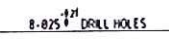
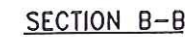
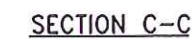
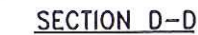
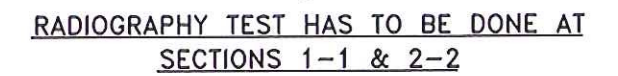
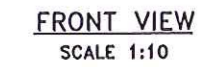
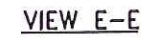
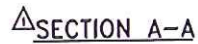


~~PROTO/PROT/PRODUCTION~~

1. CONSIDER R3 FOR UNSPECIFIED RADIUS ON CASTING.
2. SCREW MACHINING SHALL BE DONE ACCORDING TO ISO 261 NORMAL GRADE OR ABOVE
3. DEVIATIONS ON UNTOLERANCED CAST DIMENSIONS SHALL BE TO IS 4897-1994, CLASS-2
- *4. EMBOSS IN 10mm HIGH, 1.5mm RAISED LETTERS PART NO., VENDOR CODE, MONTH & YEAR OF MFG. ON ONE SIDE AND HEAT NO. & SL NO ON THE OTHER SIDE.
5. RADIOGRAPHIC EXAMINATIONS: THE CENTER PIVOT SHALL BE SUBJECTED TO RADIOGRAPHIC EXAMINATION FOR 100% OF THE CASTING. THE ACCEPTABLE RADIOGRAPHY STANDARD SHALL BE AS PER ASTM-E 446/185 LEVEL II.
6. THE X-RAY RADIATION BEAM SHALL BE FOCUSED ON THE CASTING IN THE DIRECTION AS INDICATED IN THE DWG.
7. FAI: ONE NO. OF FINISH MACHINED SAMPLE CENTER PIVOT SHALL BE SUBMITTED FREE ALONG WITH ALL MECHANICAL & CHEMICAL TEST REPORTS FOR APPROVAL BY BEML BEFORE BULK PRODUCTION ALSO THE FINISH MACHINED SAMPLE SHALL BE CHECKED IN 3D CMM FOR DIMENSIONS AND CMM REPORTS WITH DIMENSIONS CHECKSHEET SHALL BE SUBMITTED TO BEML.
8. THE CASTINGS SHALL STRICTLY CONFORM TO BEML PTS. DOC.NO. GR/IT/1477 (REFER LATEST REVISION).

UN CONTROLLED COPY

1						AAR-M-201 GR'C	
SL No	QTY/ CAR	DRG / STOCK No		DESCRIPTION		SIZE	COMPANT STD/ISO STD
		DETAIL PARTS				MATERIAL	
1		NOTES UPDATED ECN No 90900650		PRODUCT METRO BOGIE		SURFACE TREATMENT	
1		NOTE REVISED		1 909-82201		SCALE 1:2.5	
1		NOTE REVISED		QTY NEXT ASSY		MODEL	
1		NOTE REVISED		TITLE CENTER PIVOT		REF DRG 1172	
1		NOTE REVISED		APPROVED S.JAYAPRAKASH		5.1.0	
1		NOTE REVISED		CHECKED PAVAN		5.1.0	
1		NOTE REVISED		DRAWN K.SIVARAM/REDDY		5.1.0	
1		NOTE REVISED		BEML LIMITED REG. BANGALORE COMPLEX BANGALORE 560 075		AL	
1		NOTE REVISED		909-82102		AL	