

THIS DOCUMENT IS THE EXCLUSIVE PROPERTY OF BEML & CONTAINS CONFIDENTIAL INFORMATION. THIS DOCUMENT OR ITS CONTENTS SHALL NOT BE USED, REPRODUCED OR DISCLOSED IN WHOLE OR IN PART, WITHOUT PRIOR WRITTEN PERMISSION OF BEML. THIS DOCUMENT & ALL ITS COPIES SHALL BE RETURNED TO BEML ON DEMAND.

COPY RIGHT & CONFIDENTIAL

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)

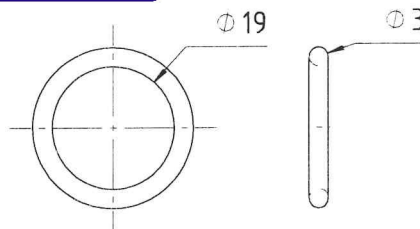
QUALITY OF WELD JOINTS REF, RD 230 MEDIUM

VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS. 1012.C

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

STATUS: **MOCKUP/PROTO/PRODUCTION**

UN CONTROLLED COPY



SPECIFICATION FOR RUBBER RING

BASE RUBBER SHALL BE NITRILE SUITABLY COMPOUNDED TO MEET FOLLOWING:

TENSILE STRENGTH : 105 Kgf/Cm2
 ELONGATION AT BREAK : 250% (MIN.)
 SHORE HARDNESS : 60 ± 5
 TEMPERATURE SUITABILITY : -10°C TO 120°C
 COMPRESSION SET AT 100 ±1°C FOR 24⁰/₂ HOUR : 35 % MAX.
 SWELLING BY VOLUME IN REFERENCE
 TO LIQUID 'B' AT 27 ±1°C FOR 24⁰/₂ HOUR : 35 % MAX.
 AFTER AGEING FOR 72⁰/₂ HOUR AT 100 ± 1° C, CHANGE IN HARDNESS.

TENSILE STRENGTH & ELONGATION AT BREAK SHALL NOT EXCEED:-

HARDNESS : ± 15
 TENSILE STRENGTH : ± 25 %
 ELONGATION AT BREAK : + 10 % , - 45 %
 COLOUR : BLACK

ALL TEST PROCEDURE SHALL BE AS PER IS: 3400-87

N1	0.075	✓
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	✓
GRADE No.		
VALUE		
SYMBOL		
SURFACE		
ROUGHNESS		

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE (mm)	COMPANY STD./I.S	Wt. (Kg)
			PRODUCT	BMRCL METRO CARS		
			REF DRG			
			MATERIAL			
			HEAT TREAT.	APPD	MS	31.10.19
			SURFACE TREAT.	REVD	DB	30.10.19
			TITLE	CHKD	DB	
			O-RING	DRWN	JC	29.10.19
				SCALE	1:1	
				SHEET	1 OF 1	
				DRG No.	926-81141	
				ALT	0	



BEML LIMITED