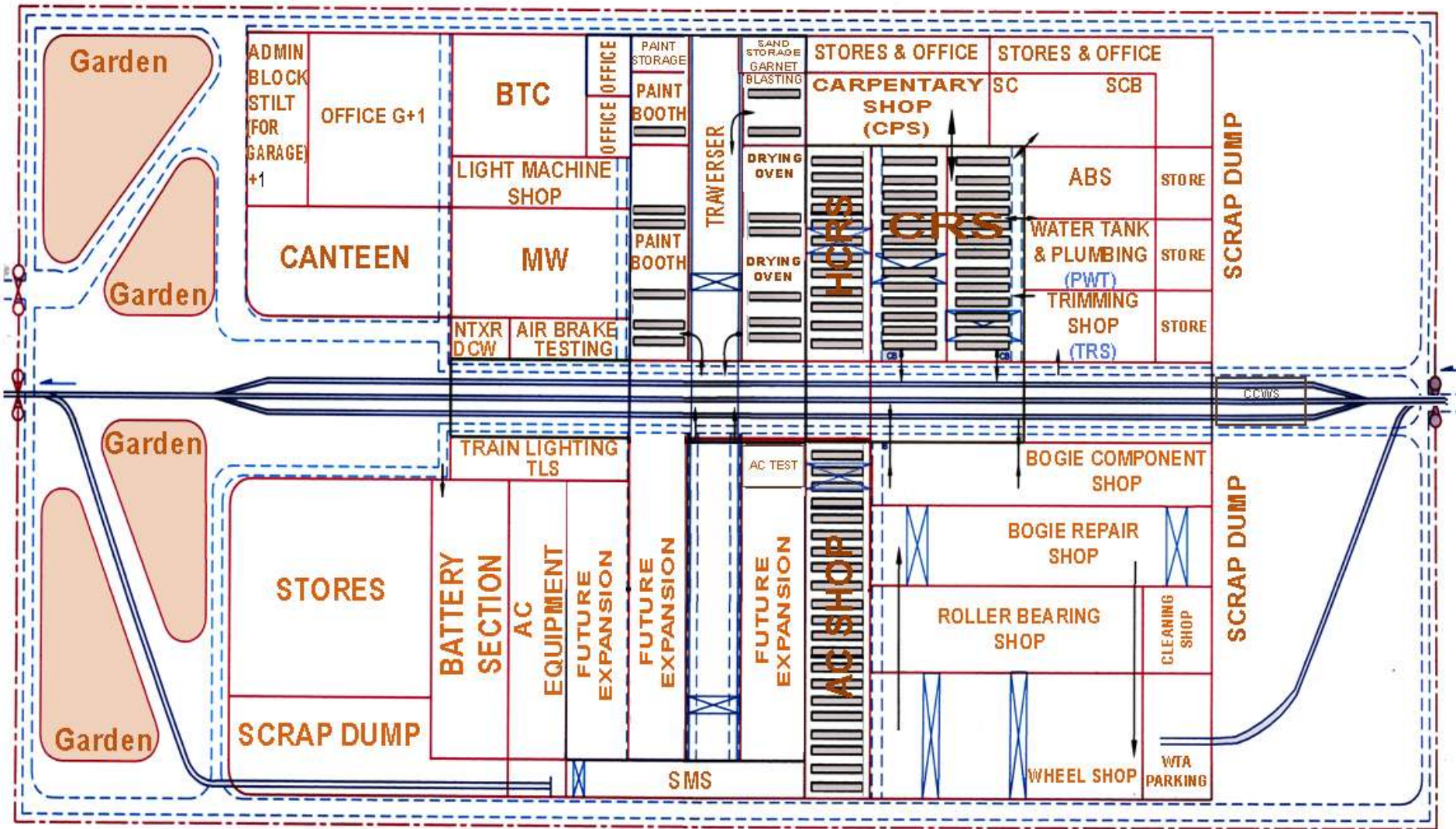


Placement of coaches in CCWS (COACH CLEANING)

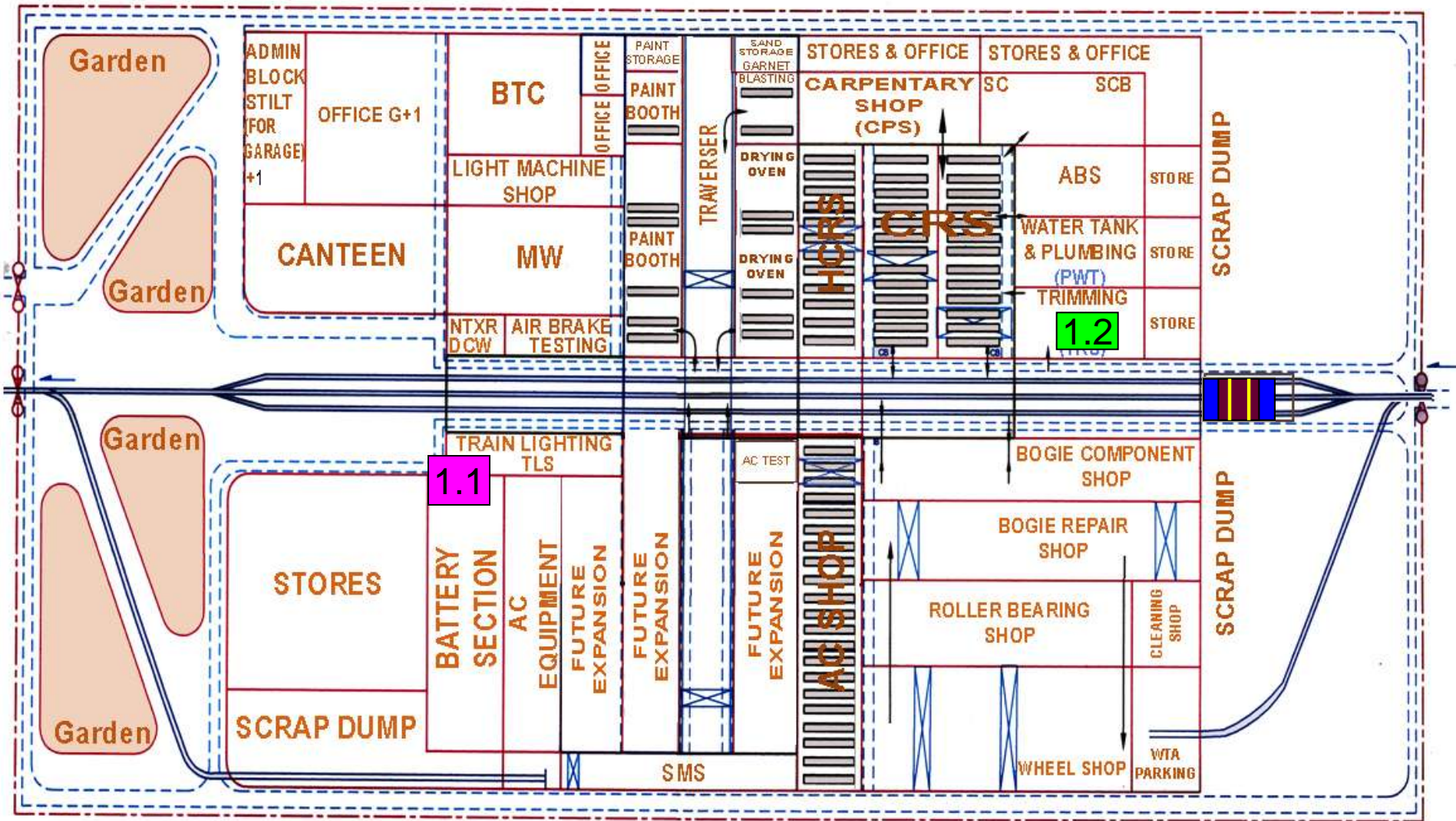


1.1

Removal of Batteries and other TL fitting and their dispatch (ICS)

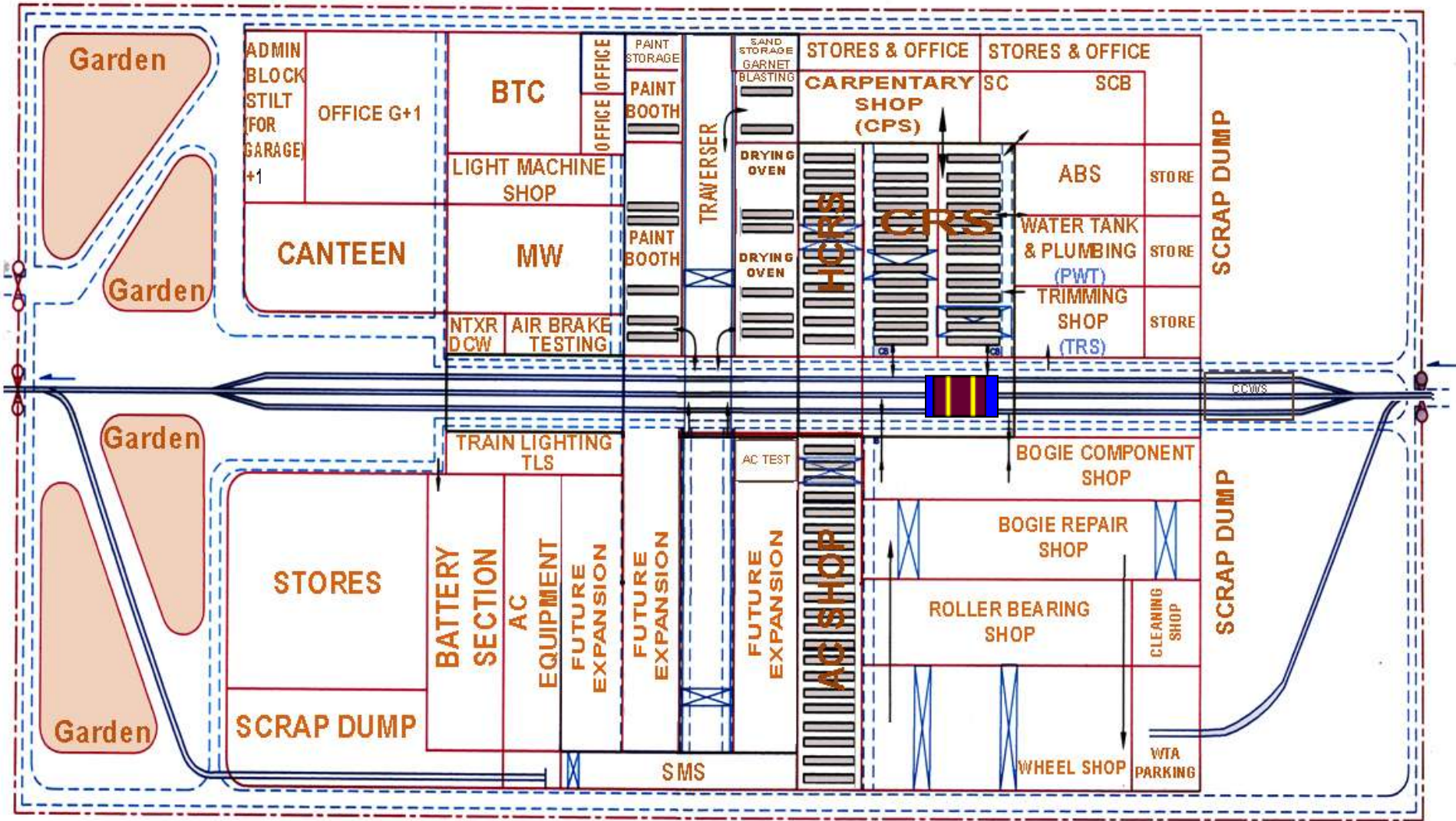
1.2

Removal of berths and dispatch to Trimming Shop (ICS)

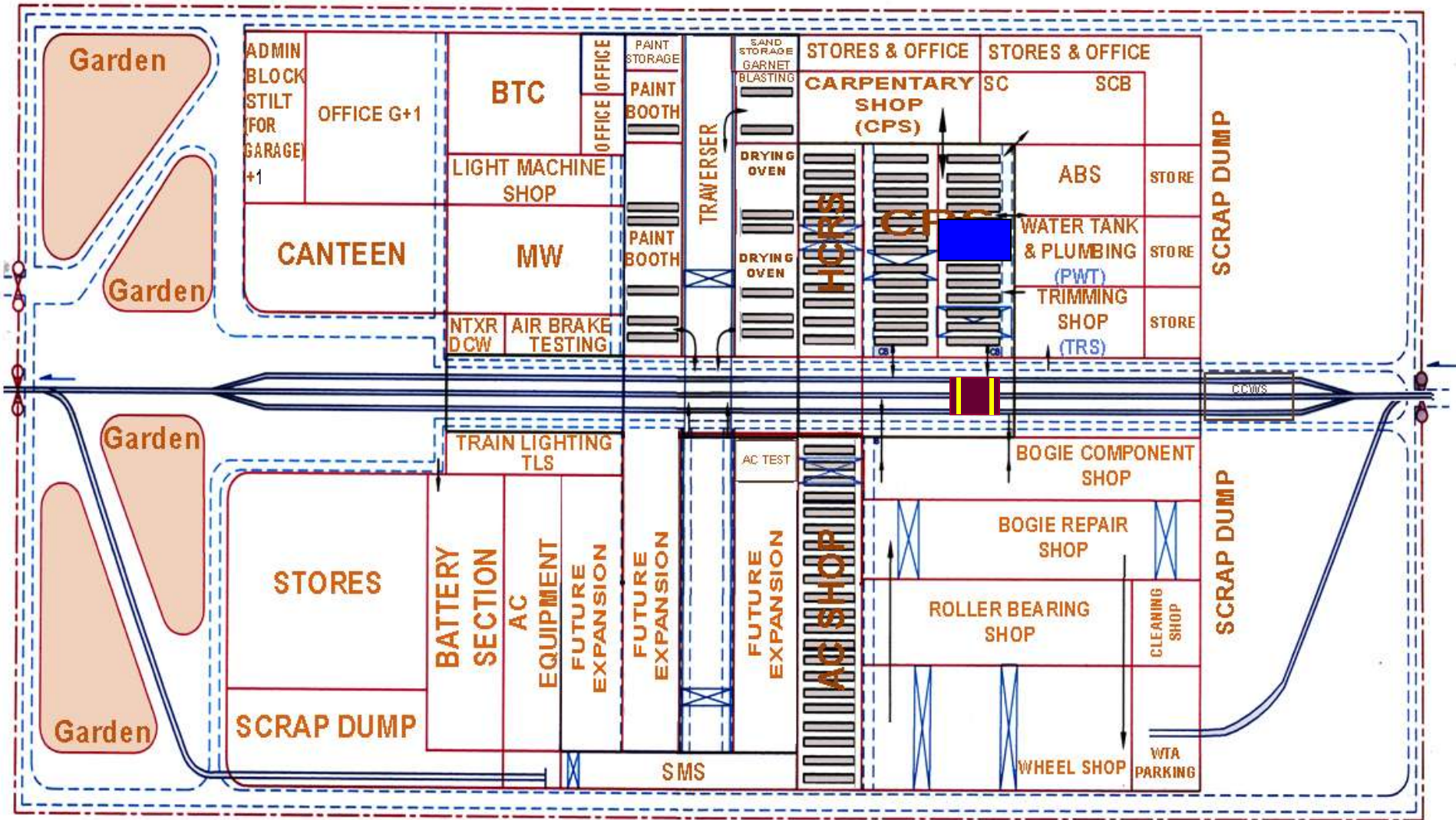


Placement of coaches in lowering/lifting Section of CRS (Carriage Repair Shop)

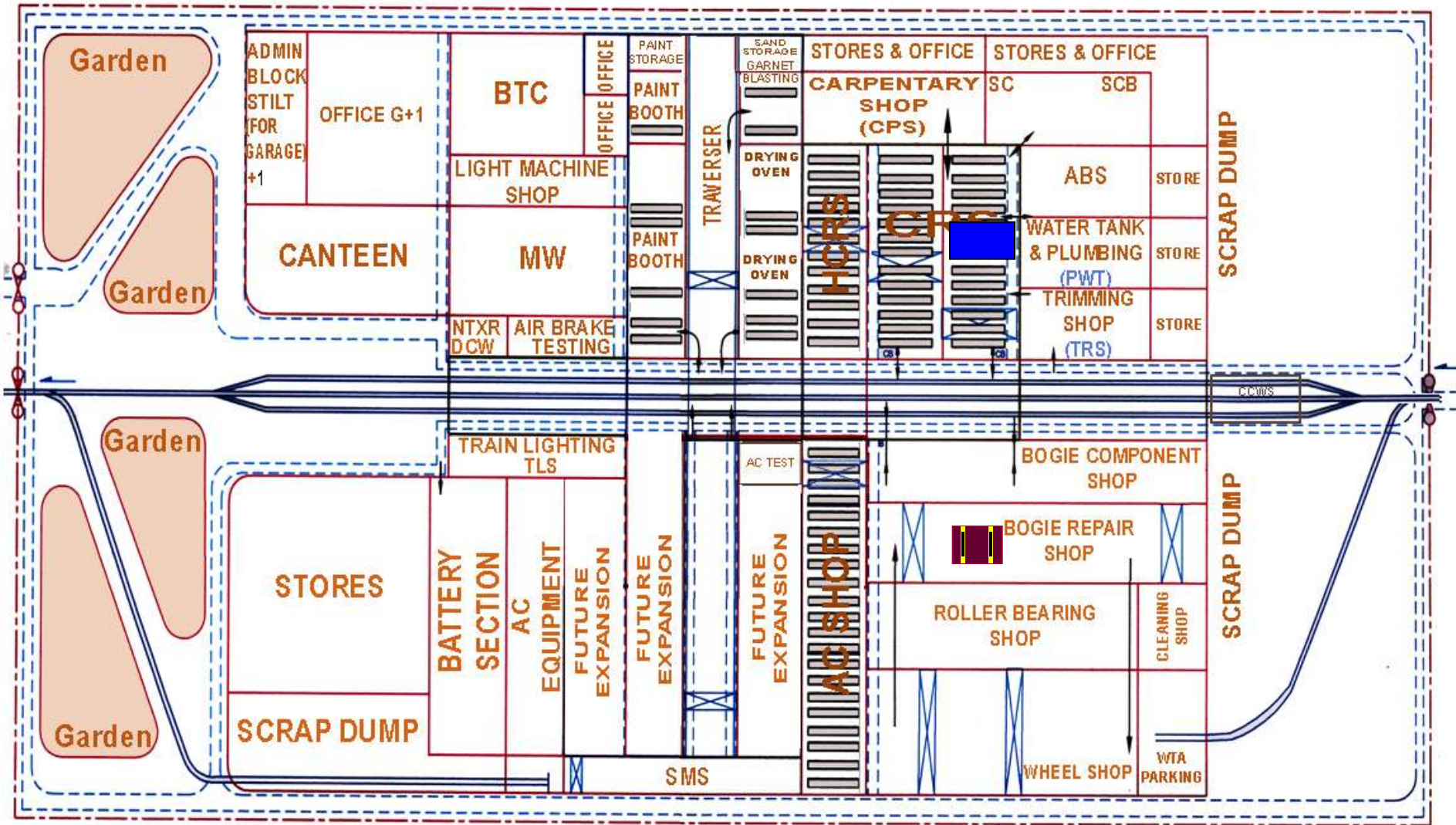
Lifting of coach body and its placement on trussel in CRS Shop



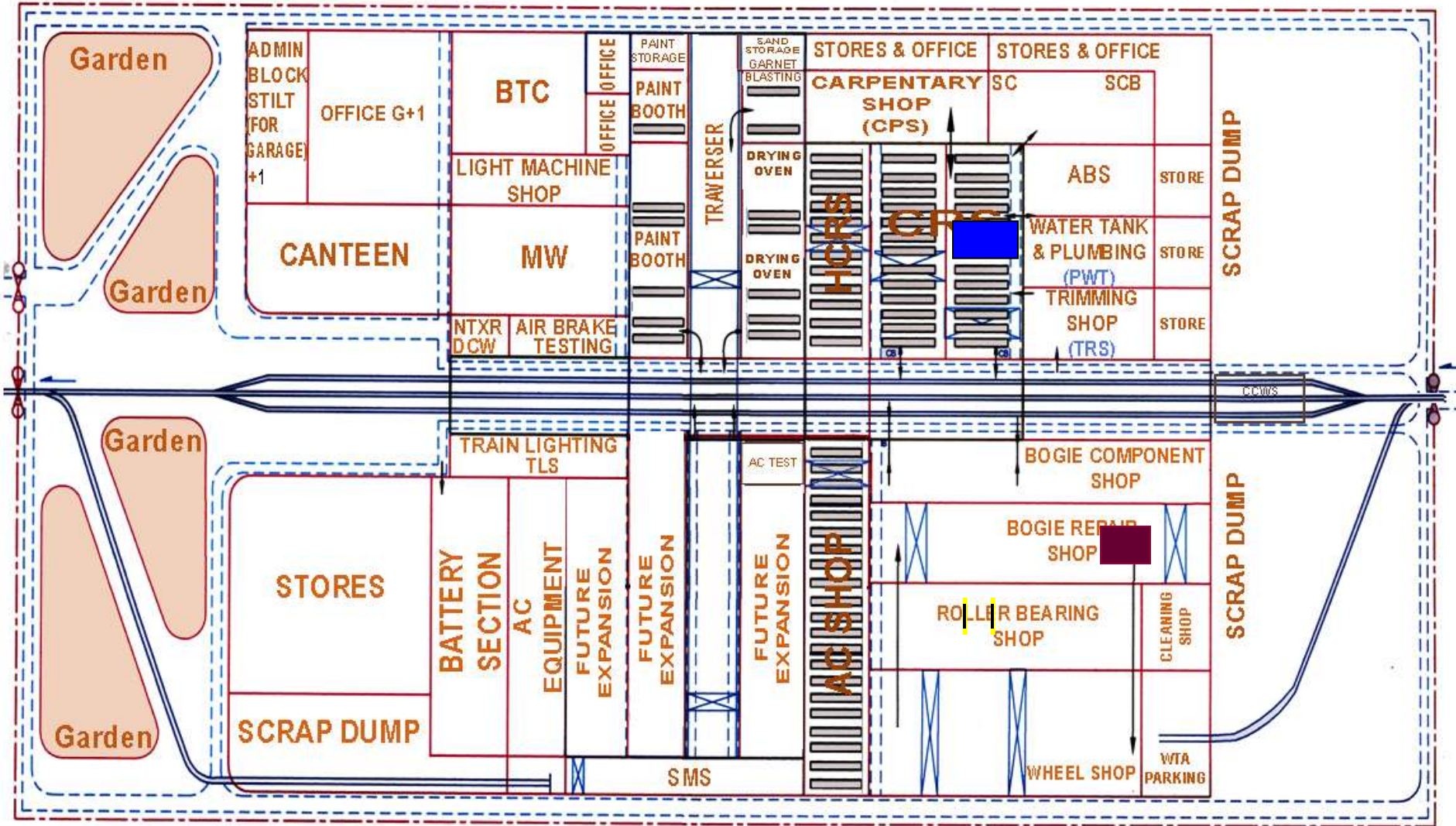
Despatch of Bogies to Bogie Repair Shop,



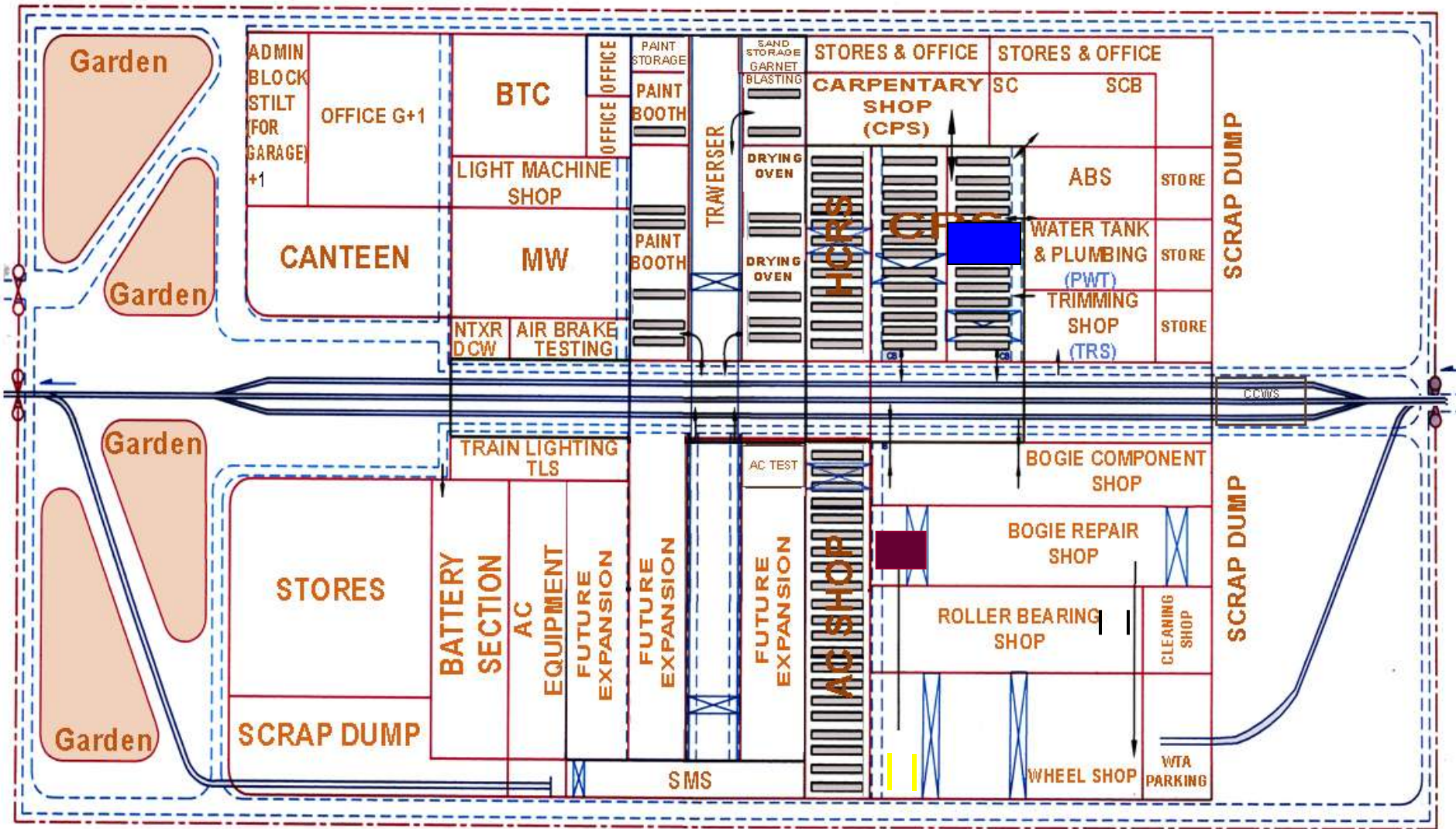
Stripping and sending Alternator to TL shop, Bogie Components to BCS Shop.
 Stripping and sending brake beam, bogie frame & bolster for shot blasting.



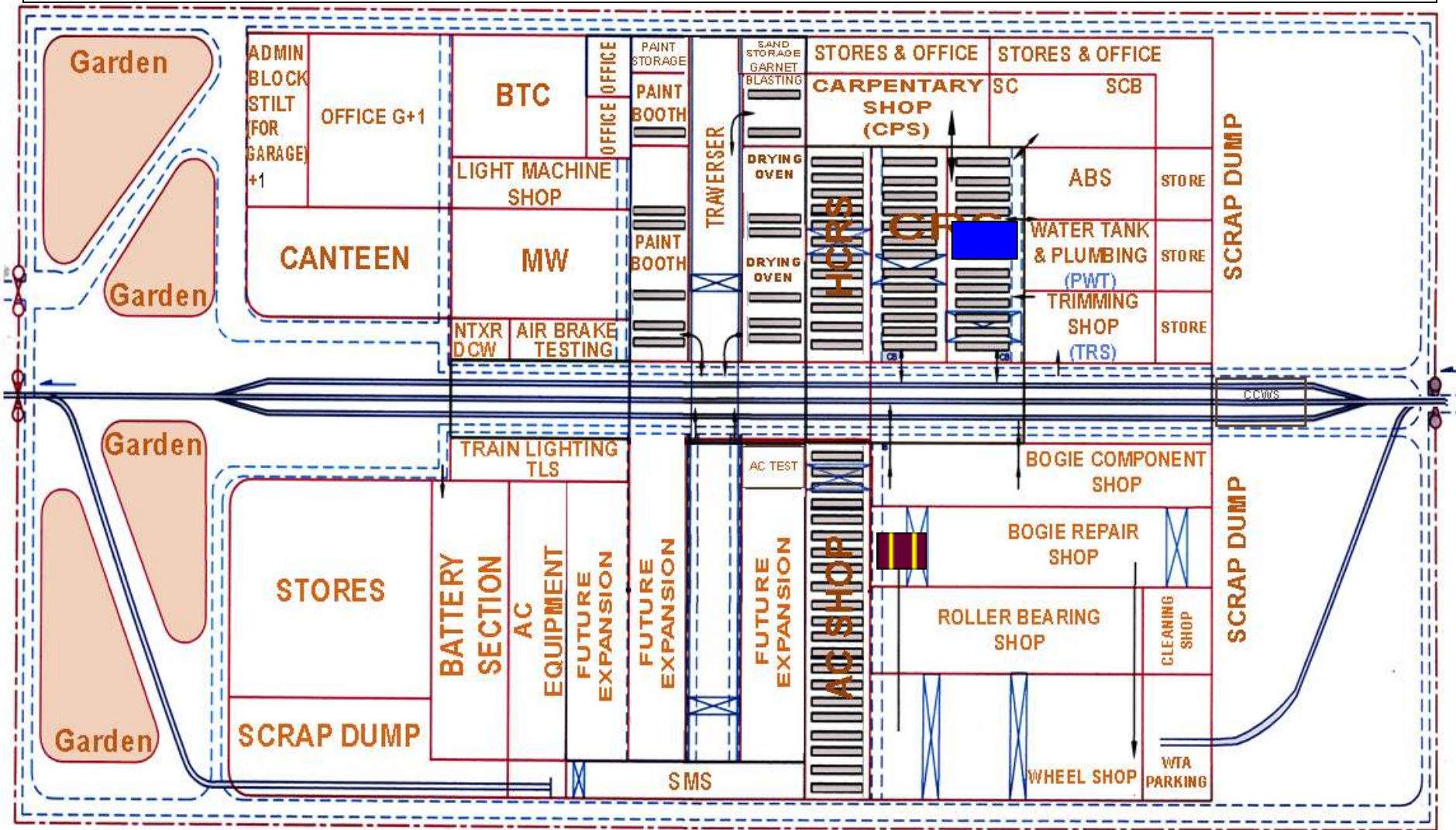
Dismantle axle box and bearing from the wheel set.
Wheel set to Wheel Shop for Attention.



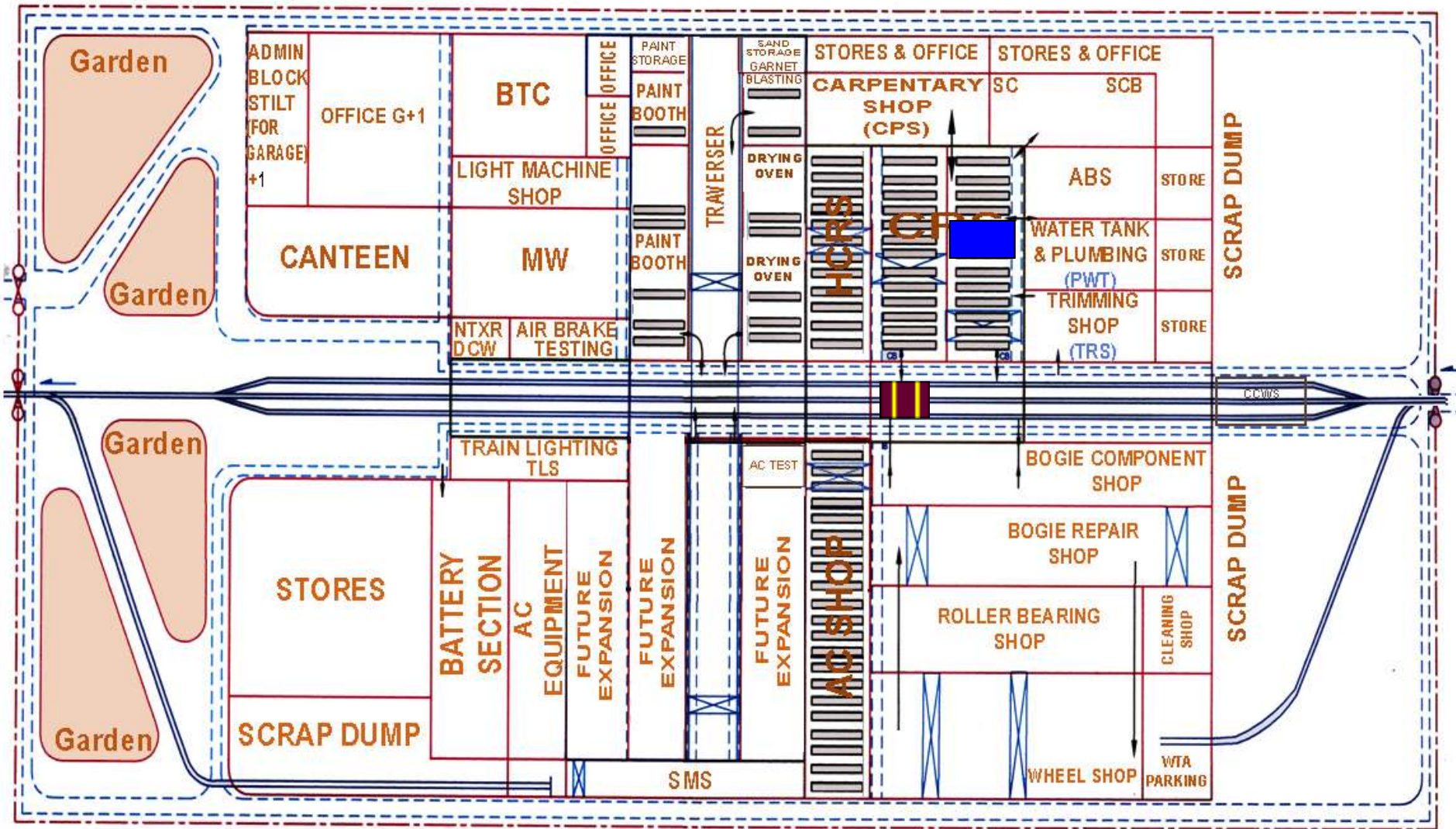
Mounting of Bearing and axle Box on Wheel Set.



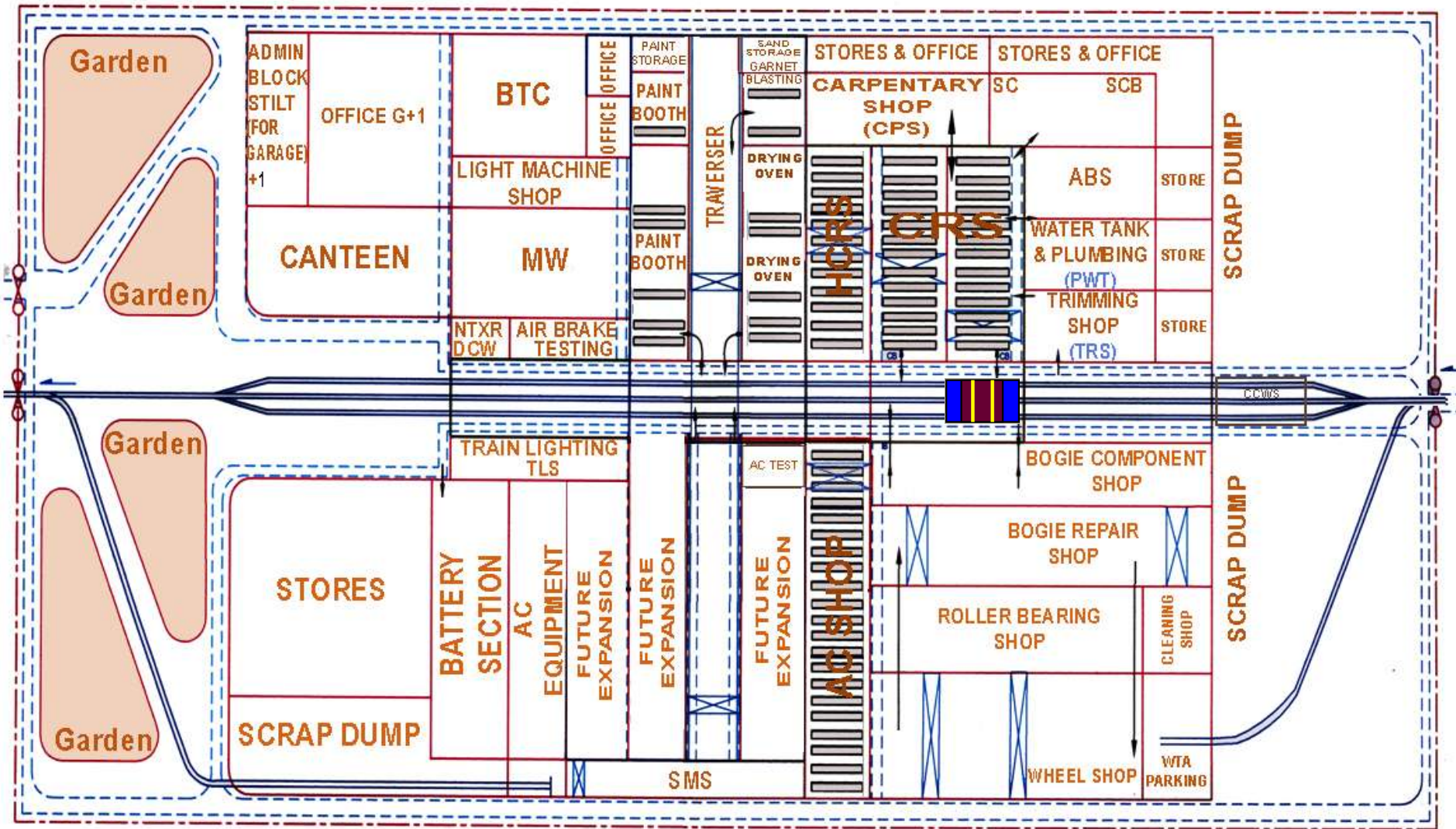
Assembled bogie at CRS



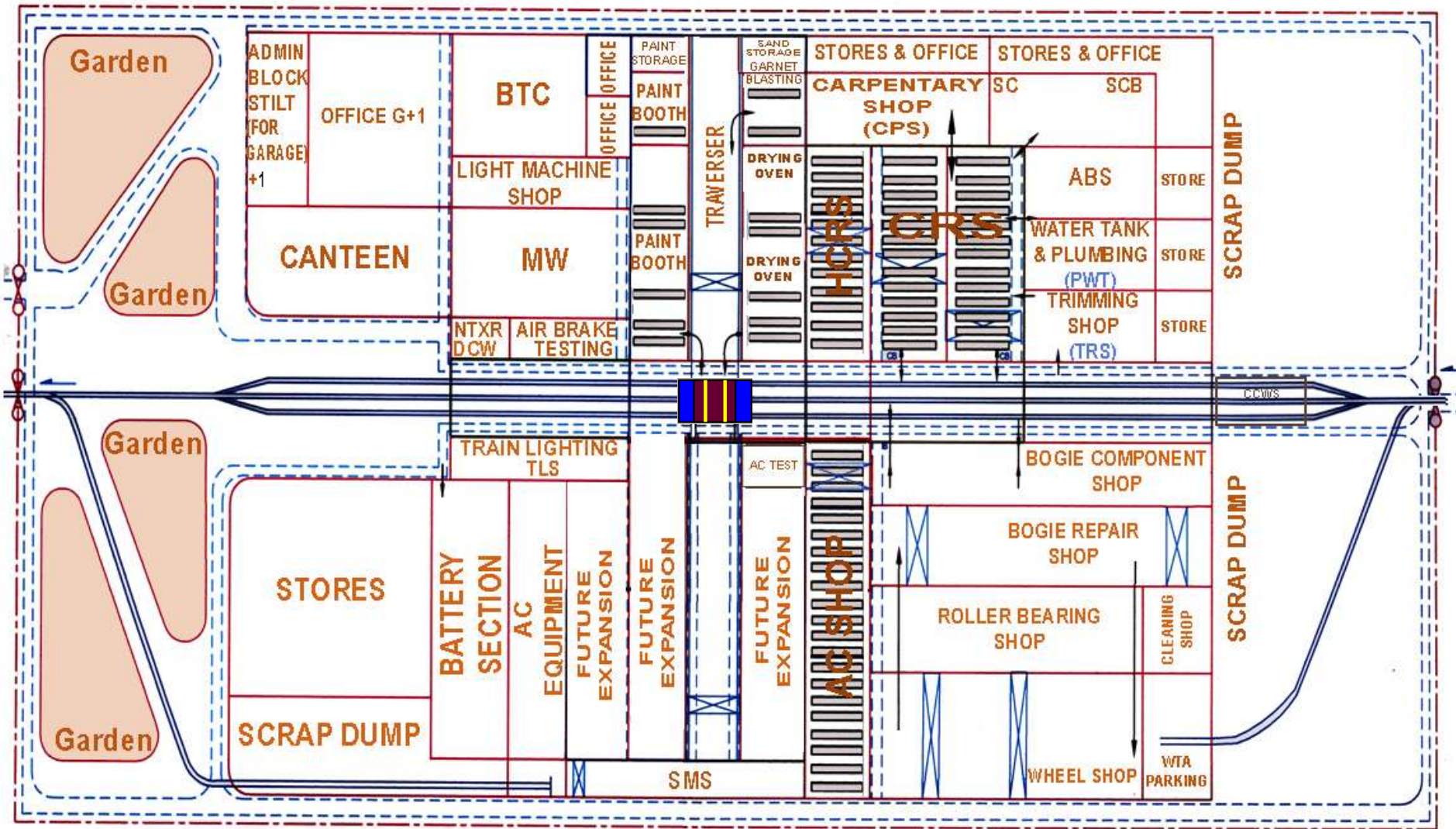
Moving of Bogie and lowering of coach body.



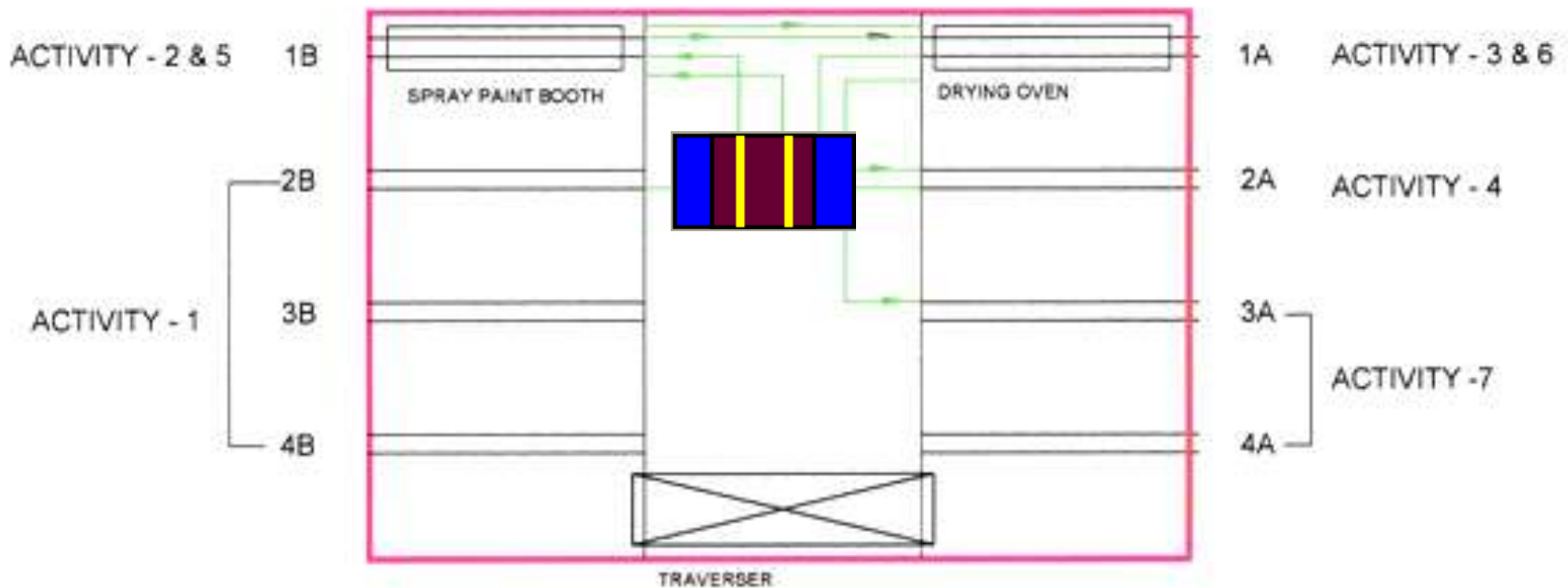
Pushing coaches to traverser for paint shop



Placement of coach using traverser in Paint Shop

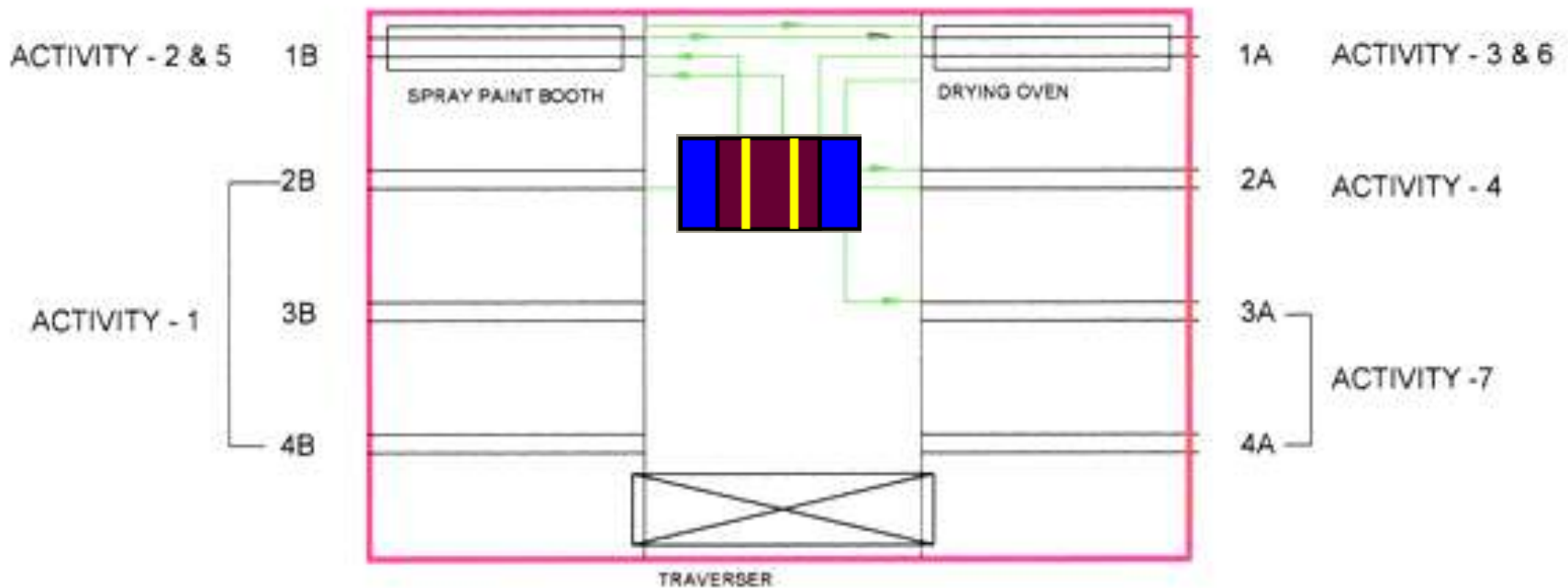


Placement of Coach in one of the line for wet rub down and masking



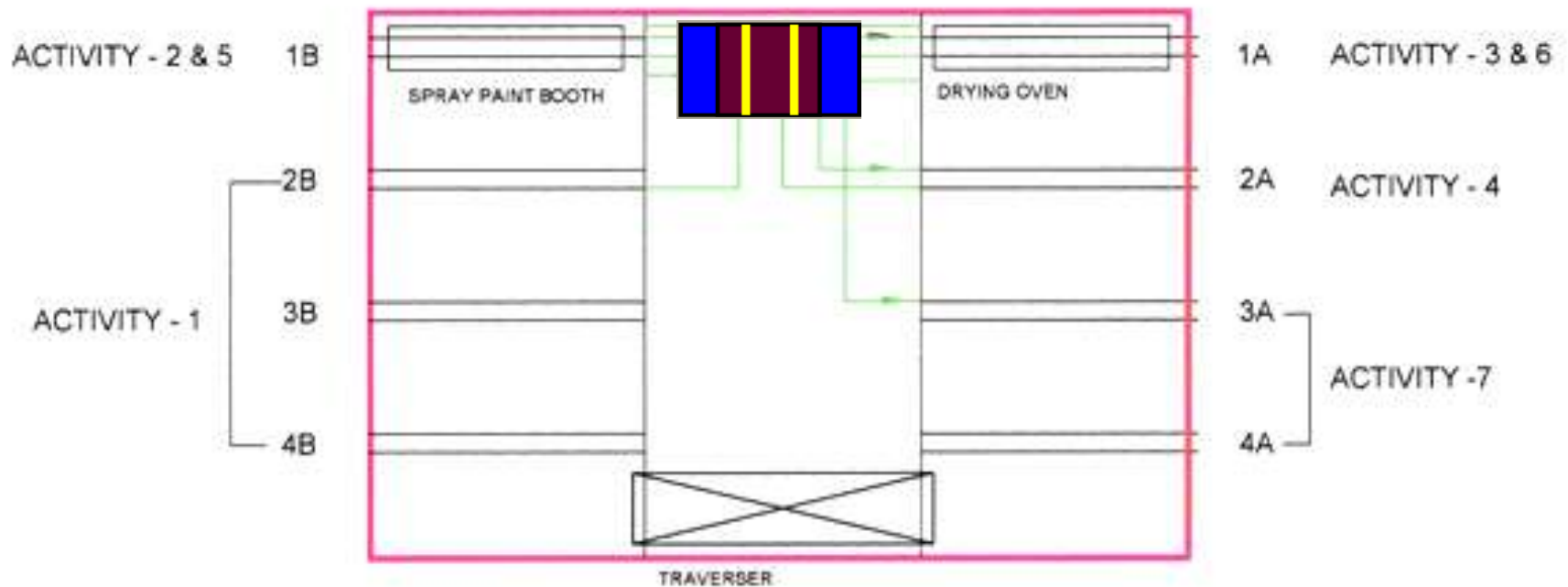
NO	ACTIVITY	TIMING FOR 1 COACH	TIMING FOR 5 COACHES	OPERATION	BERTHING LOCATION
1	WET RUB DOWN	4 HRS	20HRS	MANUAL	3 (LINE 2B,3B &4B)
2	FINAL COAT PU PAINT APPLICATION-UPPER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
3	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
4	MASKING TOP PORTION	30 min	2.5 HRS	MANUAL	1 (LINE 2 A)
5	FINAL COAT PU APPLICATION- LOWER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
6	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
7	LETTERING ETC	2 HRS	10 HRS	MANUAL	1 (LINE 3A & 4A)

Placement of Coach in paint booth for painting upper portion



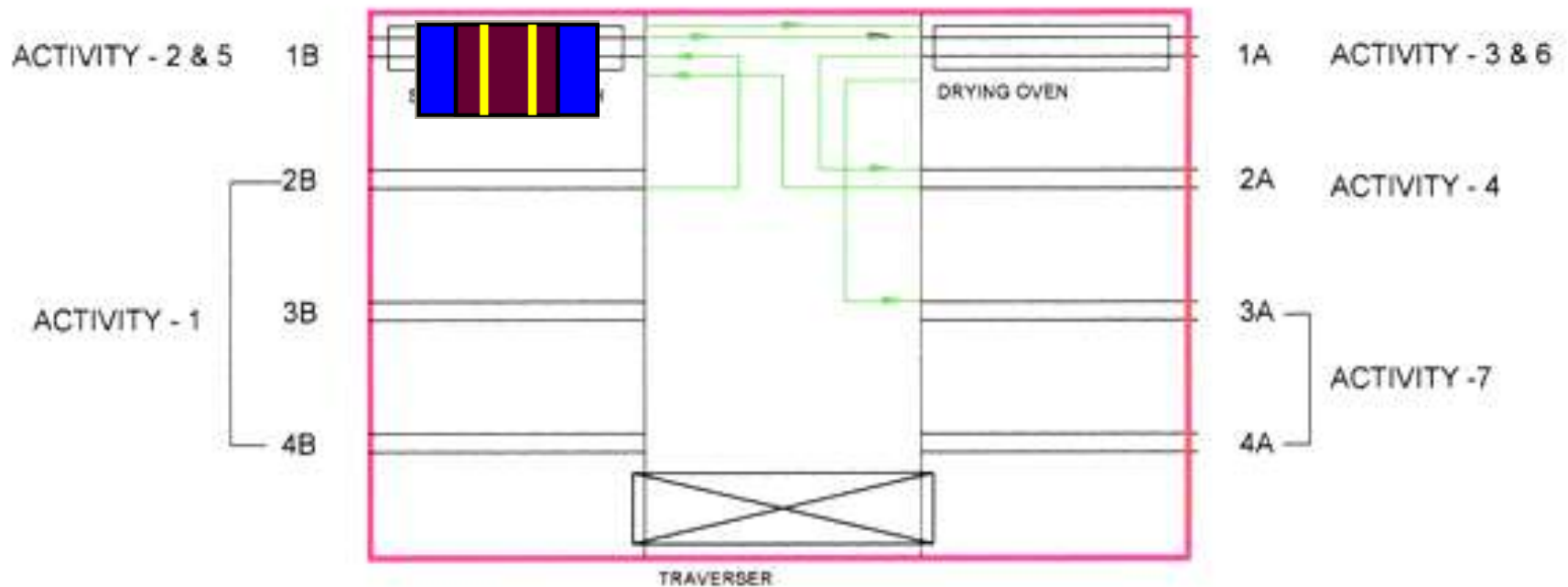
NO	ACTIVITY	TIMING FOR 1 COACH	TIMING FOR 5 COACHES	OPERATION	BERTHING LOCATION
1	WET RUB DOWN	4 HRS	20HRS	MANUAL	3 (LINE 2B,3B &4B)
2	FINAL COAT PU PAINT APPLICATION-UPPER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
3	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
4	MASKING TOP PORTION	30 min	2.5 HRS	MANUAL	1 (LINE 2 A)
5	FINAL COAT PU APPLICATION- LOWER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
6	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
7	LETTERING ETC	2 HRS	10 HRS	MANUAL	1 (LINE 3A & 4A)

Placement of Coach in paint booth for painting upper portion



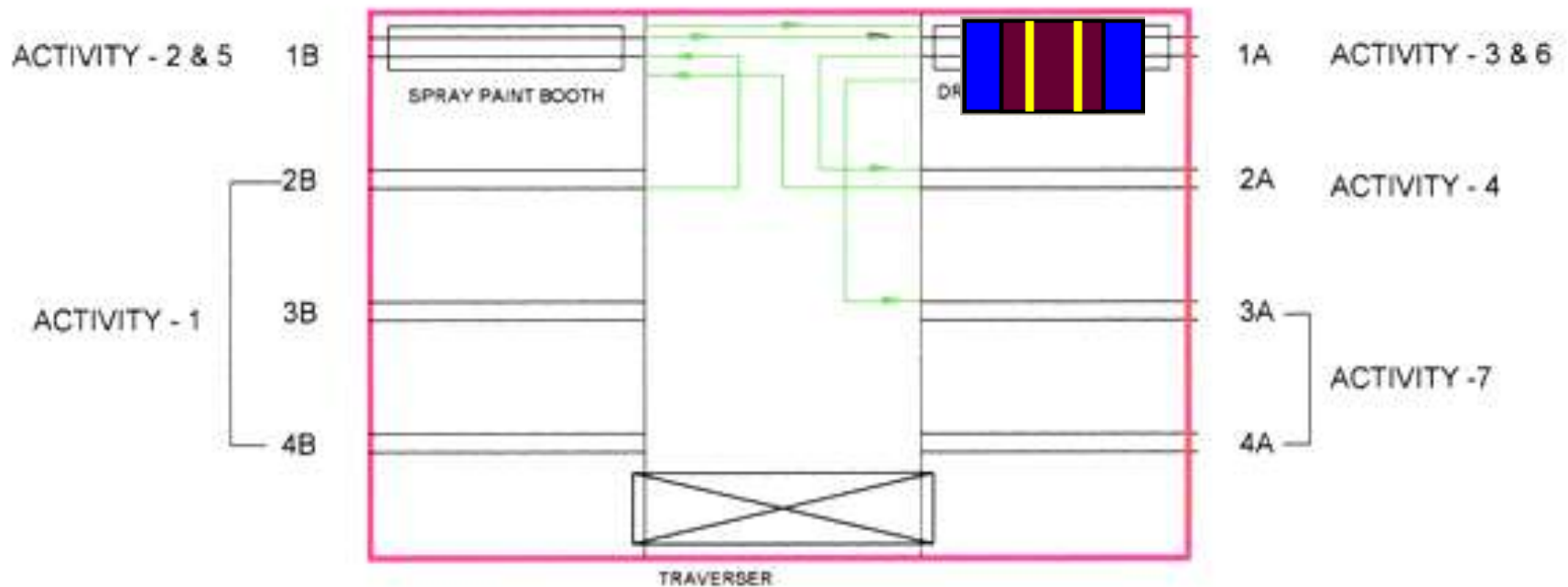
NO	ACTIVITY	TIMING FOR 1 COACH	TIMING FOR 5 COACHES	OPERATION	BERTHING LOCATION
1	WET RUB DOWN	4 HRS	20HRS	MANUAL	3 (LINE 2B,3B &4B)
2	FINAL COAT PU PAINT APPLICATION-UPPER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
3	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
4	MASKING TOP PORTION	30 min	2.5 HRS	MANUAL	1 (LINE 2 A)
5	FINAL COAT PU APPLICATION- LOWER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
6	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
7	LETTERING ETC	2 HRS	10 HRS	MANUAL	1 (LINE 3A & 4A)

Placement of Coach in Drying Owen



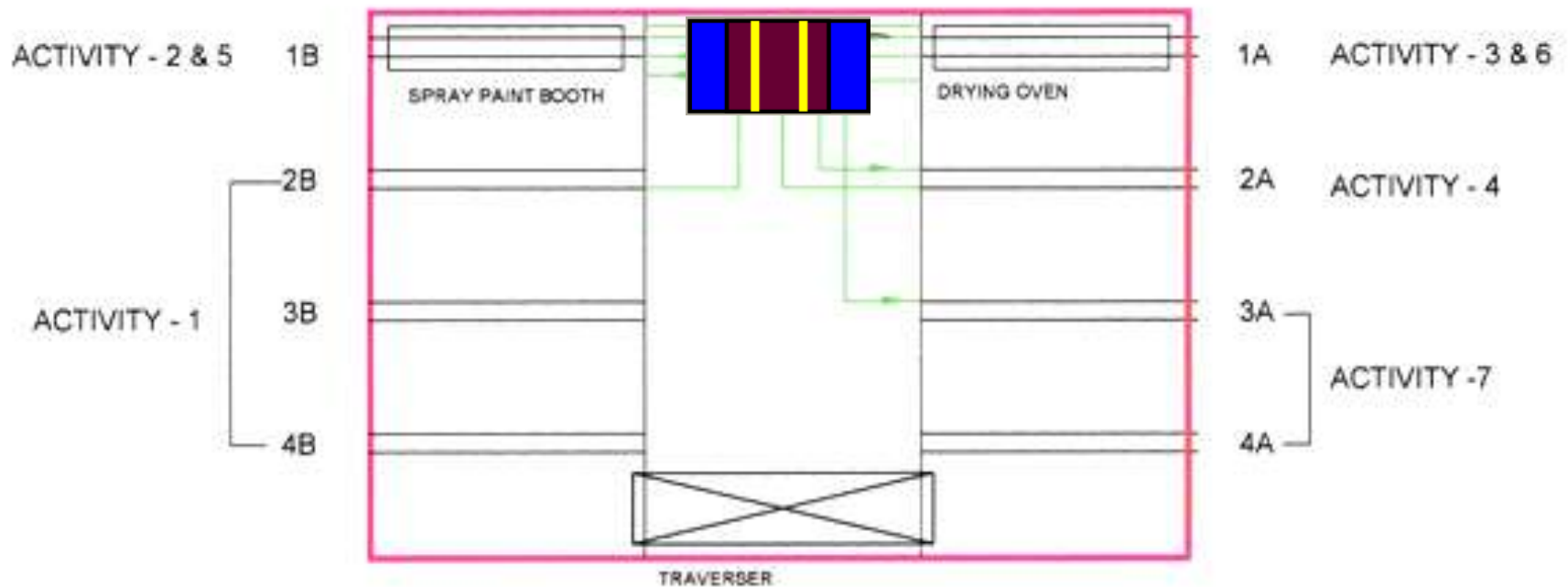
NO	ACTIVITY	TIMING FOR 1 COACH	TIMING FOR 5 COACHES	OPERATION	BERTHING LOCATION
1	WET RUB DOWN	4 HRS	20HRS	MANUAL	3 (LINE 2B,3B &4B)
2	FINAL COAT PU PAINT APPLICATION-UPPER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
3	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
4	MASKING TOP PORTION	30 min	2.5 HRS	MANUAL	1 (LINE 2 A)
5	FINAL COAT PU APPLICATION- LOWER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
6	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
7	LETTERING ETC	2 HRS	10 HRS	MANUAL	1 (LINE 3A & 4A)

Placement of Coach in one of the nominated line for de- masking



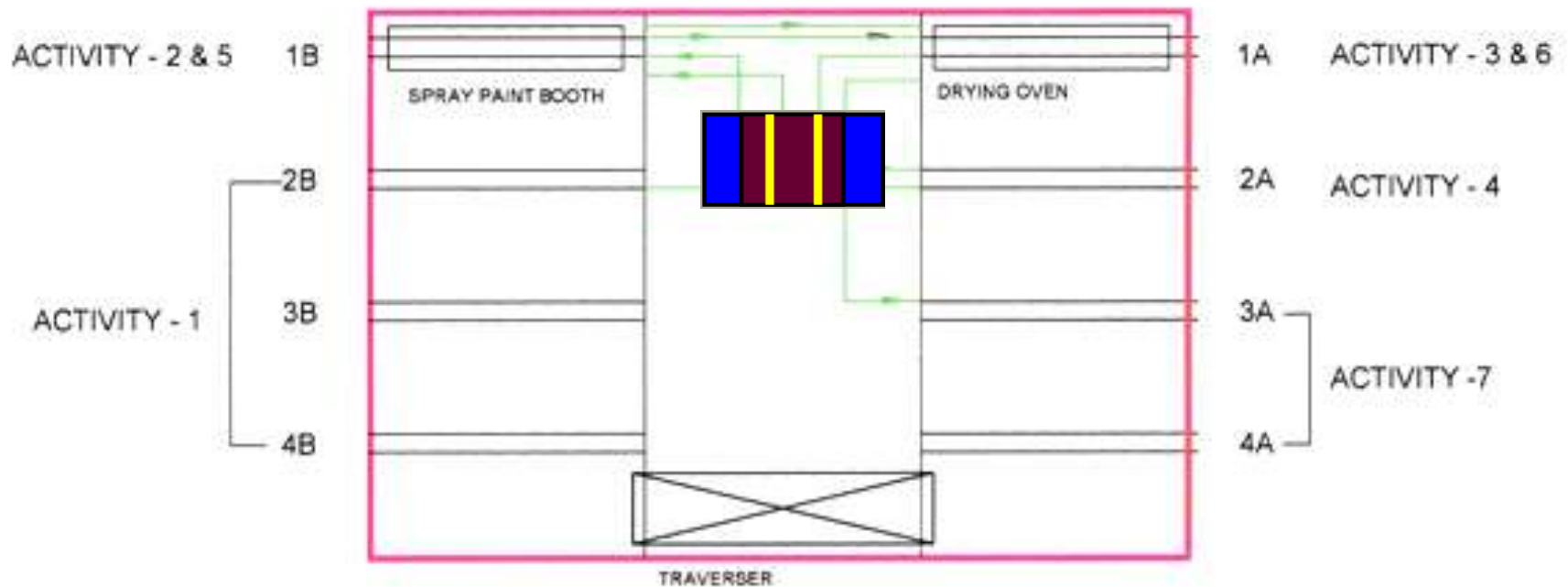
NO	ACTIVITY	TIMING FOR 1 COACH	TIMING FOR 5 COACHES	OPERATION	BERTHING LOCATION
1	WET RUB DOWN	4 HRS	20HRS	MANUAL	3 (LINE 2B,3B &4B)
2	FINAL COAT PU PAINT APPLICATION-UPPER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
3	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
4	MASKING TOP PORTION	30 min	2.5 HRS	MANUAL	1 (LINE 2 A)
5	FINAL COAT PU APPLICATION- LOWER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
6	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
7	LETTERING ETC	2 HRS	10 HRS	MANUAL	1 (LINE 3A & 4A)

Placement of Coach in one of the nominated line for de- masking



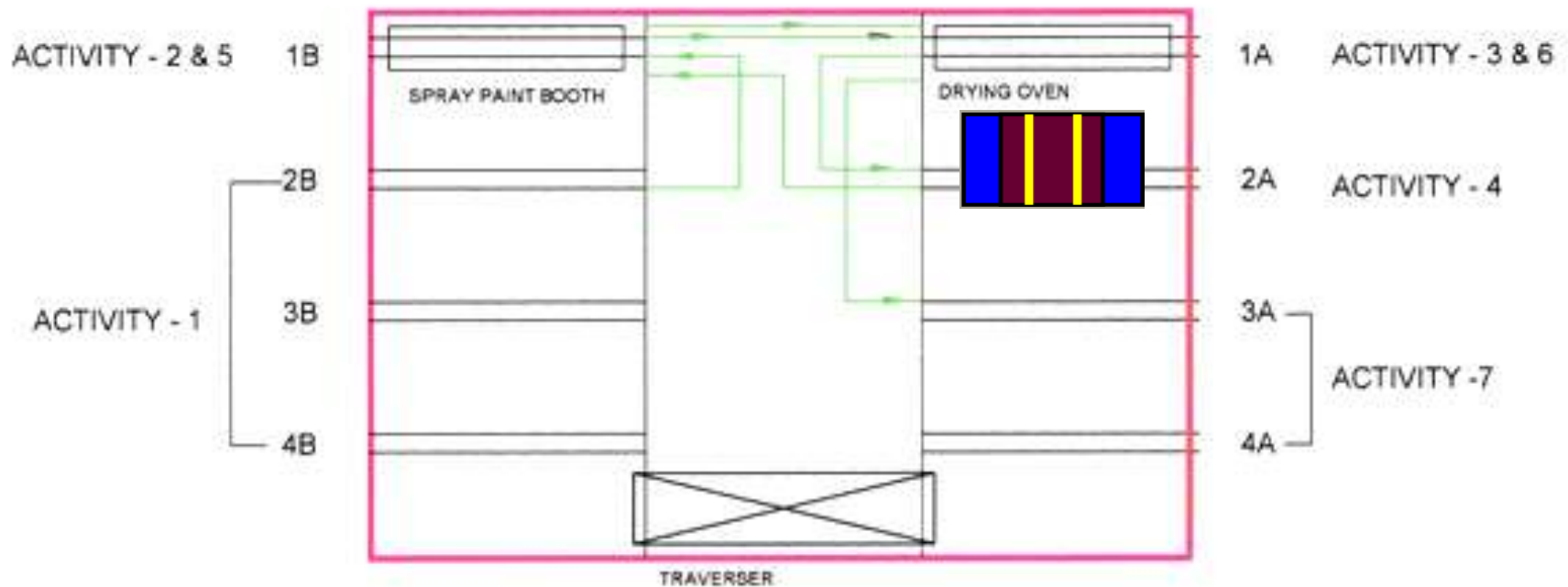
NO	ACTIVITY	TIMING FOR 1 COACH	TIMING FOR 5 COACHES	OPERATION	BERTHING LOCATION
1	WET RUB DOWN	4 HRS	20HRS	MANUAL	3 (LINE 2B,3B &4B)
2	FINAL COAT PU PAINT APPLICATION-UPPER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
3	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
4	MASKING TOP PORTION	30 min	2.5 HRS	MANUAL	1 (LINE 2 A)
5	FINAL COAT PU APPLICATION- LOWER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
6	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
7	LETTERING ETC	2 HRS	10 HRS	MANUAL	1 (LINE 3A & 4A)

Placement of Coach in one of the nominated line for de- masking



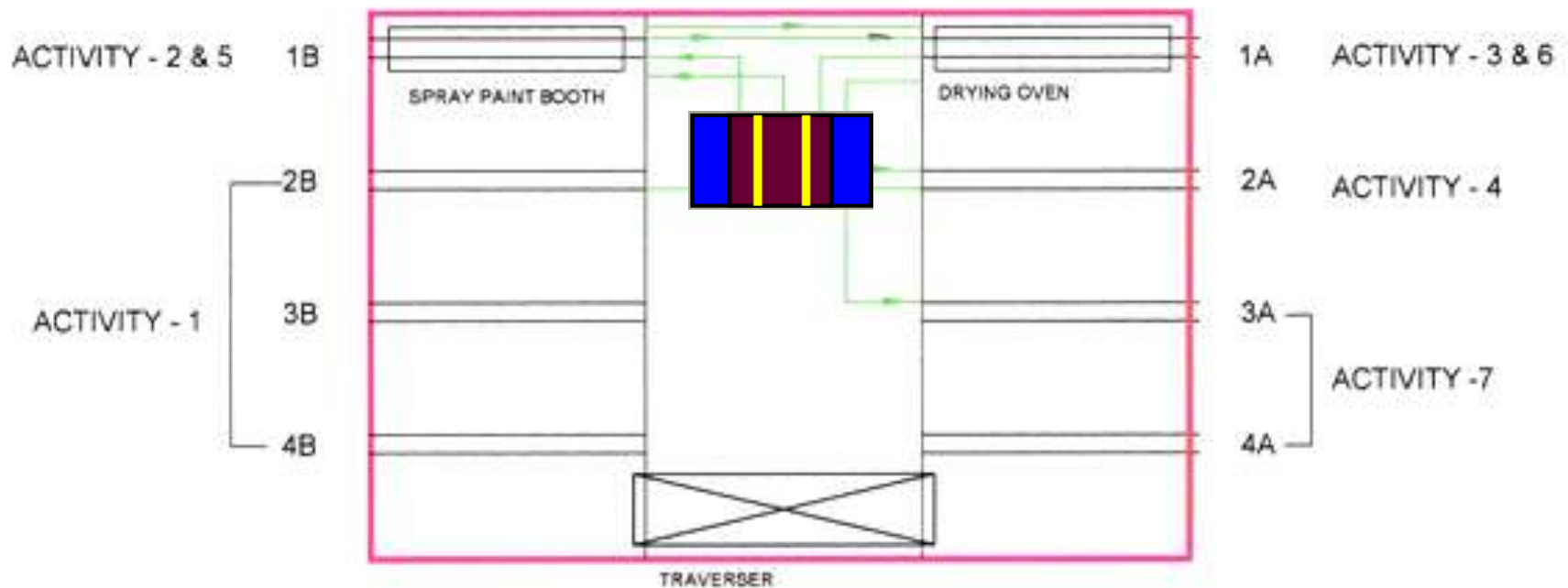
NO	ACTIVITY	TIMING FOR 1 COACH	TIMING FOR 5 COACHES	OPERATION	BERTHING LOCATION
1	WET RUB DOWN	4 HRS	20HRS	MANUAL	3 (LINE 2B,3B &4B)
2	FINAL COAT PU PAINT APPLICATION-UPPER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
3	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
4	MASKING TOP PORTION	30 min	2.5 HRS	MANUAL	1 (LINE 2 A)
5	FINAL COAT PU APPLICATION- LOWER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
6	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
7	LETTERING ETC	2 HRS	10 HRS	MANUAL	1 (LINE 3A & 4A)

Placement of Coach in paint booth for painting lower portion



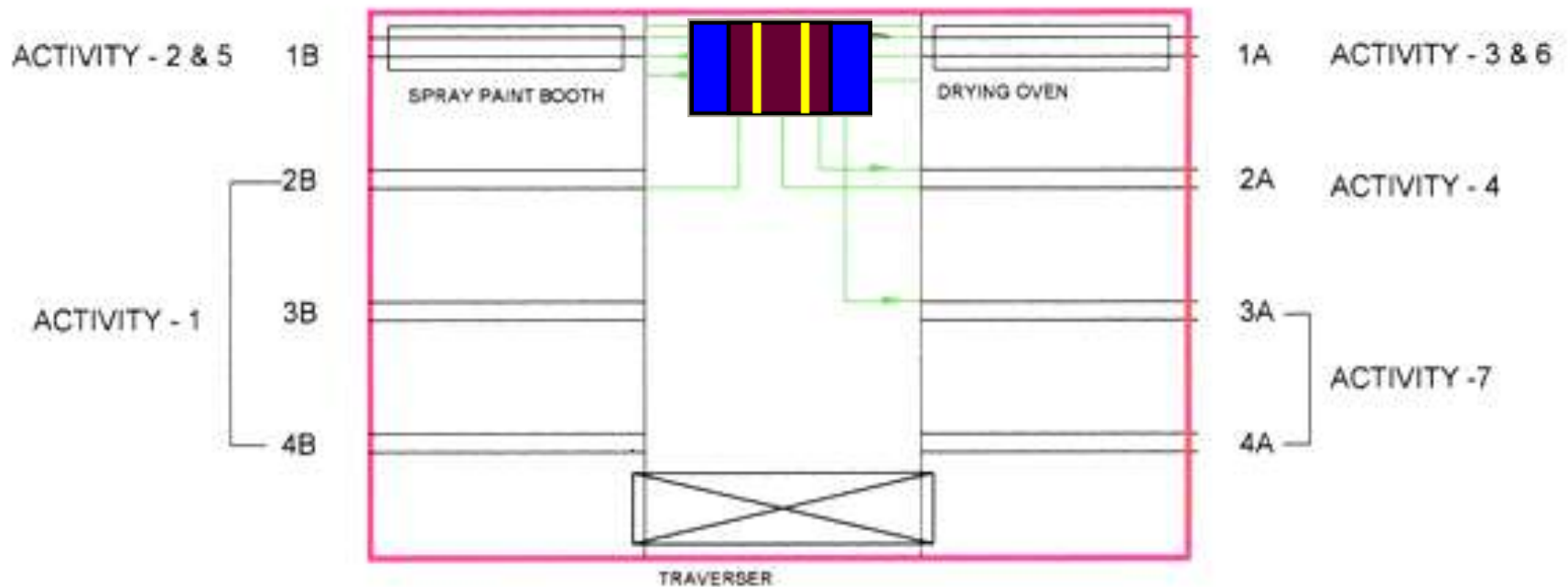
NO	ACTIVITY	TIMING FOR 1 COACH	TIMING FOR 5 COACHES	OPERATION	BERTHING LOCATION
1	WET RUB DOWN	4 HRS	20HRS	MANUAL	3 (LINE 2B,3B &4B)
2	FINAL COAT PU PAINT APPLICATION-UPPER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
3	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
4	MASKING TOP PORTION	30 min	2.5 HRS	MANUAL	1 (LINE 2 A)
5	FINAL COAT PU APPLICATION- LOWER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
6	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
7	LETTERING ETC	2 HRS	10 HRS	MANUAL	1 (LINE 3A & 4A)

Placement of Coach in paint booth for painting lower portion



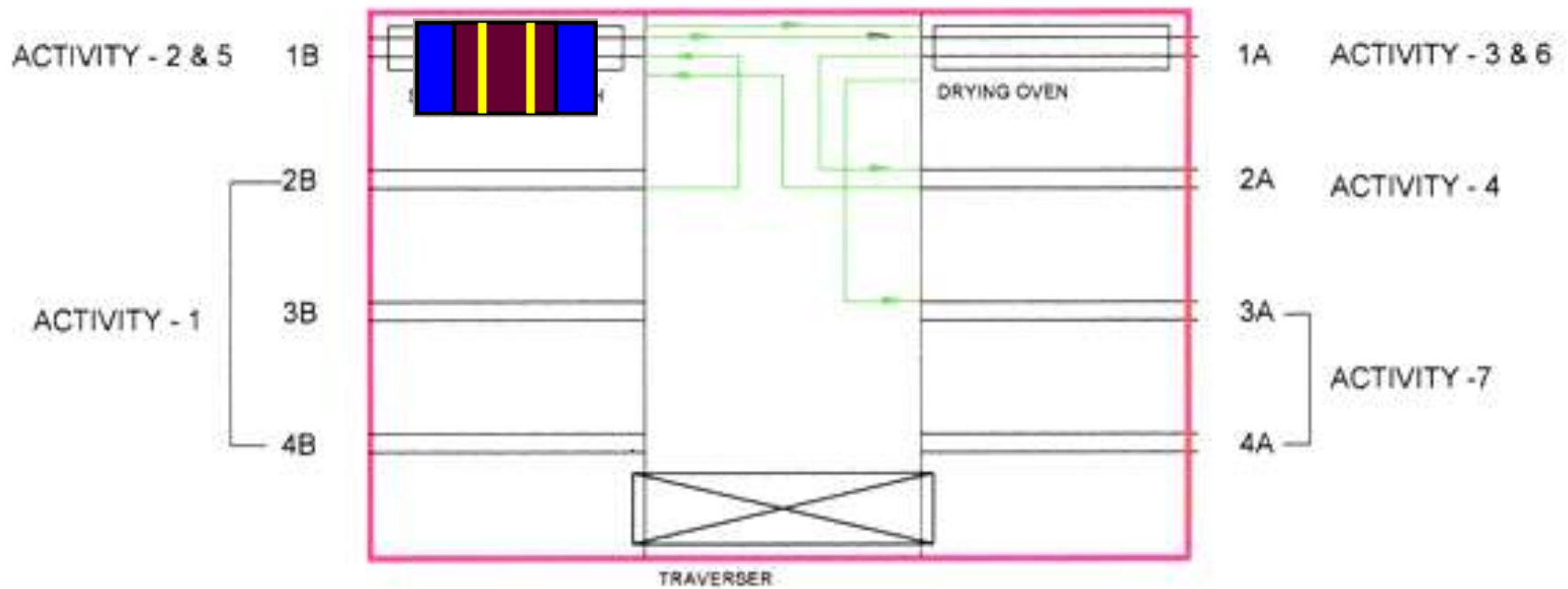
NO	ACTIVITY	TIMING FOR 1 COACH	TIMING FOR 5 COACHES	OPERATION	BERTHING LOCATION
1	WET RUB DOWN	4 HRS	20HRS	MANUAL	3 (LINE 2B,3B &4B)
2	FINAL COAT PU PAINT APPLICATION-UPPER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
3	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
4	MASKING TOP PORTION	30 min	2.5 HRS	MANUAL	1 (LINE 2 A)
5	FINAL COAT PU APPLICATION- LOWER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
6	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
7	LETTERING ETC	2 HRS	10 HRS	MANUAL	1 (LINE 3A & 4A)

Placement of Coach in paint booth for painting lower portion



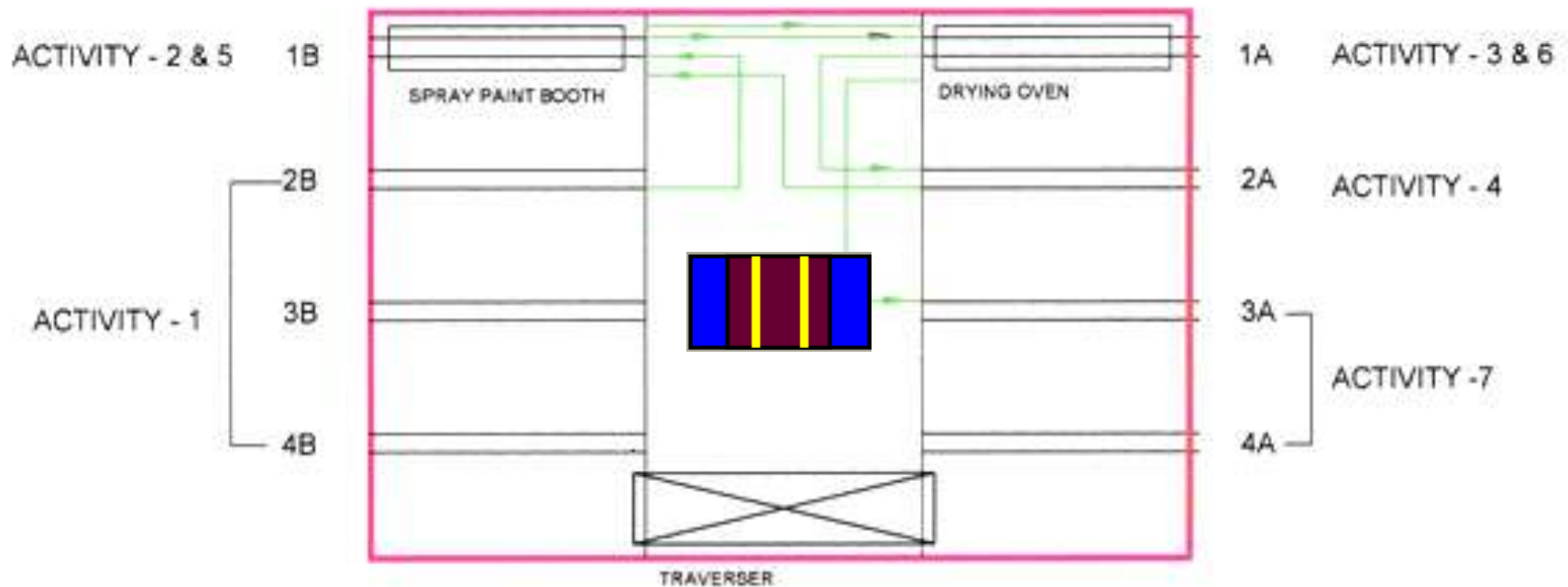
NO	ACTIVITY	TIMING FOR 1 COACH	TIMING FOR 5 COACHES	OPERATION	BERTHING LOCATION
1	WET RUB DOWN	4 HRS	20HRS	MANUAL	3 (LINE 2B,3B &4B)
2	FINAL COAT PU PAINT APPLICATION-UPPER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
3	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
4	MASKING TOP PORTION	30 min	2.5 HRS	MANUAL	1 (LINE 2 A)
5	FINAL COAT PU APPLICATION- LOWER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
6	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
7	LETTERING ETC	2 HRS	10 HRS	MANUAL	1 (LINE 3A & 4A)

Placement of Coach in Drying Oven



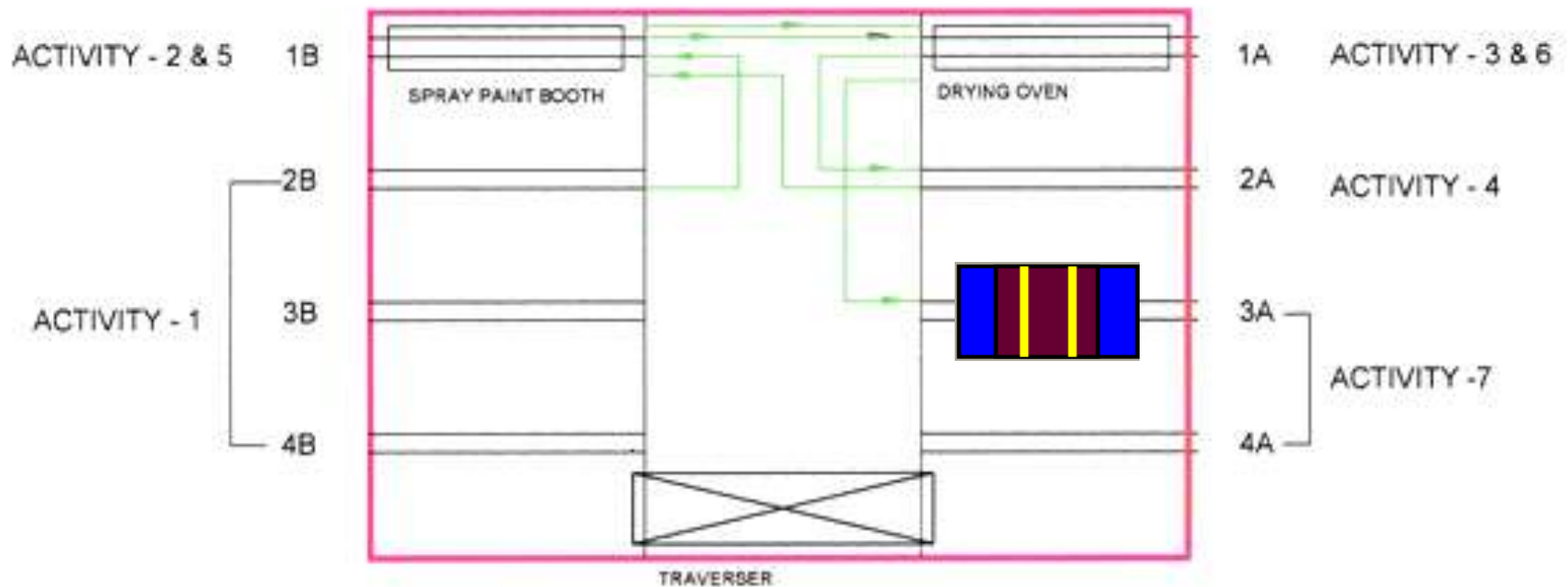
NO	ACTIVITY	TIMING FOR 1 COACH	TIMING FOR 5 COACHES	OPERATION	BERTHING LOCATION
1	WET RUB DOWN	4 HRS	20HRS	MANUAL	3 (LINE 2B,3B &4B)
2	FINAL COAT PU PAINT APPLICATION-UPPER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
3	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
4	MASKING TOP PORTION	30 min	2.5 HRS	MANUAL	1 (LINE 2 A)
5	FINAL COAT PU APPLICATION- LOWER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
6	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
7	LETTERING ETC	2 HRS	10 HRS	MANUAL	1 (LINE 3A & 4A)

Placement of Coach in nominated line for screen painting



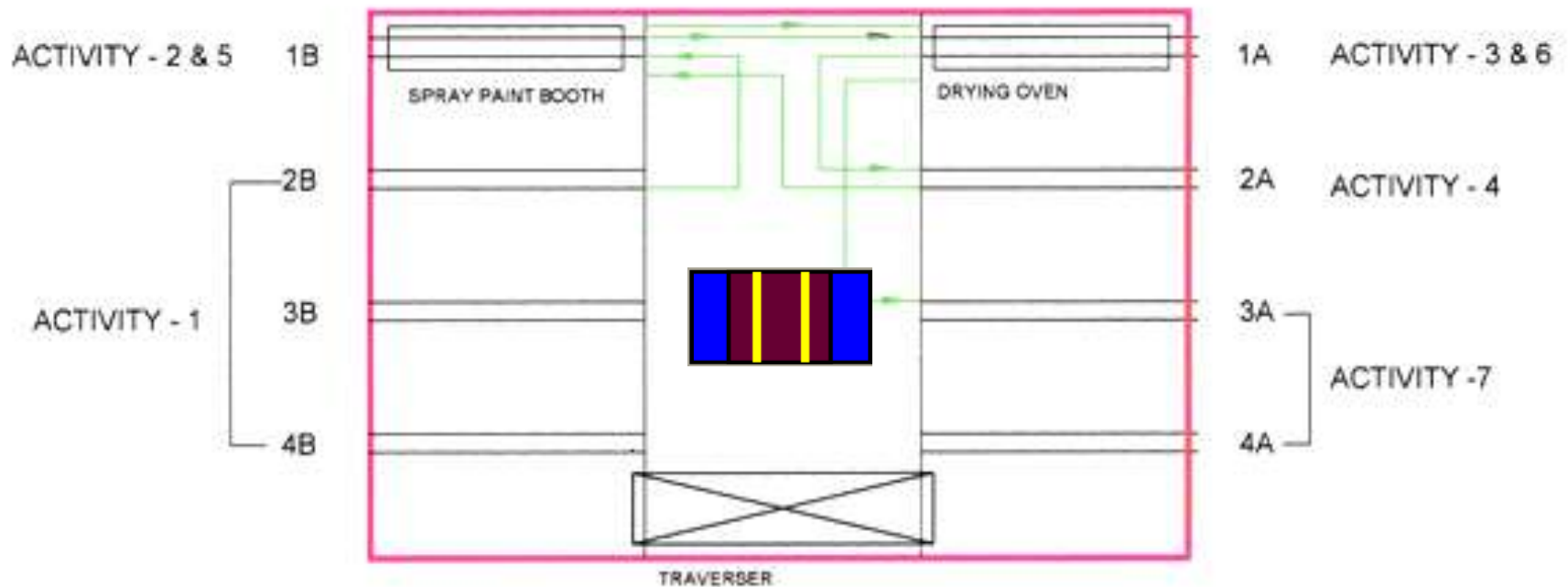
NO	ACTIVITY	TIMING FOR 1 COACH	TIMING FOR 5 COACHES	OPERATION	BERTHING LOCATION
1	WET RUB DOWN	4 HRS	20HRS	MANUAL	3 (LINE 2B,3B &4B)
2	FINAL COAT PU PAINT APPLICATION-UPPER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
3	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
4	MASKING TOP PORTION	30 min	2.5 HRS	MANUAL	1 (LINE 2 A)
5	FINAL COAT PU APPLICATION- LOWER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
6	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
7	LETTERING ETC	2 HRS	10 HRS	MANUAL	1 (LINE 3A & 4A)

Coach out after painting



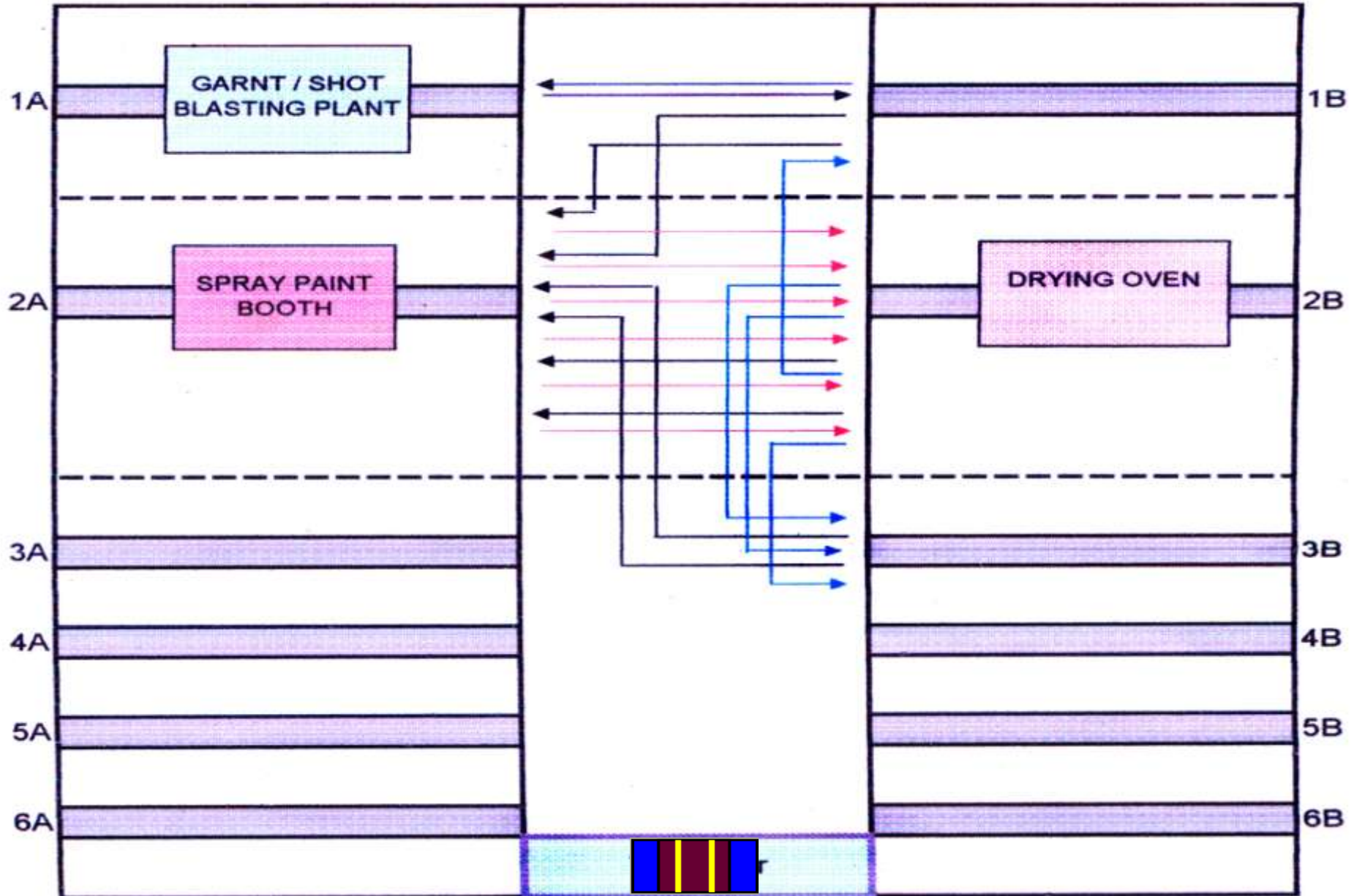
NO	ACTIVITY	TIMING FOR 1 COACH	TIMING FOR 5 COACHES	OPERATION	BERTHING LOCATION
1	WET RUB DOWN	4 HRS	20HRS	MANUAL	3 (LINE 2B,3B &4B)
2	FINAL COAT PU PAINT APPLICATION-UPPER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
3	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
4	MASKING TOP PORTION	30 min	2.5 HRS	MANUAL	1 (LINE 2 A)
5	FINAL COAT PU APPLICATION- LOWER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
6	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
7	LETTERING ETC	2 HRS	10 HRS	MANUAL	1 (LINE 3A & 4A)

Coach out after painting

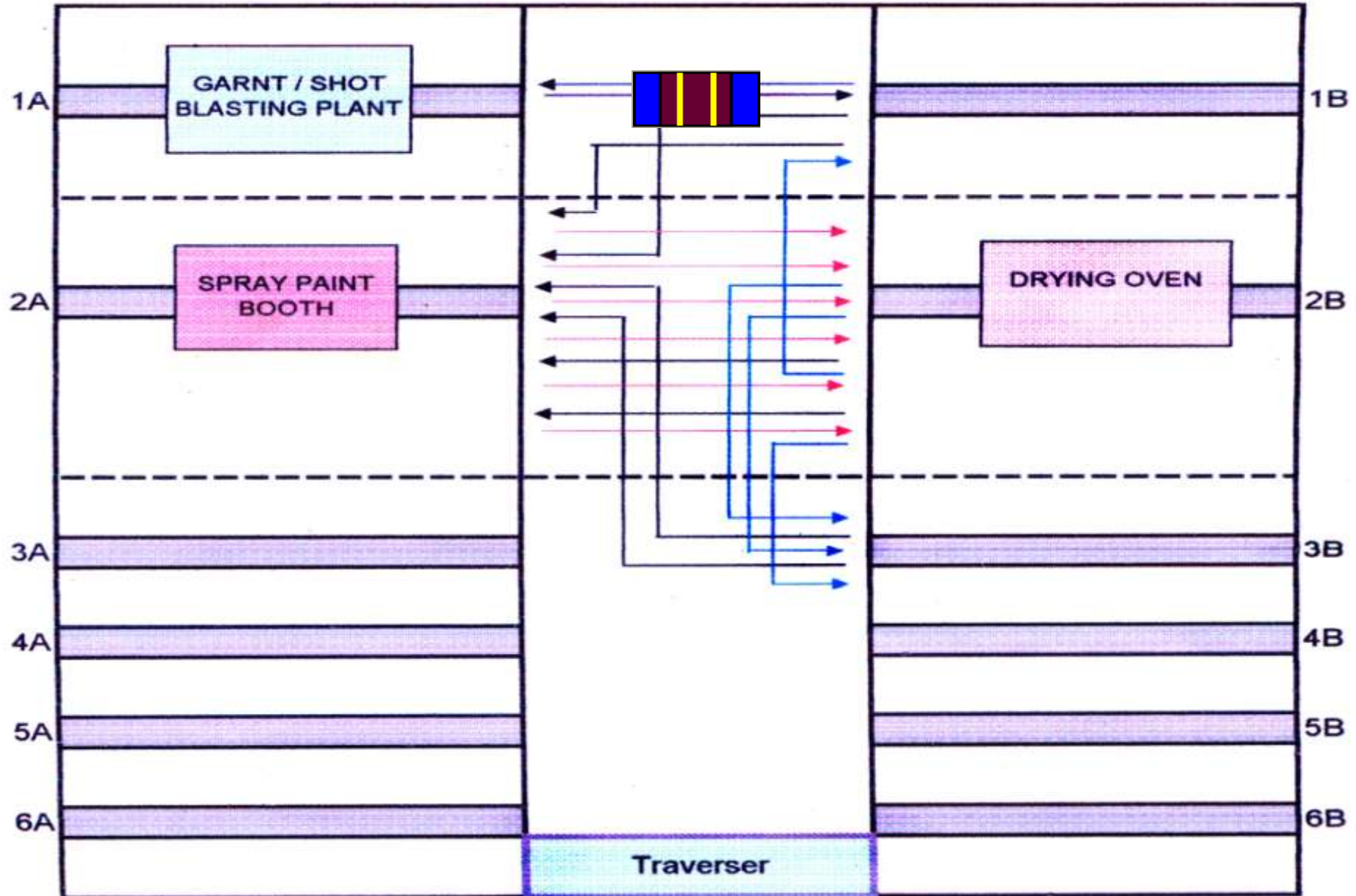


NO	ACTIVITY	TIMING FOR 1 COACH	TIMING FOR 5 COACHES	OPERATION	BERTHING LOCATION
1	WET RUB DOWN	4 HRS	20HRS	MANUAL	3 (LINE 2B,3B &4B)
2	FINAL COAT PU PAINT APPLICATION-UPPER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
3	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
4	MASKING TOP PORTION	30 min	2.5 HRS	MANUAL	1 (LINE 2 A)
5	FINAL COAT PU APPLICATION- LOWER	40 min	3H.20 M	PAINT BOOTH	1 (BOOTH 1B)
6	DRYING	40 min	3H.20 M	OVEN	1 (OVEN 1A)
7	LETTERING ETC	2 HRS	10 HRS	MANUAL	1 (LINE 3A & 4A)

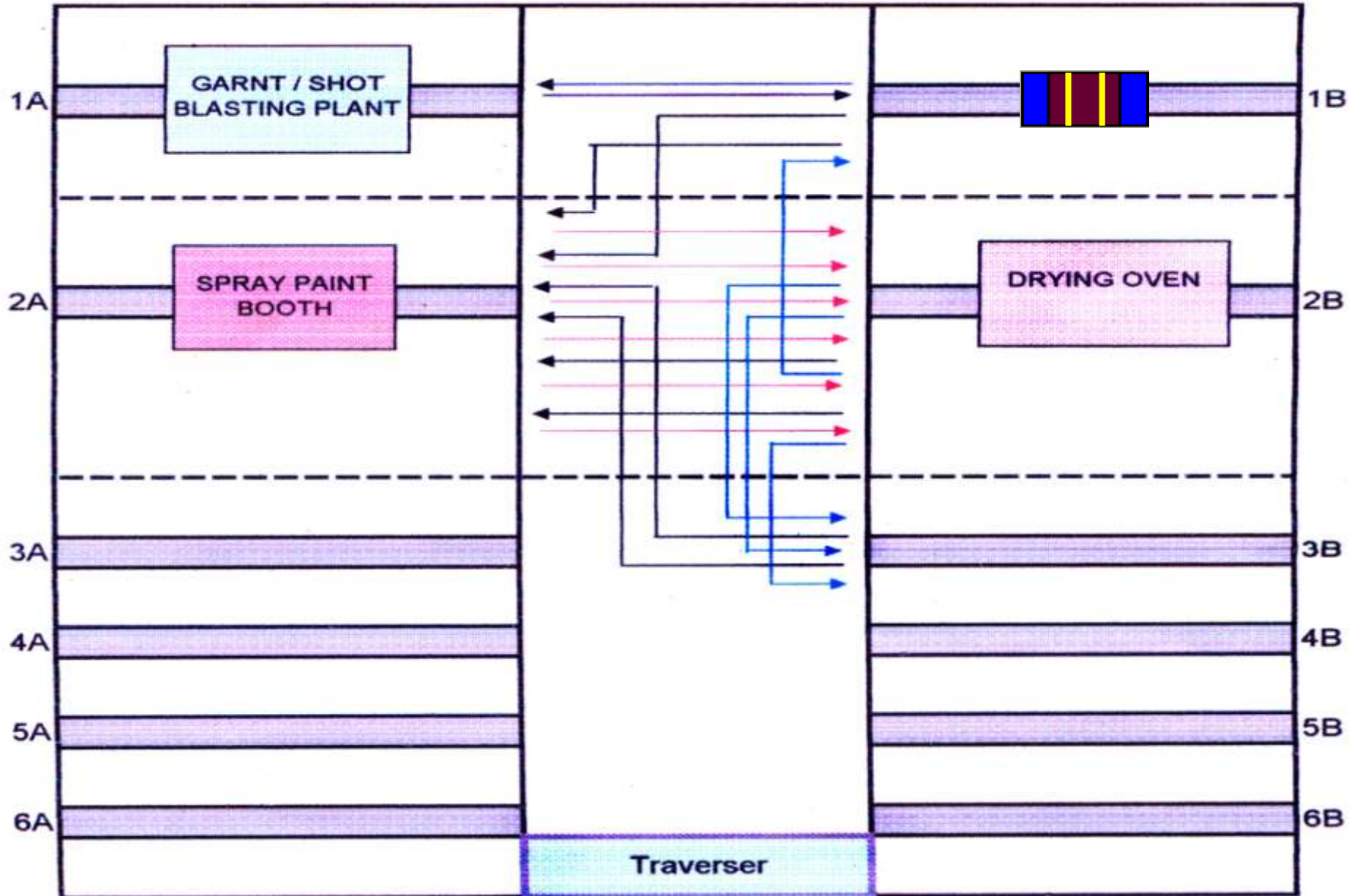
Process for A Schedule painting



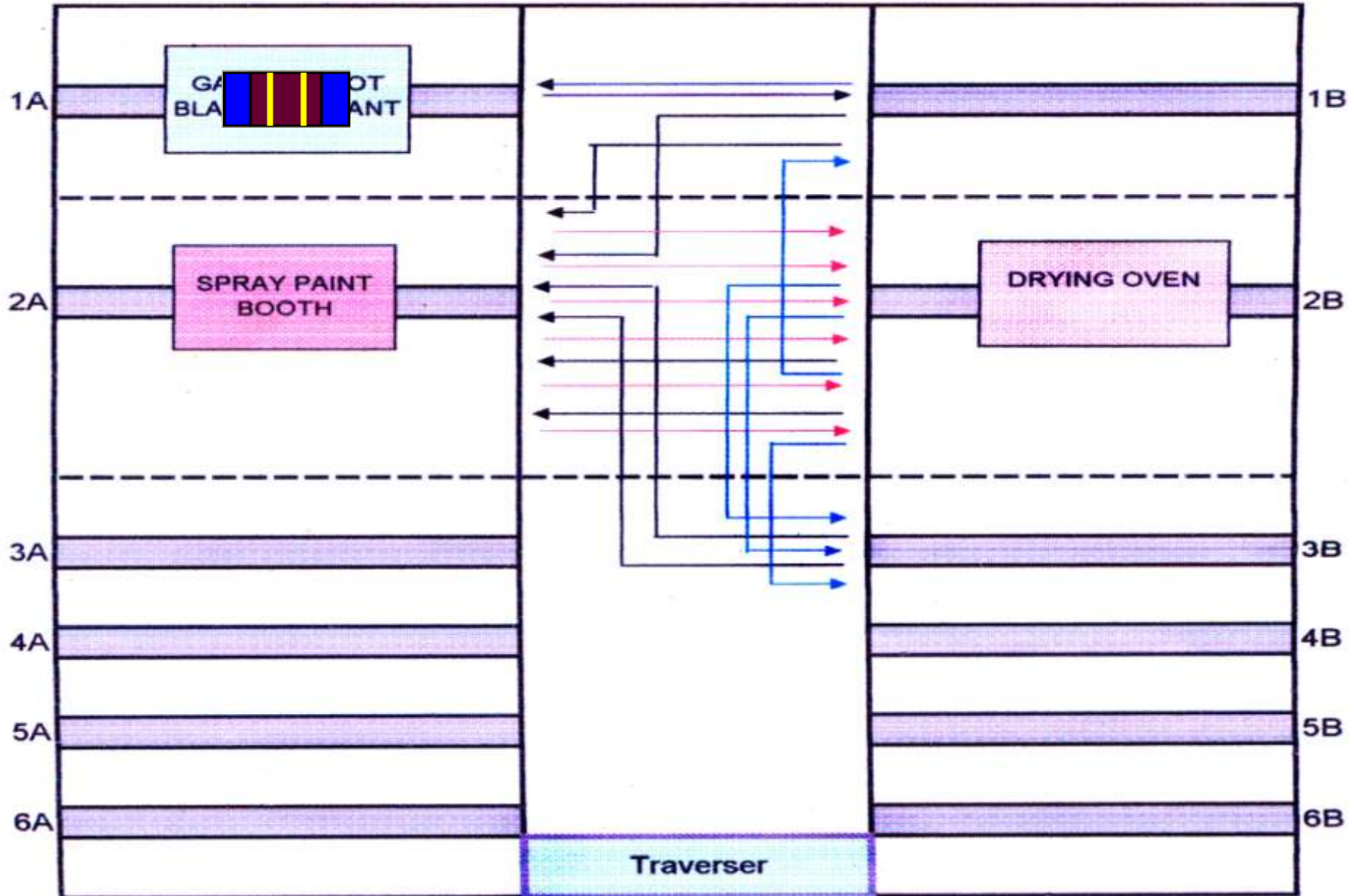
Masking of Windows

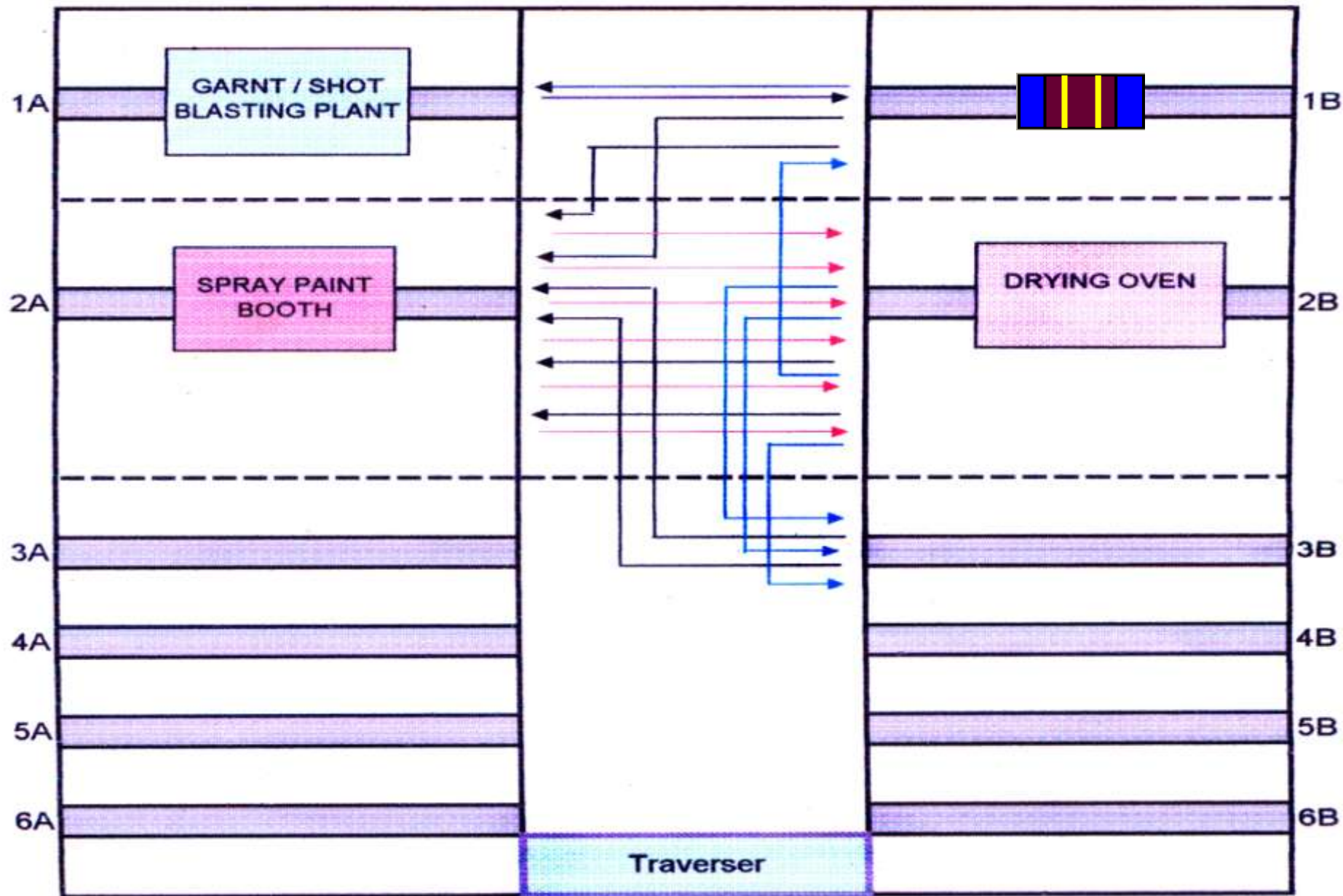


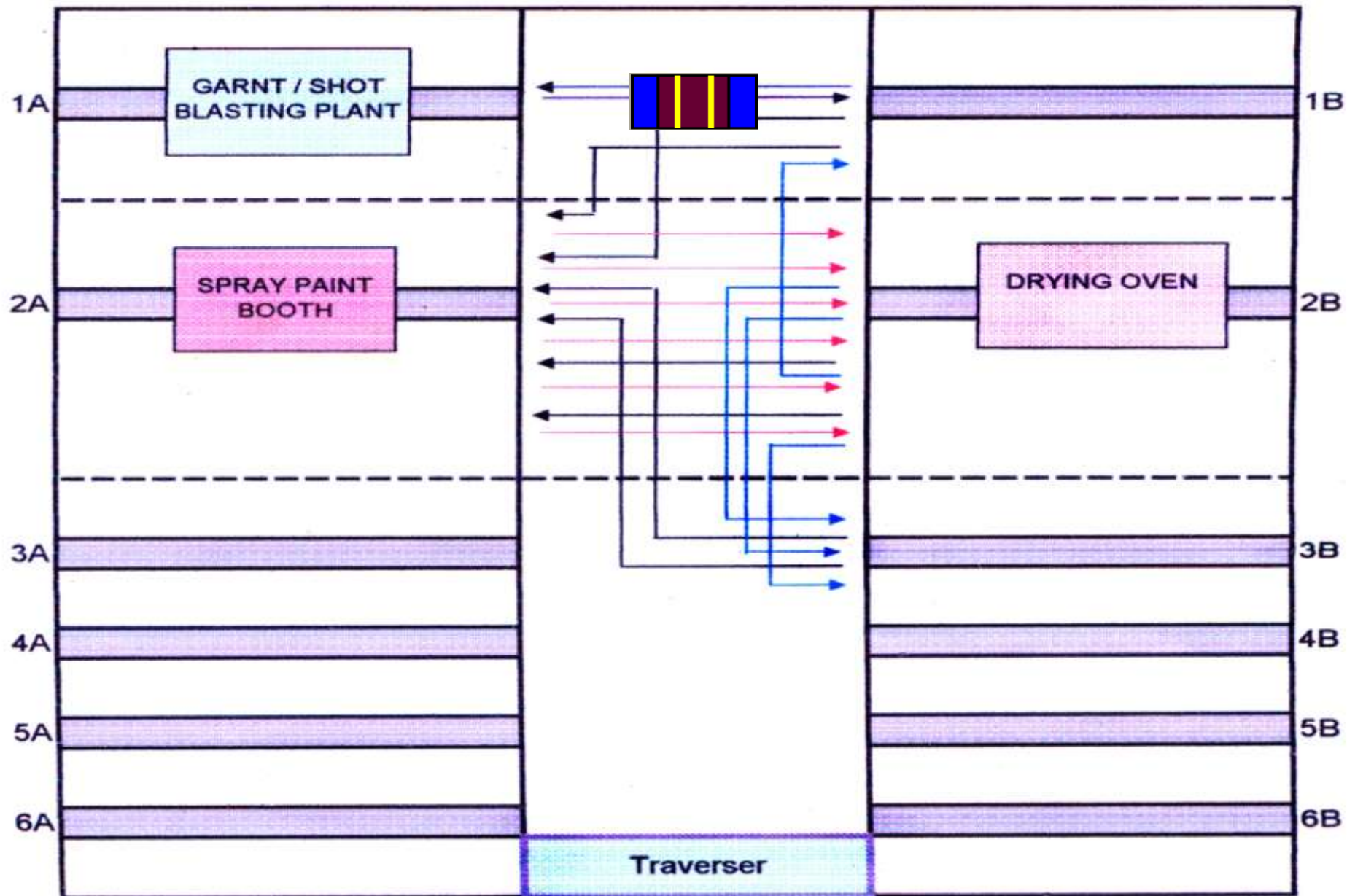
Shot Blasting & Air Wash



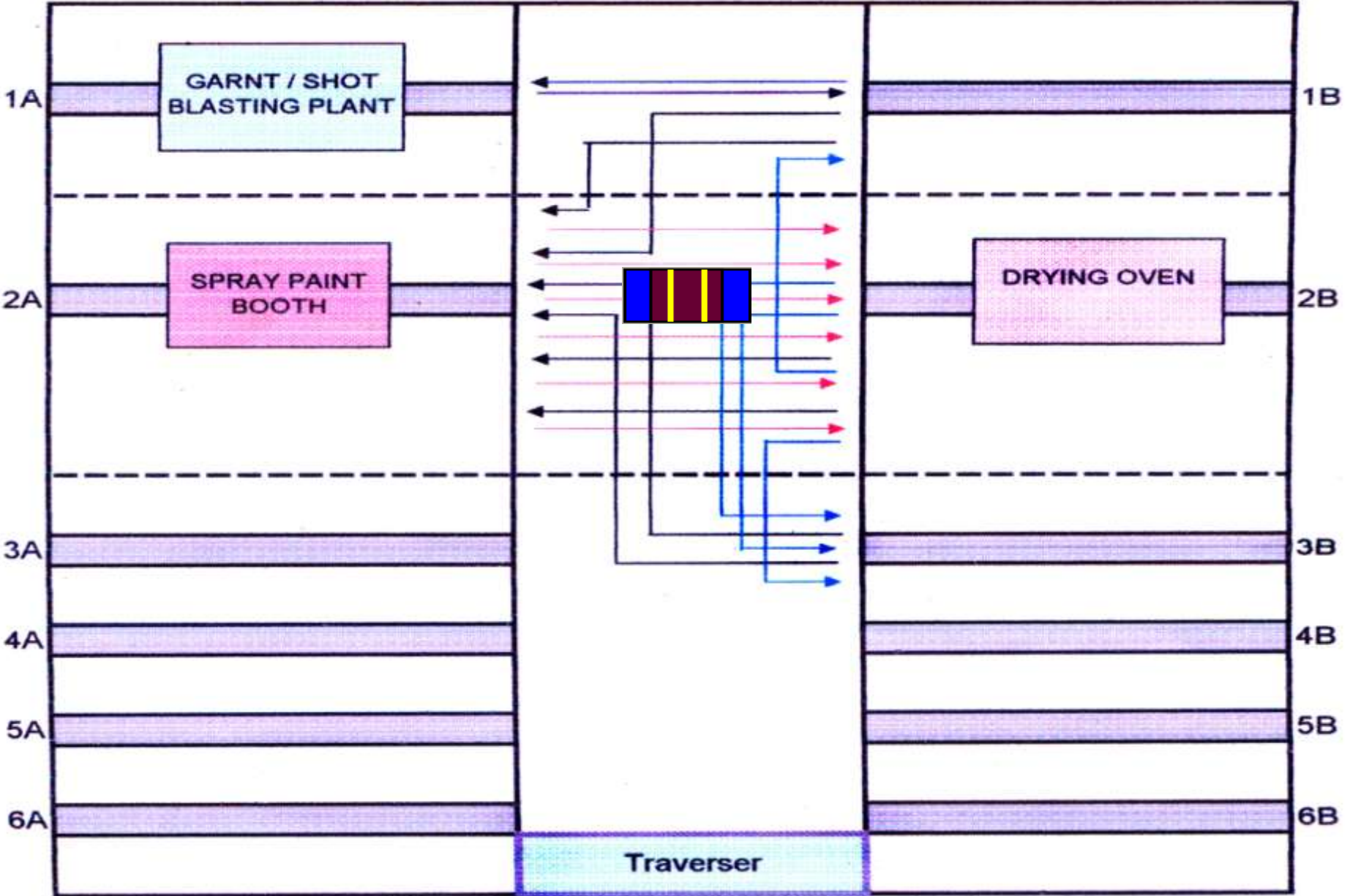
De-Masking & Re-masking



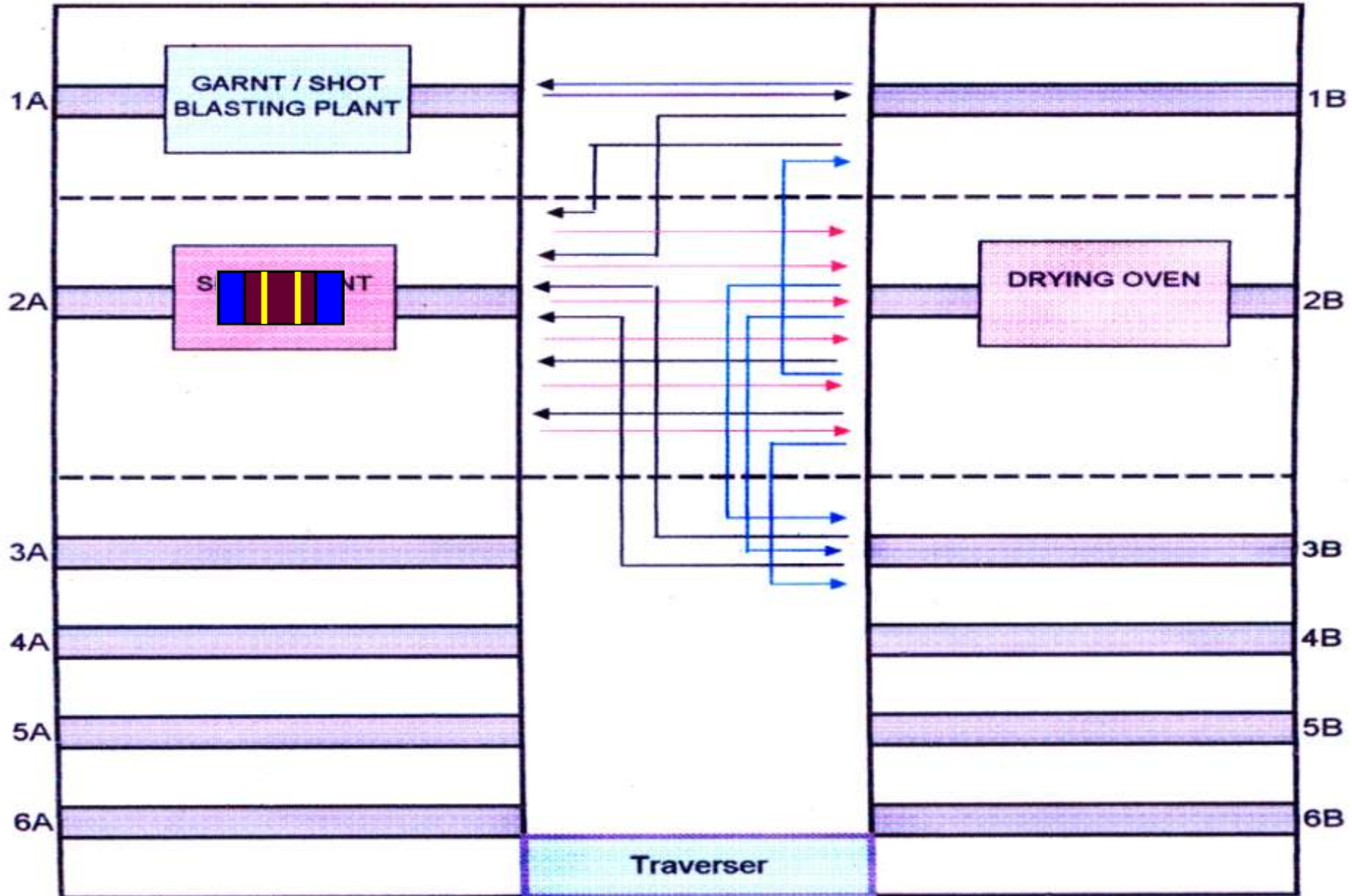


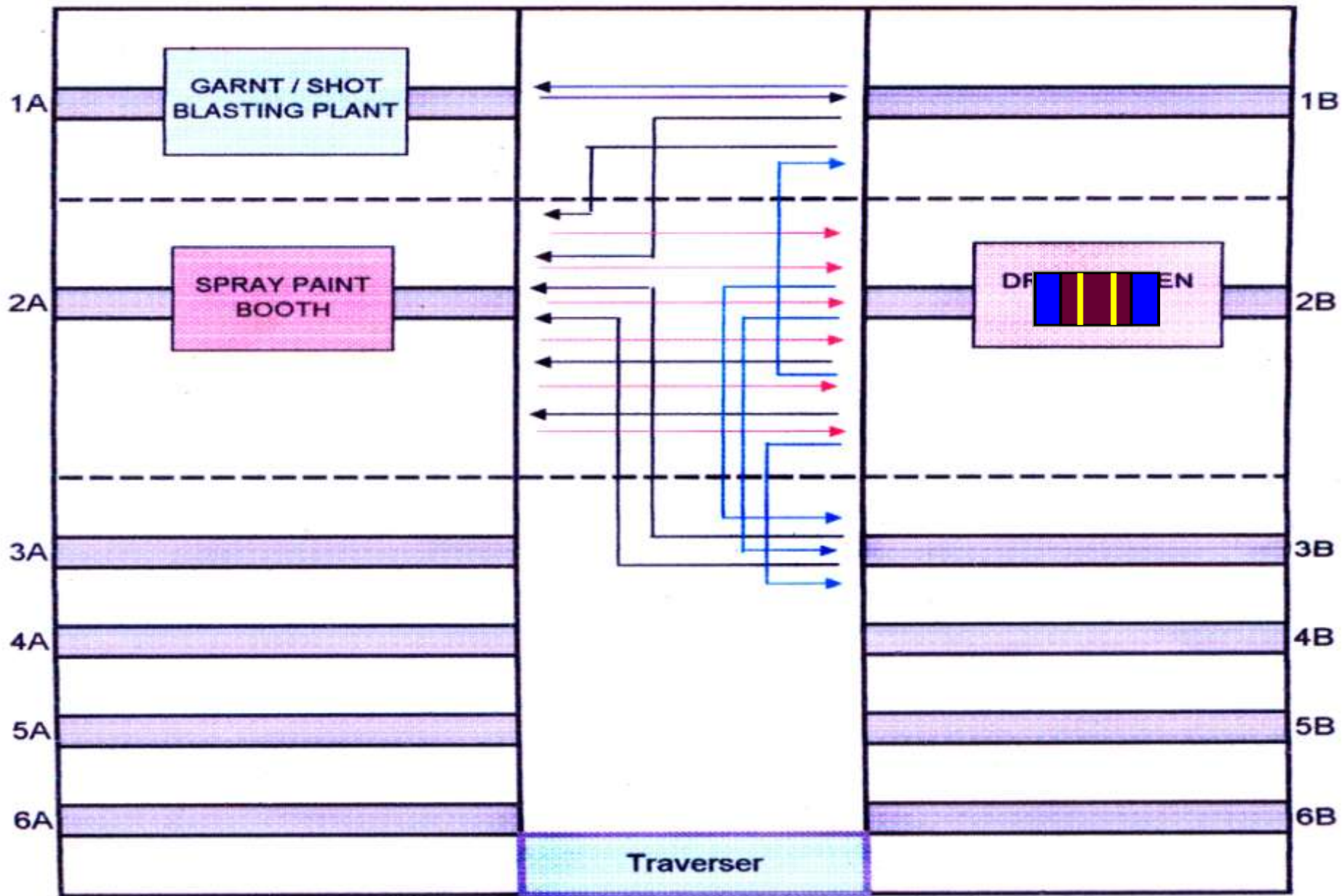


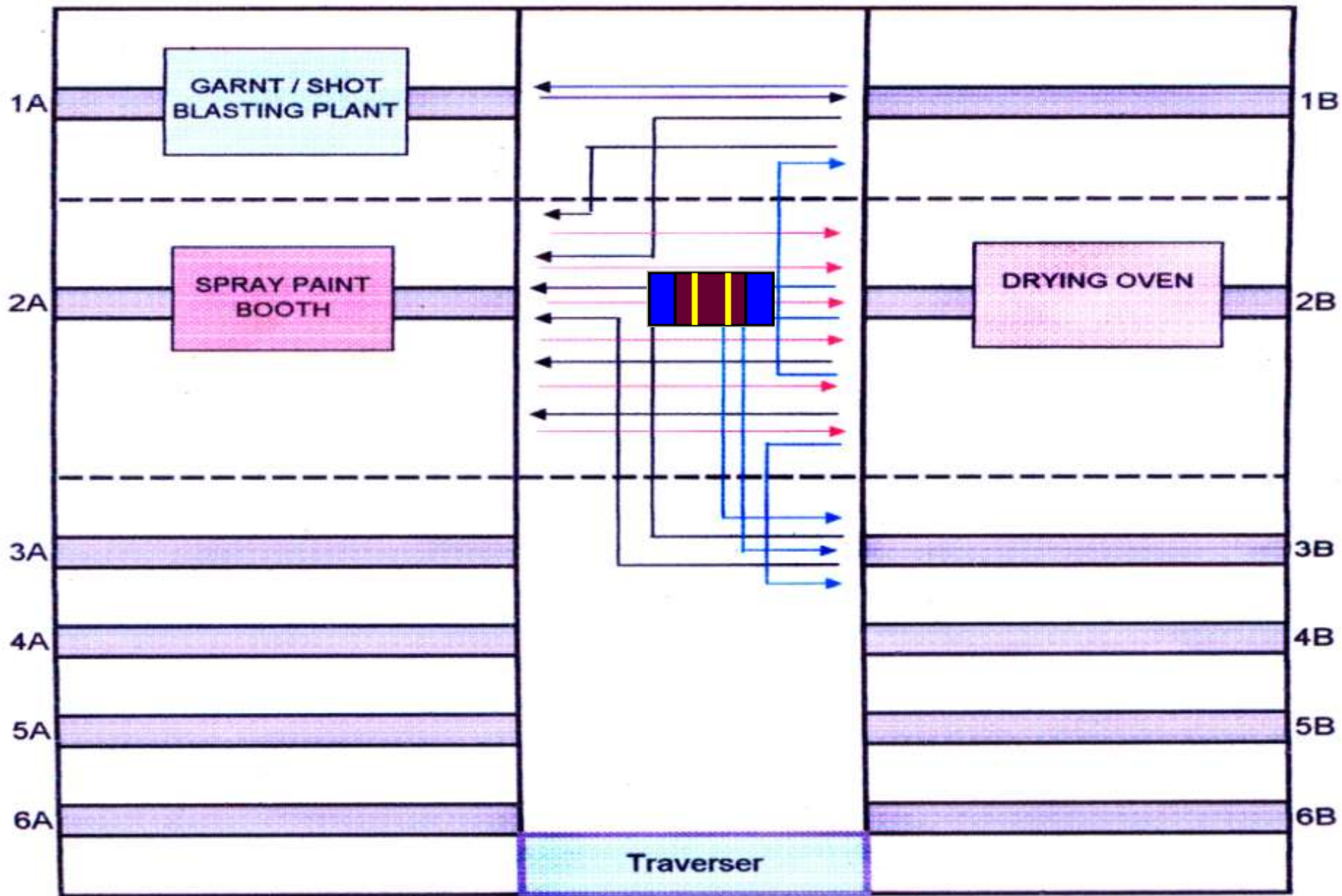
Primer Application



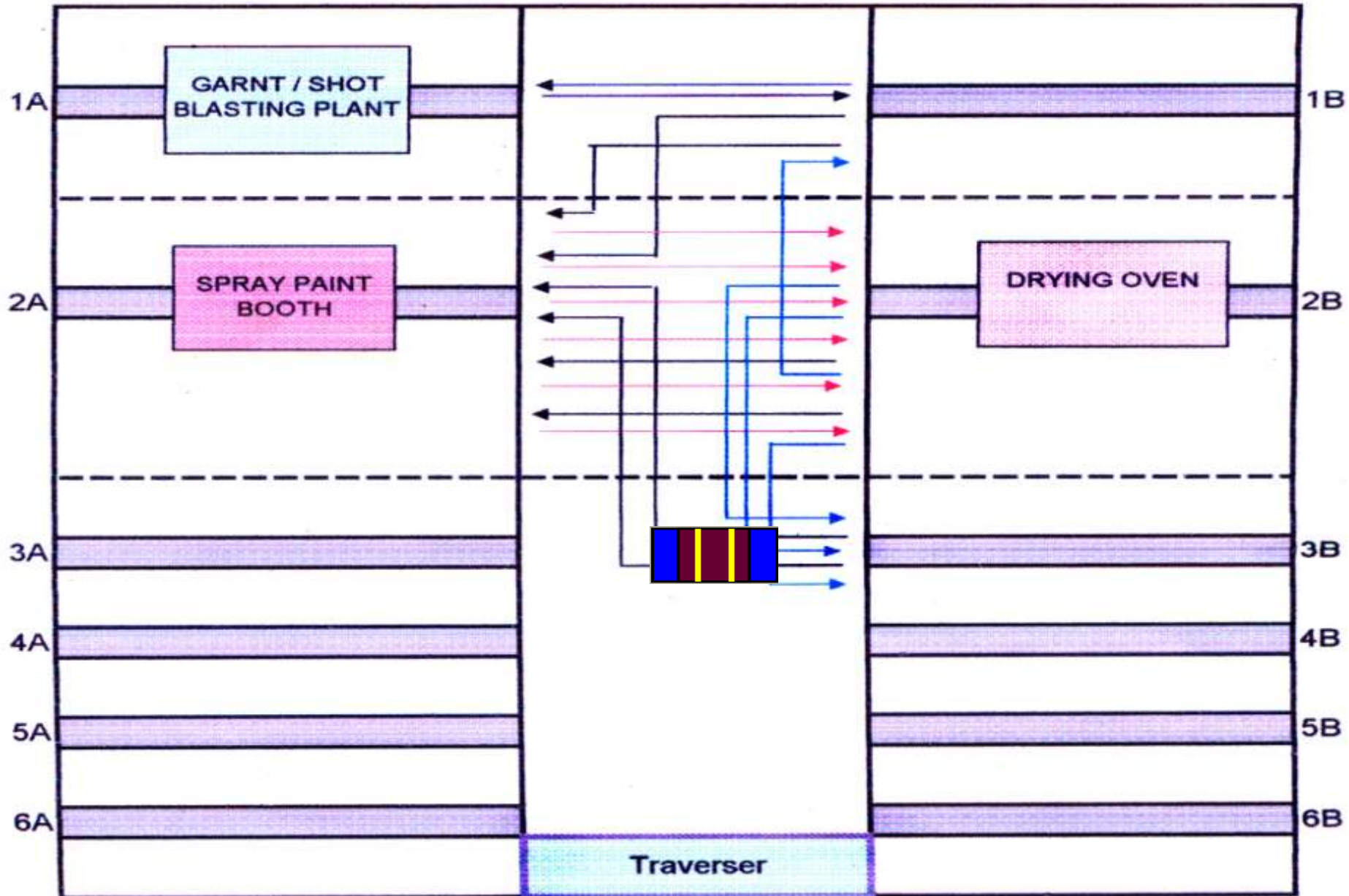
•Drying in oven

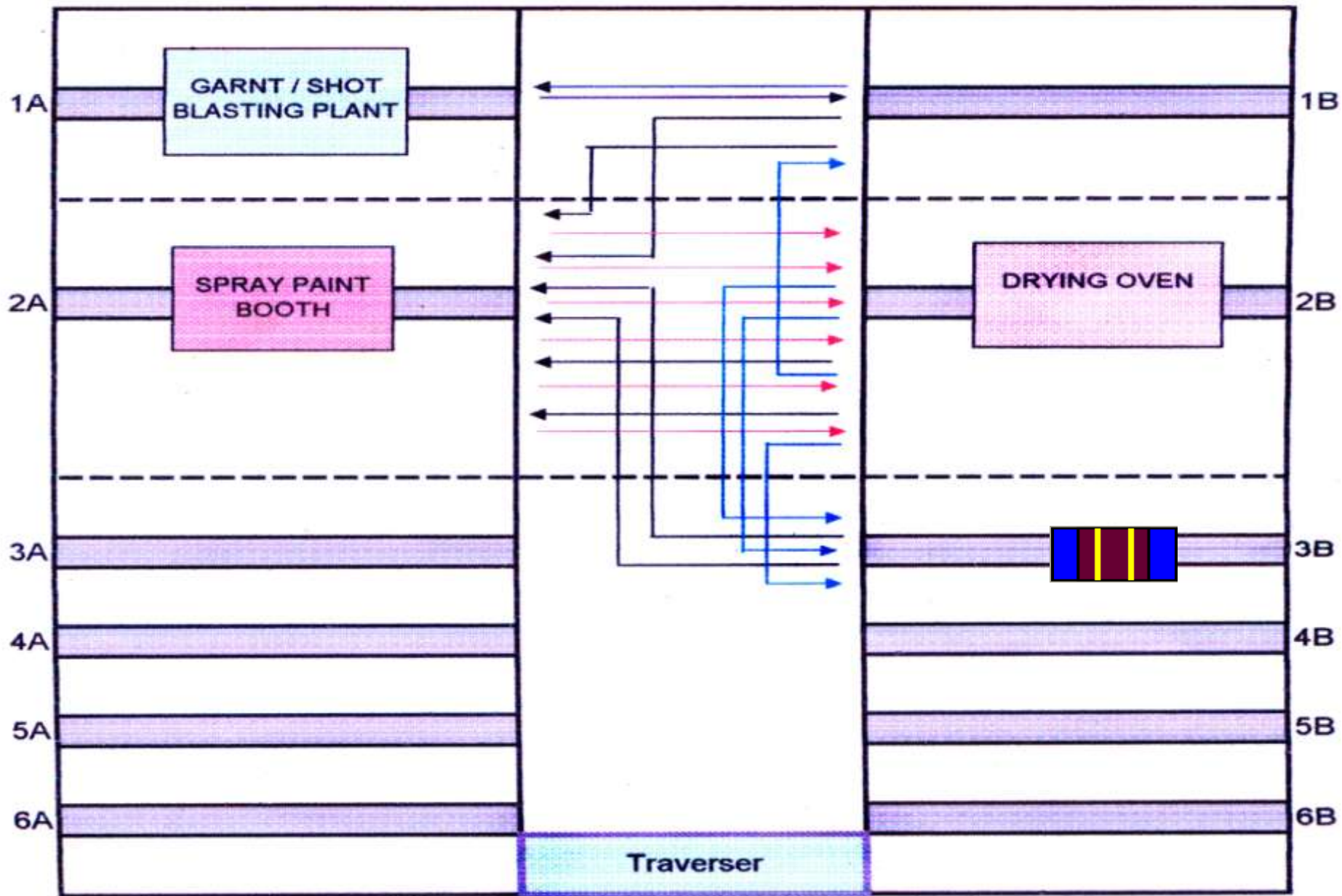


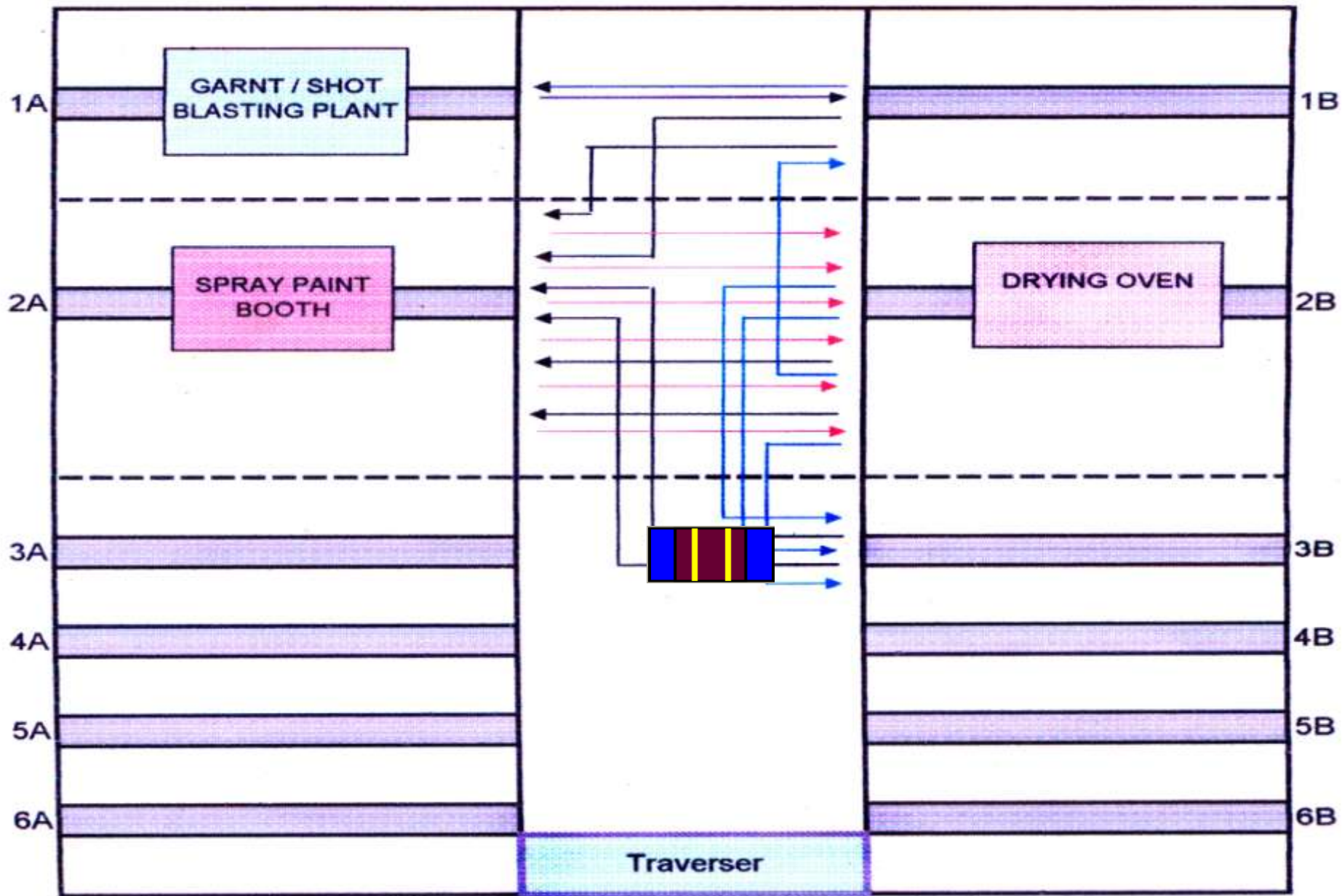




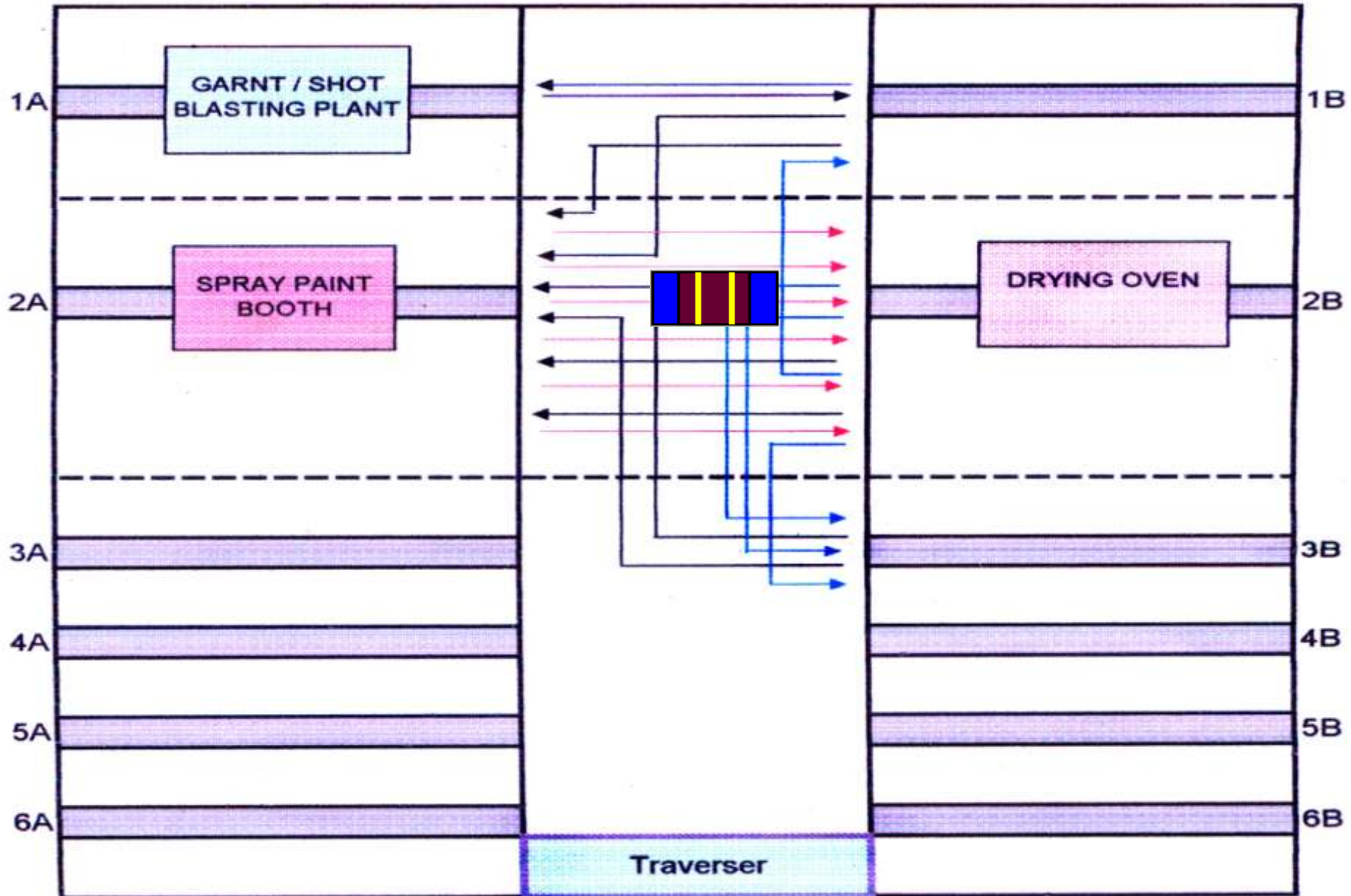
- First Coat Polyester putty Application ,Air Drying, Wet Rub down,
- Second coat of Polyester Putty application/Drying/Rub down.



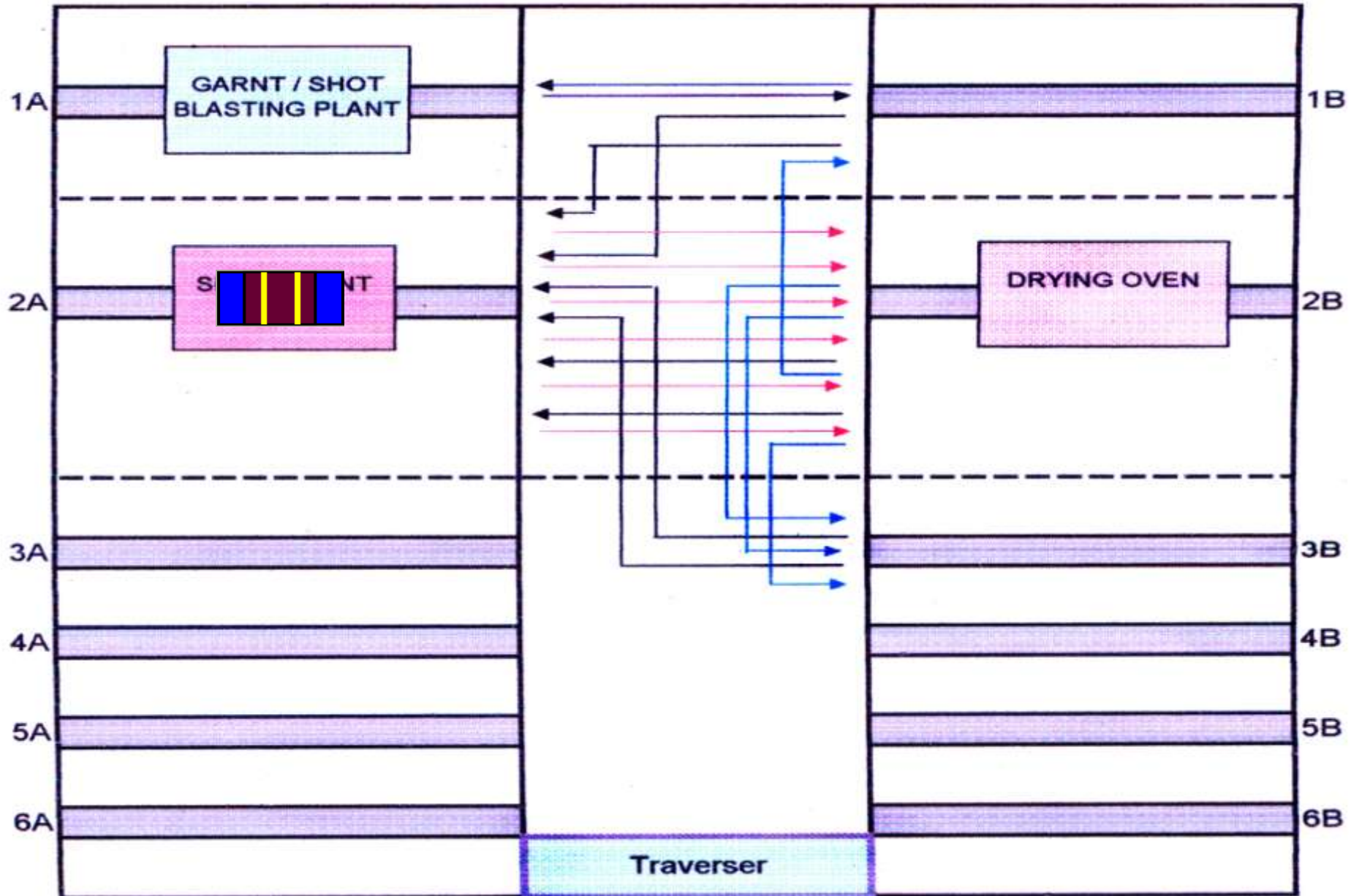


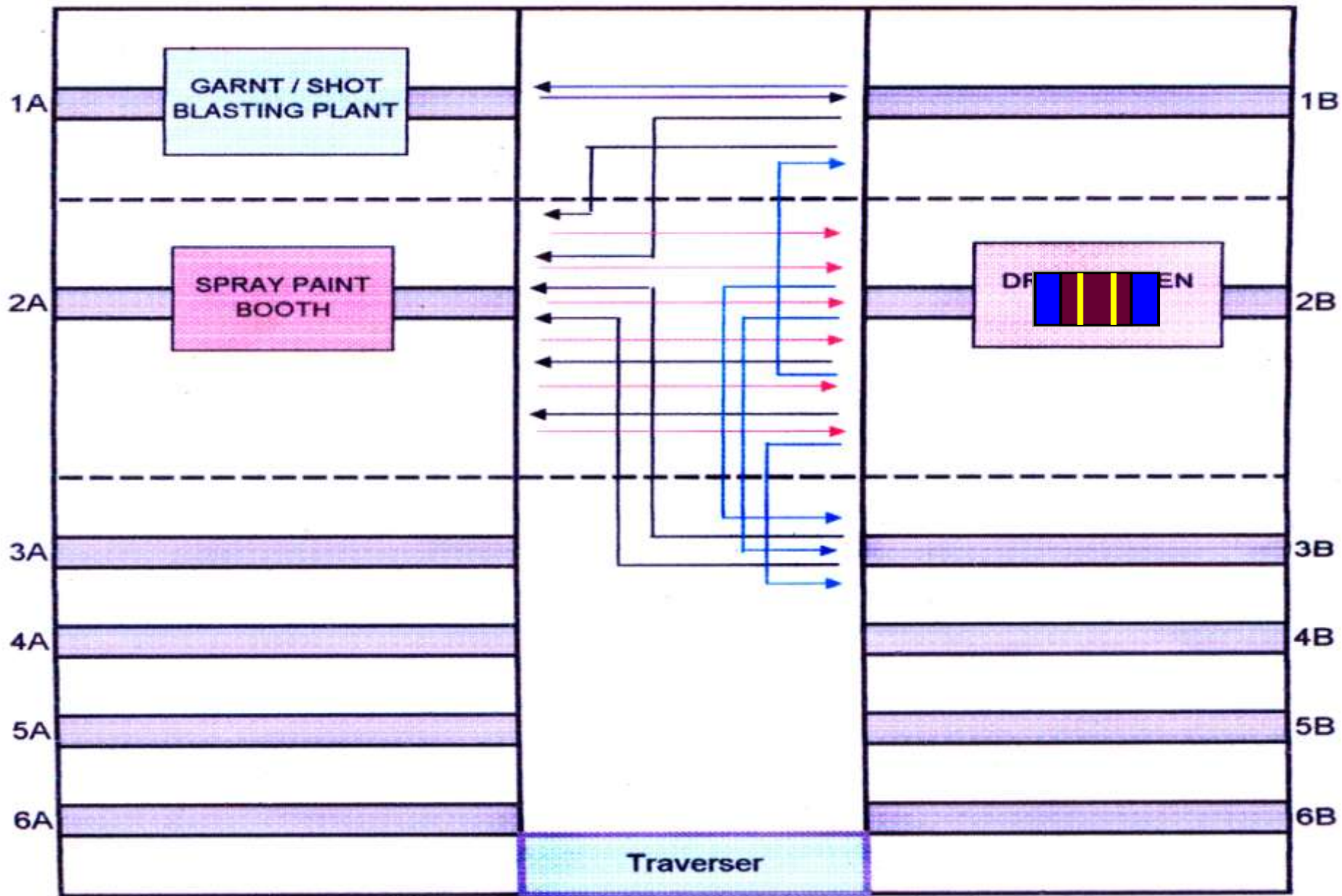


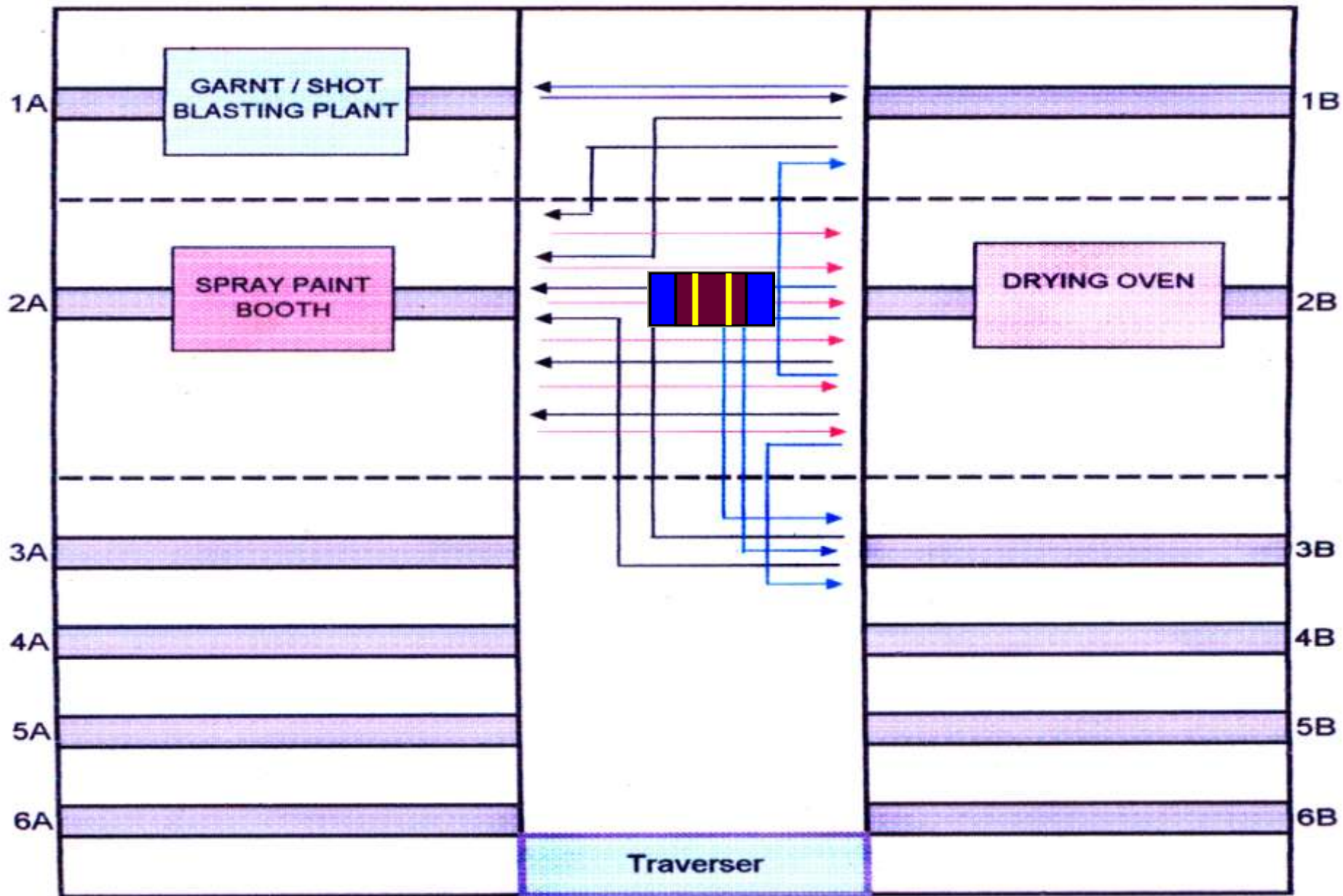
Application of Surfacer (Undercoat)



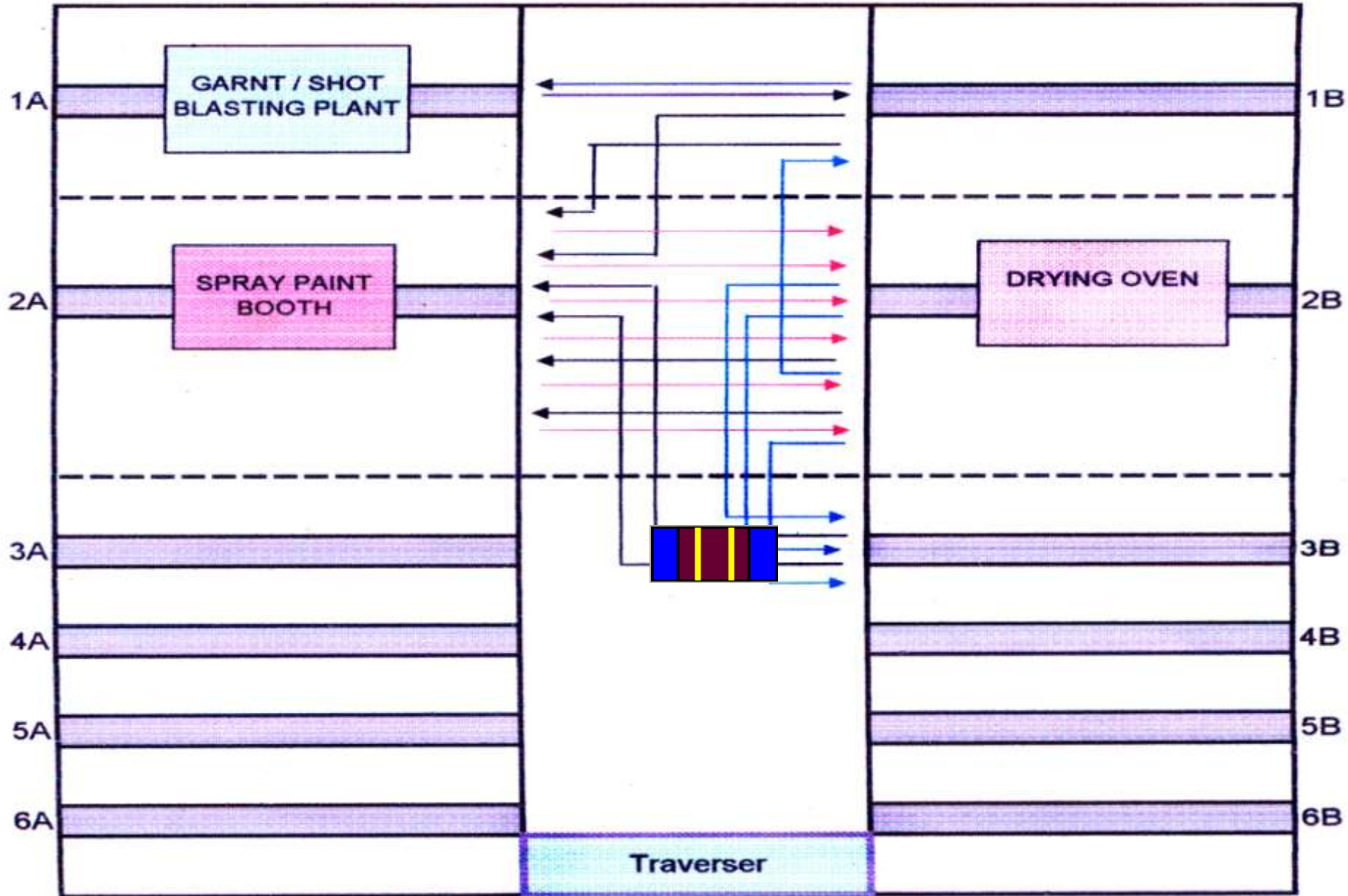
Drying in oven

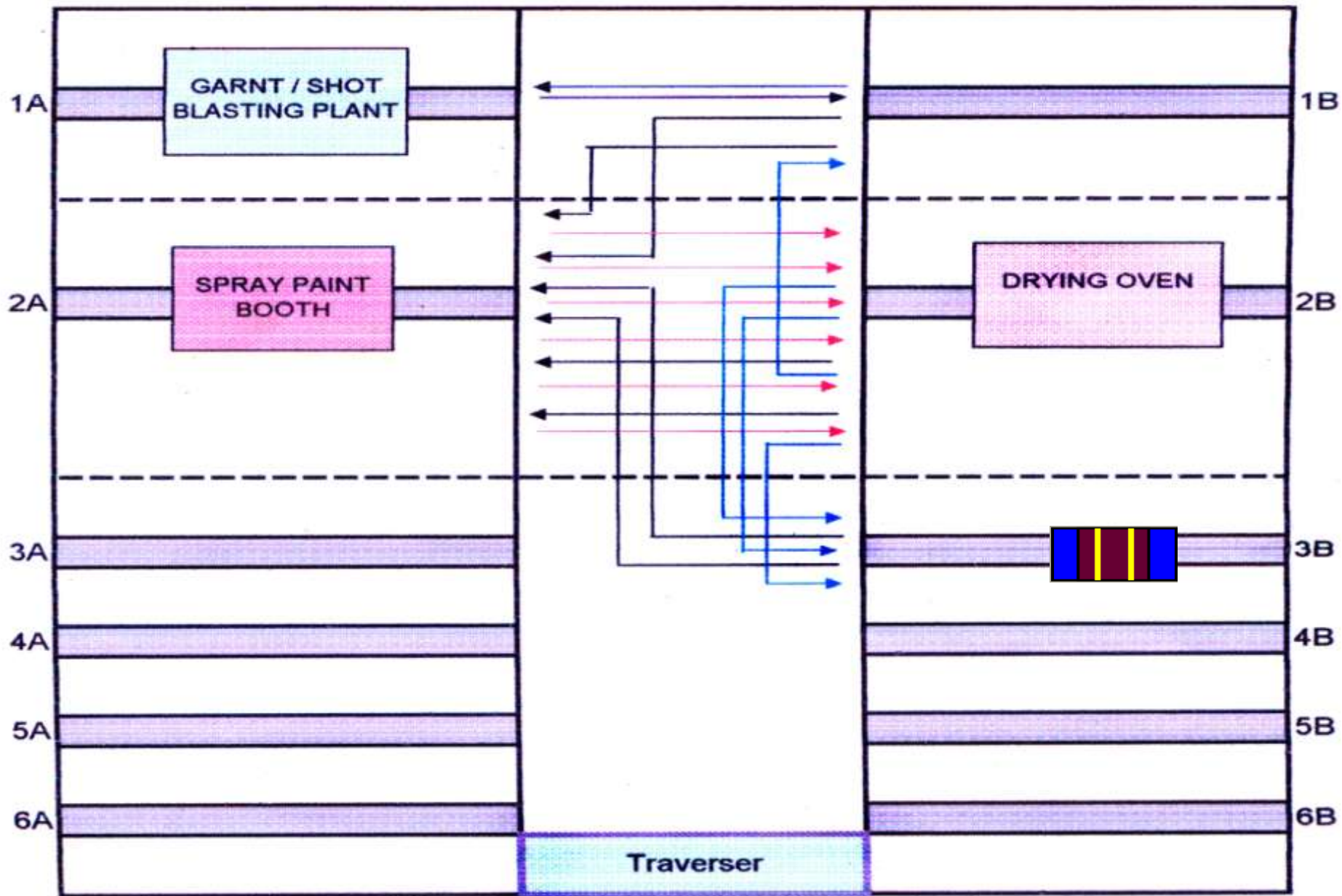


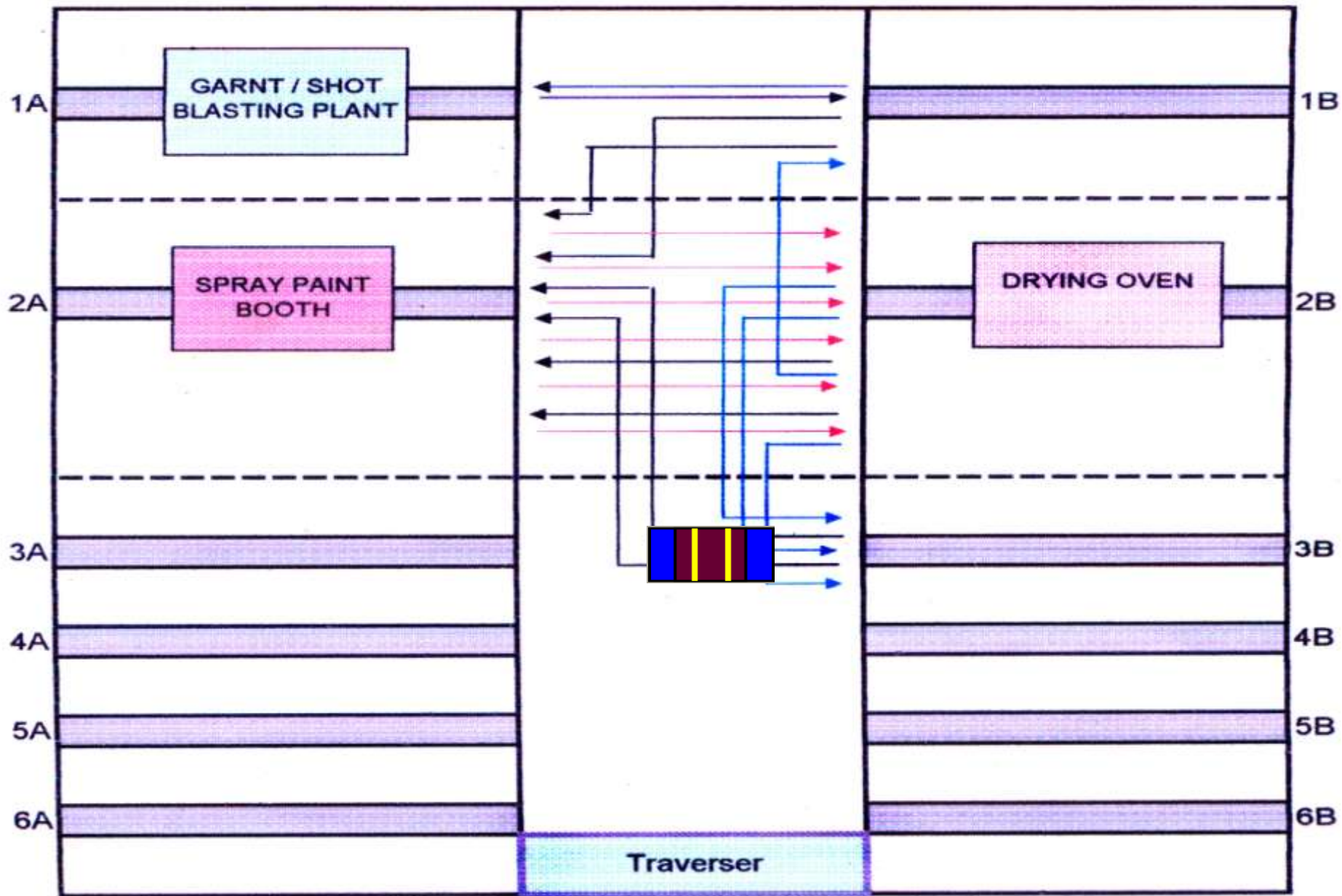




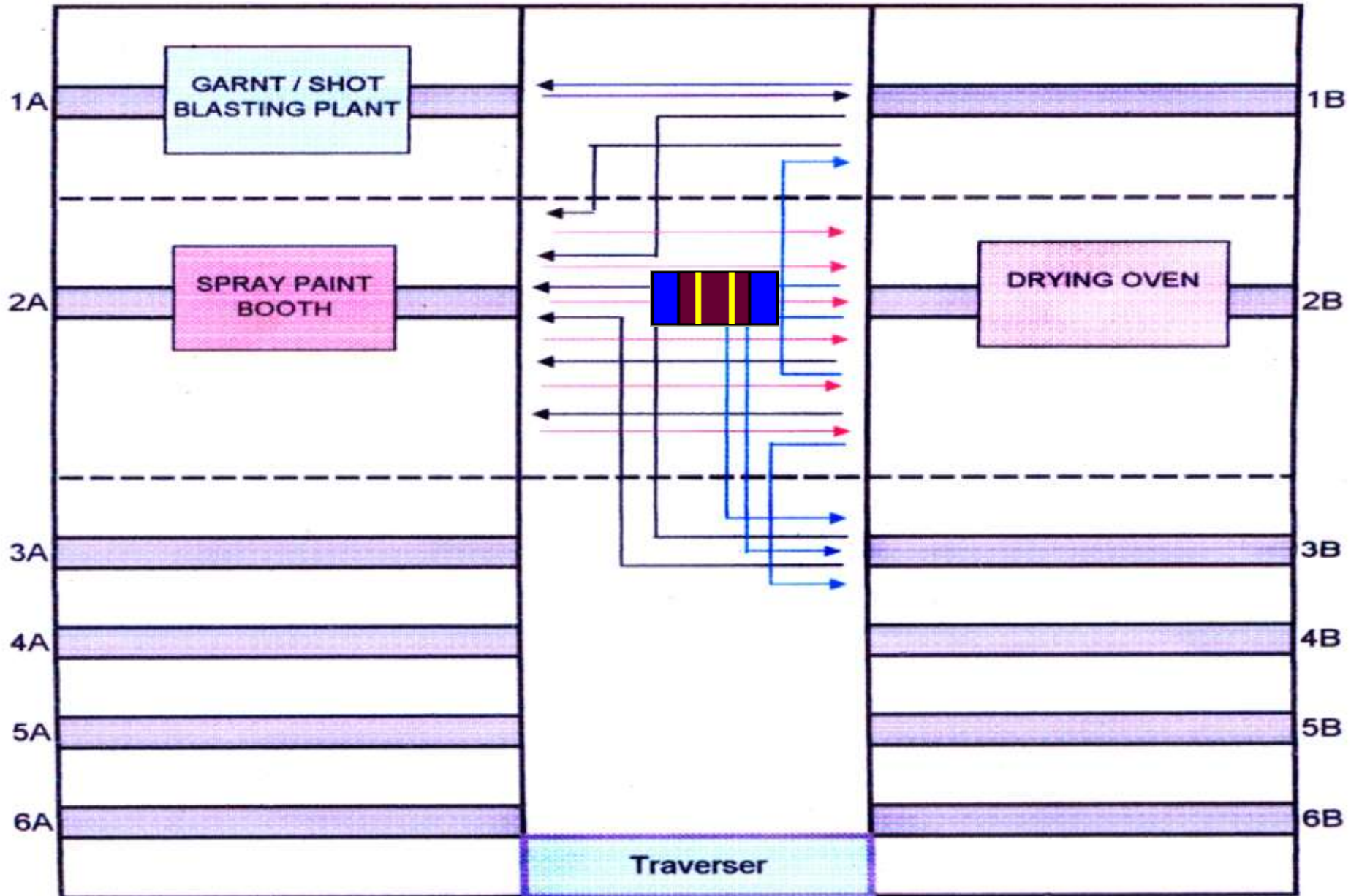
Wet rub down



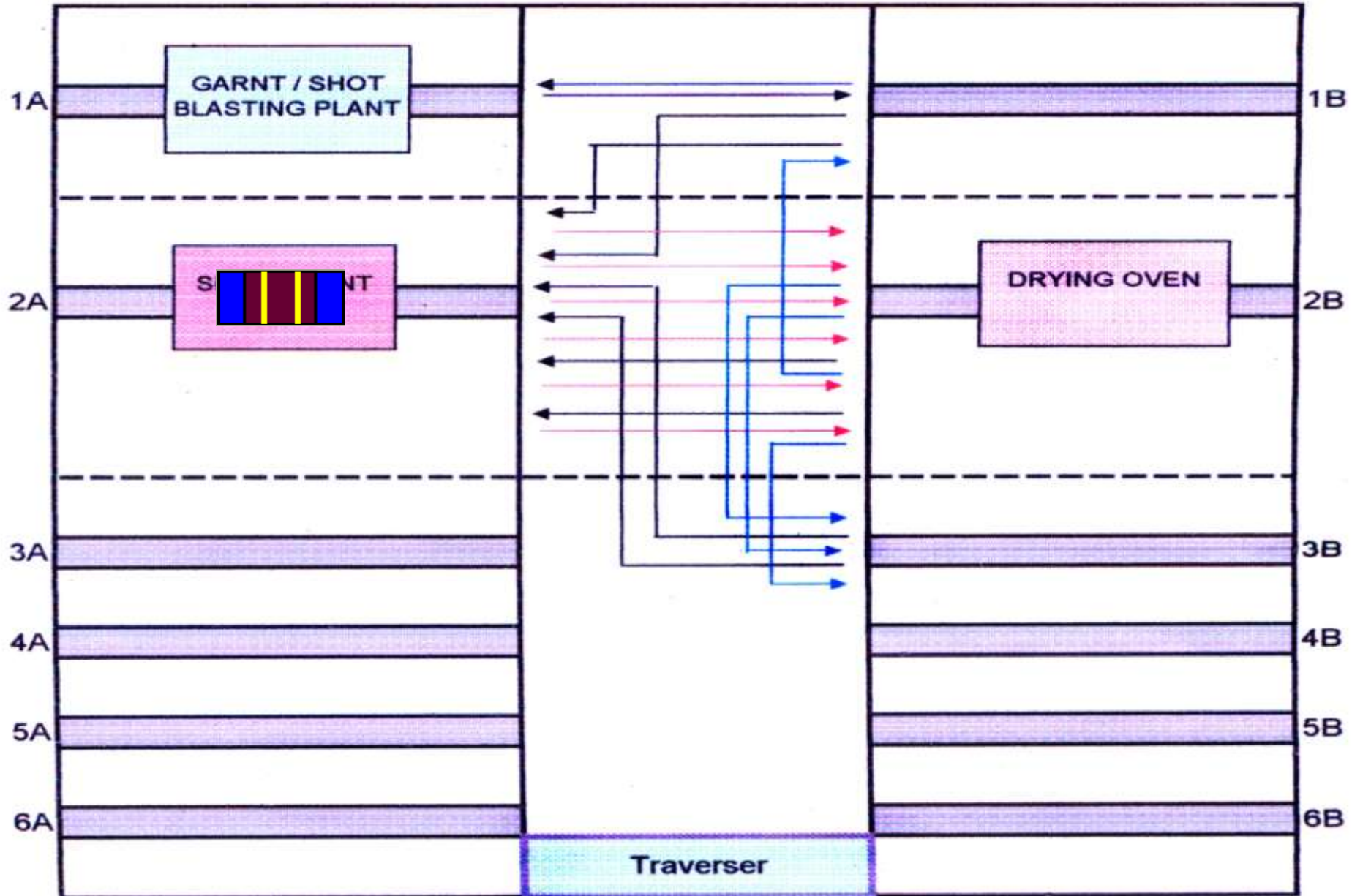




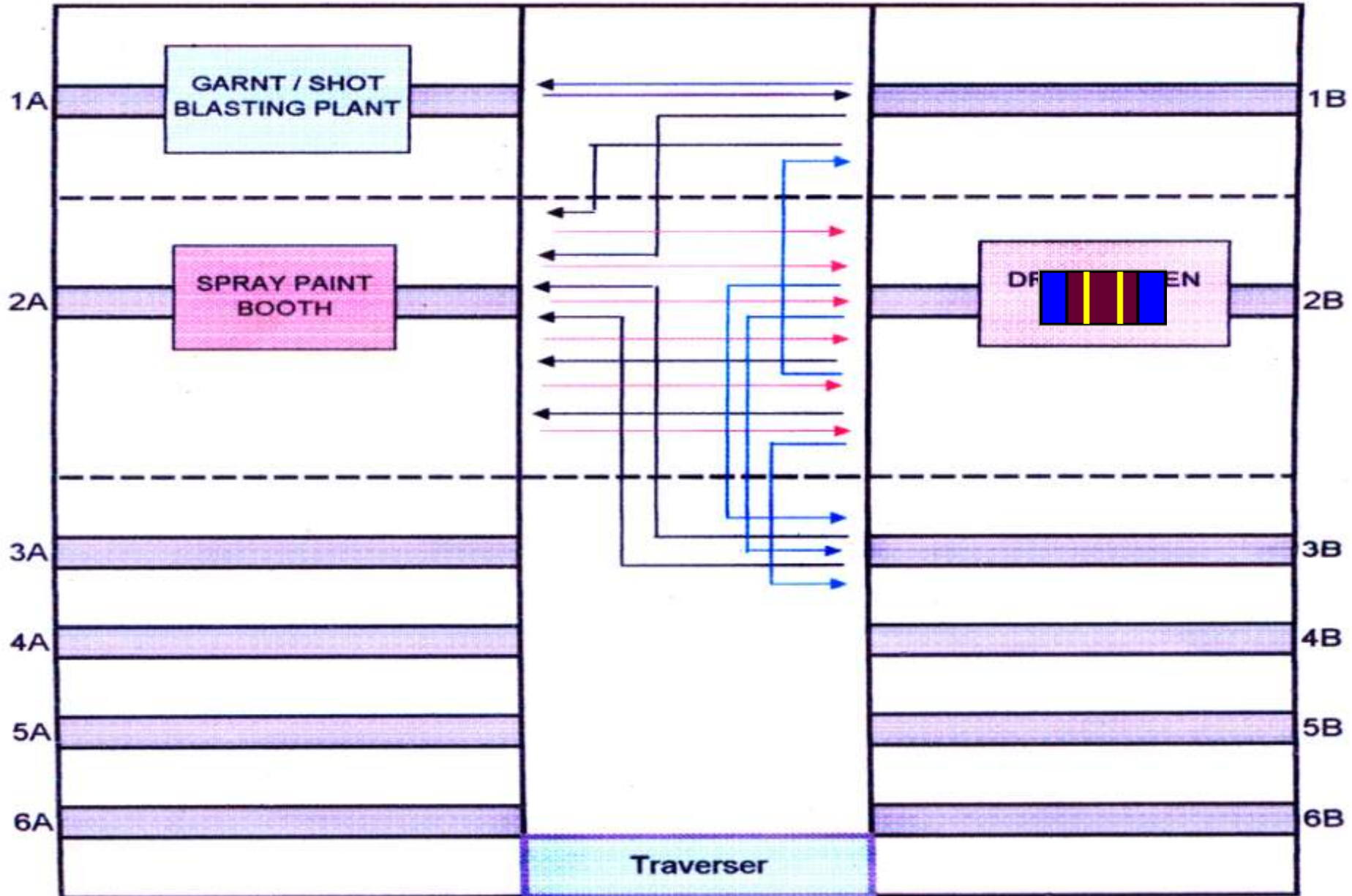
First coat PU paint application-Top



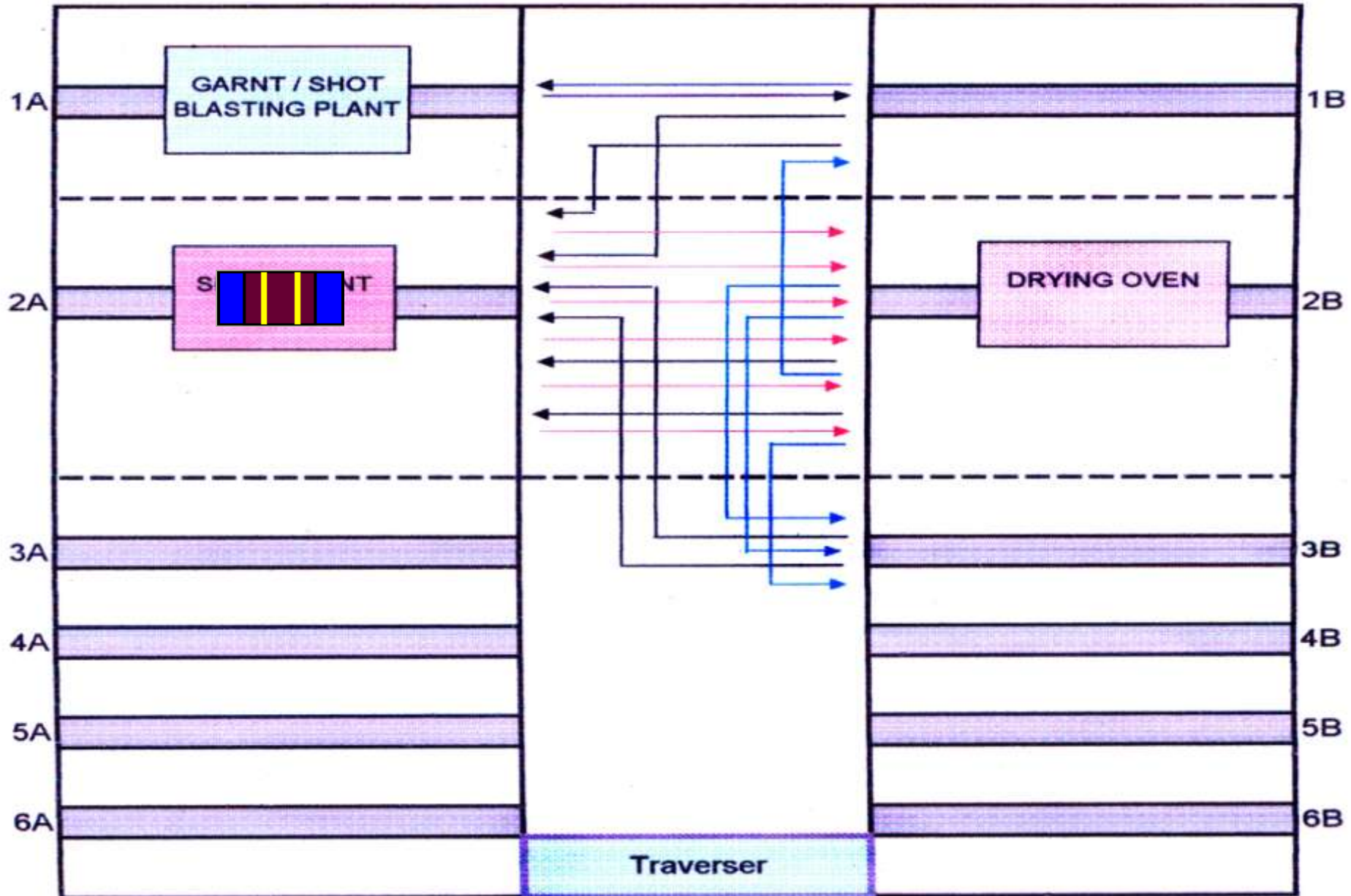
Drying in oven

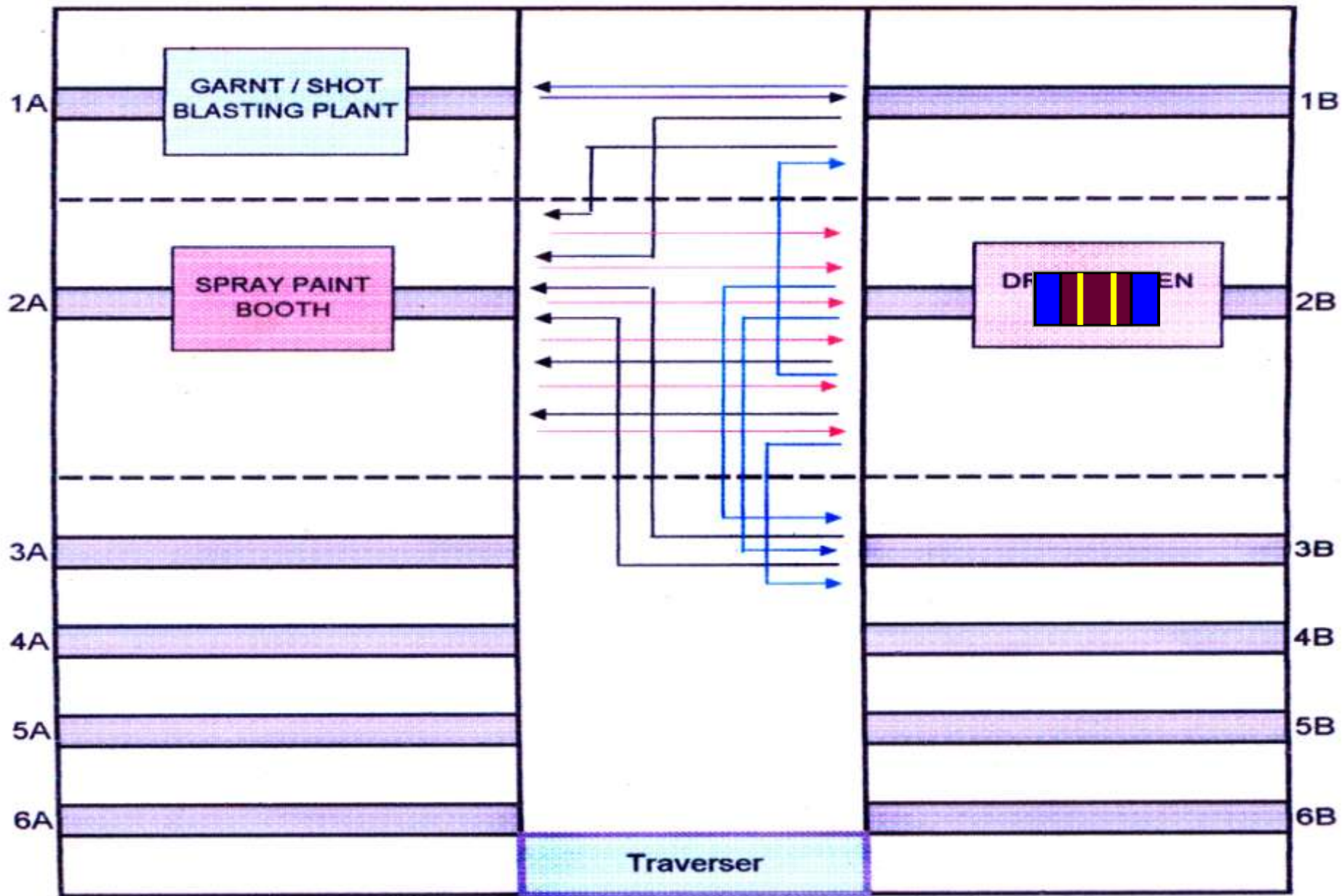


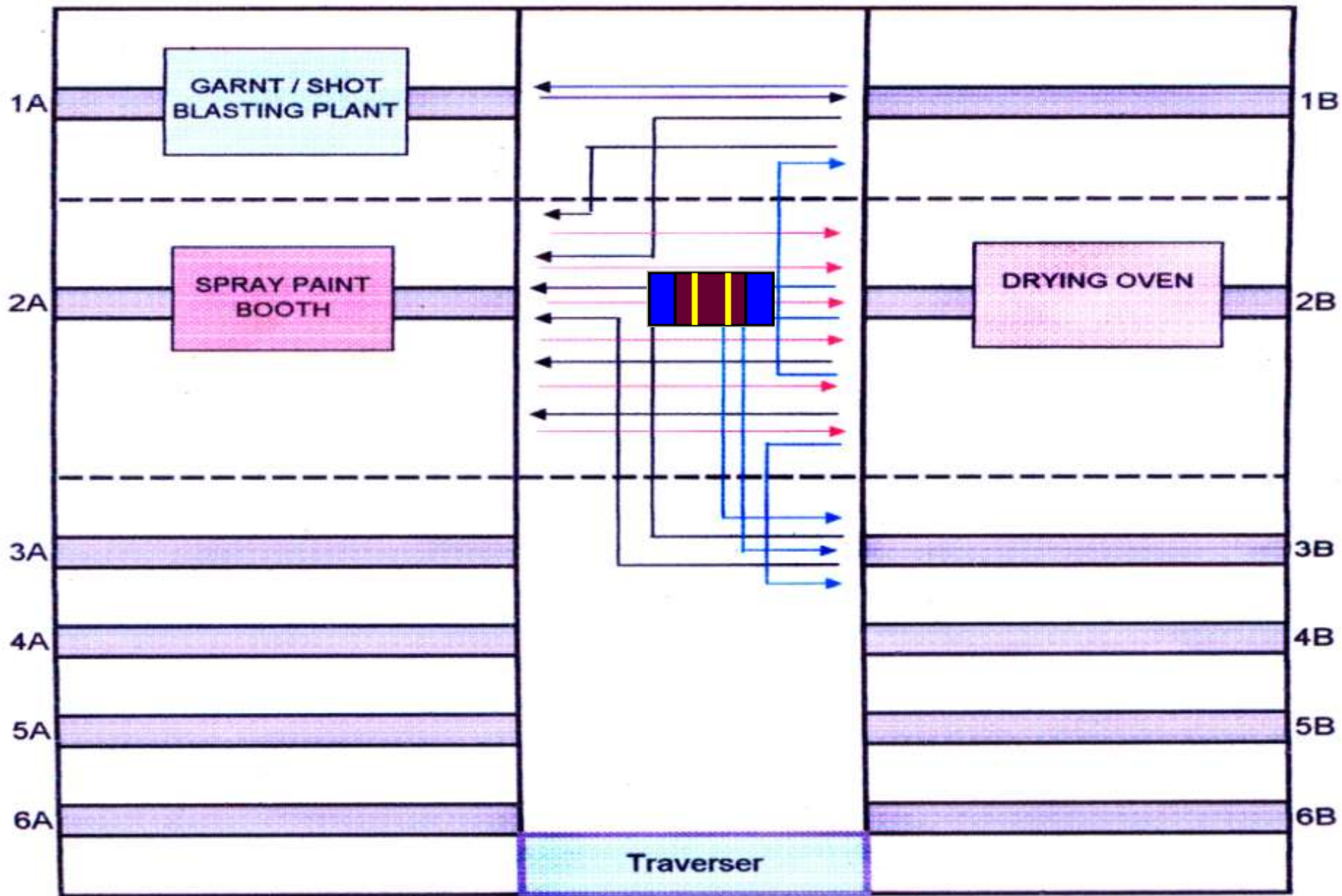
Final coat PU paint application-Top



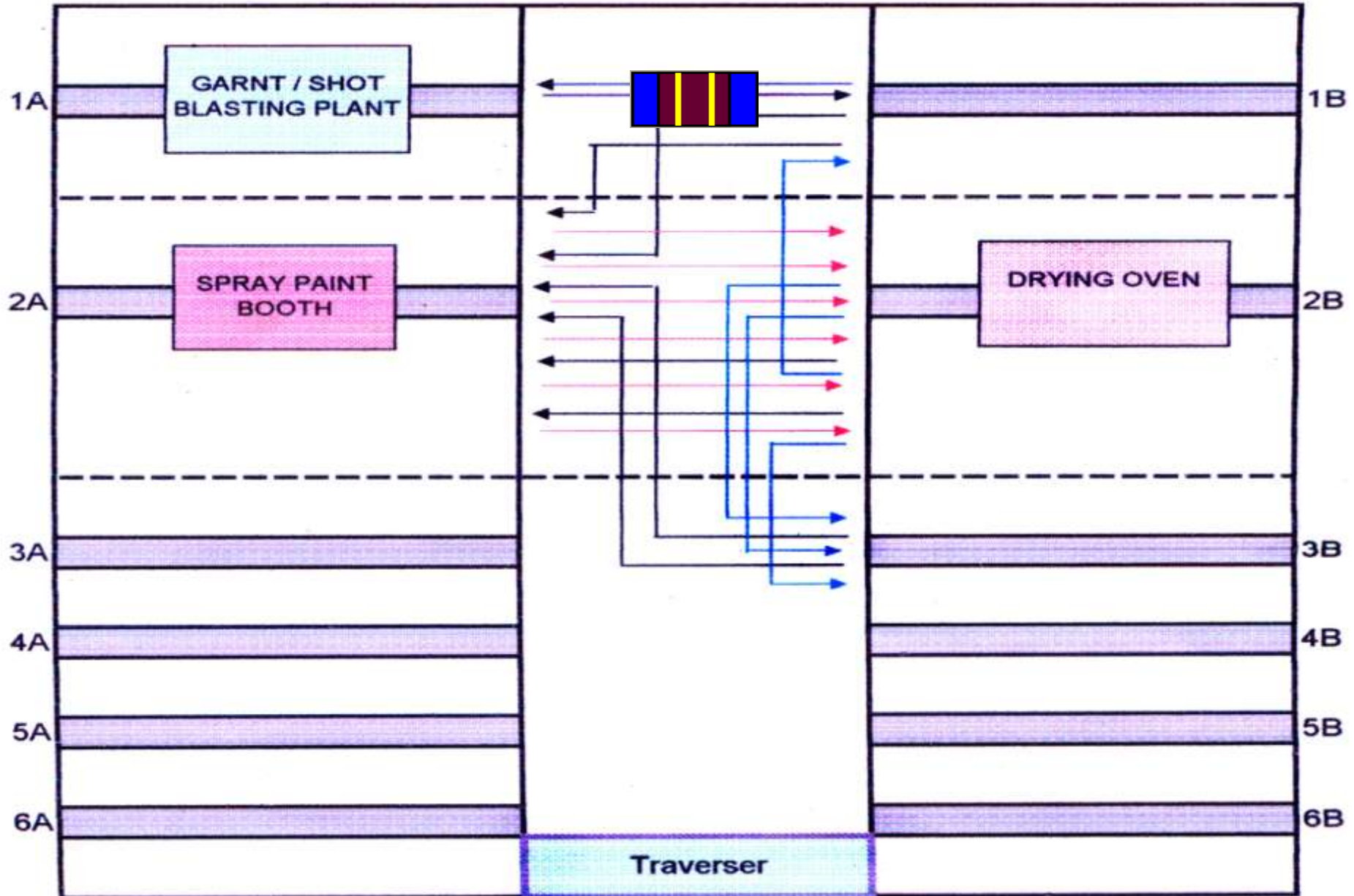
Drying in oven

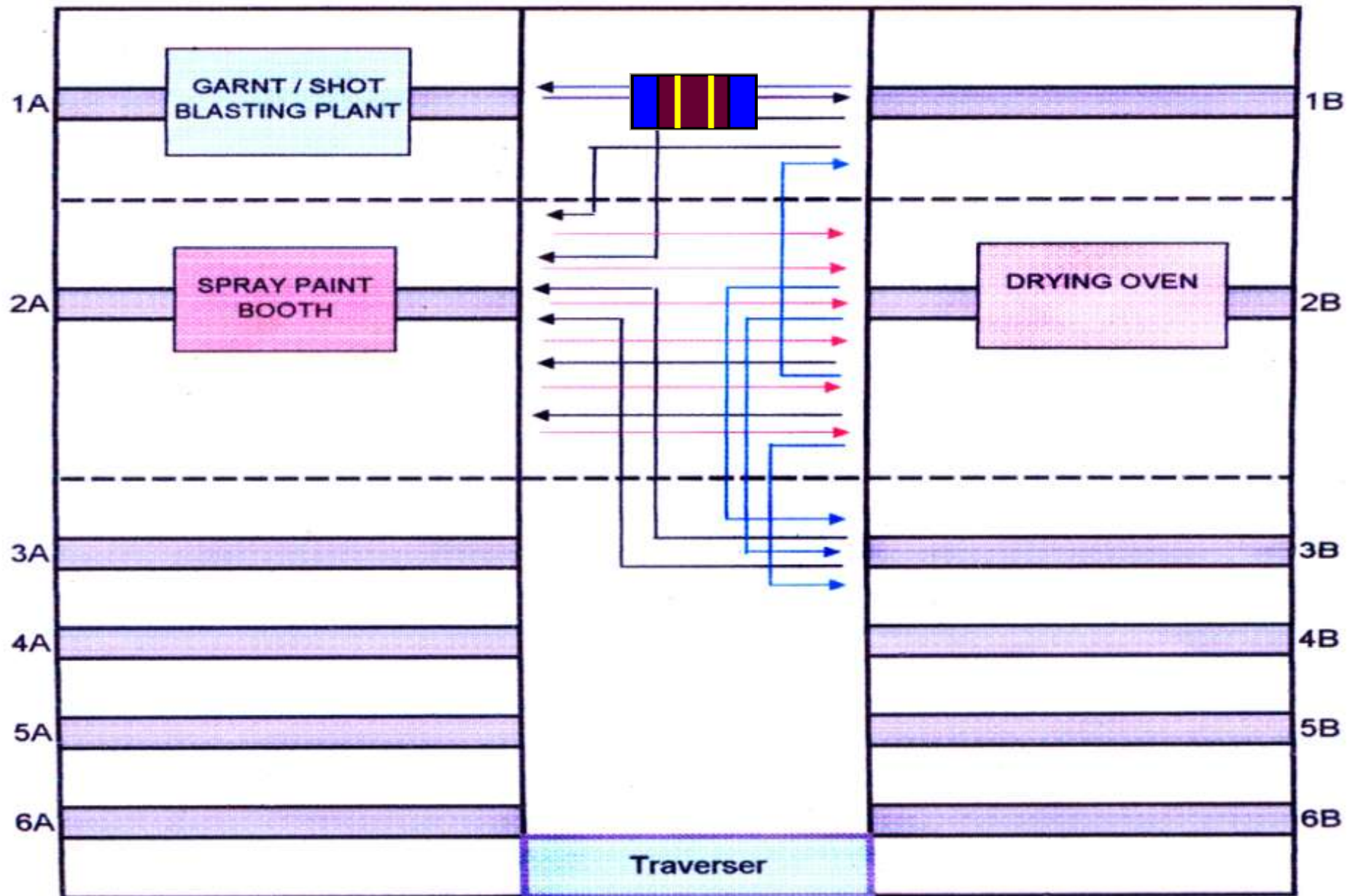




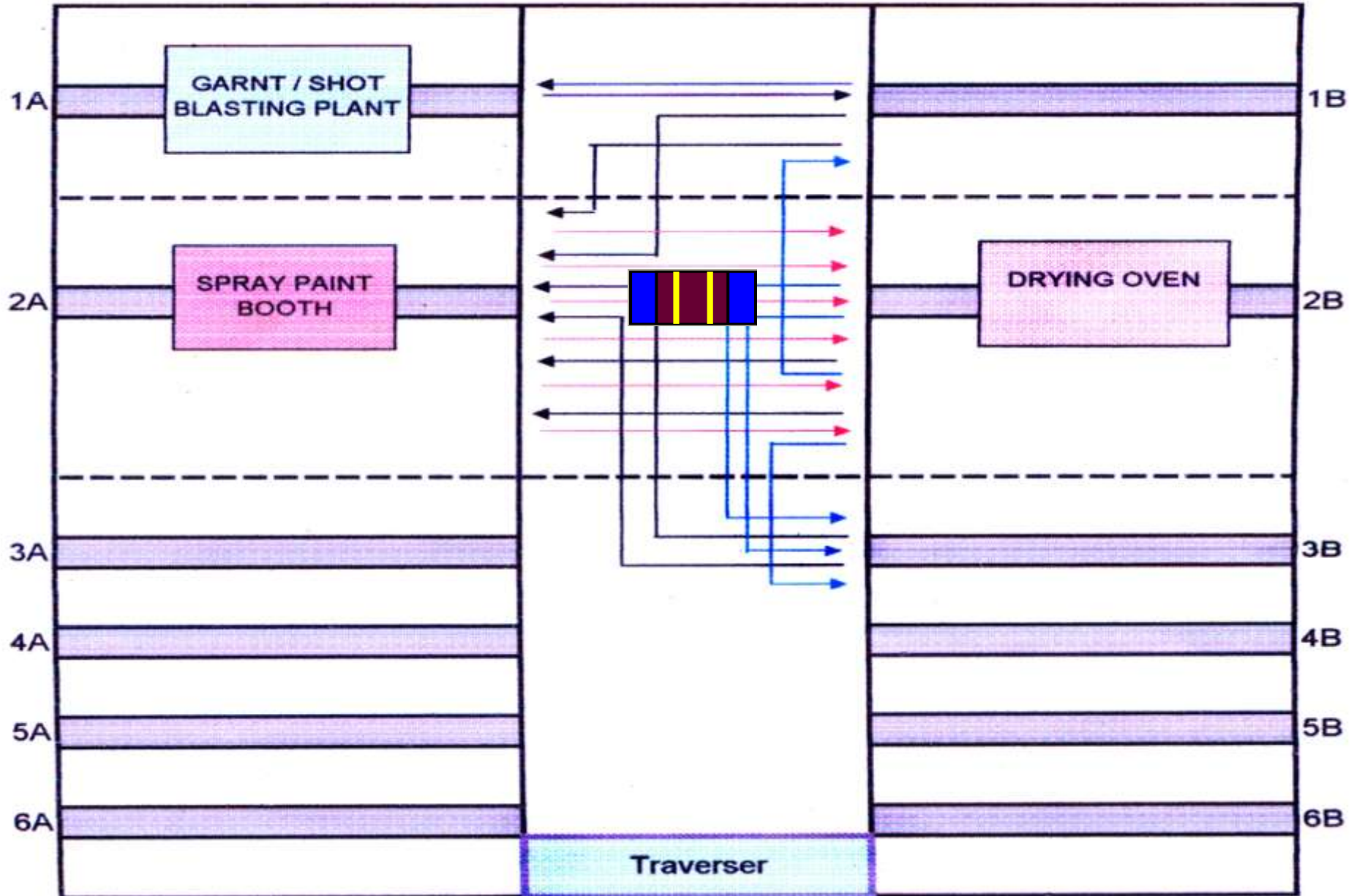


Masking top portion

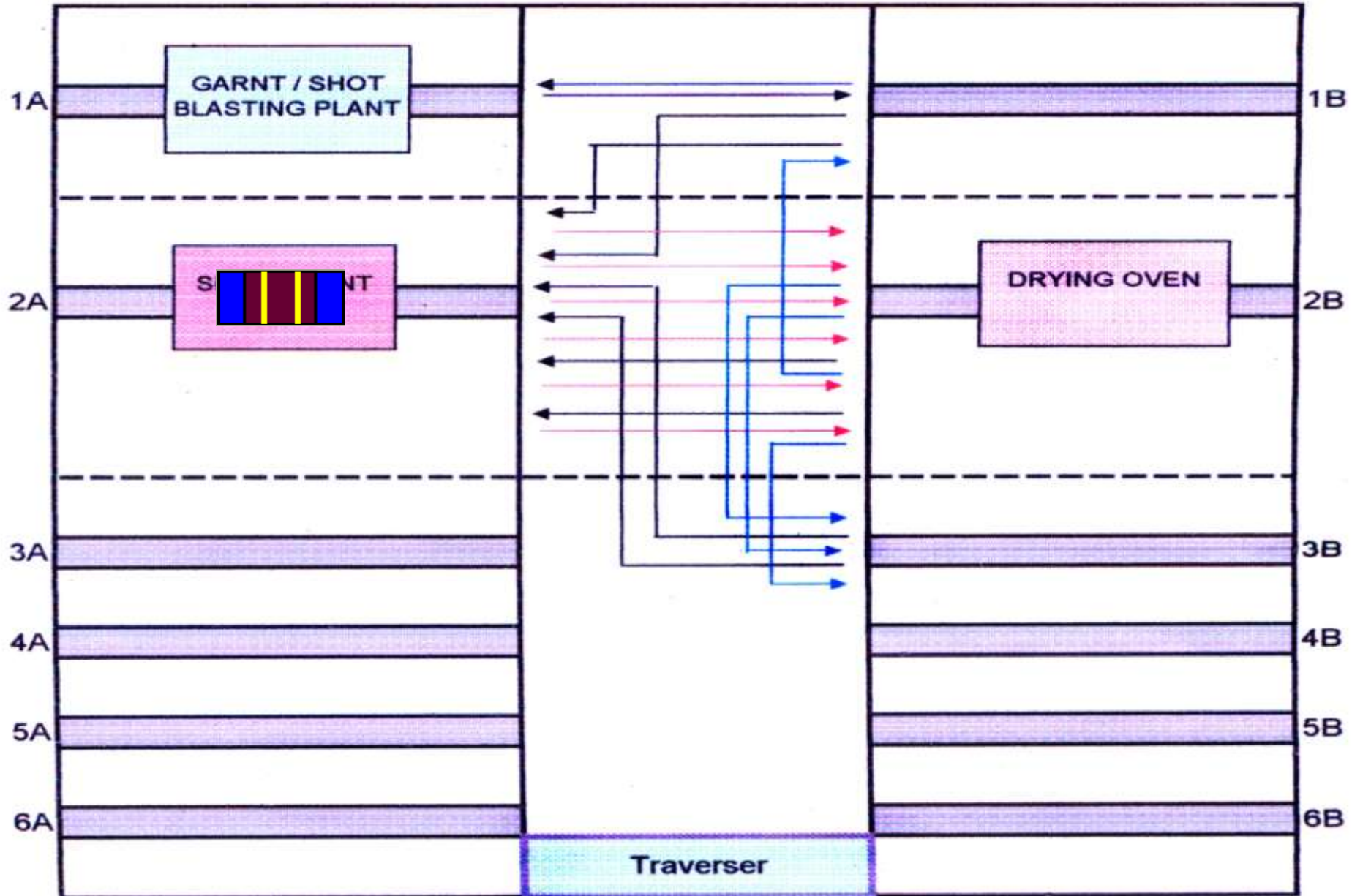




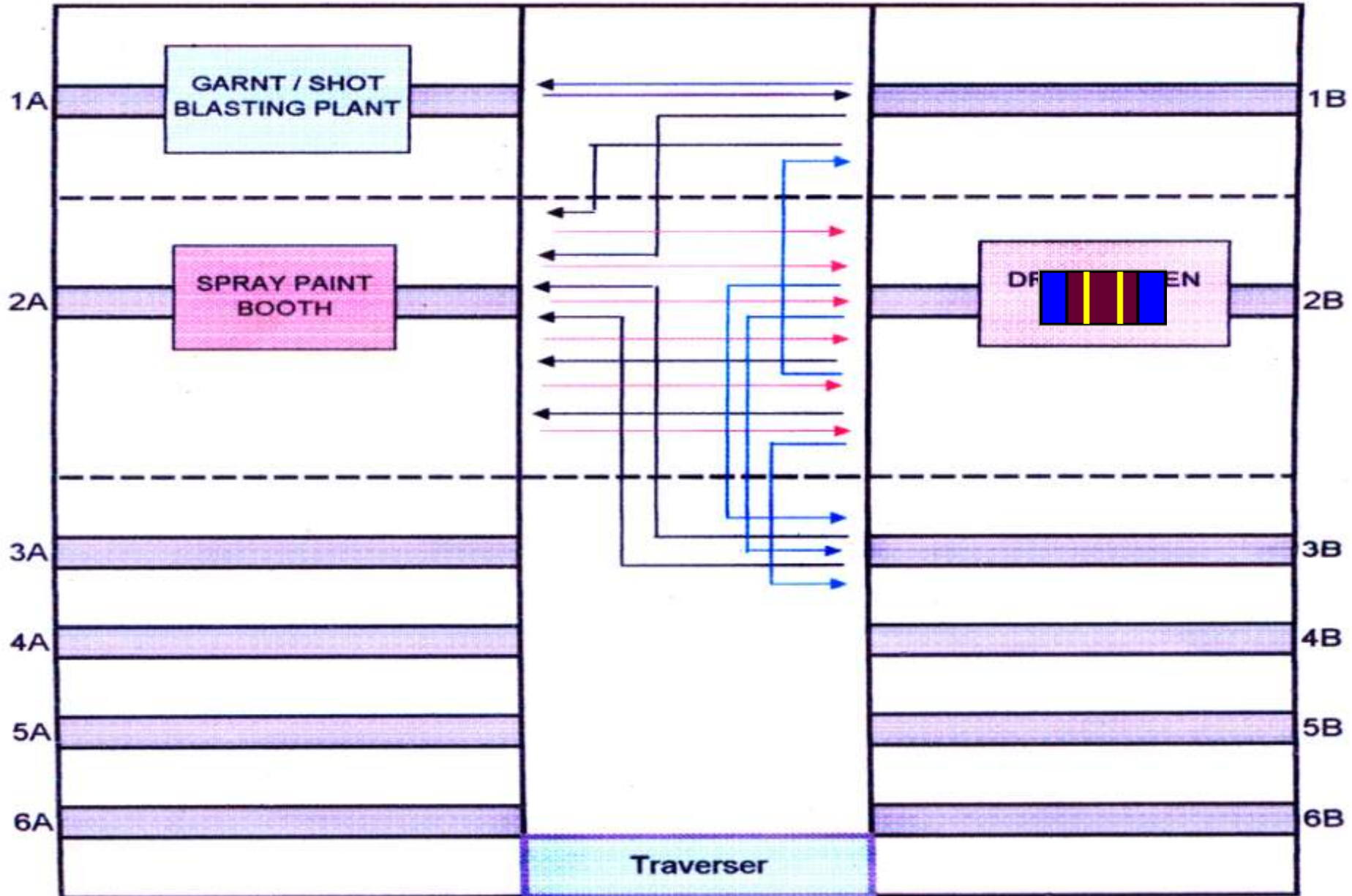
First coat PU paint application-Bottom



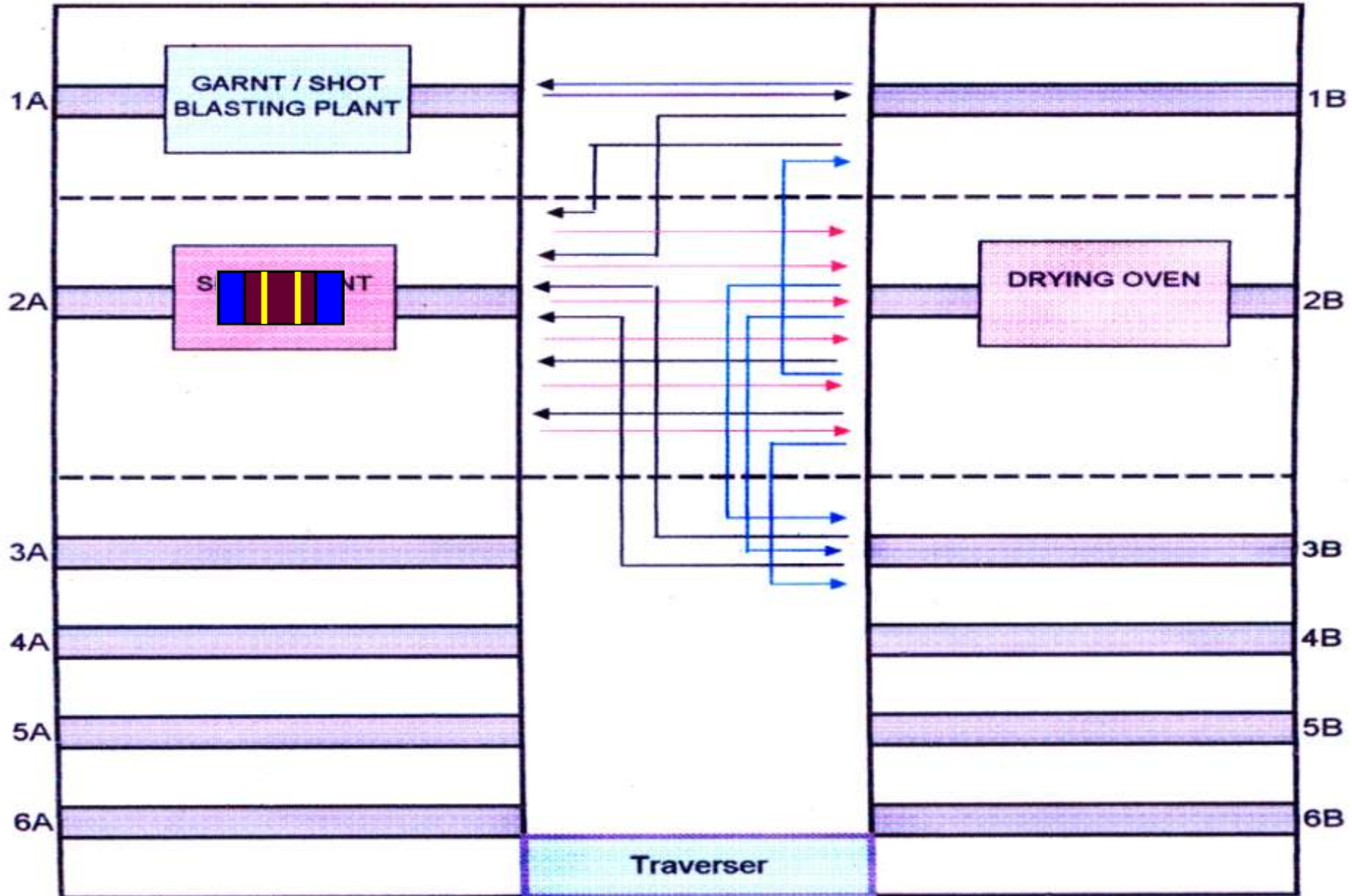
Drying in oven

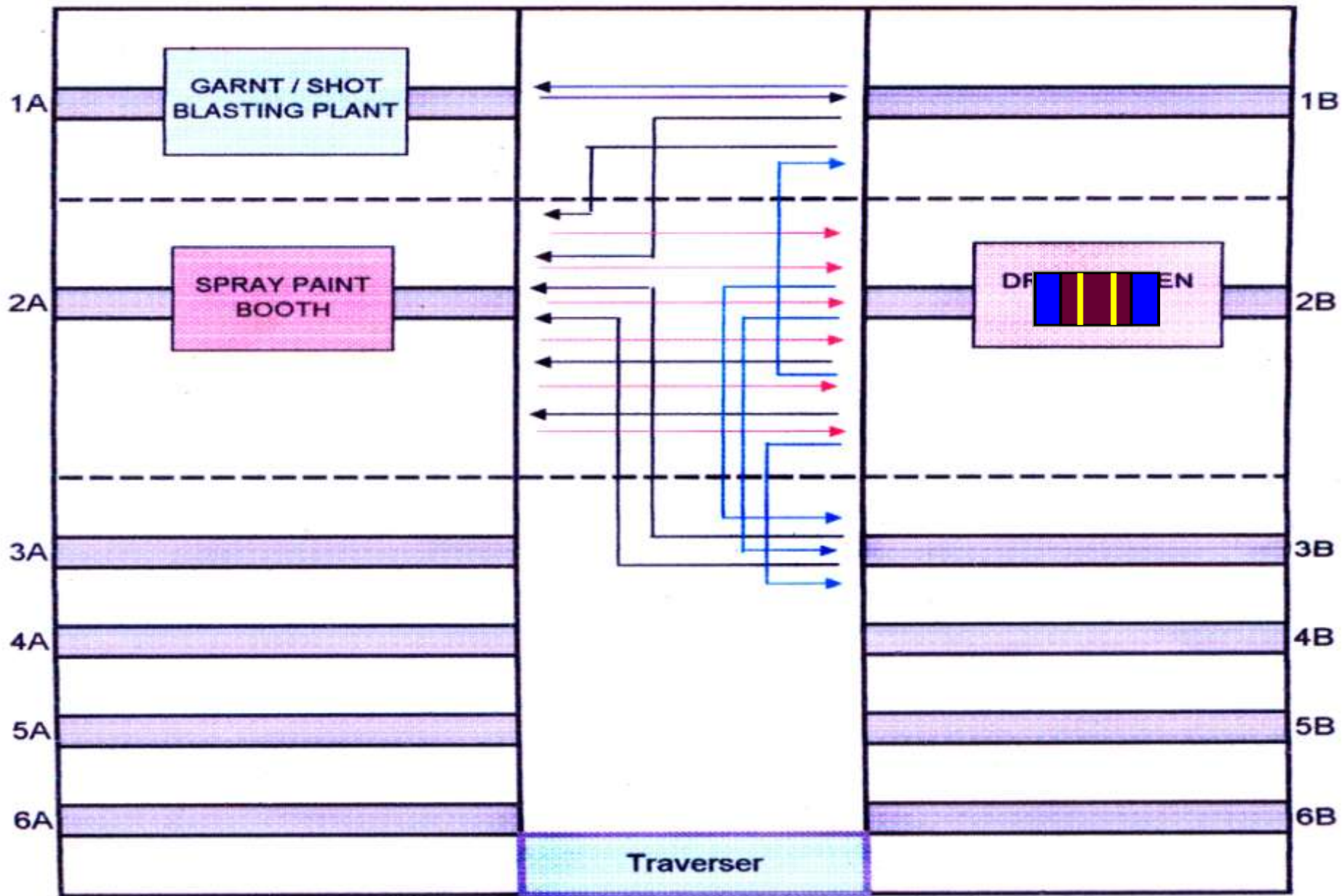


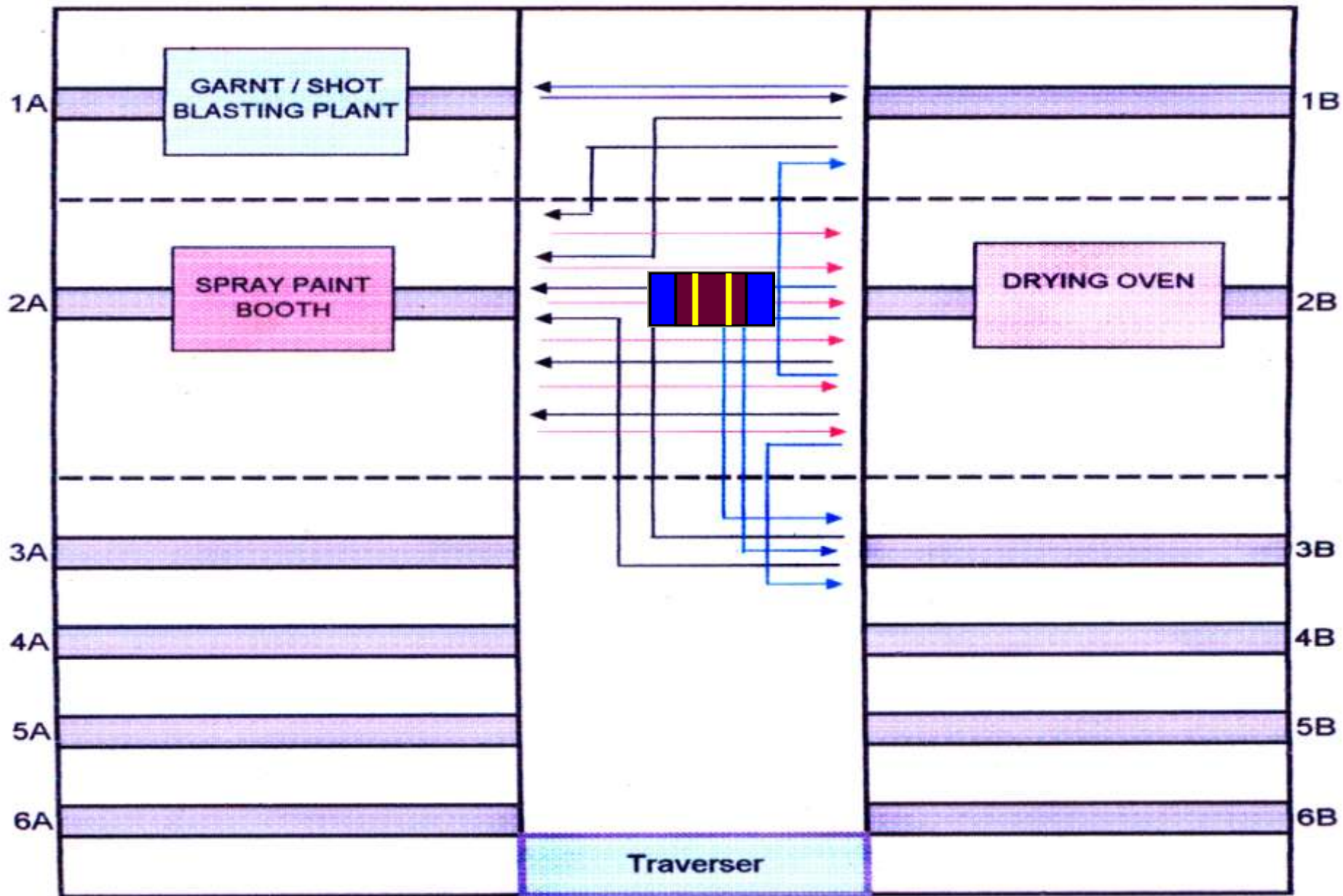
Final coat PU paint application-Bottom



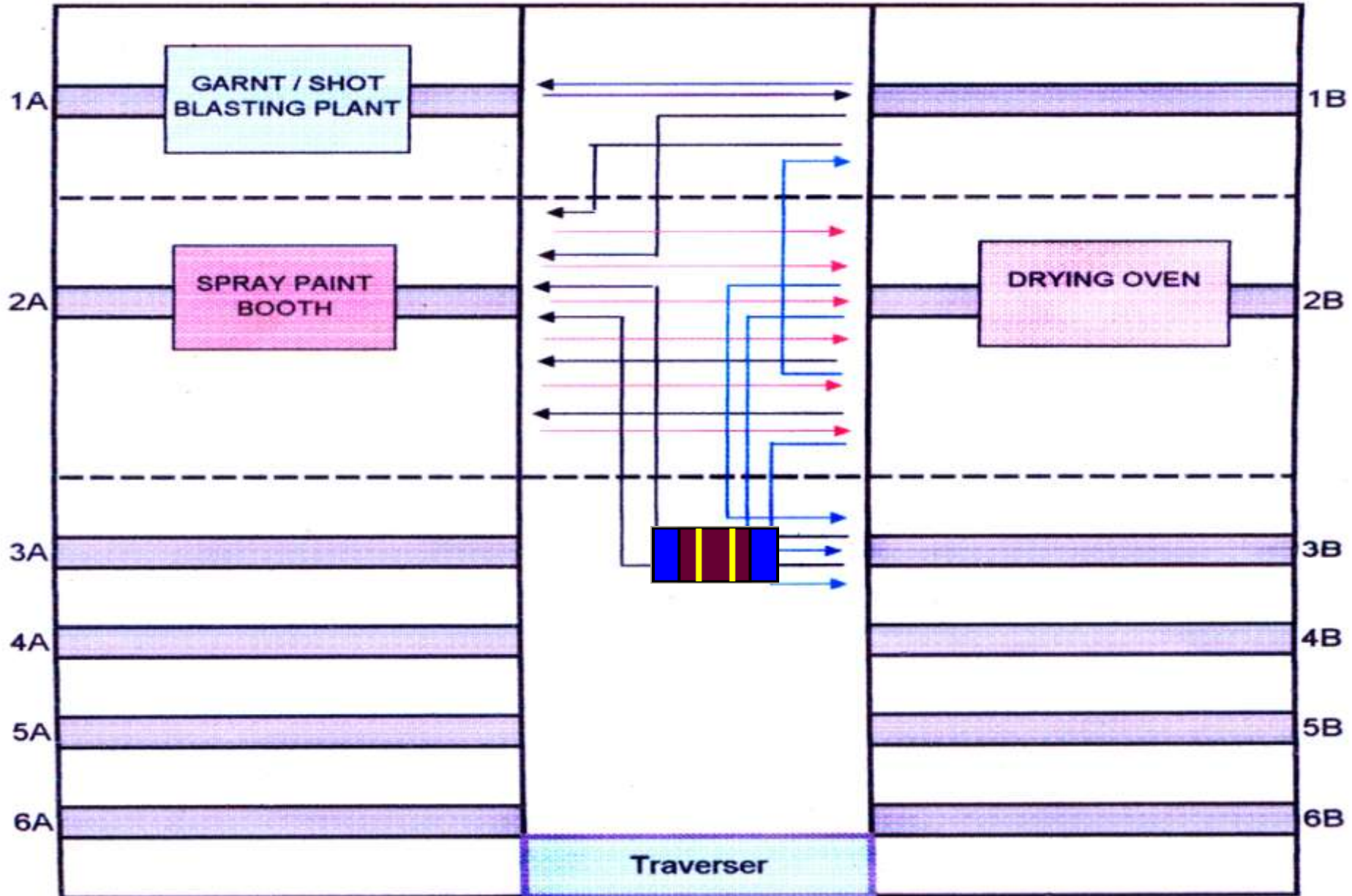
Drying in oven

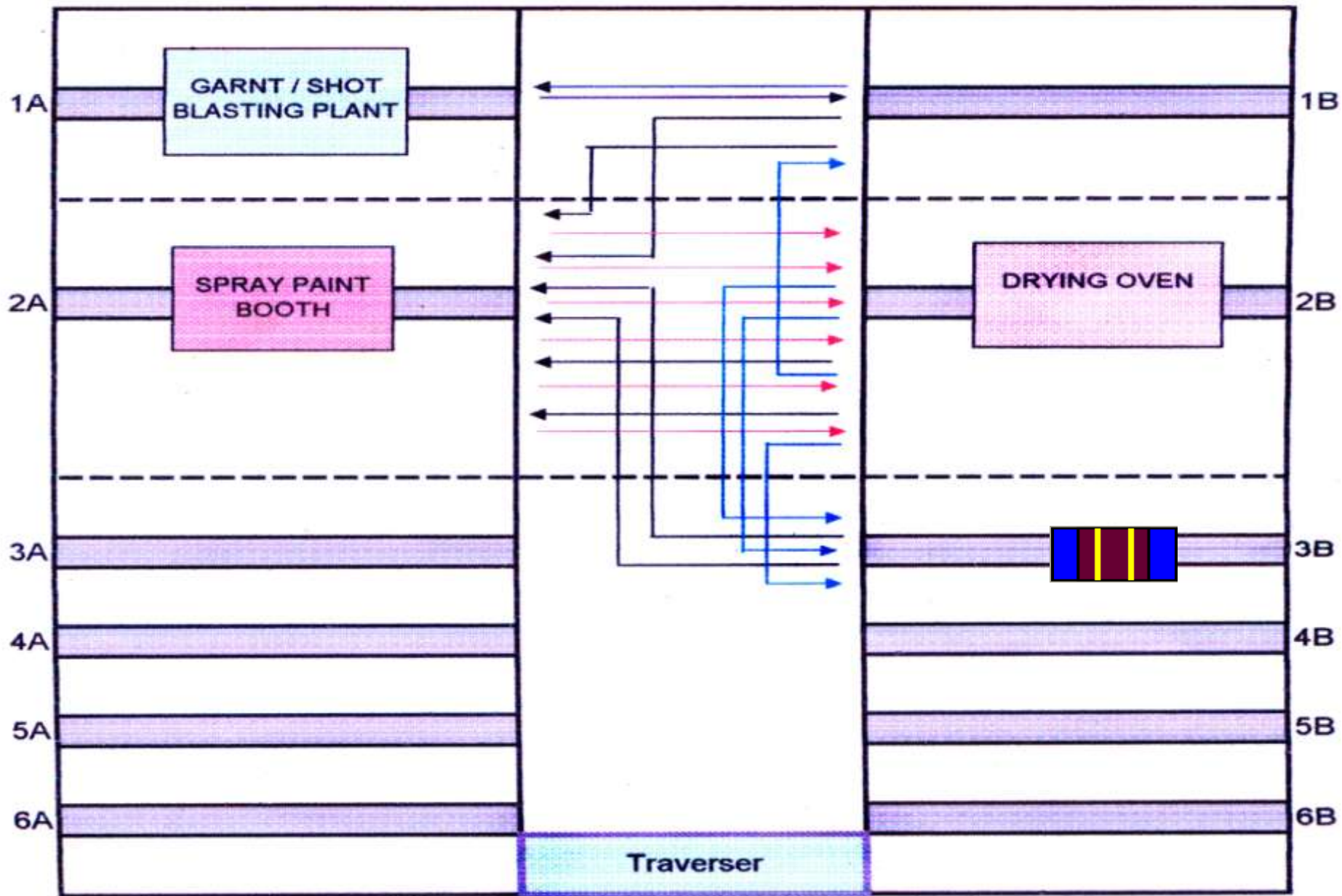


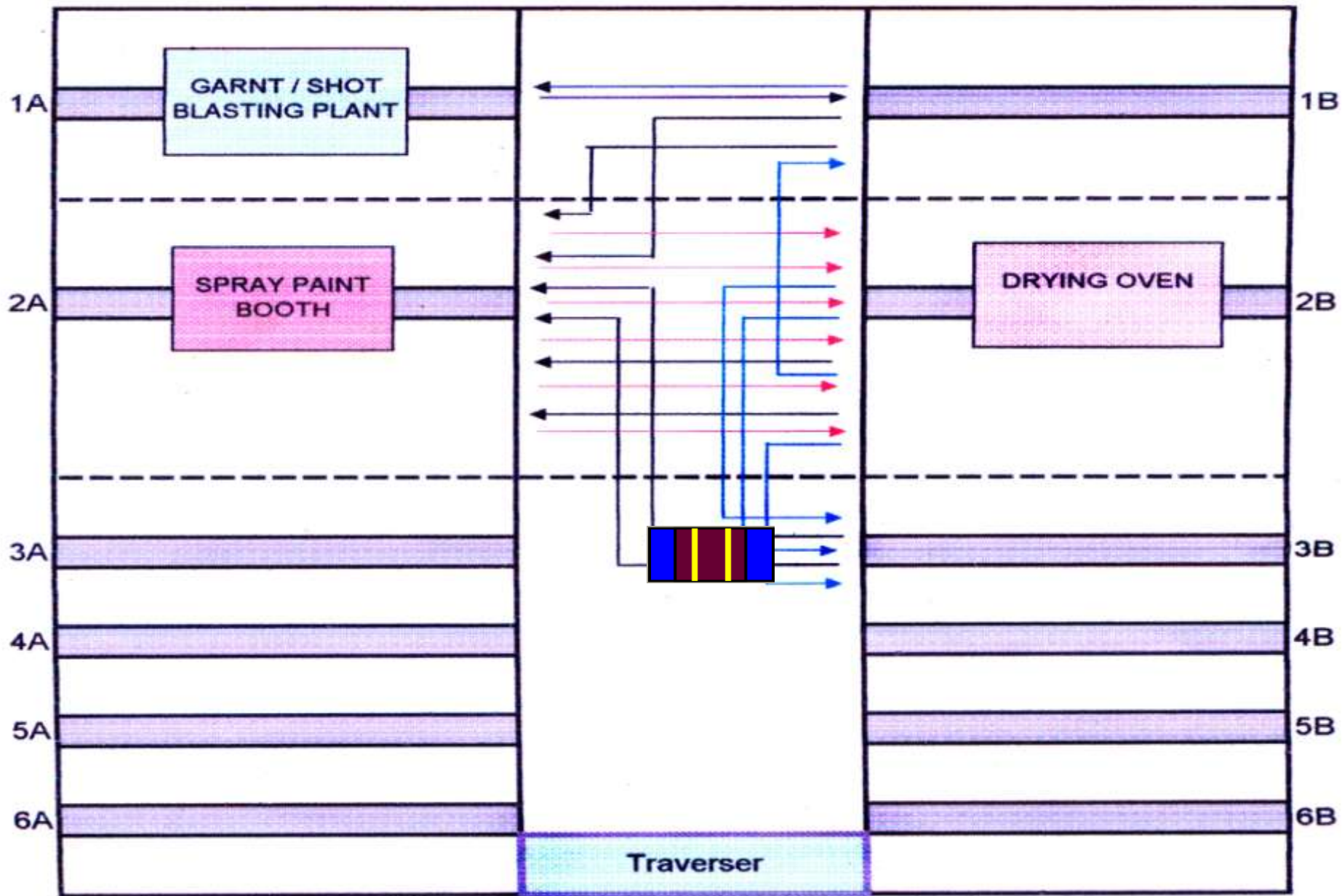




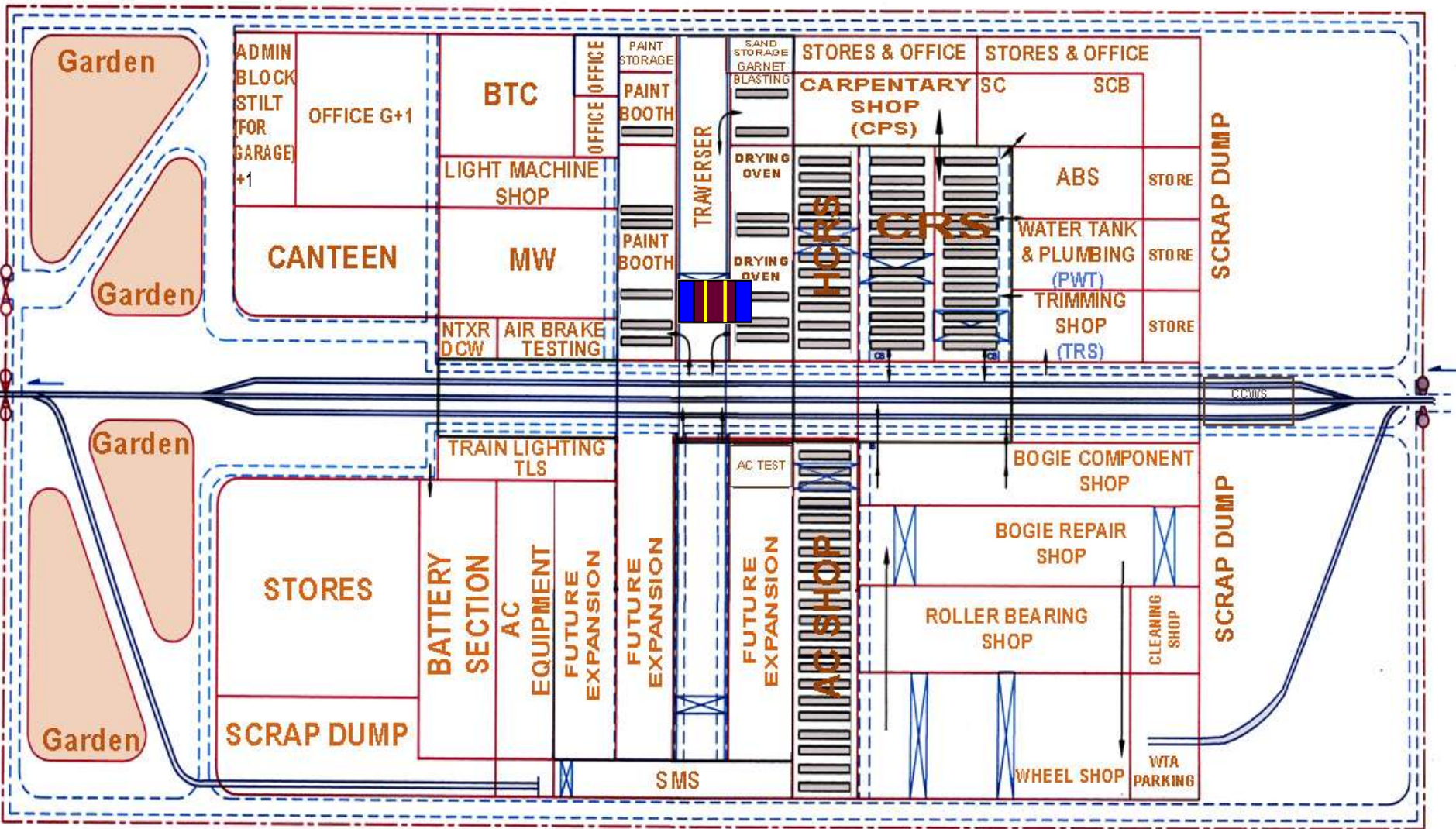
Lettering & other finishing works



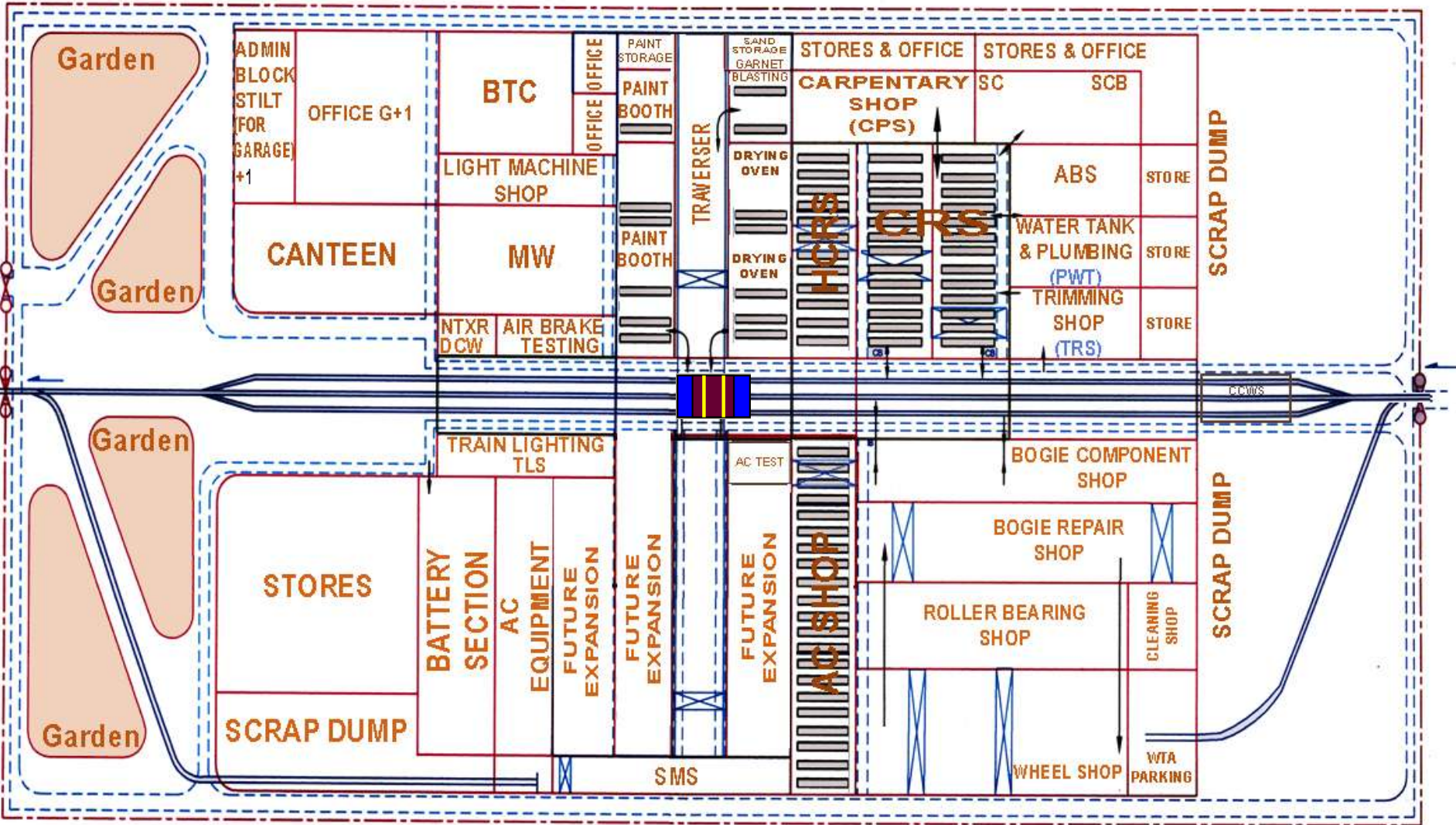




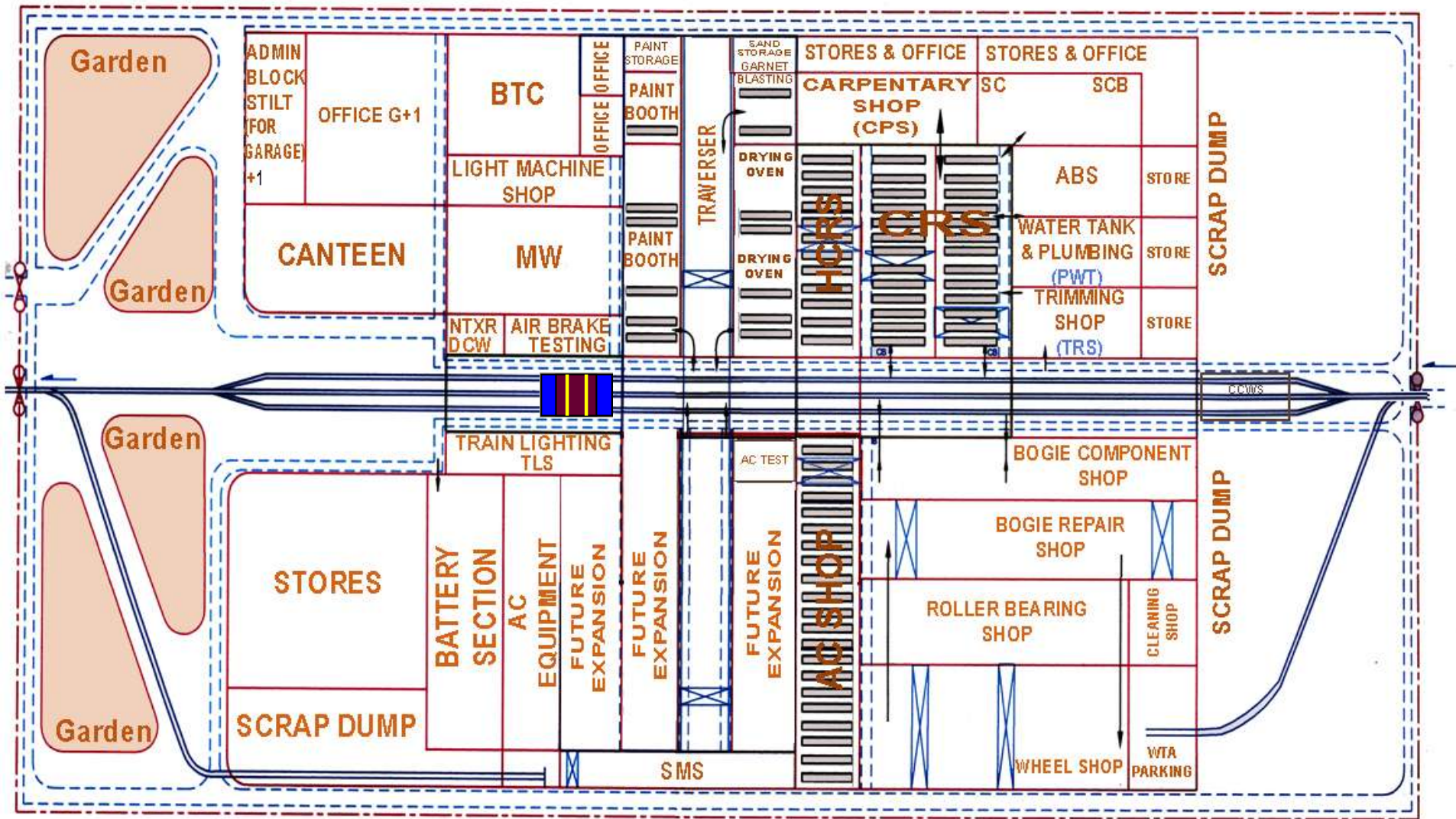
Coach out after painting



Placement of coach in the out-going Shop for fitment of electrical fittings, air brake Testing



Placement of coach in the out-going Shop for NCWS examination and DCWI inspection



Coach Turned Out

