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.

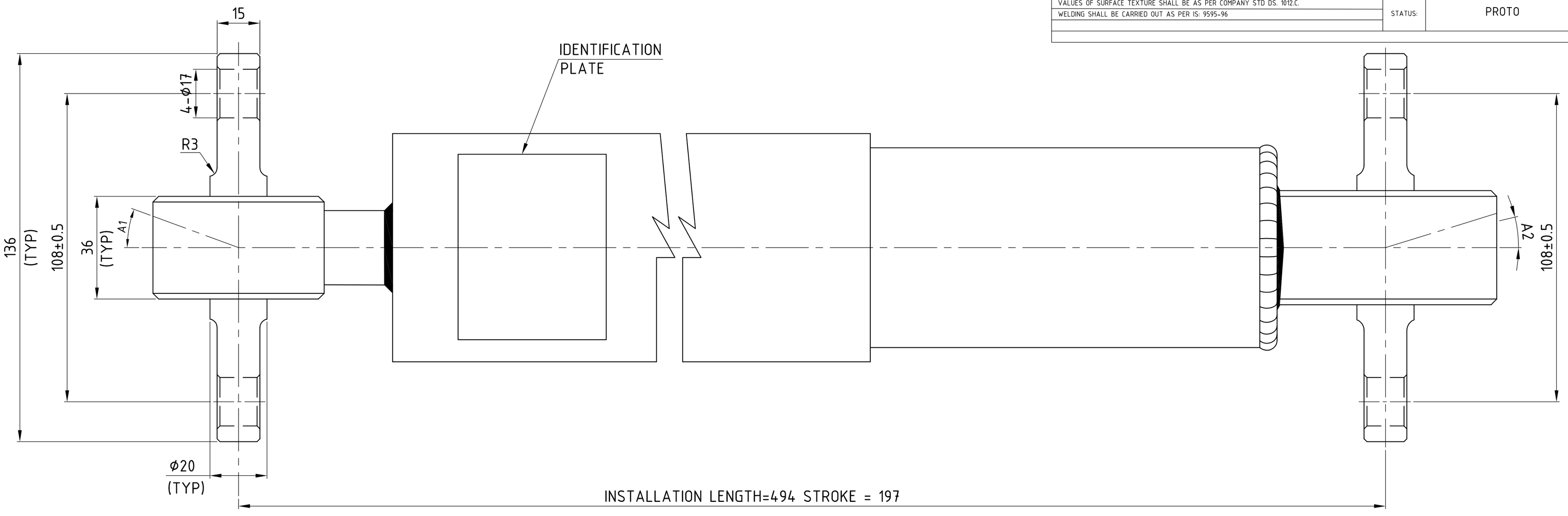
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM)

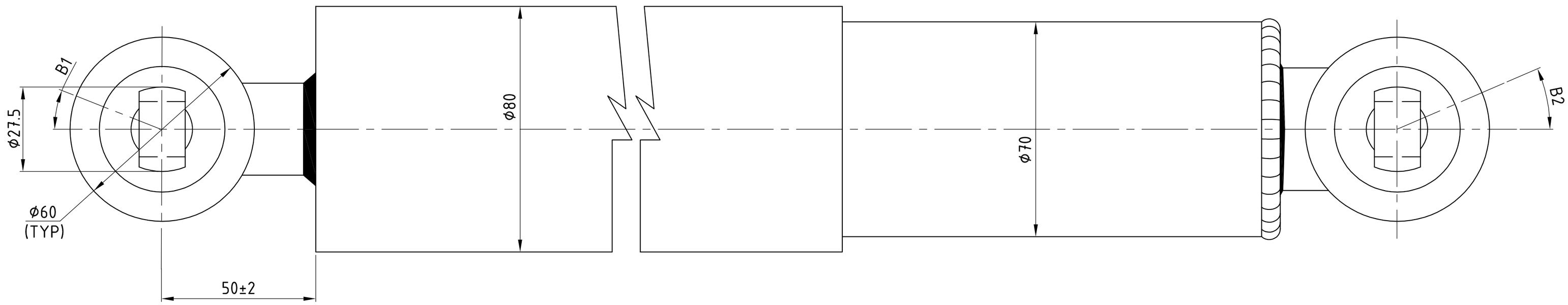
QUALITY OF WELD JOINTS REF, RD 230 MEDIUM

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

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

STATUS: PROTO





DAMPER STANDARD AS PER	DAMPING FORCE IN "N" v=0.1 m/s		CUSTOMER SPECIFICATION AS PER PTS NO.	WEIGHT in Kg	ANGLE	MAX. ANGULAR ROTATION IN SERVICE
	EXTENSION	COMPRESSION				
EN 13802	3000±15%	3000±15%	GR/TD/4487	7.0±5%	A	±13°
					B	±19°

RADIAL STIFFNESS	20±20% KN/mm

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S / MATERIAL	Wt. (Kg)

PRODUCT	MUMBAI METRO CARS L2 & L7
REF DRG	
MATERIAL	
HEAT TREAT.	
SURFACE TREAT.	
TITLE	SECONDARY VERTICAL DAMPER
APPD	MS
REVD	SSB
CHKD	RSS
DRWN	VSE
SCALE	1:1
SHEET	1 OF 1
Wt.(Kg)	-
DRG No.	525-83067
ALT	0

BEML LIMITED

ALT.NO.	ECN NO/CHANGES	DATE	BY	CHKD	APPD

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

SURFACE ROUGHNESS

A2