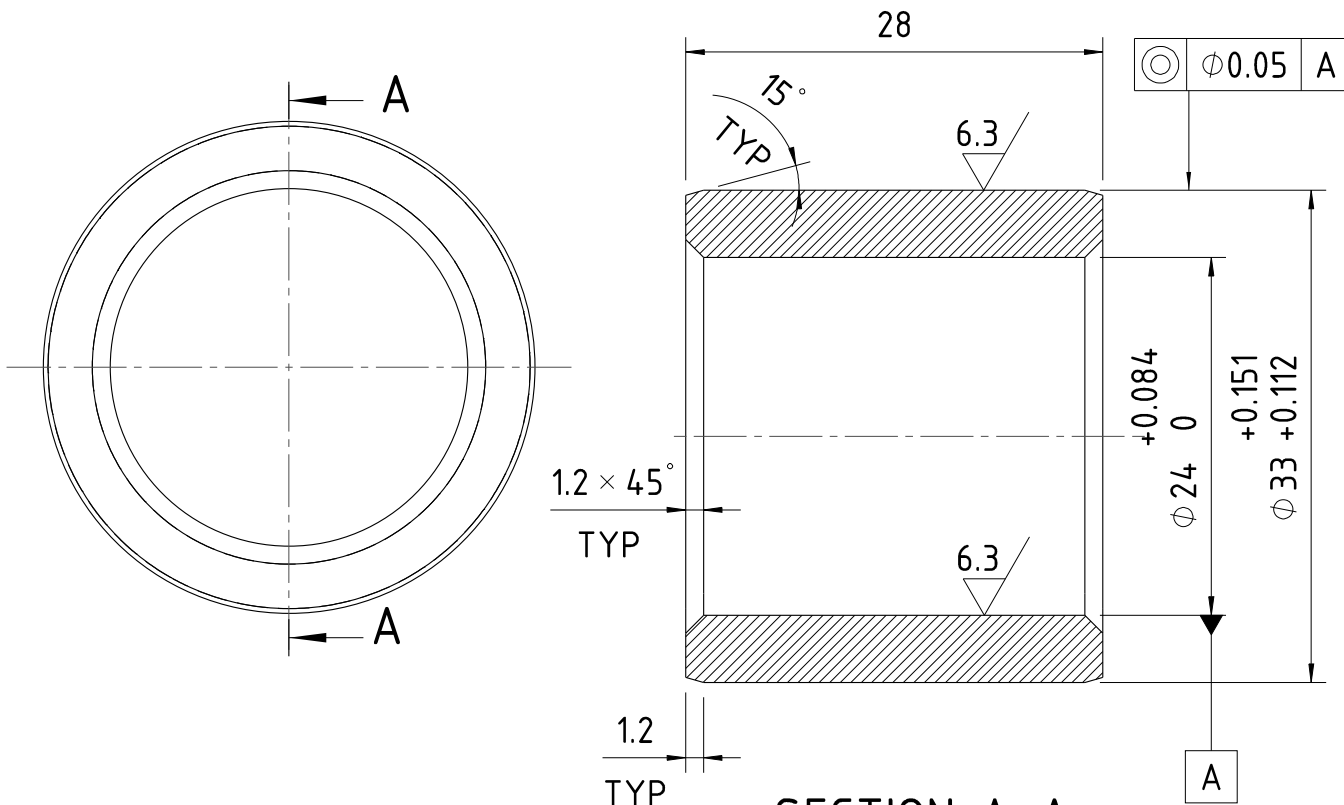


MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 – 6	6 – 30	30 – 120	120 – 315	315-1000	1000-2000	2000-4000	ABOVE 4000	RA
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	~
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227										
UNSPECIFIED TOLERANCE FOR LINEAR 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





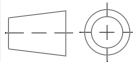



## SECTION A-A

## HEAT TREATMENT

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

CASE HARDNESS: 58-62 HRC.

										Ø40X30 LONG STEEL ROD		CASE HARDENING STEEL Gr.16Mn5 Cr4 TO IS:4432-88			
SL.No.	QTY	PART / STOCK No.	DESCRIPTION					SIZE		COMPANY STD./I.S    Wt. (Kg)					
										MATERIAL					
							PRODUCT	MUMBAI METRO CARS L2 & L7							
							REF DRG								
							MATERIAL								
							HEAT TREAT.			APPD	MS				
							SURFACE TREAT.			REVD	RSS				
							TITLE	BUSH		CHKD	VSE				
												DRWN	VSE		
							SCALE			SHEET	Wt.				
								2:1			1 OF 1		0kg		
								DRG No.		525-84105				ALT	
ALT.NO.	ECN NO/CHANGES		DATE	BY	CHKD	APPD	 BEML LIMITED <small>NEW FRONTIERS. NEW DREAMS</small>		525-84105				