

RAIL COACH FACTORY, KAPURTHALA
(Coach Alteration Instruction)
CAI/RCF/MECH/LHB/099

MD46221

Date: 17/05/2025

SN	Description	Details
1.	Description	MODIFICATION IN CHAIN LOCKING ARRGT. OF MIDDLE BERTH FOR LSCN AND LACCN COACHES
2.	Coach type affected	LHB SCN and LHB ACCN Coaches
3.	Reason for Modification	Complaints received from User Railways regarding failure of locking arrgt. of chain of the middle berth and falling of the middle berth.
4.	Drawing No.	1. AE61480 Alt-'f' 2. LE61219 Alt-'e' 3. LH61194 Alt-nil 4. C/CF-79 5. MI008248 Alt-nil 6. MI008249 Alt-nil 7. MI008250 Alt-nil
1.	Modification	1. In LSCN coaches: i) Both old chains of middle berth are to be replaced with the new chain arrgt. to drawing no. AE61480 Alt-'f'. ii) New Pin Brackets to drg. No. MI008248 Alt-nil are to be screwed on the middle berth as per fixing arrgt. drawing no. MI008249 Alt-nil. 2. In LACCN coaches: i) Both old chains of middle berth are to be replaced with the new chain arrgt. to drawing no. LE61219 Alt-'e'. ii) New Pin Brackets to drg. No. MI008248 Alt-nil are to be screwed on the middle berth as per fixing arrgt. drawing no. MI008250 Alt-nil.
1.	Implementation Stage	Immediate effect.
2.	Category of CAI	<div style="display: flex; align-items: center;"> <input checked="" type="checkbox"/> A <input type="checkbox"/> B </div> Tick A or B as applicable.

A. Modifications shall be implemented immediately by user Railways.

B. Modifications shall be implemented by user Railways as & when convenient.


 17/05/25
For General Manager (Mech)

Encls: (06 drgs as listed above)

All Principal Chief Mechanical Engineers:

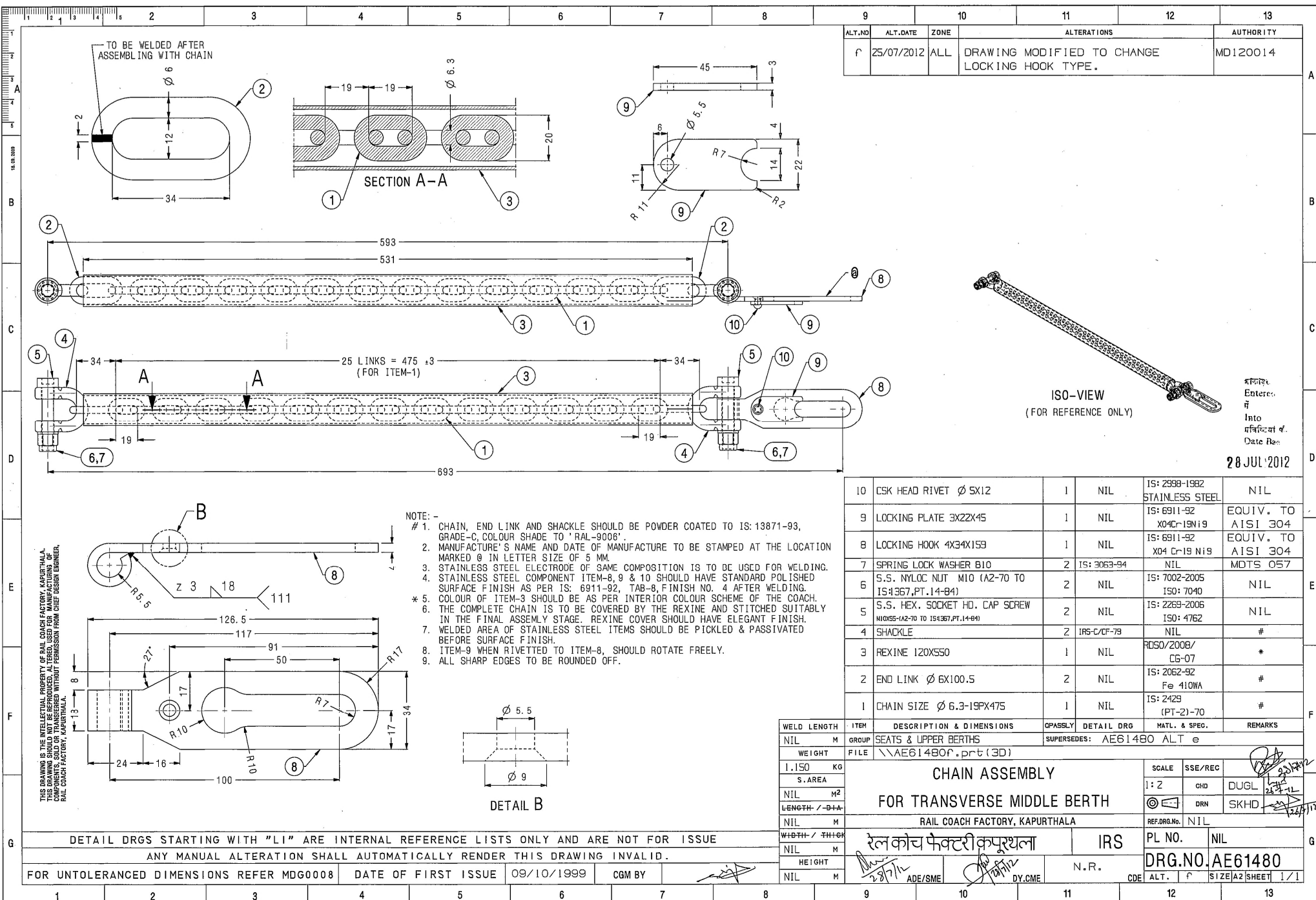
1. Central Railway, Mumbai CST-400 001
2. W. Railway Churchgate, Mumbai - 400 020
3. Northern Railway, Baroda House, New Delhi- 110 001
4. N.E. Railway Gorakhpur. Gorakhpur-273 001
5. N.F. Railway Maligaon, Guwahati- 781 011
6. S. Railway, Park Town, Chennai- 600 003
7. S. C. Railway, Rail Nilayam, Secunderabad- 500 371i
8. S. E. Railway, Garden Reach, Kolkata-700 043
9. Eastern Railway, Fairlie Place, Kolkata-700 001
10. E. Coast. Railway, Bhubaneswar- 751 016
11. North Central Railway, Allahabad — 211 001
12. Northwest Railway, Jaipur — 302 001
13. S. E. Central Railway, Bilaspur- 495 004
14. S. W. Railway, Hubli 580 023
15. West Central Railway, Jabalpur- 482 001
16. East Central Railway, Hazipur- 844 101

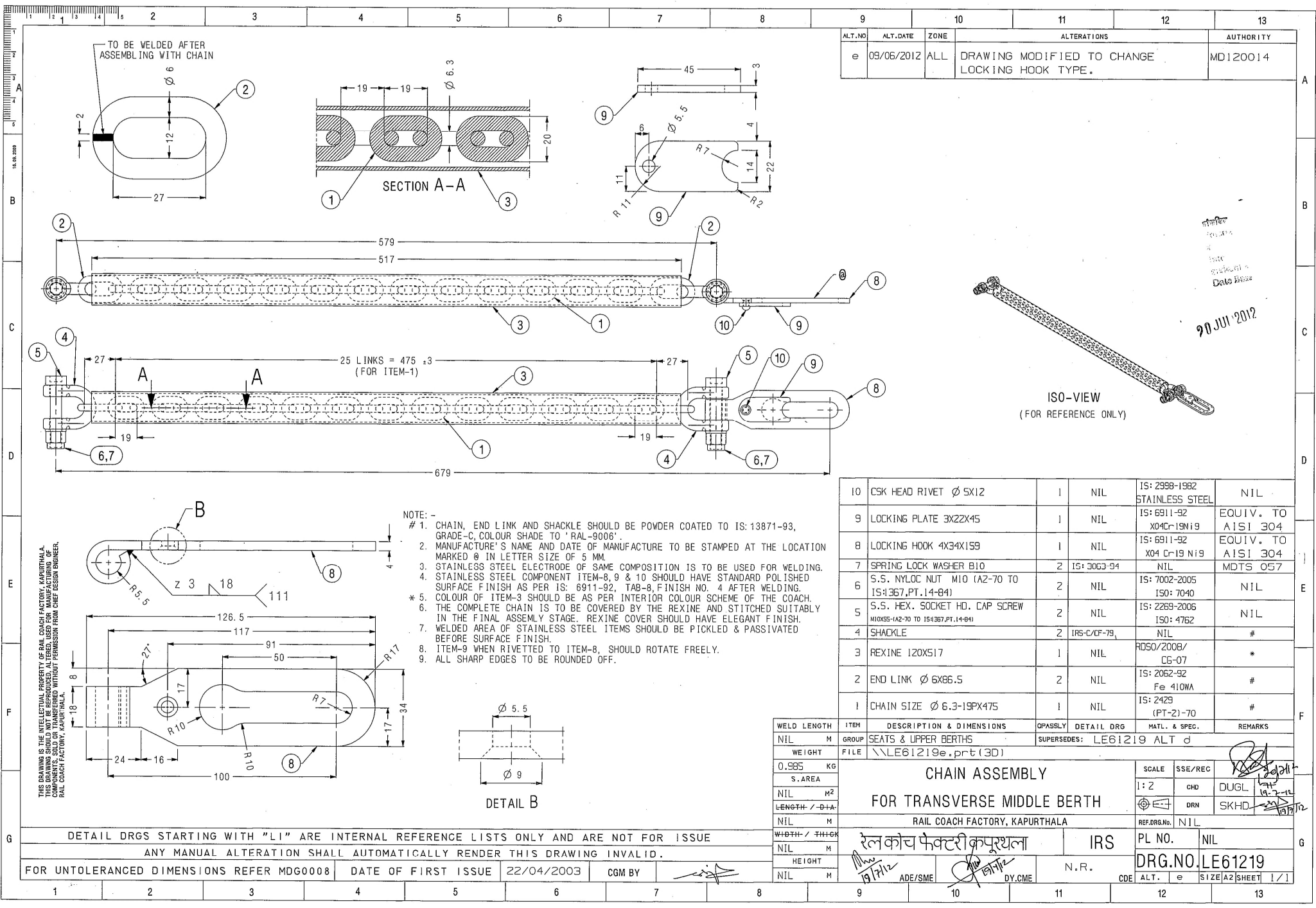
All Chief Works Engineers:

1. Central Railway, Matunga, Mumbai- 400 019
2. Bhopal, West Central Railway Nishatpura, MP-462 001
3. Lilluah, Eastern Railway, Howrah- 711 204
4. Alambagh, Northern Railway, Lucknow- 226 005
5. Jagadhari, Northern Railway, - 135 003
6. Gorakhpur N. E. Railway- 273 001
7. New Bongaigaon N. East Frontier Railway- 83 381 8, Perambur, Southern Railway, Chennai- 600 023
8. Golden Rock, Southern Railway, Trichy- 620 004
9. Ashokpuram , Southern Railway, Mysore South- 570 008
10. Lallagudda, S. C. Railway Secunderabad- 500 017
11. Hubli, South Western Railway- 580 020
12. Tirupati, S. C. Railway - 517 506
13. Mancheswar, East Coast Railway, Bhubaneswar- 751 017
14. Kharagpur, S. E. Railway- 721 301
15. Lower Parel, N.M. Joshi Marg, Western Railway, Mumbai- 400 013
16. Western Railway, Ajmer, Rajasthan
17. North East Frontier Railway, Dibrugarh, Assam-786 001

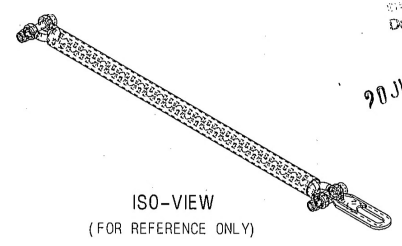
Copy to:

1. DG/Carriage, RDSO, Manak Nagar, Lucknow- 226 011
2. EDME (Coaching), Railway Board, New Delhi-110 001
3. EDME (W), (Coaching), Railway Board New Delhi-110 001
4. GM (Mech), Modern Coach Factory, Rae Bareilly-229120
5. GM (Mech), Integral Coach Factory, Chennai-600038





ALT.NO	ALT.DATE	ZONE	ALTERATIONS	AUTHORITY
e	09/06/2012	ALL	DRAWING MODIFIED TO CHANGE LOCKING HOOK TYPE.	MD120014



10	CSK HEAD RIVET Ø 5X12	1	NIL	IS: 2998-1982 STAINLESS STEEL	NIL
9	LOCKING PLATE 3X22X45	1	NIL	IS: 6911-92 X04Cr-19Ni9	EQUIV. TO AISI 304
8	LOCKING HOOK 4X34X159	1	NIL	IS: 6911-92 X04 Cr-19 Ni9	EQUIV. TO AISI 304
7	SPRING LOCK WASHER B10	2	IS: 3063-94	NIL	MDTS 057
6	S.S. NYLOC NUT M10 (A2-70 TO IS:1367,PT.14-84)	2	NIL	IS: 7002-2005 ISO: 7040	NIL
5	S.S. HEX. SOCKET HD. CAP SCREW M10X55-(A2-70 TO IS:1367,PT.14-84)	2	NIL	IS: 2269-2006 ISO: 4762	NIL
4	SHACKLE	2	IRS-C/CF-79	NIL	#
3	REXINE 120X517	1	NIL	ROSO/2008/ CG-07	*
2	END LINK Ø 6X86.5	2	NIL	IS: 2062-92 Fe 410WA	#
1	CHAIN SIZE Ø 6.3-19PX475	1	NIL	IS: 2429 (PT-2)-70	#

WELD LENGTH		ITEM	DESCRIPTION & DIMENSIONS		QPASSLY	DETAIL DRG		MATL. & SPEC.		REMARKS	
NIL		M	GROUP	SEATS & UPPER BERTHS		SUPERSEDES: LE61219 ALT d					
WEIGHT		FILE \\LE61219e.prt (3D)									
0.985		KG		CHAIN ASSEMBLY							
S. AREA											
NIL		M ²		FOR TRANSVERSE MIDDLE BERTH							
LENGTH / Ø+A											
NIL		M		RAIL COACH FACTORY, KAPURTHALA				SCALE		SSE/REC	
WIDTH / THICK		M		रेल कोच फैक्टरी कपूरथला				1:2		CHD	
NIL		M						PL NO.		NIL	
HEIGHT		M		N.R.				DRN		DUGL	
NIL		M						DRG.NO.		LE61219	
				ADE/SME		DY.CME		CDE		ALT. e	
								SIZE A2		SHEET 1/1	

THIS DRAWING IS THE INTELLECTUAL PROPERTY OF RAIL COACH FACTORY, KAPURTHALA. THIS DRAWING SHOULD NOT BE REPRODUCED, ALTERED, USED FOR MANUFACTURING OF COMPONENTS, SOLD OR TRANSFERRED WITHOUT PERMISSION FROM CHIEF DESIGNING ENGINEER, RAIL COACH FACTORY, KAPURTHALA.

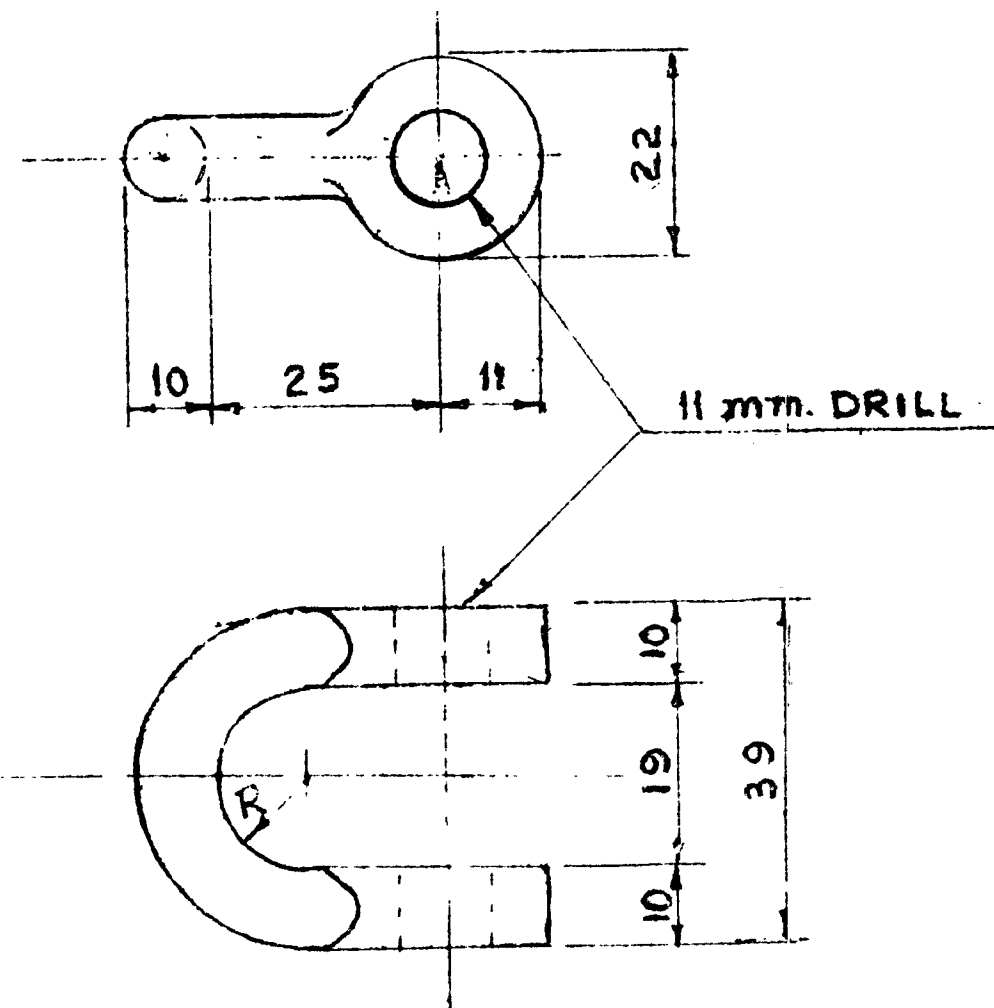
- NOTE: -
- # 1. CHAIN, END LINK AND SHACKLE SHOULD BE POWDER COATED TO IS: 13871-93, GRADE-C, COLOUR SHADE TO 'RAL-9006'.
 2. MANUFACTURE'S NAME AND DATE OF MANUFACTURE TO BE STAMPED AT THE LOCATION MARKED Ø IN LETTER SIZE OF 5 MM.
 3. STAINLESS STEEL ELECTRODE OF SAME COMPOSITION IS TO BE USED FOR WELDING.
 4. STAINLESS STEEL COMPONENT ITEM-8, 9 & 10 SHOULD HAVE STANDARD POLISHED SURFACE FINISH AS PER IS: 6911-92, TAB-8, FINISH NO. 4 AFTER WELDING.
 - * 5. COLOUR OF ITEM-3 SHOULD BE AS PER INTERIOR COLOUR SCHEME OF THE COACH.
 6. THE COMPLETE CHAIN IS TO BE COVERED BY THE REXINE AND STITCHED SUITABLY IN THE FINAL ASSEMBLY STAGE. REXINE COVER SHOULD HAVE ELEGANT FINISH.
 7. WELDED AREA OF STAINLESS STEEL ITEMS SHOULD BE PICKLED & PASSIVATED BEFORE SURFACE FINISH.
 8. ITEM-9 WHEN RIVETTED TO ITEM-8, SHOULD ROTATE FREELY.
 9. ALL SHARP EDGES TO BE ROUNDED OFF.

DETAIL DRGS STARTING WITH "LI" ARE INTERNAL REFERENCE LISTS ONLY AND ARE NOT FOR ISSUE
ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID.

FOR UNTOLERANCED DIMENSIONS REFER MDG0008 DATE OF FIRST ISSUE 22/04/2003 CGM BY

FRD

**FREELY INTERCHANGEABLE
WITH IRS C-79**



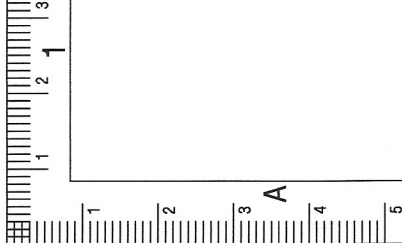
CA/KF-122	INTER BERTH CHAIN	
CA/KF-121	INTER BERTH CHAIN	
CA/KF-30	UPPER BUNK CHAIN	
WHERE USED	ASSEMBLY	DATE

I. R. S.

SHACKLE

C/CF-79

C/CF-79



16.03.2005

B

C

D

E

F

G

H

I

J

K

THIS DRAWING IS THE INTELLECTUAL PROPERTY OF RAIL COACH FACTORY, KAPURTHALA.
COMPONENTS, SOLD OR TRANSFERRED WITHOUT PERMISSION FROM CHIEF DESIGN ENGINEER,
RAIL COACH FACTORY, KAPURTHALA.

ANY MANUAL ALTERATION SHALL AUTOMATICALLY RENDER THIS DRAWING INVALID.

FOR UNTOLERANCED DIMENSIONS REFER MDG0008

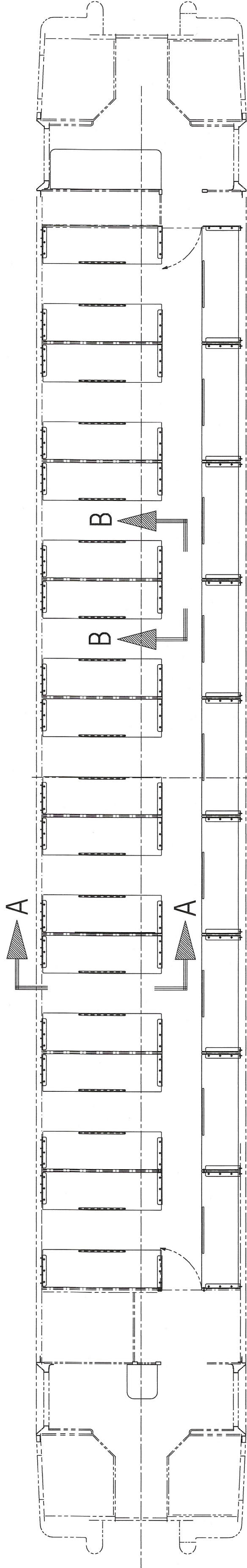
DATE OF FIRST ISSUE

17/05/2025

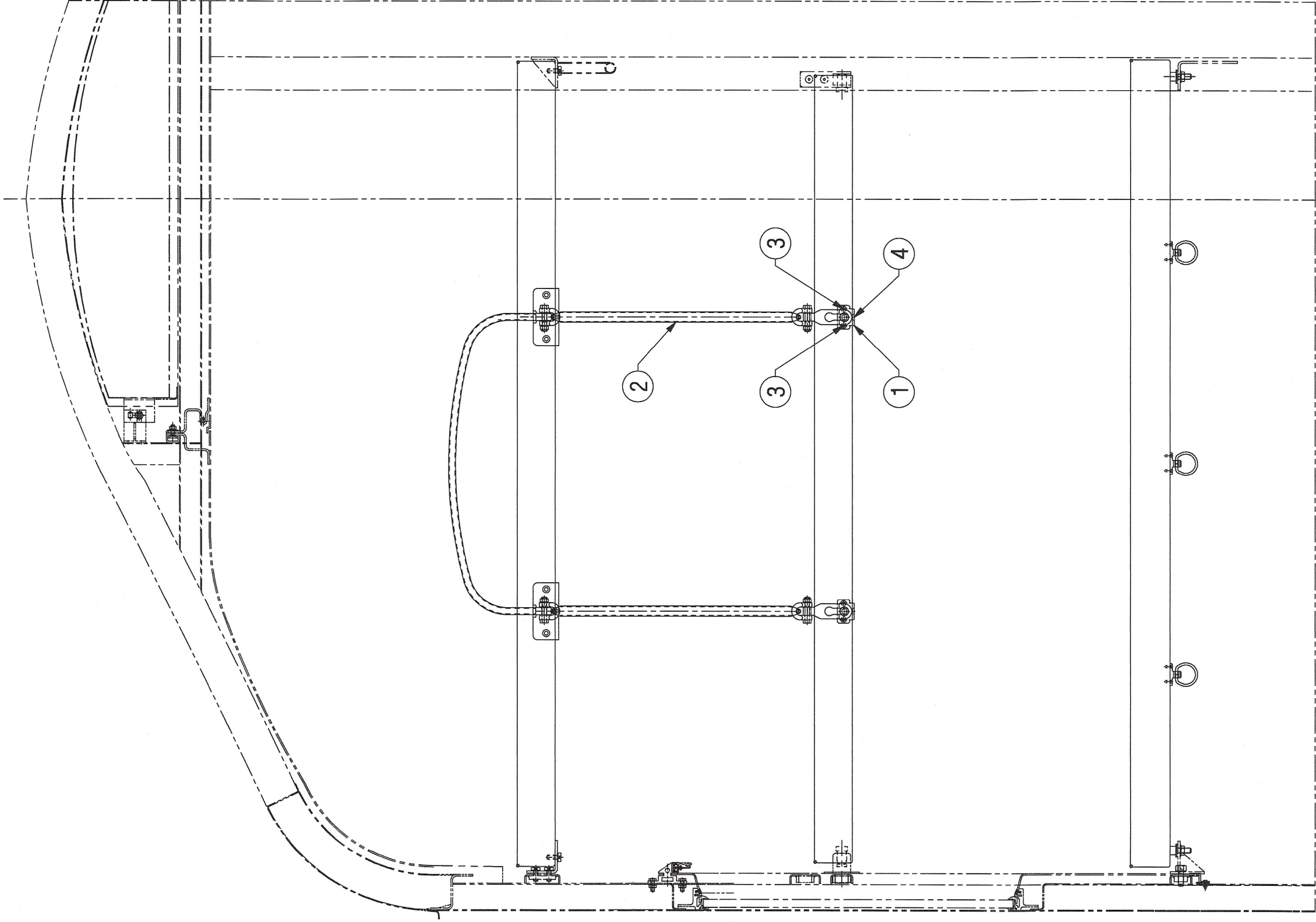
CGM BY

DETAIL DRGS STARTING WITH "LI" ARE INTERNAL REFERENCE LISTS ONLY AND ARE NOT FOR ISSUE.

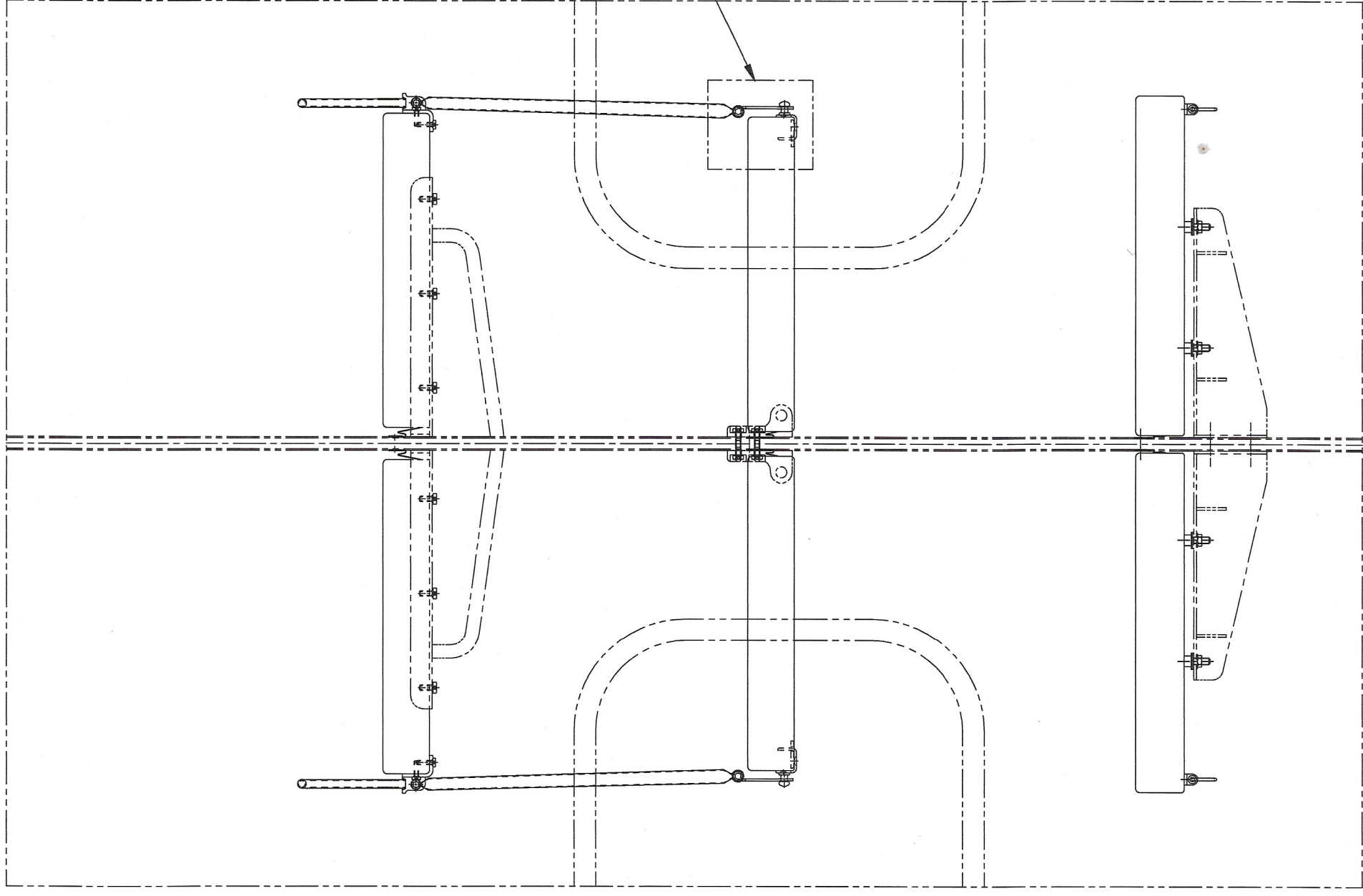
REFERENCE LAYOUT



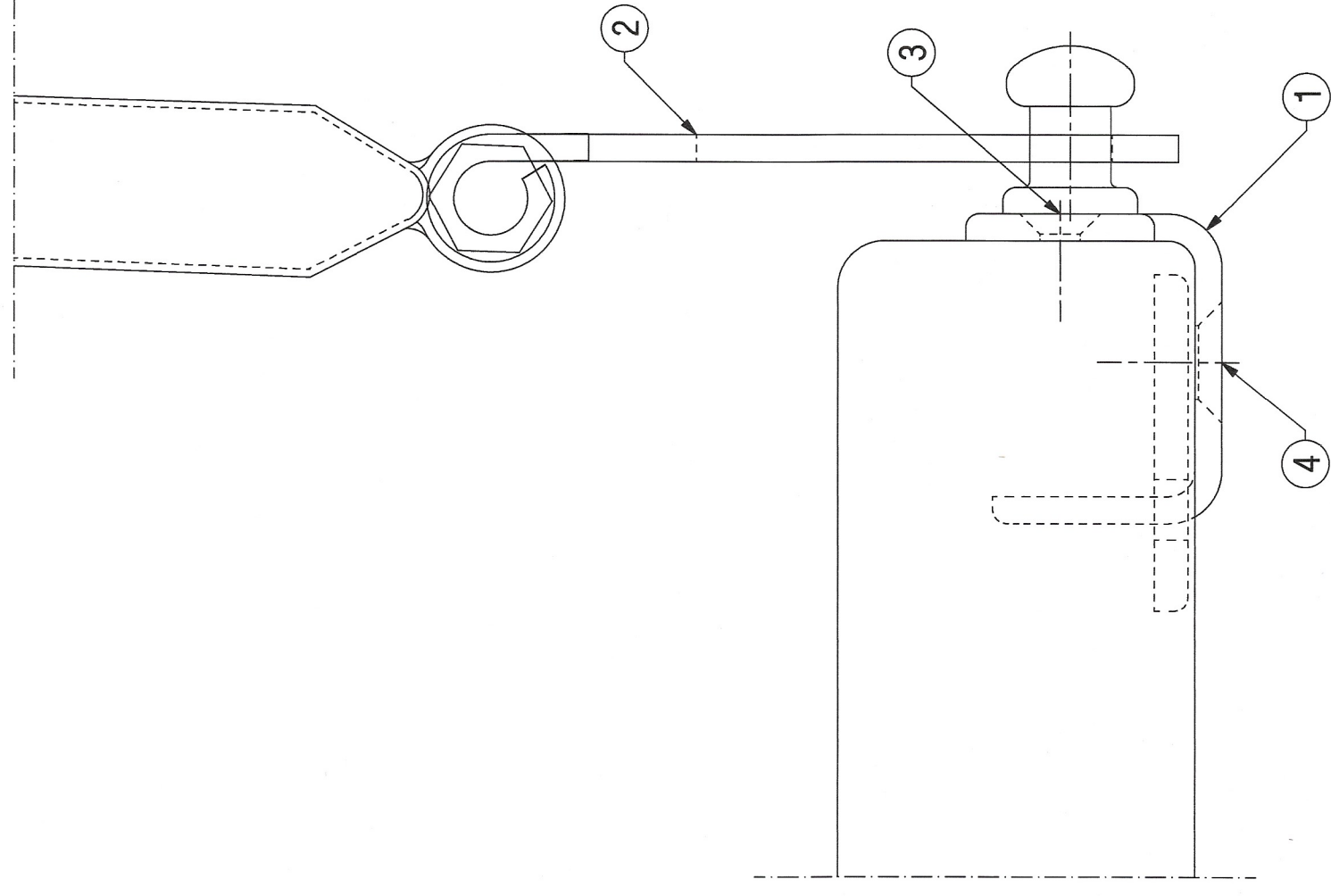
SECTION A-A



SECTION B-B



DETAIL AT 'X'



ALT. NO.	ALT. DATE	ZONE	ALTERATIONS	16	17	18	19
NIL	NIL	NIL	NIL				

AUTHORITY	18	19
NIL		

ITEM	DESCRIPTION & DIMENSIONS	OPASSLY	DETAIL DRG	MATL. & SPEC.	REMARKS
1	CHAIN ASSEMBLY	36	LEB1219	NIL	NIL
2	SLOTTED CSK HD SCREW M10X25 (A2-70 TO IS1365-2005)	36	NIL	IS: 1365-2005	NIL
3	CROSS RECESSED CSK HD TAPP (A2-70 TO IS1367-PT.1,14-84)	72	NIL	DIN 7982	NIL
4	SLOTTED CSK HD SCREW M10X25 (A2-70 TO IS1367-PT.1,14-84)	36	NIL	ISO 7050-83	NIL

WELD LENGTH	WEIGHT	S. AREA	NIL	SCALE	SS/REG
NIL	NIL	NIL	NIL	1:10	CHD
NIL	NIL	NIL	NIL	DRN	SKHD
NIL	NIL	NIL	NIL	REF. DRG. No.	NIL

PL NO.	PL NO.	PL NO.	PL NO.	PL NO.	PL NO.
DRG. NO. MI008250	DRG. NO. MI008250	DRG. NO. MI008250	DRG. NO. MI008250	DRG. NO. MI008250	DRG. NO. MI008250