Rail Coach Factory, Kapurthala

MD35131 Date:07.05.2025

Amendment -1 to Specification No. MDTS-213, Rev. 04

Sub: Issue of amendment -1 to Specification No. MDTS-213, Rev. 04 for supply of fabricated & machined FIAT type Bogie Frames.

Please find amendment -1 to Specification No. MDTS-213Rev. 04 as detailed below for information and necessary action please.

Para/ clause	Earlier	Modified
13	**Painting**: Immediately after shot blasting, the bogie frame shall be coated with primer & fully painted with High Build Epoxy paint as per RCF specification no. MDTS-166.	**Surface Protection**: Proper masking to be done on machined areas/areas where no paint/primer is required. **Pre-treatment**: Shot/grit/sand blasting according to ISO:8501, Sa 2.5 (40-50 roughness grade). **Primer**: Immediately after pre-treatment, High Performance Anti Corrosion Epoxy coating (two pack) having colour green with DFT of 125 +20/ -0 microns to be done as per RDSO spec no. M&C/PCN/123/2018 or latest. Primer, intermediate & top coats must comply to fire safety standard EN 45545 - HL3-R7. **Intermediate coat**: Fluoropolymer (Fluoroethylene) with DFT of 30 +10/ -0 microns to be done as per Japanese Industrial Standard JIS K 5659:2008. **Top coat**: Fluoropolymer (Fluoroethylene) with DFT of 25 +10/ -0 microns with shade to be RAL-7012 (Basalt Grey) to be done as per Japanese Industrial Standard JIS K 5659:2008 Class-1. ➢ Machined areas which do not require primer/paint should be protected against corrosion with suitable corrosion preventive coating which is removable easily and suitable packing should be done so as to avoid any possibility of damage during transit. ➢ Item should be preserved in the moisture free and dustless zone ➢ Ensure all threaded/tapped portion are masked.

This has approval of competent authority.

Ritika Rashmi Digitally signed by Ritika Rashmi Date: 2025.05.07 15:32:31 +05'30'

(Ritika Rashmi)
Dy.CME/Bogie Design

CQM-I, CQM-II, CPLE, CWE/Fur, CWE/Shell, CMM/HSQ, CMM/TKJ

Dy.CMM/Fur/LHB, Dy.CMM/G, CMT, Dy.CPLE-I, Dy.CPLE-II, Dy.CPLE-III, Dy.CMM/Fur

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