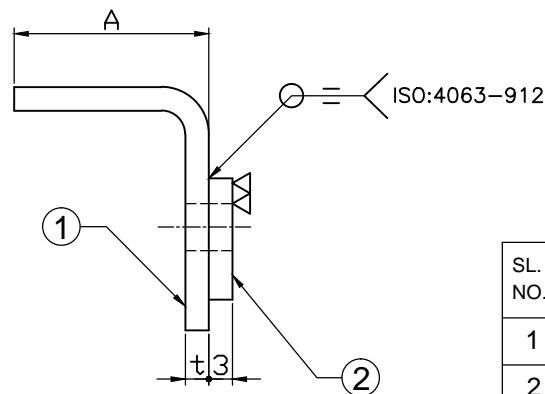
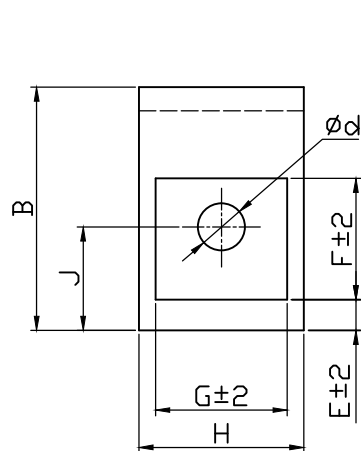


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GRADE No.	VALUE	SYMBOL	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12
SURFACE			0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50
ROUGHNESS														

NOTE:












1. REMOVE ALL SHARP EDGES AND BURRS.
2. ITEM 1 & 2 SHALL BE CLEANED FOR OIL, RUST, GREASE ETC.THEN ITEM 2 SHALL BE BRAZED TO ITEM 1. FOR BRAZING REF ISO:4063-912
3. THE ASSY. SHALL BE ELECTROPLATED WITH TIN COATING.THE THICKNESS OF TIN COATING TO BE MAINTAINED TO 10 MICRONS SERVICE Gr.2. FOR ELECTROPLATED COATING & TESTING METHODS REF ISO:2093 (IS 1359-1992)



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

UNCONTROLLED

SL. NO.	DWG. NO.	DIMENSION IN mm								
		t	H	A	B	E	F	G	J	d
1	525-40193-1	3	19	25	30	2	20	15	14	6
2	525-40193-2	3	25	25	40	3	25	20	20	7
3	525-40193-3	4	32	30	55	3	35	28	25	9
4	525-40193-4	4	50	30	70	5	50	40	35	11

2	1		PLATE	COPPER STRIP	R200102400 IS:1897-83, Gr.-		
1	1		BRACKET	SS.SHEET	AISI 304L		
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)	
					MATERIAL		
			PRODUCT	MUMBAI METRO CARS-L2&L7			
			REF ORG				
			MATERIAL				
			HEAT TREAT.	APPD	VS	28.10.19	
			SURFACE TREAT.	REVD	SNH	26.10.19	
			TITLE	CHKD	SNH	26.10.19	
			EARTH TERMINAL	DRWN	VISHNU	25.10.19	
				SCALE		SHEET	Wt.(Kg)
						OF	0
ALT.No.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	DRG No.	
						525-40193	
			 BEAML LIMITED				

BEML LIMITED