMBER : 1.5 mm/METER, SUBJECT TO MAX. OF 15 mm.
2. TWIST : 1° / METRE, SUBJECT TO MAX. OF 25 mm.
3. ANGLE OF BEND : ± 1°
4. WAVINESS/FLATNESS : 2 mm MAX.

1	LONGITUDINAL BEAM	8x570xL	1		IRS M-41-1997	343.17	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: I-1		SURFACE AREA IN Sq.m.: 11.10			WT/ASSY IN Kgs:		
LONGITUDINAL BEAM					SCALE 1:20	SSE/D	
						CHD	
					ALT a	ALTD	M.SIVAKUMAR
						DRN	K.SETHURAMAN
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1			
						AAD11232	

REF.DRG.NO.

11-02-2019	17-10-2017	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

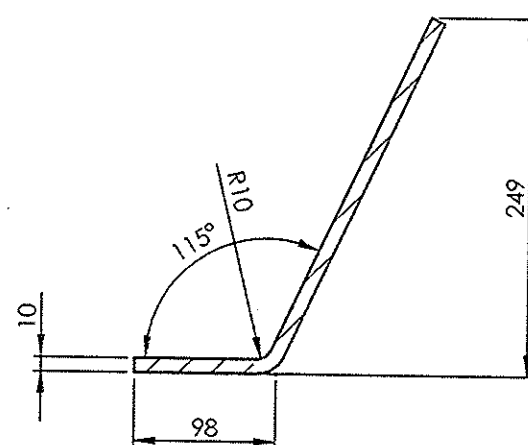
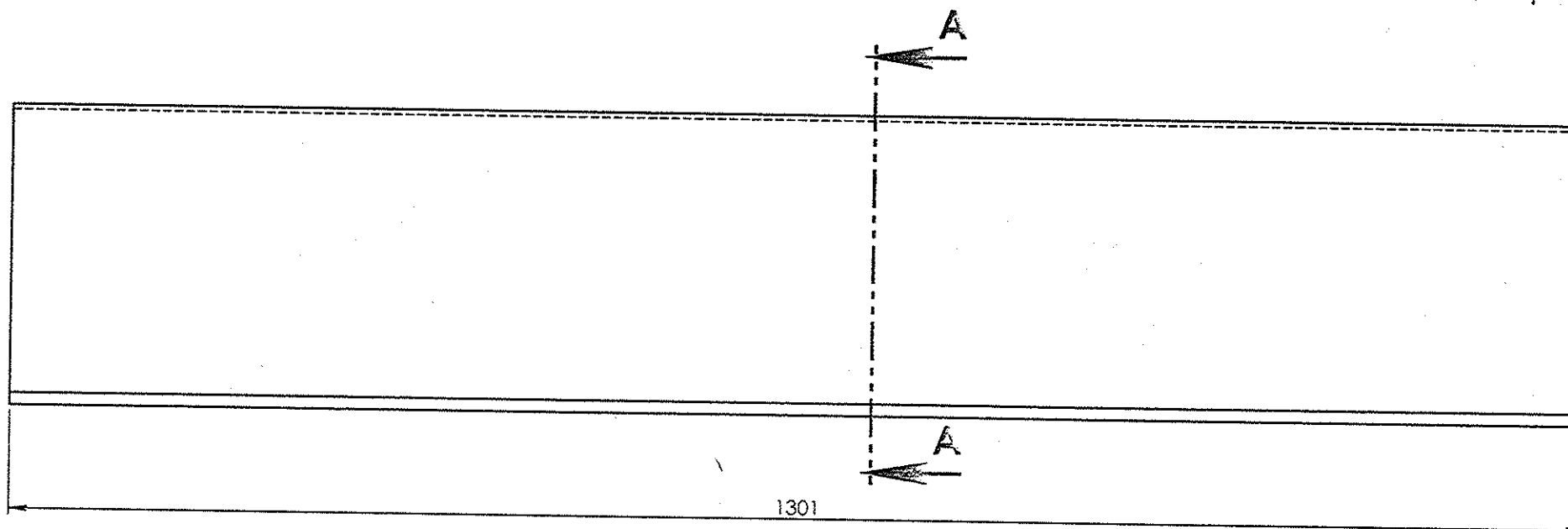
1		2		3		4		5		6		7		8																																																							
AAD11234				▽ ROUGH MACHINED		⊖ ROUGH CLEANED		REVISIONS																																																													
				▽▽ FINISH MACHINED		⊖⊖ BURRS REMOVED		ALT.		ZONE		DESCRIPTION		APPROVED & DATE																																																							
				▽▽▽ FINE FINISH MACHINED		⊖⊖⊖ CHAMFERED																																																															
																																																																					
																																																																					
																																																																					
<table><tr><td>1</td><td>ANGLE</td><td>8x303x1641</td><td>1</td><td></td><td>IRS M-41-1997</td><td>38.91</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: UNDER FRAME</td><td colspan="2">SURFACE AREA IN Sq.m.:</td><td colspan="4">WT/ASSY IN Kgs:</td></tr><tr><td colspan="4" rowspan="4">ANGLE</td><td>SCALE</td><td>SSE/D</td><td colspan="2" rowspan="4"></td></tr><tr><td>1:5</td><td>CHD</td></tr><tr><td>ALT.</td><td>ALTD</td></tr><tr><td>DRN</td><td>P.MURUGAN</td></tr><tr><td colspan="4">INDIAN RAILWAY STANDARDS</td><td colspan="2">SHEET 1 OF 1</td><td colspan="2">A3</td></tr><tr><td colspan="4">INTEGRAL COACH FACTORY, CHENNAI - 600038</td><td colspan="2"></td><td colspan="2"></td></tr></table>																1	ANGLE	8x303x1641	1		IRS M-41-1997	38.91		QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS	GROUP: UNDER FRAME		SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:				ANGLE				SCALE	SSE/D			1:5	CHD	ALT.	ALTD	DRN	P.MURUGAN	INDIAN RAILWAY STANDARDS				SHEET 1 OF 1		A3		INTEGRAL COACH FACTORY, CHENNAI - 600038							
1	ANGLE	8x303x1641	1		IRS M-41-1997	38.91																																																															
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS																																																														
GROUP: UNDER FRAME		SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:																																																																	
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INDIAN RAILWAY STANDARDS				SHEET 1 OF 1		A3																																																															
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REF.DRG.NO.		03 -10-2017		AME/SME																																																																	
DATE OF LATEST ALT.		DATE OF FIRST ISSUE																																																																			

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

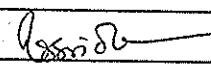
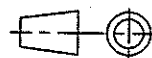
AAD11237

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

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



SECTION A-A

1	ANGLE	10x360x1301	1		IRS M-41-1997	36.74	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
ANGLE					SCALE	SSE/D	
					1:5	CHD	
					ALT.	ALTD	
						DRN	P.MURUGAN
INDIAN RAILWAY STANDARDS				SHEET 1 OF 1			
INTEGRAL COACH FACTORY, CHENNAI - 600038					AAD11237		A3

03-10-2017	AME/SME
DATE OF LATEST ALT.	DATE OF FIRST ISSUE

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

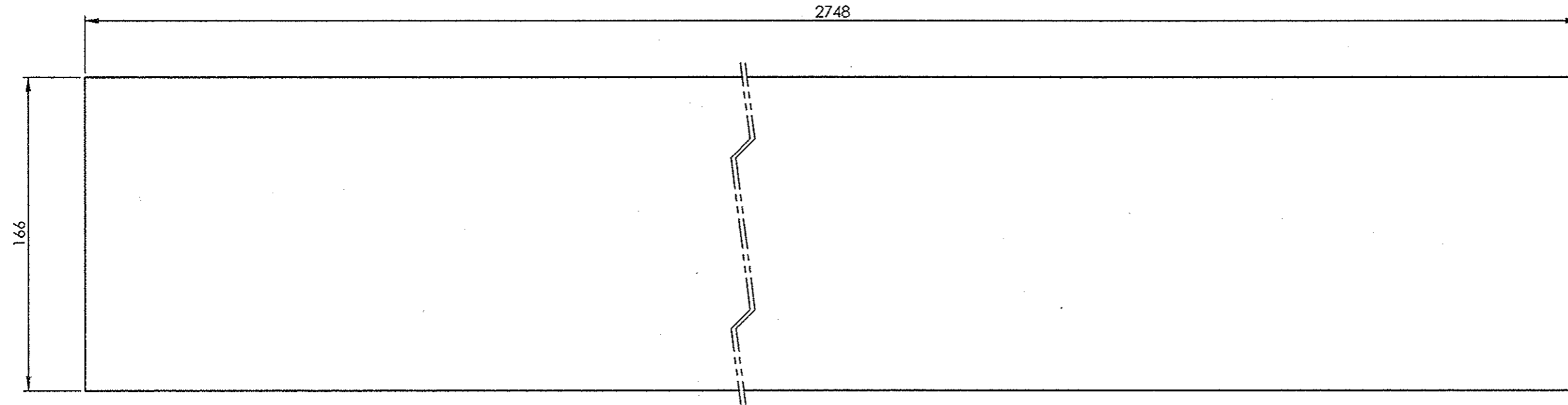
REF.DRG.NO.-

1		2		3		4		5		6		7		8		
AAD11238				▽ ROUGH MACHINED		① ROUGH CLEANED		REVISIONS								
				▽▽ FINISH MACHINED		② BURRS REMOVED		ALT.		ZONE		DESCRIPTION			APPROVED & DATE	
				▽▽▽ FINE FINISH MACHINED		③ CHAMFERED										
<div><div><div>2748</div><div>1</div></div><div><div>150</div><div>140</div><div>5</div><div>R5</div></div></div> <div><div>ISOMETRIC VIEW</div></div>																
<div><div><div>1</div><div>CHANNEL</div><div>5x410x2748</div><div>1</div><div></div><div>IRS M-41-1997</div><div>44.61</div><div></div></div><div><div>QTY.</div><div>DESCRIPTION</div><div>DIMENSIONS</div><div>ITEM NO.</div><div>REF. DRGS</div><div>MATL.SPEC.</div><div>WT/UNIT IN KGS</div><div>REMARKS</div></div><div><div>GROUP: 1-1</div><div>SURFACE AREA IN Sq.m.:</div><div>WT/ASSY IN Kgs:</div></div><div><div>CHANNEL</div><div>SCALE 1:2.5</div><div>SSE/D CHD</div><div>ALT. ALTD</div><div>DRN K.SETHURAMAN</div></div><div><div>INDIAN RAILWAY STANDARDS</div><div>INTEGRAL COACH FACTORY, CHENNAI - 600038</div><div>SHEET 1 OF 1</div><div><div><div></div><div></div></div></div><div><div>20-10-2017</div><div>20-10-2017</div><div>AME/SME</div></div><div><div>REF.DRG.NO.</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>SHEET 1 OF 1</div><div><div><div></div><div></div></div></div><div><div>AAD11238</div><div>A3</div></div></div></div></div>																
1		2		3		4		5		6		7		8		

AAD11239

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

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE



1

1	BOTTOM PLATE	5x166x2748	1		IRS M-41-1997	17.90			
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS		
GROUP: 1-1		SURFACE AREA IN Sq.m.:		WT/ASSY IN Kgs:					
BOTTOM PLATE					SCALE	SSE/D			
					1:2.5	CHD			
					ALT.	ALTD			
						DRN	K.SETHURAMAN		
INDIAN RAILWAY STANDARDS				SHEET 1 OF 1		A3			
INTEGRAL COACH FACTORY, CHENNAI - 600038				AAD11239		A3			

	20-10-2017	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	A.M.E./S.M.E.

REF.DRG.NO.

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

1	2	3	4	5	6	7	8	
AAD11240			▽ ROUGH MACHINED	① ROUGH CLEANED	REVISIONS			
			▽▽ FINISH MACHINED	② BURRS REMOVED	ALT.	ZONE	DESCRIPTION	APPROVED & DATE
			▽▽▽ FINE FINISH MACHINED	③ CHAMFERED				

30

2748

5

1

INDIAN RAILWAY STANDARDS

INTEGRAL COACH FACTORY, CHENNAI - 600038

20-10-2017

1

IRS M-41-1997

3.24

WT/UNIT IN KGS

REMARKS

GROUP: 1-1

SURFACE AREA IN Sq.m.:

WT/ASSY IN Kgs:

SCALE 1:1

SSE/D

CHD

ALT.

ALTD

DRN

K.SETHURAMAN

SHEET 1 OF 1

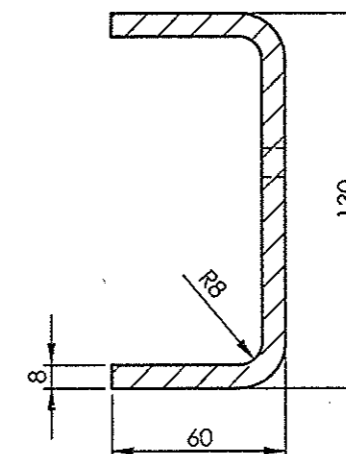
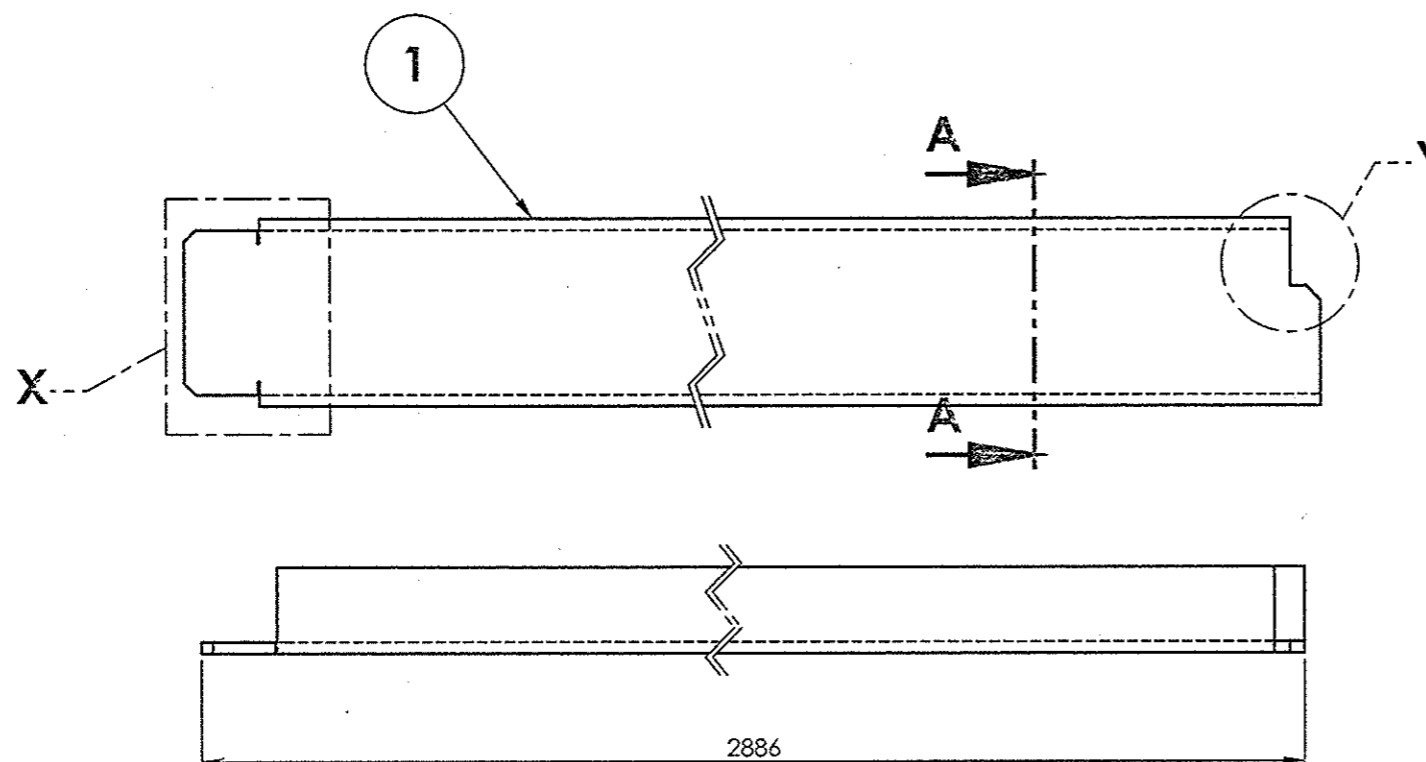
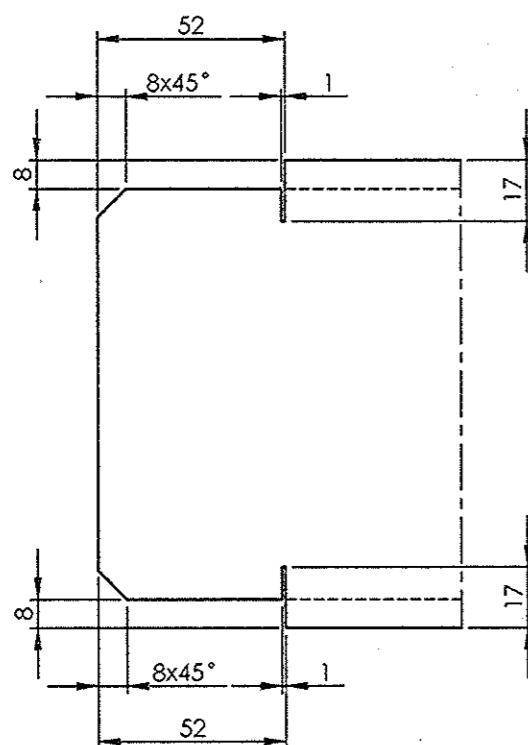
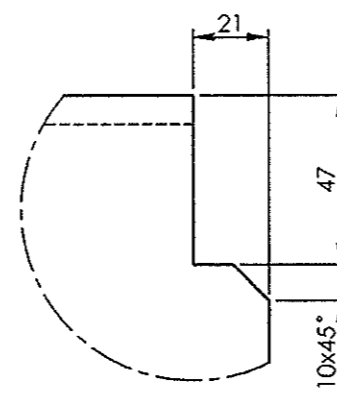
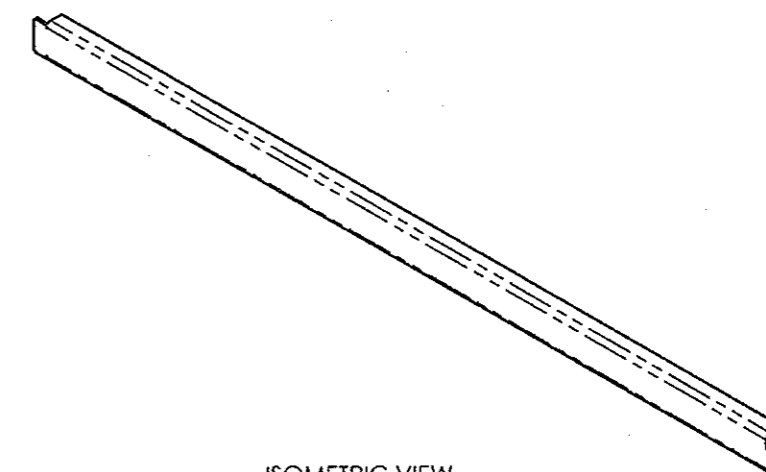
AAD11240

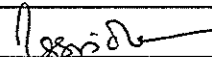
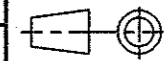
A3

AAD11241

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

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE

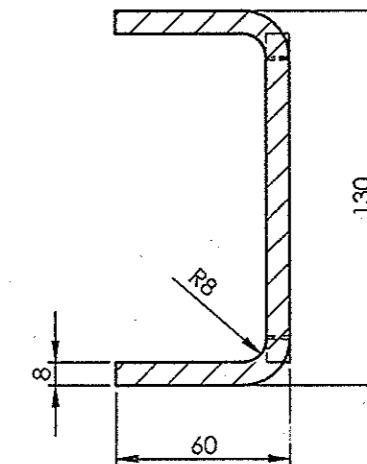
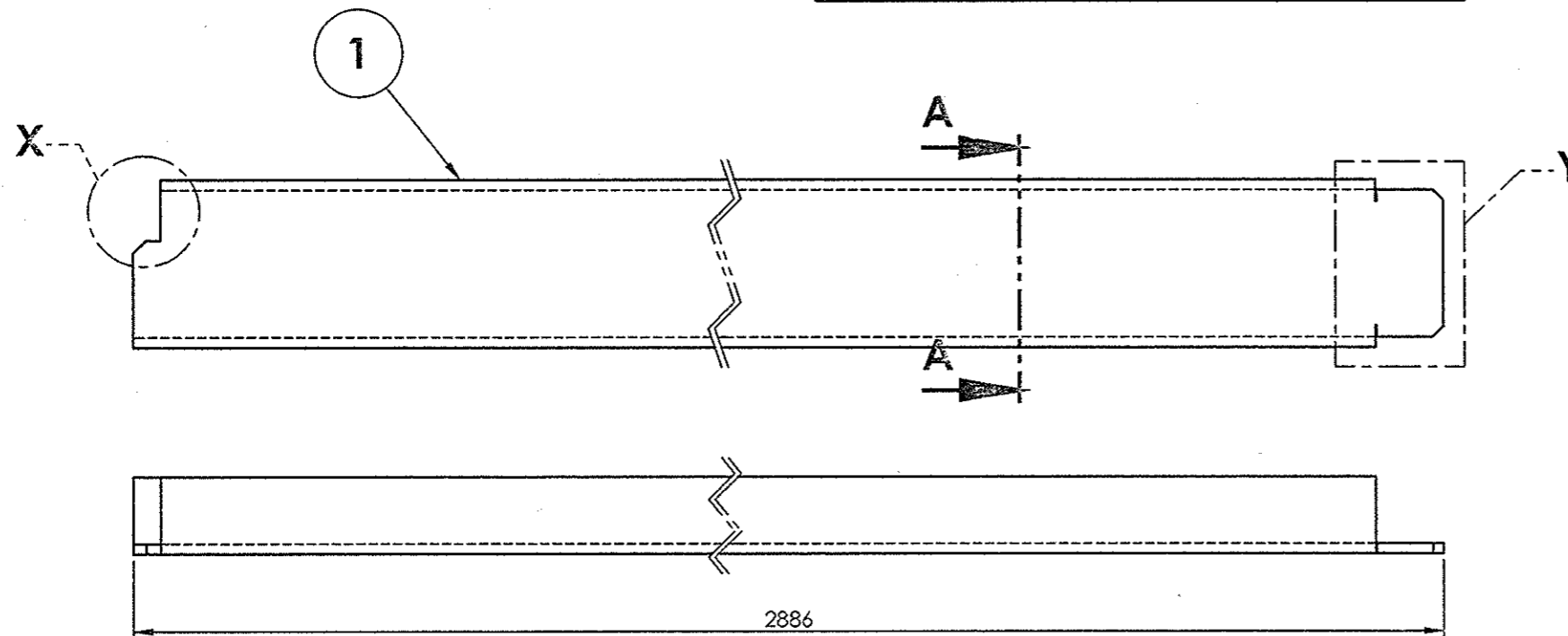
SECTION A-A
SCALE 1 : 2.5DETAIL X
SCALE 1 : 2DETAIL Y
SCALE 1 : 2

1	CHANNEL	8x218x2886	1		IRS M-41-1997	40.05	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:5	CHD	
					ALT.	ALTD	
						DRN	K.SETHURAMAN
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1			
					AAD11241		A3

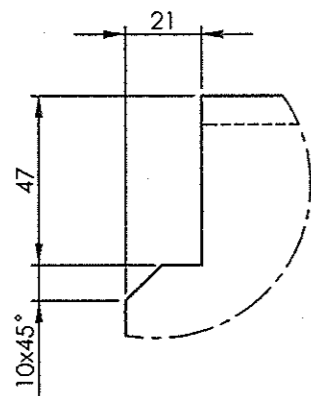
AAD11242

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

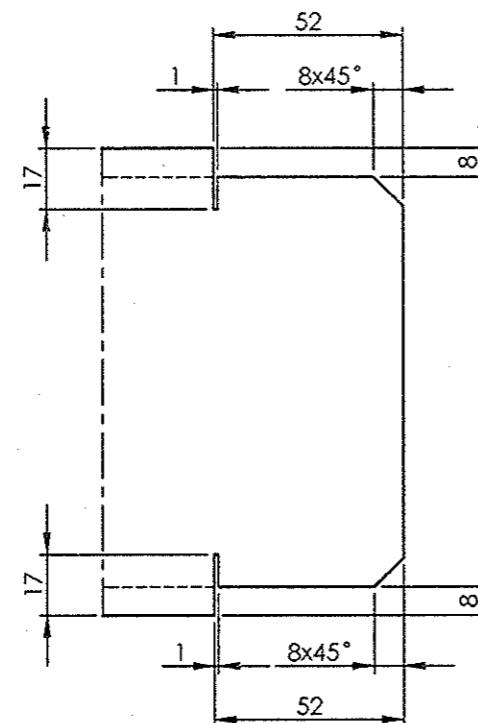
REVISIONS				APPROVED & DATE	
ALT.	ZONE	DESCRIPTION			



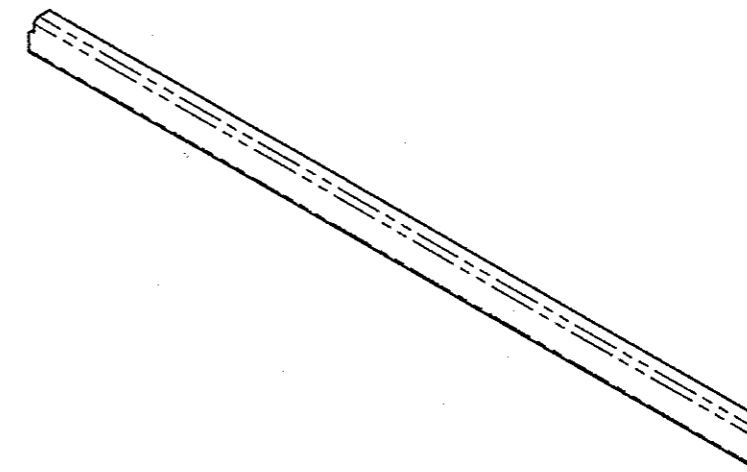
SECTION A-A
SCALE 1:2.5



DETAIL X
SCALE 1:2



DETAIL Y
SCALE 1:2

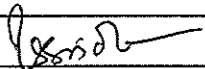
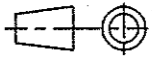


ISOMETRIC VIEW

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REF.DRG.NO.

	23-10-2017	<i>K. SETHURAMAN</i>
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

1	CHANNEL	8x218x2886	1		IRS M-41-1997	40.05	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:5	CHD	
					ALT.	ALTD	
						DRN	K.SETHURAMAN
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038							
					SHEET 1 OF 1		AAD11242

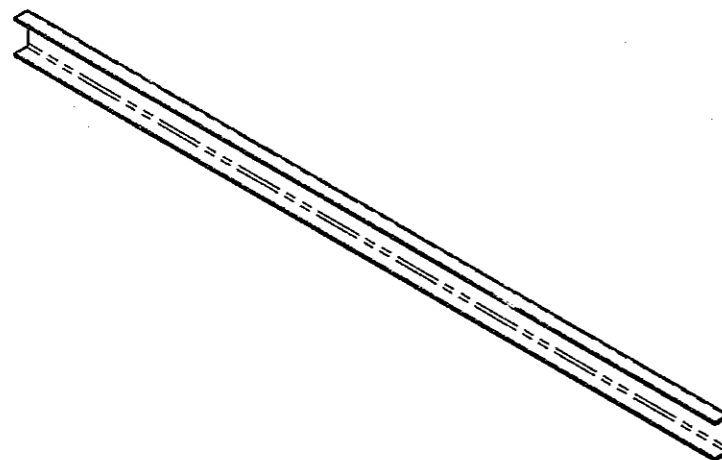
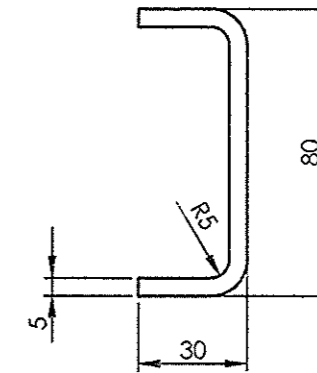
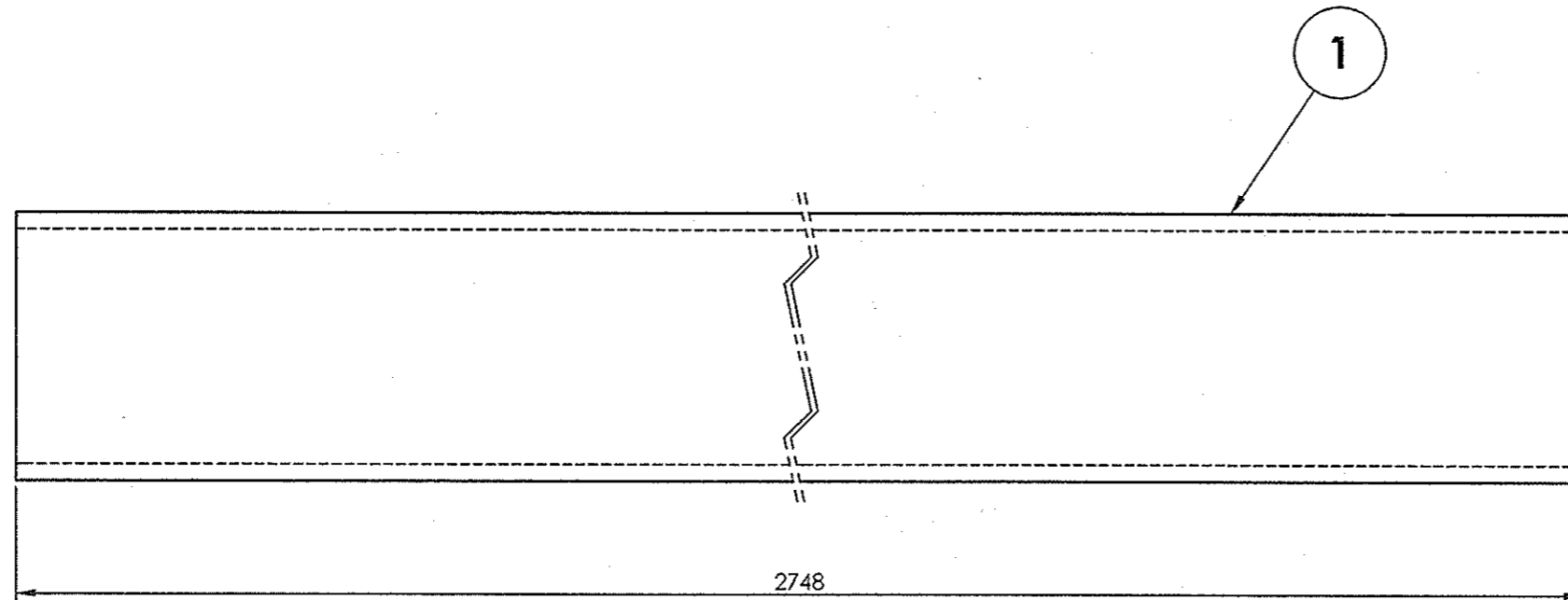
1		2		3		4		5		6		7		8		
AAD11243				▽ ROUGH MACHINED		① ROUGH CLEANED		REVISIONS								
				▽▽ FINISH MACHINED		② BURRS REMOVED		ALT.		ZONE		DESCRIPTION			APPROVED & DATE	
				▽▽▽ FINE FINISH MACHINED		③ CHAMFERED										
<div><div><div>1</div><div></div></div><div></div><div></div><div>ISOMETRIC VIEW</div></div>																
<div><div><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 IS: 813-1986. WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY</div><div>REF.DRG.NO.</div><div><div>23-10-2017</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>SHEET</div><div>1 OF 1</div></div><div><div>AAD11243</div><div>A3</div></div></div></div>																
1		2		3		4		5		6		7		8		

1	CHANNEL	8x218x2748	1		IRS M-41-1997	38.60	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1		SURFACE AREA IN Sq.m.:			T/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:2.5	CHD	
					ALT.	ALTD	K.SETHURAMAN
						DRN	
INDIAN RAILWAY STANDARDS					SHEET 1 OF 1		
INTEGRAL COACH FACTORY, CHENNAI - 600038					AAD11243		
					A3		

AAD11244

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

REVISIONS				APPROVED & DATE	
ALT.	ZONE	DESCRIPTION			



ISOMETRIC VIEW

1	CHANNEL	5x120x2748	1		IRS M-41-1997	13.33				
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS			
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:					
CHANNEL					SCALE	SSE/D				
					1:2	CHD				
					ALT.	ALTD				
						DRN	K.SETHURAMAN			
INDIAN RAILWAY STANDARDS				SHEET 1 OF 1		AAD11244 A3				
INTEGRAL COACH FACTORY, CHENNAI - 600038										
DATE OF LATEST ALT.		DATE OF FIRST ISSUE	AME/SME							
		23 -10-2017								

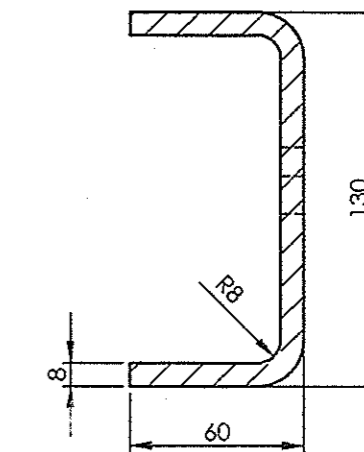
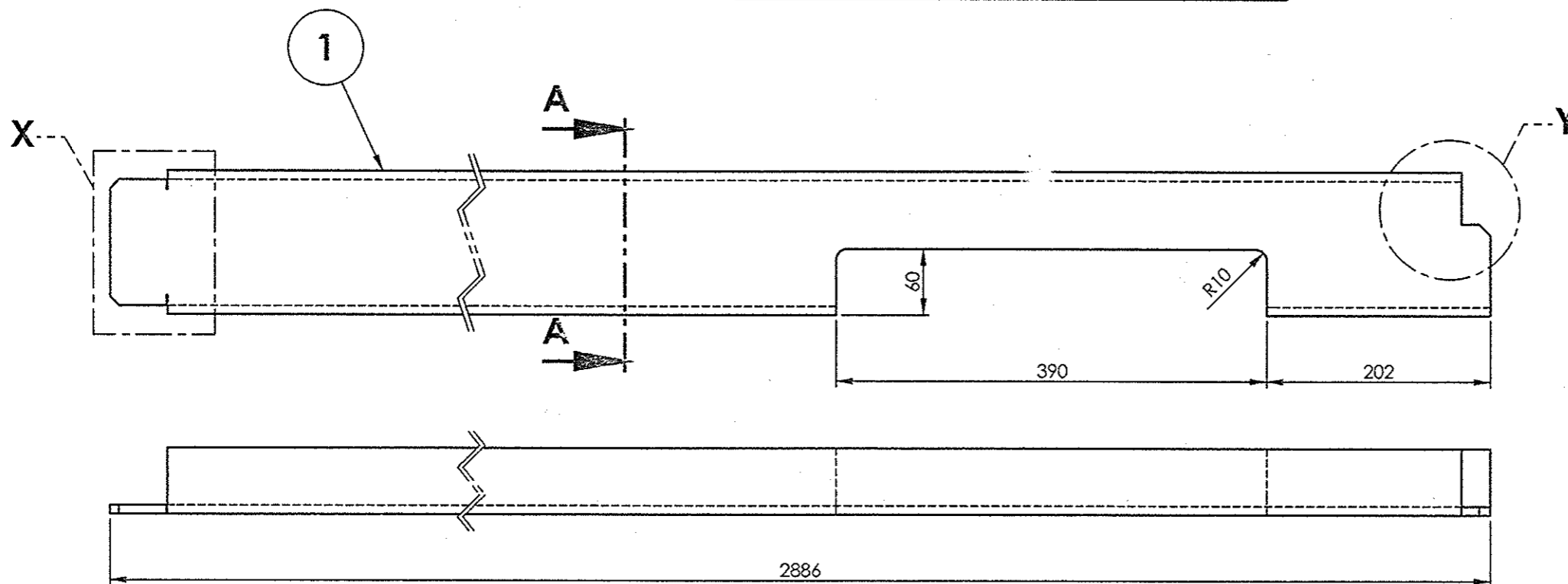
ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICE/SID 9-0-001.
ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER IS: 813: 1986.
WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY

REF.DRG.NO.

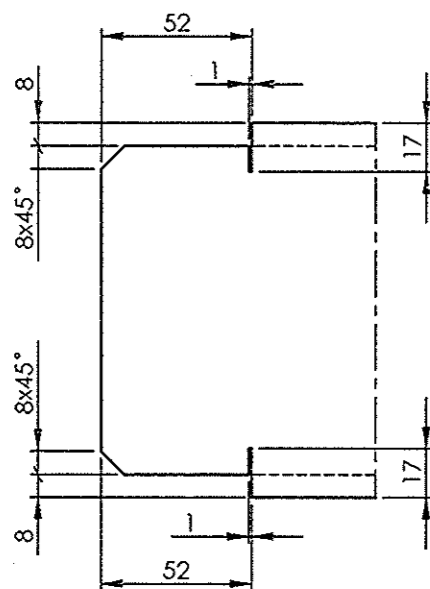
AAD11245

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

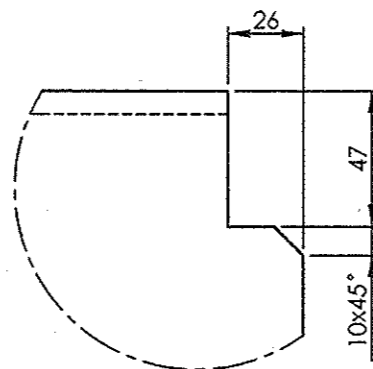
REVISIONS				APPROVED & DATE	
ALT.	ZONE	DESCRIPTION			



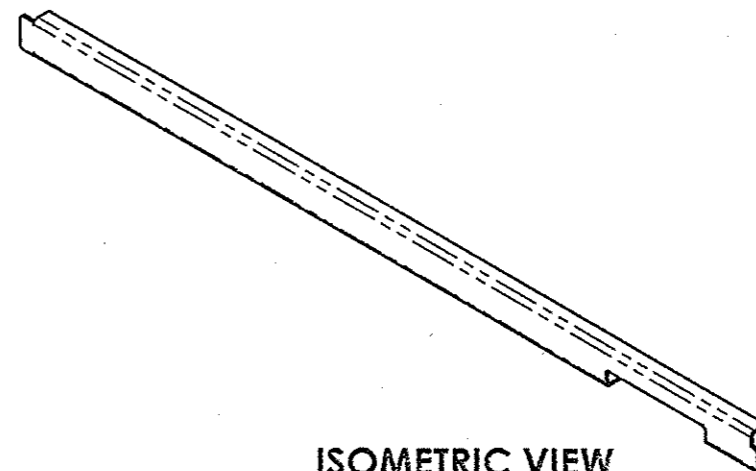
SECTION A-A
SCALE 1 : 2.5



DETAIL X
SCALE 2 : 5



DETAIL Y
SCALE 1 : 2.5

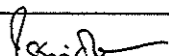
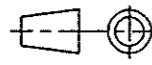


ISOMETRIC VIEW

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WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY

REF.DRG.NO.

23 -10-2017	
DATE OF LATEST ALT.	DATE OF FIRST ISSUE
	AME/SME

1	CHANNEL	8x218x2886	1		IRS M-41-1997	37.41	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:5	CHD	
					ALT.	ALTD	
						DRN	K.SETHURAMAN
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1			
					AAD11245		A3

1		2		3		4		5		6		7		8		
AAD11246				▽ ROUGH MACHINED		③ ROUGH CLEANED		REVISIONS								
				▽▽ FINISH MACHINED		④ BURRS REMOVED		ALT.		ZONE		DESCRIPTION			APPROVED & DATE	
				▽▽▽ FINE FINISH MACHINED		⑧ CHAMFERED										
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REF.DRG.NO.

23 -10-2017

AME/SME

INDIAN RAILWAY STANDARDS

INTEGRAL COACH FACTORY, CHENNAI - 600038

SHEET 1 OF 1

AAD11246

A3

ISOMETRIC VIEW

STIFFENING CHANNEL

GROUP: 1-1

SURFACE AREA IN Sq.m.:

WT/ASSY IN Kgs:

SCALE 1:2

SSE/D CHD

ALT. ALTD

DRN K.SETHURAMAN

INDIAN RAILWAY STANDARDS

INTEGRAL COACH FACTORY, CHENNAI - 600038

SHEET 1 OF 1

AAD11246

A3

1

STIFFENING CHANNEL

5x80x490

1

REF. D. S

IRS M-41-1997

1.55

REMARKS

QTY.

DESCRIPTION

DIMENSIONS

ITEM NO.

REF. D. S

MATL.SPEC.

WT/UNIT IN KGS

REMARKS

1

STIFFENING CHANNEL

5x80x490

1

REF. D. S

IRS M-41-1997

1.55

REMARKS

QTY.

DESCRIPTION

DIMENSIONS

ITEM NO.

REF. D. S

MATL.SPEC.

WT/UNIT IN KGS

REMARKS

1

STIFFENING CHANNEL

5x80x490

1

REF. D. S

IRS M-41-1997

1.55

REMARKS

QTY.

DESCRIPTION

DIMENSIONS

ITEM NO.

REF. D. S

MATL.SPEC.

WT/UNIT IN KGS

REMARKS

1

STIFFENING CHANNEL

5x80x490

1

REF. D. S

IRS M-41-1997

1.55

REMARKS

QTY.

DESCRIPTION

DIMENSIONS

ITEM NO.

REF. D. S

MATL.SPEC.

WT/UNIT IN KGS

REMARKS

1

STIFFENING CHANNEL

5x80x490

1

REF. D. S

IRS M-41-1997

1.55

REMARKS

QTY.

DESCRIPTION

DIMENSIONS

ITEM NO.

REF. D. S

MATL.SPEC.

WT/UNIT IN KGS

REMARKS

1

STIFFENING CHANNEL

5x80x490

1

REF. D. S

IRS M-41-1997

1.55

REMARKS

QTY.

DESCRIPTION

DIMENSIONS

ITEM NO.

REF. D. S

MATL.SPEC.

WT/UNIT IN KGS

REMARKS

1

STIFFENING CHANNEL

5x80x490

1

REF. D. S

IRS M-41-1997

1.55

REMARKS

QTY.

DESCRIPTION

DIMENSIONS

ITEM NO.

REF. D. S

MATL.SPEC.

WT/UNIT IN KGS

REMARKS

1

STIFFENING CHANNEL

5x80x490

1

REF. D. S

IRS M-41-1997

1.55

REMARKS

QTY.

DESCRIPTION

DIMENSIONS

ITEM NO.

REF. D. S

MATL.SPEC.

WT/UNIT IN KGS

REMARKS

1

STIFFENING CHANNEL

5x80x490

1

REF. D. S

IRS M-41-1997

1.55

REMARKS

QTY.

DESCRIPTION

DIMENSIONS

ITEM NO.

REF. D. S

MATL.SPEC.

WT/UNIT IN KGS

REMARKS

1

STIFFENING CHANNEL

5x80x490

1

REF. D. S

IRS M-41-1997

1.55

REMARKS

QTY.

DESCRIPTION

DIMENSIONS

ITEM NO.

REF. D. S

MATL.SPEC.

WT/UNIT IN KGS

REMARKS

1

STIFFENING CHANNEL

5x80x490

1

REF. D. S

IRS M-41-1997

1.55

REMARKS

QTY.

DESCRIPTION

DIMENSIONS

ITEM NO.

REF. D. S

MATL.SPEC.

WT/UNIT IN KGS

REMARKS

1

STIFFENING CHANNEL

5x80x490

1

REF. D. S

IRS M-41-1997

1.55

REMARKS

QTY.

DESCRIPTION

DIMENSIONS

ITEM NO.

REF. D. S

MATL.SPEC.

WT/UNIT IN KGS

REMARKS

1

STIFFENING CHANNEL

5x80x490

1

REF. D. S

IRS M-41-1997

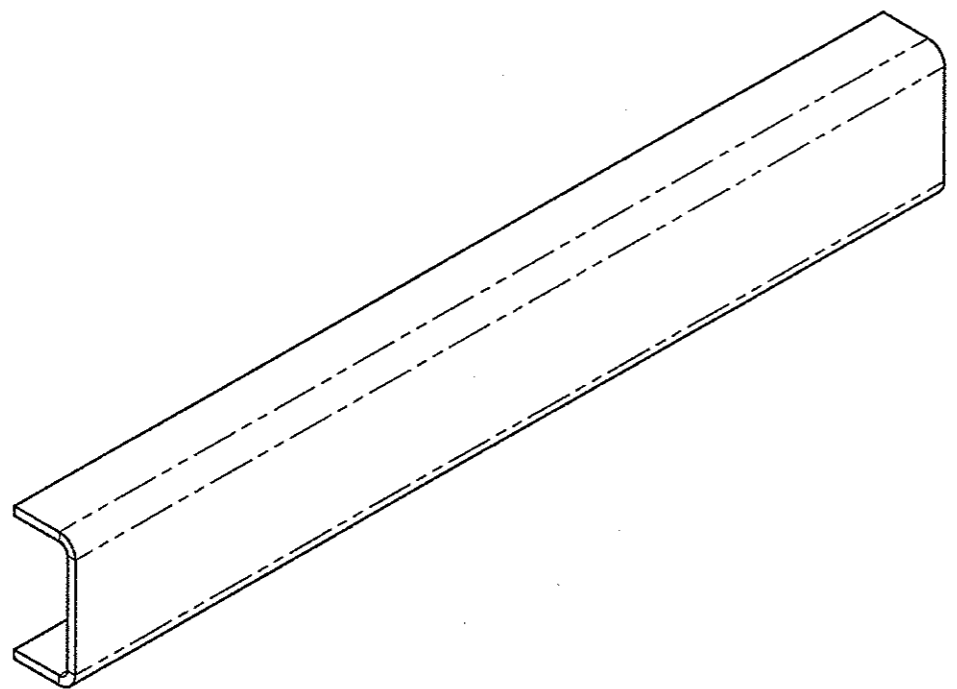
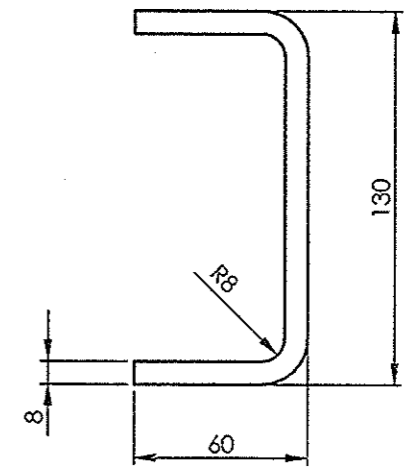
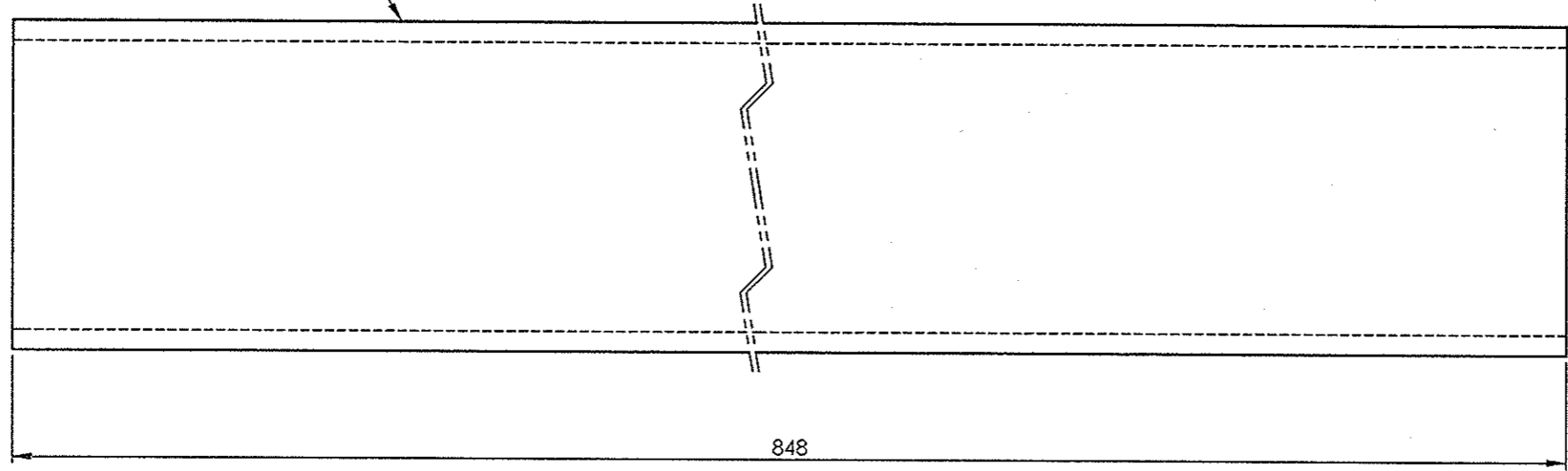
1.55

AAD11247

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

REVISIONS			
ALT.	ZONE	DESCRIPTION	APPROVED & DATE

1

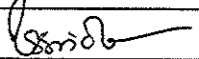
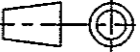


ISOMETRIC VIEW

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.

	23-10-2017	<i>[Signature]</i>
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

1	CHANNEL	8x218x848	1		IRS M-41-1997	11.91	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:2.5	CHD	
					ALT.	ALTD	
						DRN	K.SETHURAMAN
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1			
					AAD11247		A3

AAD11248

▽ ROUGH MACHINED

▽▽ FINISH MACHINED

▽▽▽ FINE FINISH MACHINED

① ROUGH CLEANED

② BURRS REMOVED

③ CHAMFERED

REVISIONS

ALT.

ZONE

DESCRIPTION

APPROVED &
DATE

1

567

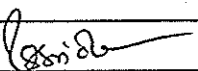
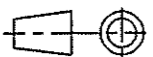
130

R8

60

8

ISOMETRIC VIEW

1	CHANNEL	8x218x567	1		IRS M-41-1997	7.97	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:2.5	CHD	
					ALT.	ALTD	
						DRN	K.SETHURAMAN
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038							
					SHEET 1 OF 1		AAD11248

REF.DRG.NO.

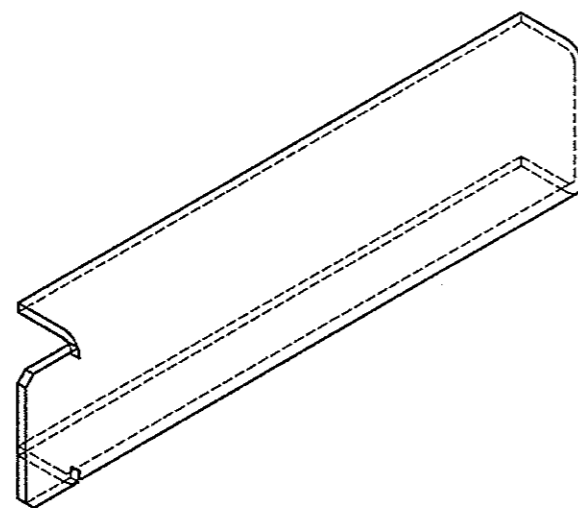
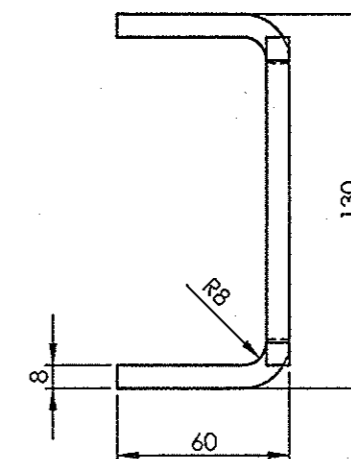
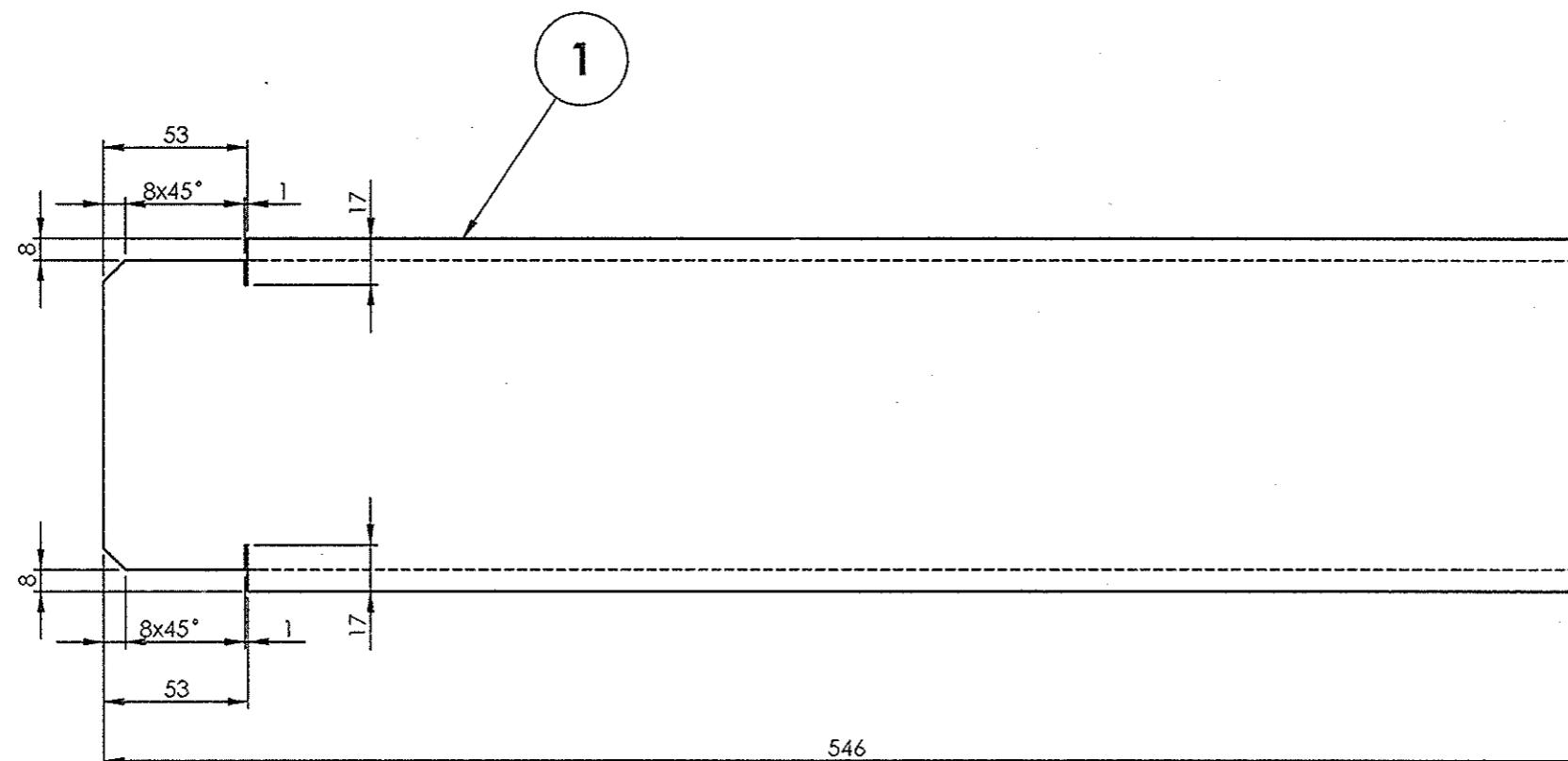
ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED. FOR UNTOLERANCED DIMENSIONS AND ROUGHNESS VALUES, REFER DRAWING NO ICF/STD 9-0-001.
ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID. WELDING SYMBOLS ARE AS PER IS: 813-1986.
WEIGHT GIVEN IN DRAWING IS FOR INDICATIVE PURPOSE ONLY

AAD11249

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

REVISIONS

ALT.	ZONE	DESCRIPTION	APPROVED & DATE
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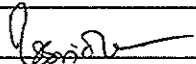
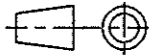


ISOMETRIC VIEW

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.

	23-10-2017	<i>S. V. S.</i>
DATE OF LATEST ALT.	DATE OF FIRST ISSUE	AME/SME

1	CHANNEL	8x219x546	1		IRS M-41-1997	7.30	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:2.5	CHD	
					ALT.	ALTD	
						DRN	K.SETHURAMAN
INDIAN RAILWAY STANDARDS INTEGRAL COACH FACTORY, CHENNAI - 600038							
					SHEET 1 OF 1		AAD11249

AAD11250

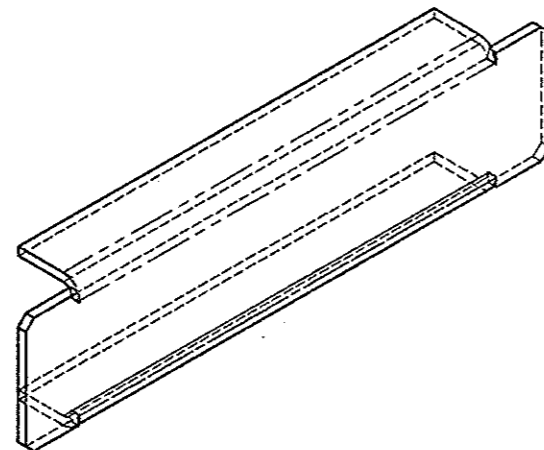
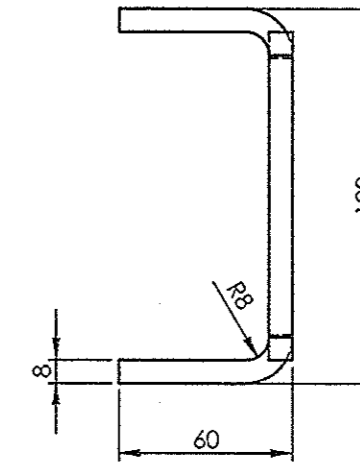
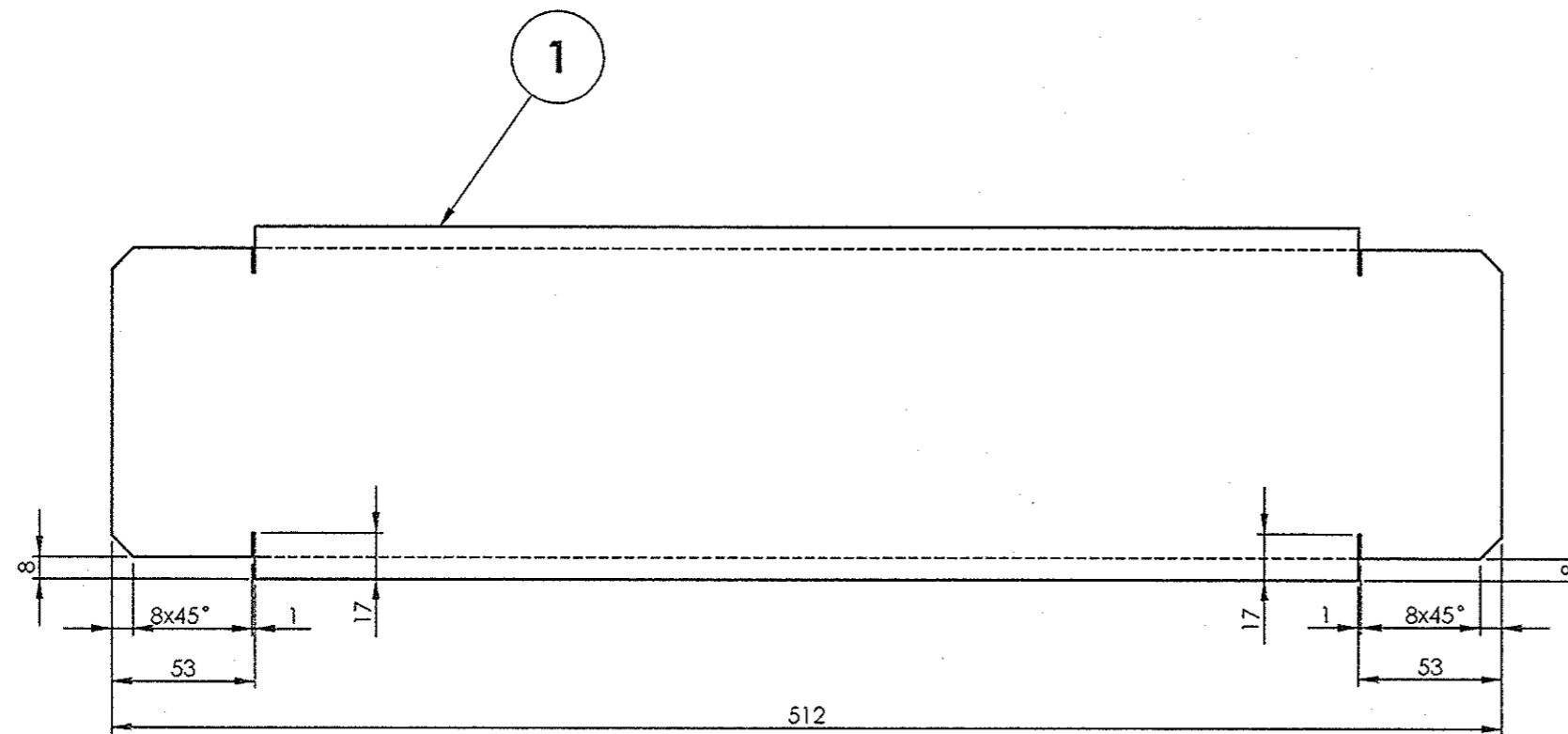
▽ ROUGH MACHINED	⊖ ROUGH CLEANED
▽▽ FINISH MACHINED	⊖⊖ BURRS REMOVED
▽▽▽ FINE FINISH MACHINED	⊖⊖⊖ CHAMFERED

REVISIONS

ALT.

ZONE

DESCRIPTION

APPROVED &
DATE

ISOMETRIC VIEW

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

REF.DRG.NO.

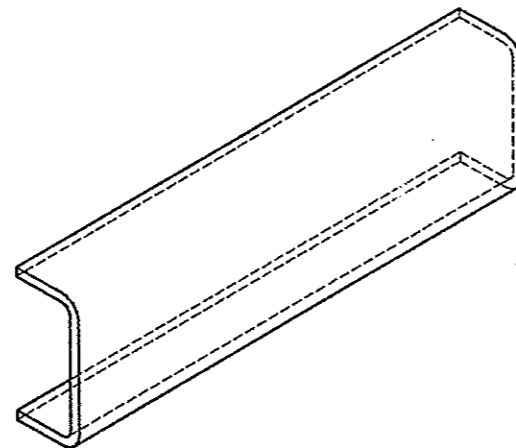
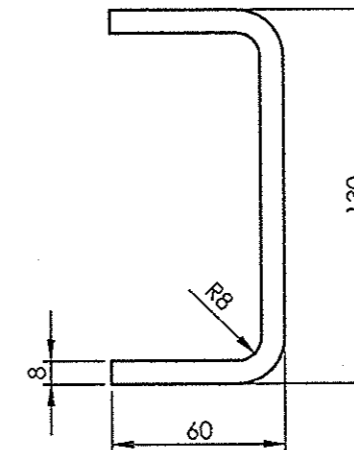
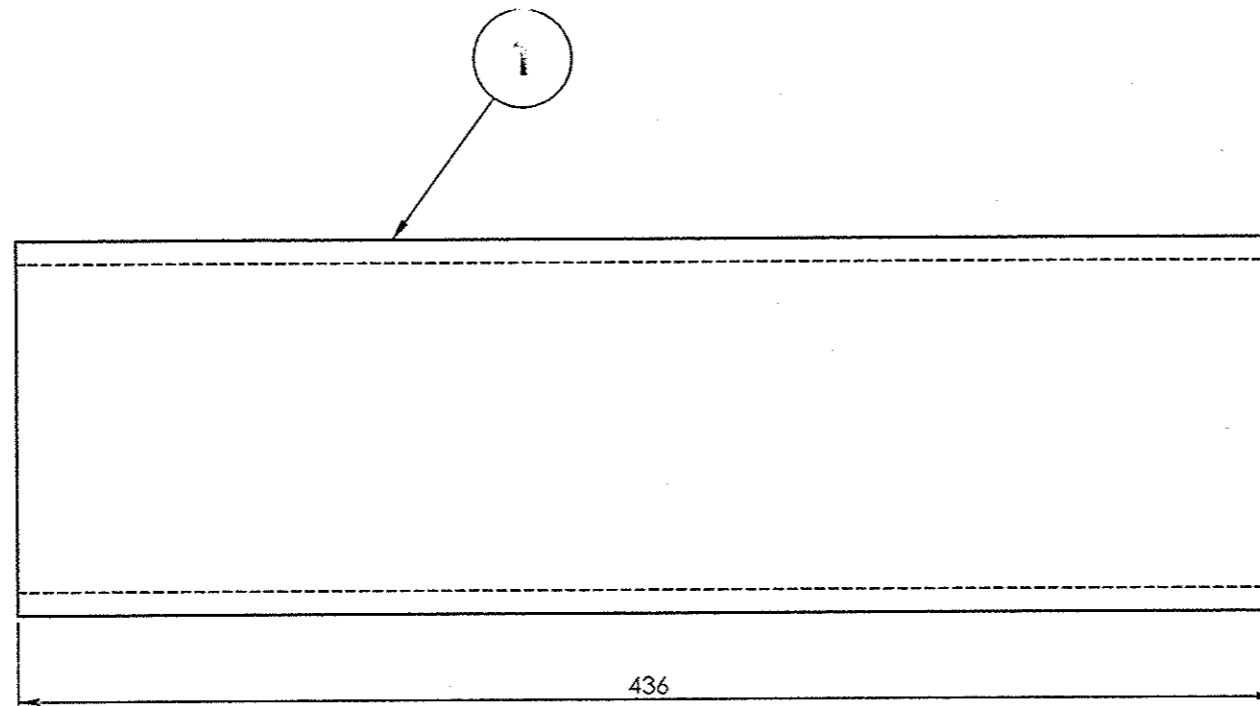
DATE OF LATEST ALT.	23-10-2017	AME/SME
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1	CHANNEL	8x218x512	1		IRS M-41-1997	6.45	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:2.5	CHD	
					ALT.	ALTD	
						DRN	K.SETHURAMAN
INDIAN RAILWAY STANDARDS							
INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1		AAD11250	A3

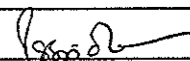
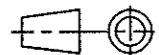
AAD11251

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

REVISIONS				APPROVED & DATE	
ALT.	ZONE	DESCRIPTION			



ISOMETRIC VIEW

1	CHANNEL	8x218x436	1		IRS M-41-1997	6.13	
QTY.	DESCRIPTION	DIMENSIONS	ITEM NO.	REF. DRGS	MATL.SPEC.	WT/UNIT IN KGS	REMARKS
GROUP: 1-1		SURFACE AREA IN Sq.m.:			WT/ASSY IN Kgs:		
CHANNEL					SCALE	SSE/D	
					1:2.5	CHD	
					ALT.	ALTD	
						DRN	K.SETHURAMAN
INDIAN RAILWAY STANDARDS							
INTEGRAL COACH FACTORY, CHENNAI - 600038				SHEET 1 OF 1		AAD11251	A3