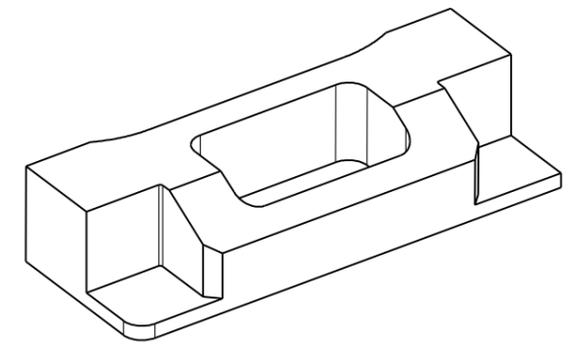
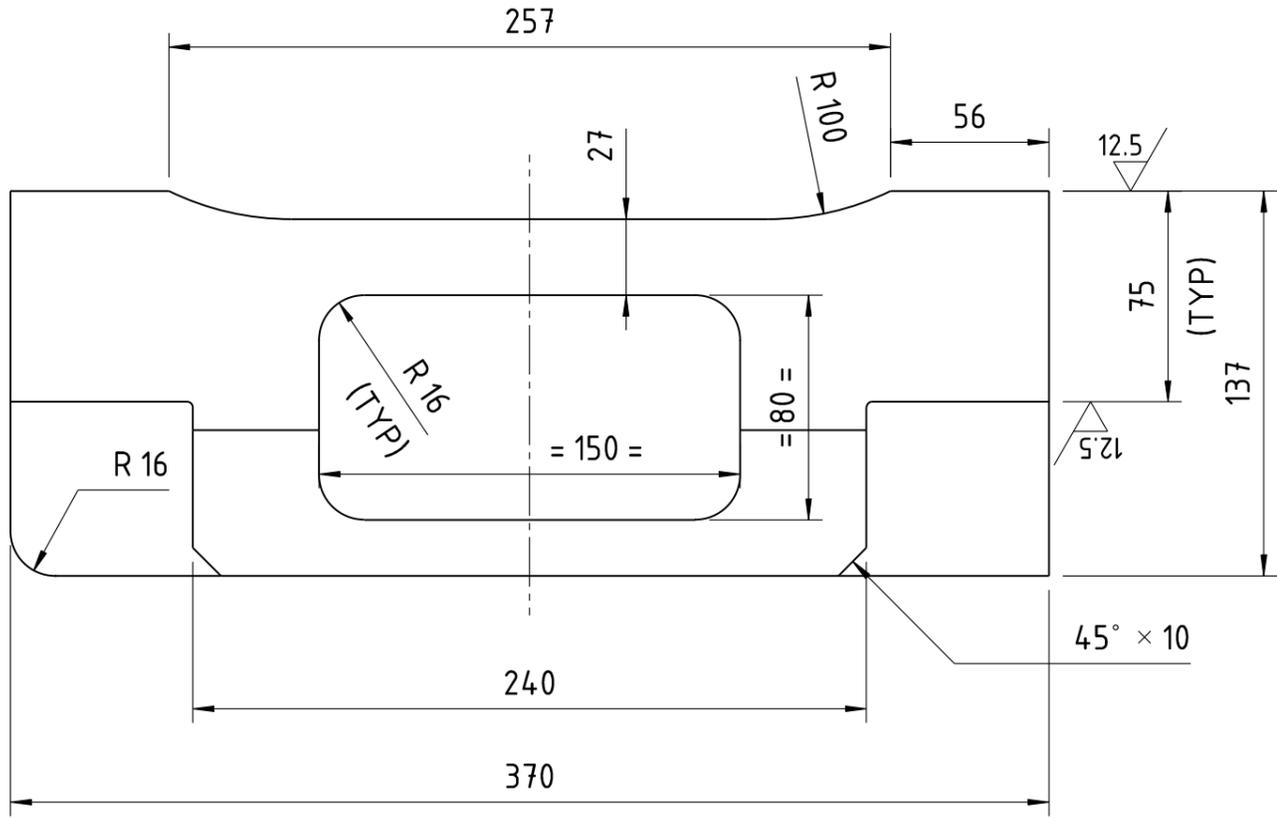


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GRADE No.	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12
VALUE	0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50
SYMBOL												
SURFACE ROUGHNESS												

MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000	RA
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	~
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227										
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM)								QUALITY OF WELD JOINTS REF, RD 230 MEDIUM		
VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS. 1012.C.										STATUS: MOCKUP/PROTO/PRODUCTION
WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96										



ISOMETRIC VIEW

UN CONTROLLED COPY

PRELIMINARY

NOTES:-

1. CONSIDER R3 FOR UNSPECIFIED RADIUS ON FORGING.
2. THE FLOW LINES SHALL FOLLOW THE CONTOUR OF THE FORGING. THE FLOW LINES SHALL NOT CUT THE CONTOUR.
3. MANUFACTURER MUST FURNISH THE TEST CERTIFICATES FOR CHEMICAL,MECHANICAL PROPERTIES AND CHECK SHEET FOR EACH BATCH OF SUPPLY
4. THE MACHINED SURFACES SHALL BE COATED WITH THE RUST PREVENTIVE FLUID TO IS:1154-2000
5. REMOVE ALL SHARP EDGES AND BURRS
6. FORGING SHALL BE SUPPLIED IN NORMALIZED CONDITION.
7. THE FORGING SHALL STRICTLY CONFIRM TO BEML PTS DOC.No. GR/TD/4640 (REFER LATEST REVISION)
8. AS IT IS A PERLIMINARY DRAWING ANY CHANGES IN DIMENSION & WEIGHT OF PART HAS TO BE CONSIDERED BY THE VENDOR.

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE (mm)	FORGING	COMPANY STD./I.S	Wt. (Kg)
						MATERIAL	
			PRODUCT	MUMBAI METRO CARS - L2 & L7			
			REF DRG				
			MATERIAL	EN 10025-5:2004, S355 J2W+N			
			HEAT TREAT.	APPD	MS		
			SURFACE TREAT.	REVD	DB		
			TITLE	CHKD	JC		
			LOWER SUPPORT, T/M MOUNTING ASSY	DRWN	ILYAS		
				SCALE	1:2.5	SHEET	1 OF 1
							18.9
ALT.No.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	DRG No.	ALT
						525-83167	0

