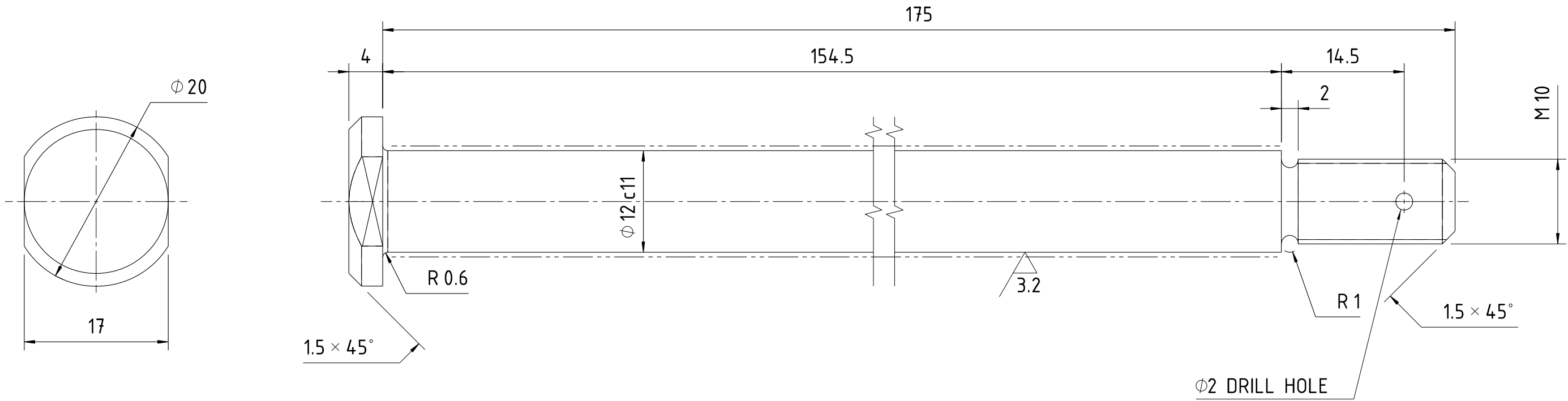


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GRADE No.	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12	VALUE	SYMBOL
	0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50		
SURFACE ROUGHNESS														





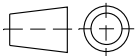
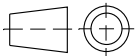

PRELIMINARY DRAWING



NOTES:

- 1.THE MACHINED SURFACES SHALL BE COATED WITH RUST PREVENTIVE FLUID TO IS: 1154-2000.
2. INDUCTION HARDENING SHOULD BE DONE IN THE MARKED ----- AREA. CASE DEPTH: 1.2 TO 1.5 mm. CASE HARDNESS: 55-57 HRC.
3. TO BE PLATED WITH ZINC, SC3 TYPE II, YELLOW AS PER ASTM B633
4. SCREW MACHINING AS PER ISO 261 NORMAL GRADE OR ABOVE.

		2						1		
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										

									Φ22X180 L	Gr.45C8, IS:5517-93			
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							
						HEAT TREAT.					APPD	MS	
						SURFACE TREAT.					REVD	RSS	
						TITLE					CHKD	RSS	
						PIN, SPECIAL					DRWN	VSE	
	ECN: 52510182	DATE 22-05-2020	BY VSE	CHKD RSS	APPD MS		SCALE			SHEET		Wt.	
	Revised and Redrawn						2:1		1 OF 1	0.17 kg			
ALT.NO.	ECN NO/CHANGES					 BEM BEML LIMITED <small>NEW FRONTIERS · NEW DREAMS</small>	DRG No.		525-84106			ALT 