

MDTS044 (REV - 1)
 DATED 10/04/97

SCHEDULE OF TECHNICAL REQUIRMENTS FOR END CONSTRUCTION ASSEMBLY.

NAME	DESIGNATION	SIGNATURE	DATE	LEVEL
MR. J P SINGH	SSE/CAD CAM	<i>J.P. Singh</i>	10/4/97	PREPARE
MR. H.S. SOHANPAL	ADE/D1	<i>H.S. Sohanpal</i>	10/4/97	AGREE
MR. H.S. SOHANPAL	for Dy. CME/D	<i>H.S. Sohanpal</i>	10/4/97	REVIEW
MR. A.K. KANSAL	CDE	<i>A.K. Kansal</i>	10/4/97	APPROVE

ISSUE	DETAILS OF CHANGE	DATE
0.0	FIRST ISSUE	05/03/97
1.0	In para 1, under heading scope : drg no's deleted. : In para 5 under heading protec- : tion 'All over except area marked: : "Not to be painted and should be : covered with protective tape : before painting " as shown in drg : no MI000676 has been added.	10/04/97

PREPARED BY : *J.P. Singh*

AGREED BY : *H.S. Sohanpal*

SCHEDULE OF TECHNICAL REQUIREMENTS OF END CONSTRUCTIONS ASSEMBLY
FOR AC & NON AC COACHES

1. SCOPE: This specification covers the technical requirements of End Constructions for AC coaches and Non AC coaches.
2. MATERIAL: Material of the components which are made up of corten steel to IRS.M.41-93 may be manufactured from IS: 2062-92, Fe 410 Wc. for sheet thickness greater than & equal to 5mm and IS:5986-92 Fe 330 for sheet thickness less than 5mm.
3. QUALITY OF END CONSTRUCTION ASSEMBLY : End Construction Assembly shall be fabricated either by MAG welding or by electric arc welding and must be free from welding defects. Distortion and shrinkage must be avoided by suitable fabrication method using jigs and fixtures.
4. SAMPLING: Pilot sample of End Construction to be offered to RCF for inspection. After approval and clearance of the sample bulk manufacturing is to be undertaken.
5. PROTECTION: End Construction Assembly shall be protected as per RCF protection procedure order no. WI 100040 all over except area marked "Not to be painted and should be covered with protective tape before painting" as shown in drg no MI000676.
6. PACKING: End Construction Assembly should be supplied in suitable packing /pallet so that no damage may occur during handling and transit.
7. INSPECTION: All Dimensions and tolerances to be maintained as per drawing.

H. S. Sibalpal