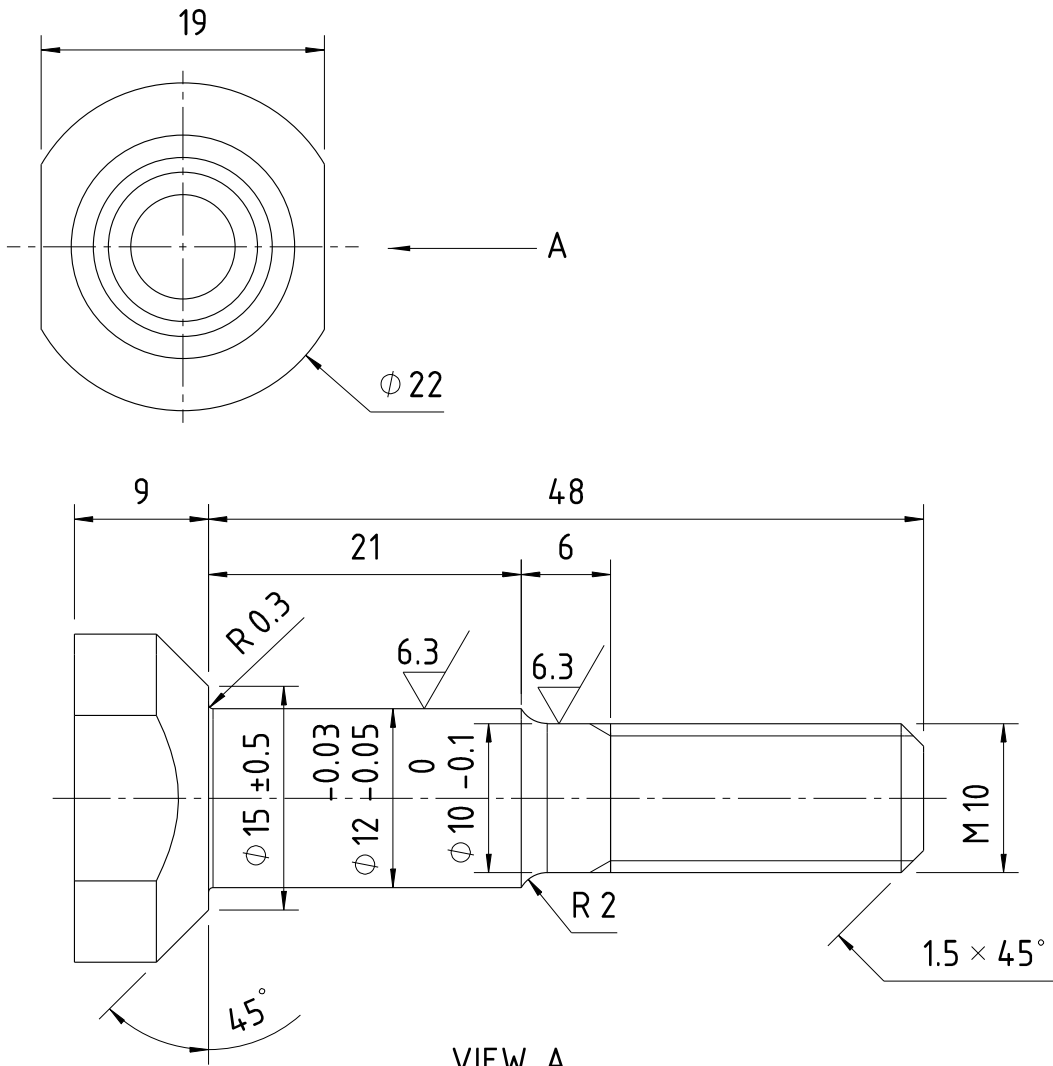


GRADE No.	VALUE	SYMBOL
N1	0.025	▽
N2	0.05	▽
N3	0.1	▽
N4	0.2	▽
N5	0.4	▽
N6	0.8	▽
N7	1.6	▽
N8	3.2	▽
N9	6.3	▽
N10	12.5	▽
N11	25	▽
N12	50	▽
ROUGHNESS		

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



NOTES

1. TO BE PLATD WITH ZINC.
2. SCREW MACHINING SHALL BE DONE ACCORDING TO ISO 261 NORMAL GRADE OR ABOVE.

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
MATERIAL						
			PRODUCT	MUMBAI METRO CARS L2 & L7		
			REF DRG			
			MATERIAL	AISI 304 1		
			HEAT TREAT.	APPD	MS	
			SURFACE TREAT.	REVD	RSS	
			TITLE	CHKD	VSE	
				DRWN	VSE	
			PIN SPECIAL			
			SCALE	1:1	SHEET	Wt.
			1:1		1 OF 1	0.06kg
			DRG No.	525-84113		
			ALT	1		
ECN: 52510182	DATE 08-05-2020	BY VSE	CHKD RSS	APPD MS	BEML LIMITED	
Material Changed from SS400 to AISI 304						
Note 1 removed						
ALT.NO.	ECN NO/CHANGES					