



▽ ROUGH MACHINED		01	ROUGH CLEANING	ALTERATIONS	
▽▽ FINISH MACHINED		18	CHAMFERED	(b) 02/2012	
▽▽▽ FINE FINISH MACHINED		01b	BURRS REMOVED	TOLERANCE ON DIM.18 & 94 ALTD. FROM ±3 & ±2 TO +3/-0 & +0/-2 RESPECTIVELY. DIM.4 ALTD. TO 6. NOTE-1 TO 3, MAT. SPEC. IN REMARKS 'FOR 125x292 APPROX' AND ASSY. DRG. NOS. T-0-3-670 & EMU/M-0-3-094 ADDED.	
		92	DIE FORGED	-sd- 10-02-2012 SSE/D SME/DSD	
M1		13/4/2017	LATEST ICF DRG. ALT. 'd' UPDATED ECN No.94310001	VVS	(c) 05/2012 NOTE-1 REVISED. -sd- 24-05-2012 SSE/D AME/D
				MVR	(d) 01/2014 " HARDNESS VALUE 120-130 BHN " IN NOTE-1 DELETED. IN MAT. SPEC. YEAR 92 ADDED. SSE/D AME/D

- NOTE:
- FORGED GUIDE SHALL BE NORMALISED SO AS TO OBTAIN GRAIN SIZE OF ASTM 6 -8.  
THERE SHOULD NOT BE ANY DISTORTION AFTER THE PROCESS OF NORMALISING.
  - NORMALISED GUIDES SHALL BE GRIT BLASTED TO REMOVE SCALES ETC.
  - THIS FORGING IS COMMON FOR FINISH MACHINED GUIDE TO DRG. NOS.  
T-0-3-670 & EMU/M-0-3-094.

\$ ALL TYPES OF COACHES

	16	GUIDE	1		IS:1875-92 CL-2	24 kg approx	FROM Ø125x292 APPROX.		
QTY		DESCRIPTION & DIMENSION	ITEM	REF.DRGS	MAT.SPEC	WEIGHT/UNIT	REMARKS		
2	1	GROUP: 0-3				SUPERSEDED BY:			
PER COACH	GUIDE  AS FORGED					SUPERSEDES ICF/J&T/SK/FORGE-0-3-201 ALT c/-			
						SCALE	SSE/D	M. Sabapathy	
						1:1	CHD		
							ALTD	S.N.Karthikeyan	
							DRN	R.Muralidar	
						Alpha Alt:- d			
	DATA CODE NO.	INDIAN RAILWAY STANDARDS			SHEET	INTEGRAL COACH FAC CHENNAI-3E			
	246				1 OF 1	ICF/J&T/SK/FORGE-0-3-201			

T-0-3-670	
EMU/M-0-3-094	
ASSEMBLY DRAWINGS	
06-01-2014	28-08-2001
0	Num. Alt.
DATE OF LATEST ALT	DATE OF FIRST ISSUE
AME/SME	