

Retro fitment procedure for double side swing IC door for AC coaches

Double side swing IC door to drg. No.ICF/SK₃-5-6-014 shall be provided in all AC 2 /AC 3 tier coaches as a safety measure for evacuation of passengers during emergencies and ease of entry/exit during normal travel.

The following procedure is to be adopted in order to retrofit the swing doors by Workshops/Zonal Railways:

(A) PROCEDURE FOR ICF AC/2T AND AC/3T COACHES:

(I) Pre fitment procedure for door as indicated at A to drg. no. ICF/SK3-5-6-015.

- (a) Door fixing channel welded with square tube to be removed.
- (b) The removed portion on the square tube shall be ground.
- (c) The gap between square tubes shall be 576 mm (minimum)
- (d) Partition with cubicle door shall be shifted by 30 mm towards linen room as shown in the drawing.
- (e) Touchup painting with ROZ primer to spec. IS: 2074-92 shall be done wherever necessary followed by final painting as per interior colour scheme.

(II) Pre fitment procedure for door as indicated at B to drg. no. ICF/SK3-5-6-015.

- (a) Door fixing channel welded with square tube to be removed.
- (b) The removed portion on the square tube shall be ground.
- (c) The gap between square tubes shall be 576 mm (minimum).
- (d) Touchup painting with ROZ primer to spec. IS: 2074-92 shall be done wherever necessary followed by final painting as per interior colour scheme.

(III) Fitment procedure for door:

- (a) Modular Double side swing IC door to drg. No.ICF/SK₃-5-6-014 shall be placed between square tubes.
- (b) Alignment shall be taken care while fixing the door.
- (c) Door with frame assembly shall be fixed from the lavatory side only.
- (d) Thus, 180 deg. position of the opened door on both sides shall align as shown in the drawing.
- (e) The pivot side shall be ensured as mentioned in location of door to drg.No.WGSCWAC₇-5-6-701.

- (f) The SS door fixing frame shall be screwed with raised counter sunk screws to Spec.IS:7169-74, TYPE-B of size M5x25 with material spec.IS:1367-84 P (14) grade A2-70.

(B) PROCEDURE FOR RCF AC-3T COACHES :

(I) Pre fitment procedure for door as indicated at A to drg. No. ICF/SK₃-5-6-019.

- (a) Existing door fixing channel welded with square tube on pivot side to be removed.
- (b) The removed portion on the square tube shall be ground.
- (c) The gap between square tube and door fixing channel (non-pivot side) shall be 576 mm (minimum).
- (d) Electrical cubicle partition shall be shifted by 50 mm towards linen room.
- (e) Touchup painting with ROZ primer to spec. IS:2074-92 shall be done wherever necessary followed by final painting as per internal colour scheme.

(II) Pre fitment procedure for door as indicated at B to drg. No. ICF/SK₃-5-6-019

- (a) Existing door fixing channel welded with square tube on pivot side to be removed.
- (b) The removed portion on the square tube shall be ground.
- (c) The gap between square tube and door fixing channel (non-pivot side) shall be 576 mm (minimum).
- (d) Linen room partitions in the doorway shall be shifted by 50 mm towards linen room sidewall.
- (e) Touchup painting with ROZ primer to spec. IS:2074-92 shall be done wherever necessary followed by final painting as per internal colour scheme.

(III) Fitment procedure for door:

- (a) Modular bi-directional swing door to drg. No.ICF/SK₃-5-6-014 shall be placed between square tube and channel with square tube.
- (b) Alignment shall be taken care while fixing the door.
- (c) Door with frame assembly shall be fixed from the lavatory side only.
- (d) Thus 180 deg. position of the opened door on both sides shall align as shown in drg.
- (e) The pivot side shall be ensured as mentioned in location of door drawings.
- (f) The SS door fixing frame shall be screwed with raised counter sunk screws to Spec. IS: 7169-74, Type B Fig-1, Type-H of size M5 x 25 with material Spec. IS:1367-84 P(14) grade A2-70.