

MDTS039 REV.1
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SCHEDULE OF TECHNICAL REQUIREMENTS FOR END STATIONION WITH STIFFENER ASSLY.

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SCHEDULE OF TECHNICAL REQUIREMENTS OF END STANCHION WITH STIFFENERS ASSEMBLY OF RCF TYPE COACHES

1. SCOPE:

This specification covers the technical requirements of End Stanchion with Stiffeners assembly for A.C. & non A.C. coaches to assembly drawings no. AE15148 alt.b., AE15149 alt.b., AE15128 alt.b., AE15134 alt.b., CC15318 alt.b., CC15319 alt.b., AW15108 alt.b., CC15272 alt.a., CC15291 alt.b., CC15305 alt.a., LB15117 alt.b. & LB15118 alt.b.

2.0 MATERIAL:

Material of the components as Stiffeners to drg. nos. CC15342 alt nil., CC15276 alt nil., CC15147 alt.a., CC15243 alt.c., CC15340 alt nil., CC15306 alt nil., CC15333 alt.a., Angles to drg. no. CC15341 alt nil & Top Closing Plate to drg. nos. CC15277 alt nil., CC15300 alt nil which are made up of corton steel to IRS:M41-93 may be manufactured from IS:5986-92 Fe 330. RCF will supply corton steel 5mm thick as raw material of width 1250mm. The firm should get approval of the cutting diagram before drawing the material for manufacturing.

3. QUALITY OF END STANCHION WITH STIFFENERS ASSEMBLY :

End Stanchion with Stiffeners assembly shall be fabricated either by MAG welding or by good quality electric arc welding and must be free from welding defects. Distortion and shrinkage losses must be avoided by suitable fabrication method using jigs and fixtures.

4. SAMPLING:

Pilot sample of End Stanchion with Stiffeners assembly to be offered to RCF for inspection. After approval and clearance of the sample bulk manufacturing is to be undertaken.

5. PROTECTION:

End Stanchion with Stiffeners assembly shall be protected as per RCF protection procedure order no. WI 100040.

6. PACKING:

End Stanchion with Stiffeners Assembly should be supplied in suitable packing so that no damage may occur during handling.

7. INSPECTION:

All Dimensions and tolerances to be maintained as per drawing.