



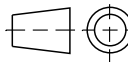


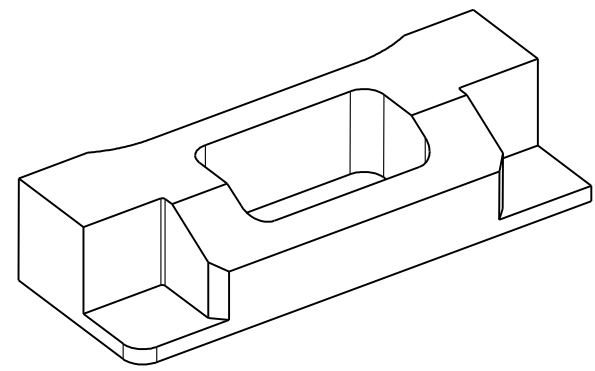


SURFACE		N12	N11	N10	N9	N8	N7	N6	N5	N4	N3	N2	N1
GRADE No.													
VALUE		50	25	12.5	6.3	3.2	1.6	0.8	0.4	0.2	0.1	0.05	0.025
SYMBOL													

						FORGING				
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE (mm)	COMPANY STD./I.S		Wt. (Kg)			
					MATERIAL					
					PRODUCT	MUMBAI METRO CARS - L2 & L7				
					REF DRG					
					MATERIAL	EN 10025-5:2004, S355 J2W+N				
					HEAT TREAT.	APPD		MS		
					SURFACE TREAT.	REVD		DB		
					TITLE	CHKD		JC		
					LOWER SUPPORT, T/M MOUNTING ASSY	DRWN		ILYAS		
						SCALE		SHEET	Wt.(kg)	
					1:2.5		1 OF 1	18.9		
					DRG No.		525-83167		ALT	
ALT.NO.	ECN NO/CHANGES		DATE	BY	CHKD	APPD	 BEML LIMITED			
							NEW FRONTIERS. NEW DREAMS			



PRELIMINARY

1. CONSIDER R3 FOR UNSPECIFIED RADIUS ON FORGING.
2. THE FLOW LINES SHALL FOLLOW THE CONTOUR OF THE FORGING. THE FLOW LINES SHALL NOT CUT THE CONTOUR.
3. MANUFACTURER MUST FURNISH THE TEST CERTIFICATES FOR CHEMICAL,MECHANICAL PROPERTIES AND CHECK SHEET FOR EACH BATCH OF SUPPLY
4. THE MACHINED SURFACES SHALL BE COATED WITH THE RUST PREVENTIVE FLUID TO IS:1154-2000
5. REMOVE ALL SHARP EDGES AND BURRS
6. FORGING SHALL BE SUPPLIED IN NORMALIZED CONDITION.
7. THE FORGING SHALL STRICTLY CONFIRM TO BEML PTS DOC.No. GR/TD/4640 (REFER LATEST REVISION)
8. AS IT IS A PERLIMINARY DRAWING ANY CHANGES IN DIMENSION & WEIGHT OF PART HAS TO BE CONSIDERED BY THE VENDOR.