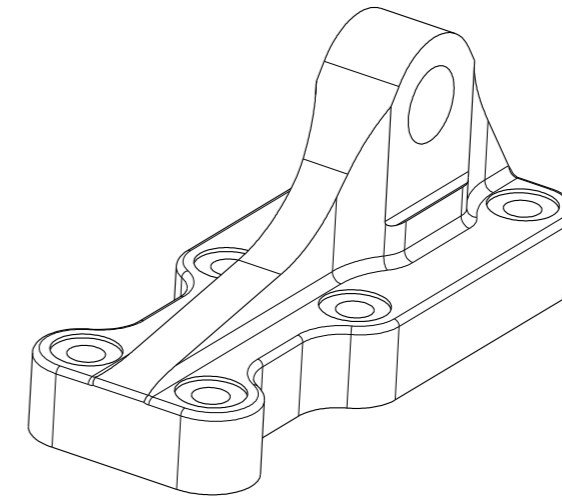
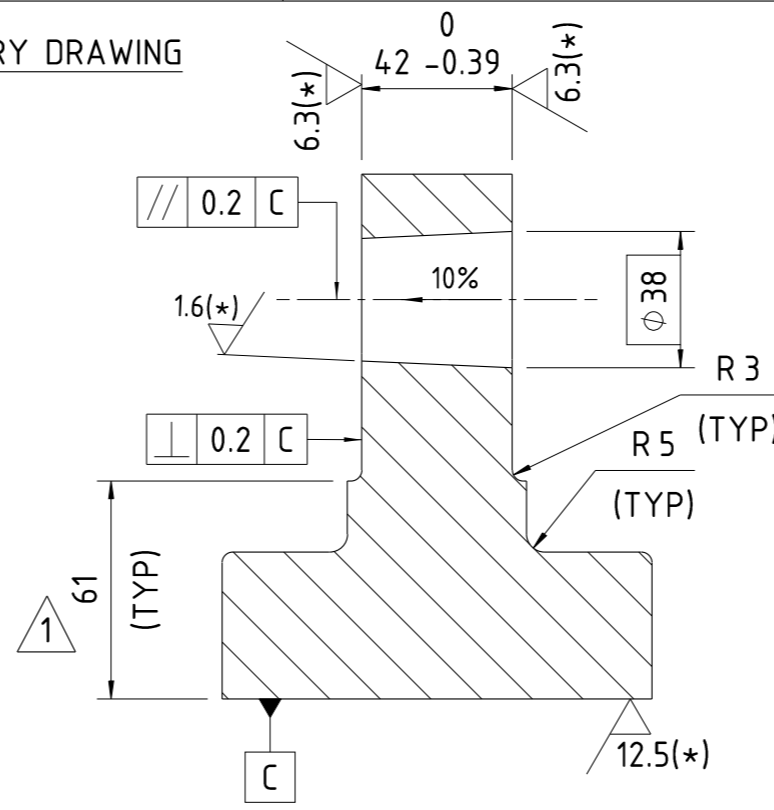
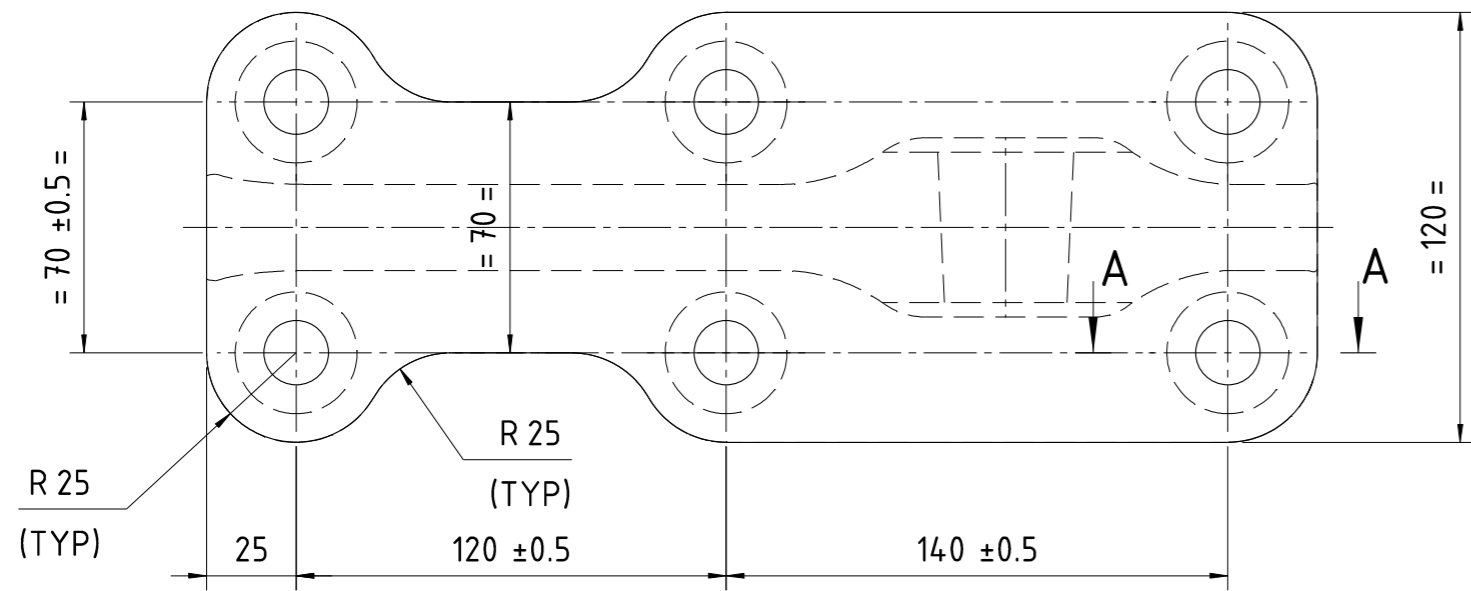


PRELIMINARY DRAWING

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

STATUS: **PROTO**



SL. NO.	PART NO.	PART TYPE
1	525-83257-01	AS SHOWN
2	525-83257-02	OPPOSITE DRAWN

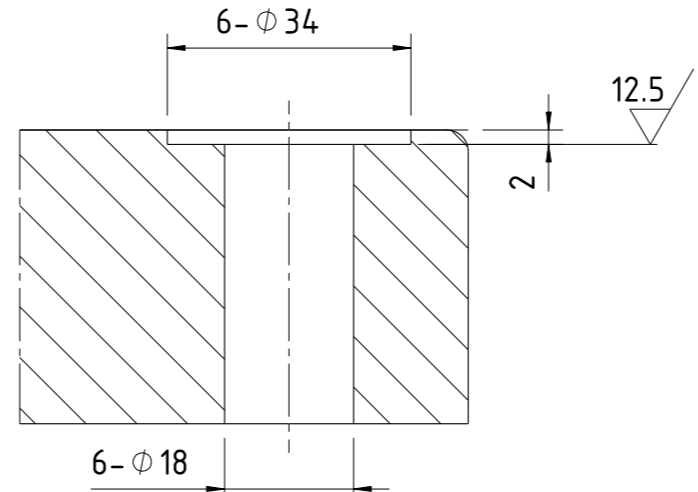
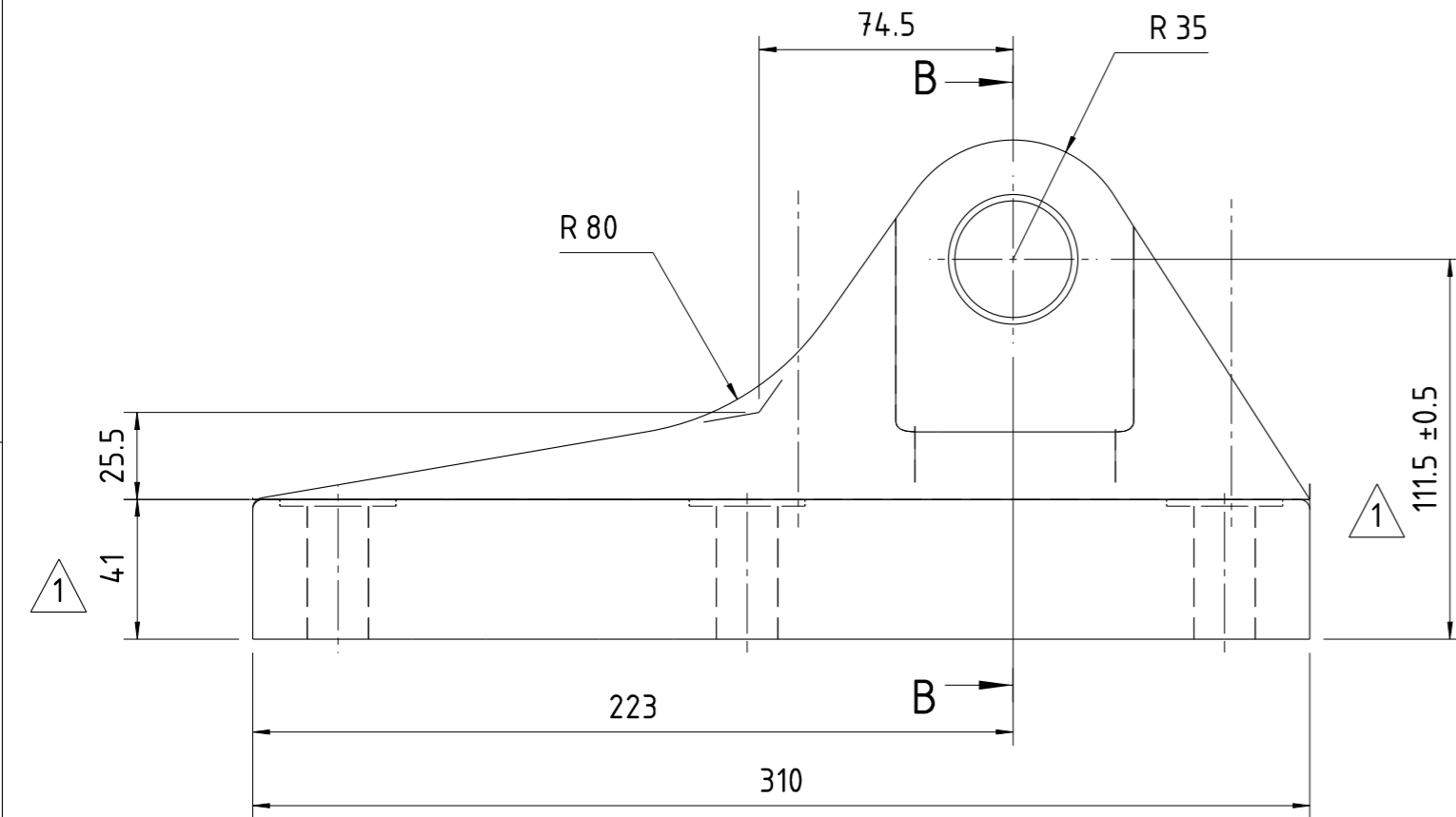
SECTION B-B

ISOMETRIC VIEW 1

NOTES:

- CONSIDER R3 FOR UNSPECIFIED RADIUS ON CASTING.
- SCREW MACHINING SHOULD BE DONE ACCORDING TO ISO 261 NORMAL GRADE OR ABOVE.
- DEVIATIONS ON UNTOLERENCED CAST DIMENSIONS SHALL BE TO IS: 4897-1994, CLASS-2.
- EMBOSS IN 10mm HIGH, 1.5mm RAISED LETTERS PART No., VENDOR CODE, MONTH & YEAR OF MFG., HEAT No., & SL. No., ON THE CASTING AS SHOWN IN THE DWG.
- MANUFACTURER MUST FURNISH TEST CERTIFICATES FOR CHEMICAL COMPOSITION & MECHANICAL PROPERTIES FOR EACH BATCH OF SUPPLY.
- THE MACHINED SURFACE SHALL BE COATED WITH RUST PREVENTIVE FLUID TO IS: 1154-2000. EXCEPT AREA THUS MARKED (*) SHALL BE PRIMER PAINTED.
- OUTSIDE: TO BE PAINTED ACCORDING TO PAINTING MENTIONED IN BEML PTS DOC No. GR/TD/4637 EXCEPT MACHINED SURFACES.
- FAI: ONE No. OF FINISH MACHINED SAMPLE SHALL BE SUPPLIED FREE ALONG WITH ALL MECHANICAL & CHEMICAL TEST REPORTS & DIMENSION CHECK SHEETS FOR EACH BATCH OF SUPPLY FOR APPROVAL BY BEML BEFORE BULK PRODUCTION. ALSO THE FINISH MACHINED SAMPLE SHALL BE CHECKED IN 3D CMM FOR DIMENSIONS & CMM REPORTS WITH DIMENSIONS CHECK SHEETS SHALL BE SUBMITTED TO BEML.
- THE CASTINGS SHALL CONFORM TO BEML PTS DOC. No. GR/TD/4637 (REFER LATEST REVISION).
- MOULDING TOOLING DEFINITION & DRAFT VALUES MUST COMPLY WITH THIS STANDARD FOR SG-IRON OBTAINED BY SAND CASTING AS PER EN 12890
- REMOVE ALL SHARP EDGES, BURRS AND CLEAN THE PARTS.
- DIAMETER CONCENTRICITY OF 0.20 TO BE MAINTAINED
- PERPENDICULARITY OF 0.20 TO BE MAINTAINED W.R.T. DIAMETERS
- PARALLELISM OF 0.20 TO BE MAINTAINED W.R.T. AXIS LINE
- MINIMUM WALL THICKNESS AS MENTIONED IN THE DRAWING MUST BE MAINTAINED.
- VENDOR SHOULD INCORPORATE CHANGES IN THE DRAWING WITHOUT ANY DEVIATION

UN CONTROLLED



SECTION A-A

1:1

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S.	Wt. (Kg)
1			PRODUCT			
			REF DRG			
			MATERIAL			
			HEAT TREAT.			
			SURFACE TREAT.			
			TITLE			
			APPD	MS		
			REVD	SSB		
			CHKD	SSB		
			DRWN	VSE		
			SCALE	1:2	SHEET	Wt.
			DRG No.	1 OF 1		13.5kg
			BEML LIMITED			
			525-83257			

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GRADE No.	VALUE	SYMBOL
N1	0.05	▽
N2	0.1	▽
N3	0.15	▽
N4	0.2	▽
N5	0.3	▽
N6	0.4	▽
N7	0.5	▽
N8	0.6	▽
N9	0.7	▽
N10	0.8	▽
N11	0.9	▽
N12	1.0	▽

Part No., Vendor Code,
Month Year of manufacturing

Heat No. & Serial No. of Casting