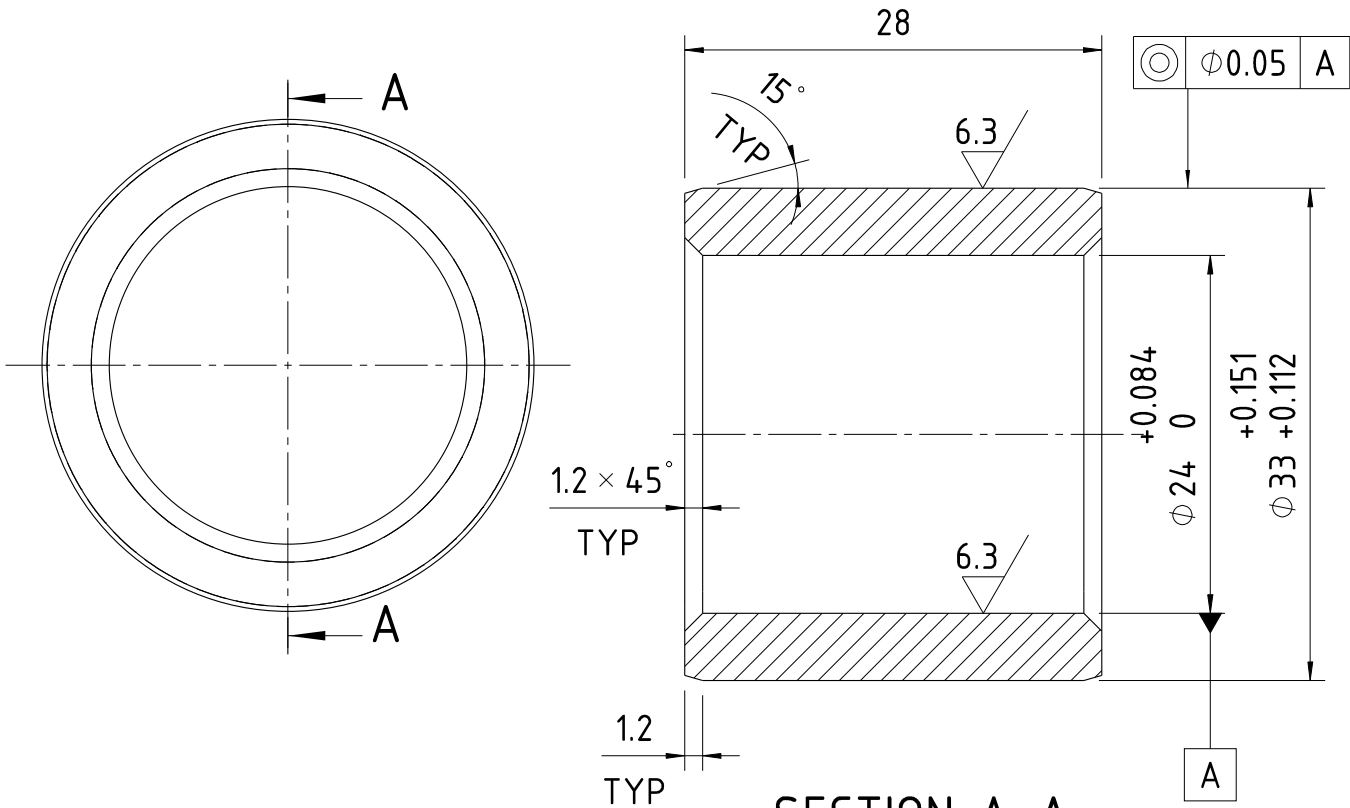


COPY RIGHT & CONFIDENTIAL
THIS DOCUMENT IS THE EXCLUSIVE PROPERTY OF BEML & CONTAINS CONFIDENTIAL INFORMATION. THIS DOCUMENT OR ITS CONTENTS SHALL NOT BE USED, REPRODUCED OR DISCLOSED IN WHOLE OR IN PART, WITHOUT PRIOR WRITTEN PERMISSION OF BEML. THIS DOCUMENT & ALL ITS COPIES SHALL BE RETURNED TO BEML ON DEMAND
DRAWING RELEASED FROM PLM, PHYSICAL SIGNATURE NOT REQUIRED

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:	PROTO			
WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96										

PRELIMINARY DRAWING



SECTION A-A

HEAT TREATMENT

CASE CARBURISE TO A CASE DEPTH OF 0.8-1.2 mm.

CASE HARDNESS: 58-62 HRC.



															TYP										SECTION A-A										A
N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12																								
0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50																								
												HEAT TREATMENT																							
												CASE CARBURISE TO A CASE DEPTH OF 0.8-1.2 mm.																							
												CASE HARDNESS: 58-62 HRC.																							
												<div>1</div>																							
												Ø36X30 LONG STEEL ROD																							
												CASE HARDENING STEEL Gr.16Mn5 Cr4 TO IS:4432-88																							
												COMPANY STD./I.S Wt. (Kg)																							
												MATERIAL																							
												SL.No. QTY PART / STOCK No. DESCRIPTION SIZE																							
												PRODUCT MUMBAI METRO CARS L2 & L7																							
												REF DRG																							
												MATERIAL																							
												HEAT TREAT. APPD MS																							
												SURFACE TREAT. REVD RSS																							
												TITLE CHKD VSE																							
												DRWN VSE																							
												SCALE 2:1																							
												SHEET 1 OF 1																							
												Wt. 0.1kg																							
												DRG No. 525-84105																							
												ALT 1																							
												BEML LIMITED																							
												NEW FRONTIERS. NEW DREAMS																							
												ECN NO/CHANGES																							
												DATE 08-05-2020																							
												BY VSE																							
												CHKD RSS																							
												APPD MS																							
												SURFACE ROUGHNESS																							