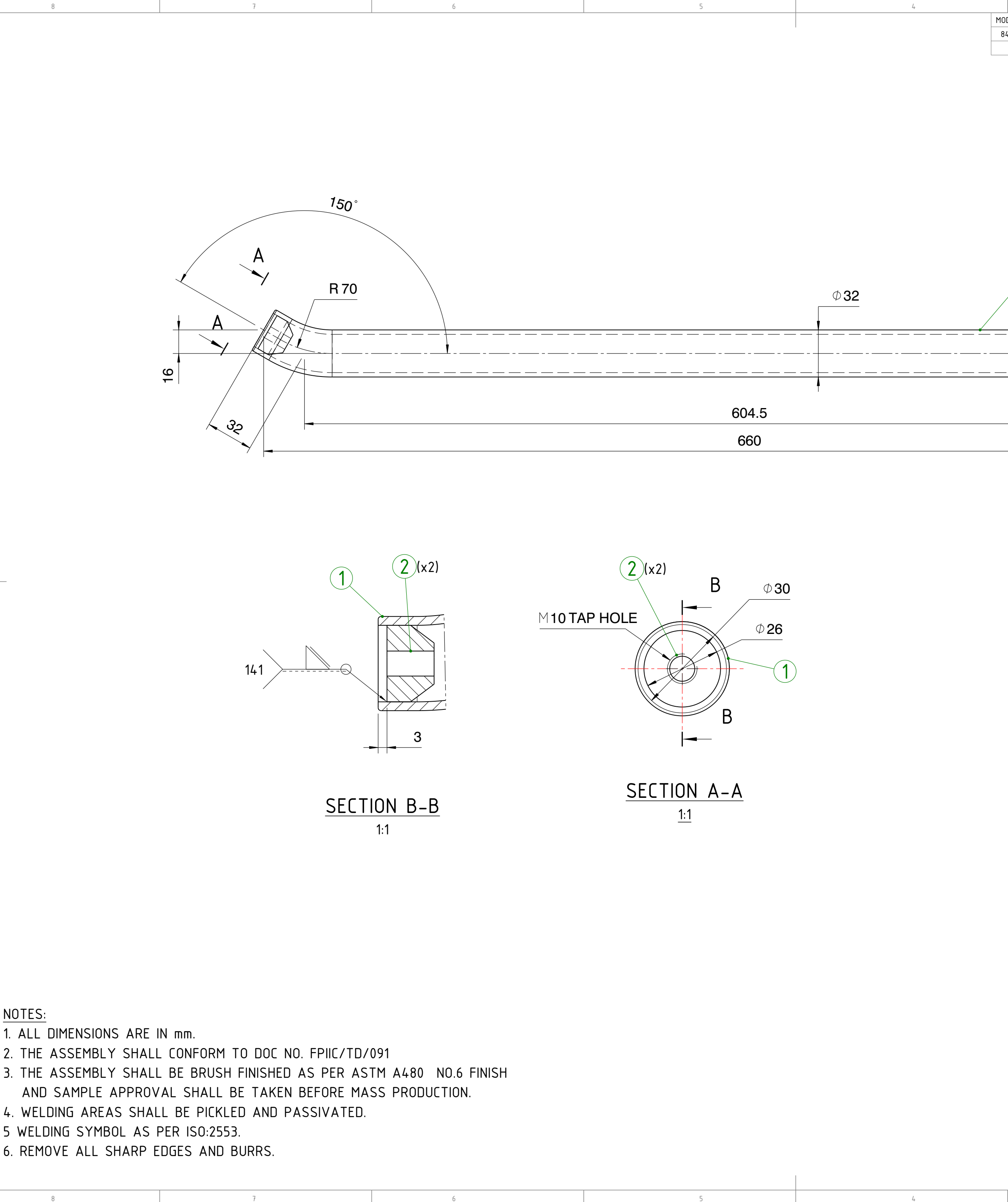




NOTES:

1. ALL DIMENSIONS ARE IN mm.
2. THE ASSEMBLY SHALL CONFORM TO DOC NO. FPIIC/TD/091
3. THE ASSEMBLY SHALL BE BRUSH FINISHED AS PER ASTM A480 NO.6 FINISH AND SAMPLE APPROVAL SHALL BE TAKEN BEFORE MASS PRODUCTION.
4. WELDING AREAS SHALL BE PICKLED AND PASSIVATED.
- 5 WELDING SYMBOL AS PER ISO:2553.
6. REMOVE ALL SHARP EDGES AND BURRS.

3				2						1					
MODEL	NEXT ASSY	QTY	MACHINING DEVIATIONS FOR LINEAR DIMENSIONS CLASS - MEDIUM	RANGE	0.5 - 3	3 - 6	6 - 30	30 - 120	120 - 400	400 - 1000	1000 - 2000	2000 - 4000			
843	843-4101X	01		TOLERANCE	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2			
				GENERAL TOLERANCES FOR LINEAR & ANGULAR DIMENSION SHALL BE AS PER ISO 2768-1				GENERAL GEOMETRICAL TOLERANCES SHALL BE AS PER ISO 2768-2							
				GENERAL TOLERANCES FOR WELDED STRUCTURE SHALL BE AS PER ISO 13920				VALUES OF SURFACE TEXTURE SHALL BE AS PER ISO 1302.							
				WELDING SHALL BE CARRIED OUT AS PER EN 15085-3		WELDING PROCESS SHALL BE AS PER EN ISO-4063				STATUS: MOCK-UP PROTO/PRODUCTION					
				WELDING SYMBOLS SHALL BE AS PER EN ISO-2553		WELDING POSITIONS SHALL BE AS PER EN ISO 6947									
				QUALITY LEVELS FOR IMPERFECTIONS IN FUSION WELDED JOINTS SHALL BE AS PER EN ISO 5817											
				WELD JOINT PREPARATIONS SHALL BE AS PER EN ISO 9692 & EN 15085-3									INSPECTION & TESTING OF WELDED JOINTS SHALL BE AS PER EN 15085-5		

2		2		843-27146		INSERT		Ø26x16THK		SUS304/AISI304	
1		1		843-27145		HANDRAIL		OD32xWT 2		ERW SS PIPE TO GRADE SUS304/ TP 304 OF ASTM A 269	
SL.No.		QTY		PART / STOCK No.		DESCRIPTION		SIZE (mm)		COMPANY STD./I.S Wt. (Kg)	
										MATERIAL	
						PRODUCT		TRAIN B28			
						REF DRG		---			
						MATERIAL		ASSY			
						HEAT TREAT.		---		APPD KRISHNA PRASAD 22.06.26	
						SURFACE TREAT.		---		REVD KRISHNA PRASAD 22.06.26	
						TITLE		HANDRAIL		CHKD SANTOSH KUMAR 22.06.26	
										DRWN SANTOSH KUMAR 22.06.26	
								SCALE 1:2		SHEET 1 OF 1 1.533	
ALT.No.		ECN No./CHANGES		DATE		BY		CHKD		APPD	
3										BANGALORE COMPLEX	
										843-27040	
										ALT 0	

	TECHNICAL DELIVERY CONDITION	Project: Train B28
Aggregate	Hand Rail/Grab handles	DOC No.: FPIIC/TD/091
BEML Enquiry/ RFQ Reference :		

Sl. No.	Technical Delivery Conditions	COMPLIED	NOT COMPLIED
1	Each of the Grabrail and grab handle shall confirm to the tender drawing requirements.	☐	☐
2	All pipes for the hand rail / grab handle shall be ERW stainless steel pipe to grade SUS 304 / TP 304 of ASTM A 269 and shall be procured from reputed sources.	☐	☐
3	The firm shall submit material test certificate for chemical composition and mechanical properties from the source.	☐	☐
4	Due care shall be taken to ensure quality of welding and after fabrication the weld areas shall be pickled and passivated. Pickling & Passivation process details shall be submitted along with the technical bid.	☐	☐
5	Fabrication of the assembly shall be carried out by qualified welders. Welder qualification certificate and Welding Process Qualification (WPS & PQR) as per EN / ISO / DIN standard shall be submitted along with the technical bid.	☐	☐
6	The hand rail / grab handle assemblies shall be fabricated using dedicated tooling, jigs & fixtures and the final part shall be free of die marks & scratches .	☐	☐
7	The bending of hand rail / grab handle shall be done using CNC bending machines.	☐	☐
8	The hand rail / grab handle shall be brush finished. The brush finish shall match with the reference sample to be shared by BEML after award of the contract.	☐	☐
9	After fabrication, the finish products shall be of sound quality without any defects. 100% quantity of the hand rail / grab handle shall be subjected to visual and dimensional inspection. Inspection reports shall be submitted along with supplies.	☐	☐
10	The supplier shall obtain sample approval and fitment trials clearance on the car from BEML before taking up mass production.	☐	☐
11	The hand rail / grab handle shall be packed to ensure that no damage will occur during transit & storing at BEML.	☐	☐

Signature of the Bidder with Seal
(Name, Designation & Address)