

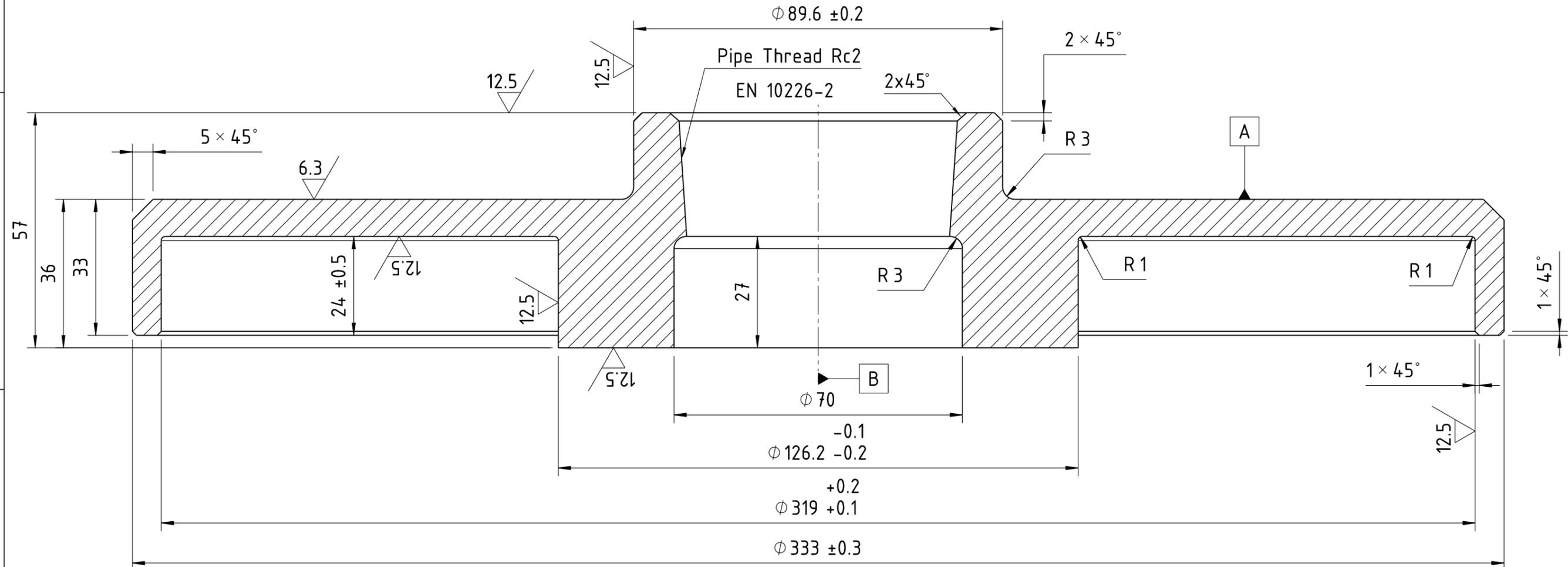
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GRADE No.	VALUE	SYMBOL
N1	0.025	▽
N2	0.05	▽
N3	0.1	▽
N4	0.2	▽
N5	0.4	▽
N6	0.8	▽
N7	1.6	▽
N8	3.2	▽
N9	6.3	▽
N10	12.5	▽
N11	25	▽
N12	50	▽
SURFACE ROUGHNESS		

PRELIMINARY DRAWING

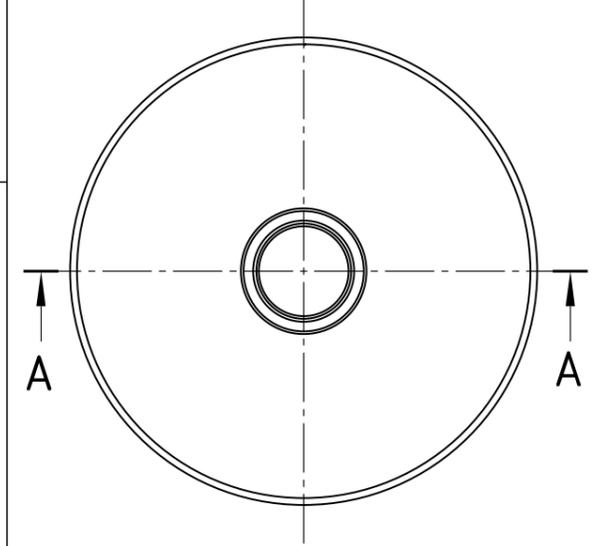
UNCONTROLLED

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										



SECTION A-A

1:1



- NOTE:**
1. REMOVE ALL SHARP EDGES AND BURRS
 2. PAINTING TO BE DONE AS PER PAINTING SPECIFICATION GR/TD/4390 EXCEPT SCREW.
 3. TO BE PLATED WITH PHOSPHATE CLASS B AS PER IS 3618
 4. THE PERPENDICULARITY & PARALLEISM SHALL BE WITHIN 0.1 W.R.T. DATUM A, CONCENTRICITY SHALL BE WITHIN 0.1 W.R.T DATUM B
 5. THE RAW MATERIAL FOR PLATE SHALL BE 100% UT AND REPORTS SHALL BE SUBMITTED.
 6. THE PART SHALL BE MANUFACTURED USING ONLY BAR STOCK /PLATE STOCK MATERIAL.

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
				PLATE $\phi 333 \times 57$		
			PRODUCT	MUMBAI METRO CARS L2 & L7		
			REF DRG			
			MATERIAL	E410BR AS PER IS 2062-2011 IMPACT TEST REQUIRED		
			HEAT TREAT.	APPD	MS	
			SURFACE TREAT.	REVD	RSS	
			TITLE	CHKD	VSE	
				DRWN	AKSHAY	
				SCALE	1:5	
				SHEET	1 OF 1	Wt. 9.5kg
				DRG No.	525-81124	ALT 0
ALT.NO.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	



525-81124