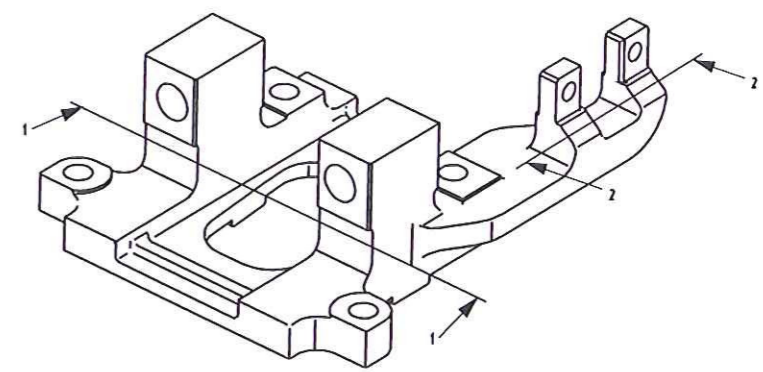
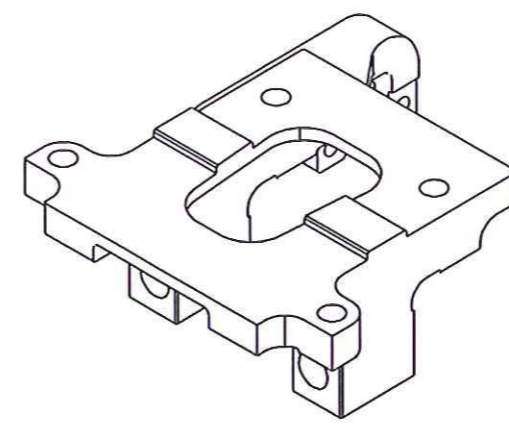
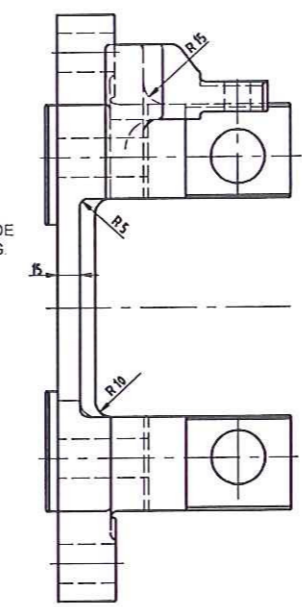
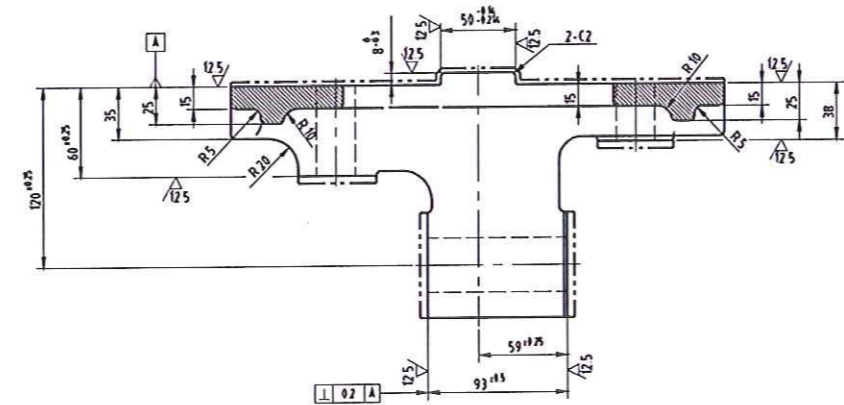
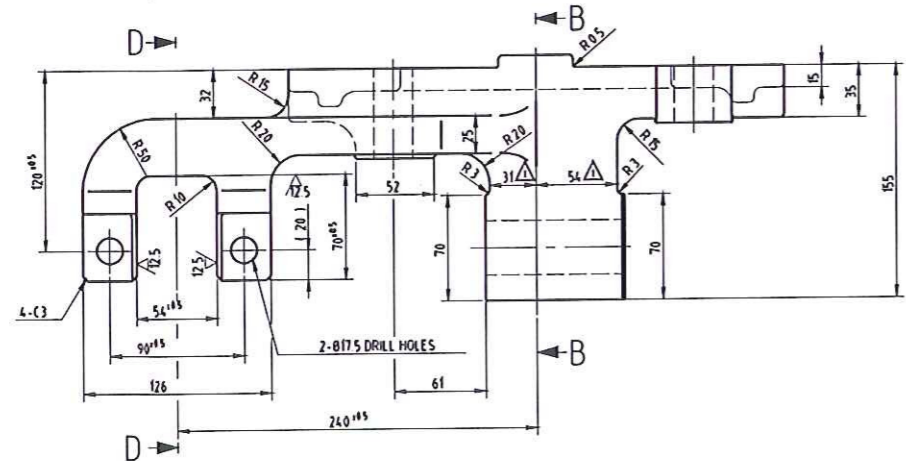


PART NO., VENDOR CODE
MONTH & YEAR OF MFG.



RADIOGRAPHIC TEST HAS TO BE DONE AT SECTIONS 1-1 AND 2-2

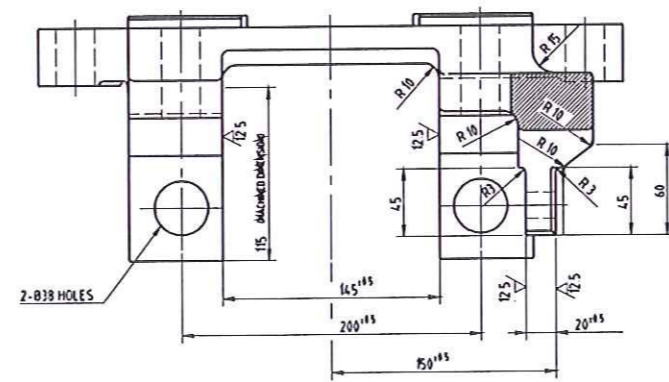
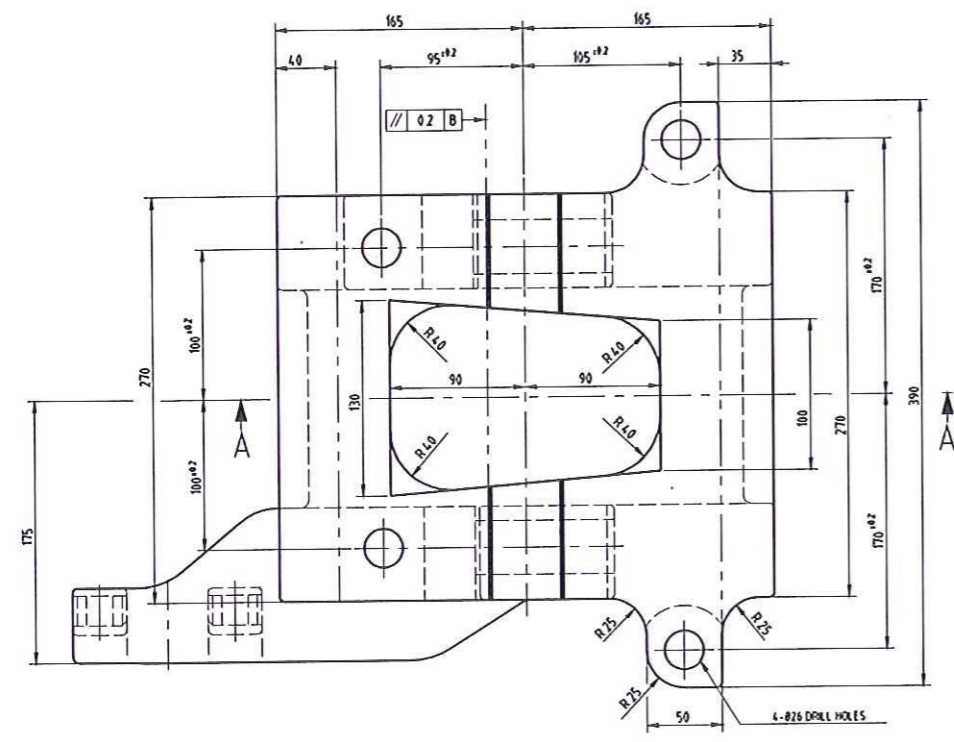


SECTION A-A

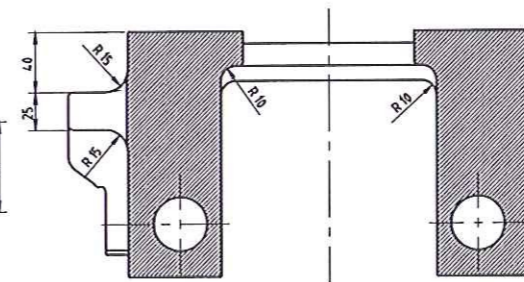
- NOTES:-**

1. CONSIDER R3 FOR UNSPECIFIED RADIUS ON CASTING
2. SCREW MACHINING SHALL BE DONE ACCORDING TO ISO 261 NORMAL GRADE OR ABOVE
3. DEVIATIONS ON UNTOLERANCED CAST DIMENSIONS SHALL BE TO IS 4897-1994, CLASS-2
4. EMBOSS IN 10mm HIGH, 1.5mm RAISED LETTERS PART NO., VENDOR CODE, MONTH & YEAR OF MFG., HEAT NO. & SL NO ON THE CASTING AS SHOWN IN THE DWG
5. RADIOGRAPHIC EXAMINATIONS: THE CENTER PIVOT LOWER SHALL BE SUBJECTED TO RADIOGRAPHIC EXAMINATION FOR 100% OF THE CASTING. THE ACCEPTABLE RADIOGRAPHY STANDARD SHALL BE AS PER ASTM-E-446/188 LEVEL II.
6. THE X-RAY RADIATION BEAM SHALL BE FOCUSED ON THE CASTING IN THE DIRECTION AS INDICATED IN THE DWG.
7. FAI: ONE NO. OF FINISH MACHINED SAMPLE CENTER PIVOT LOWER SHALL BE SUPPLIED FREE ALONG WITH ALL MECHANICAL & CHEMICAL TEST REPORTS FOR APPROVAL BY BEML BEFORE BULK PRODUCTION. ALSO THE FINISH MACHINED SAMPLE SHALL BE CHECKED IN 3D CMM FOR DIMENSIONS AND CMM REPORTS WITH DIMENSIONS CHECKSHEET SHALL BE SUBMITTED TO BEML.
8. THE CASTINGS SHALL STRICTLY CONFORM TO BEML PTS DOC.NO GR/TD/1477 (REFER LATEST REVISION).

UN CONTROLLED COPY



SECTION D-D



SECTION B-B

[illegible]