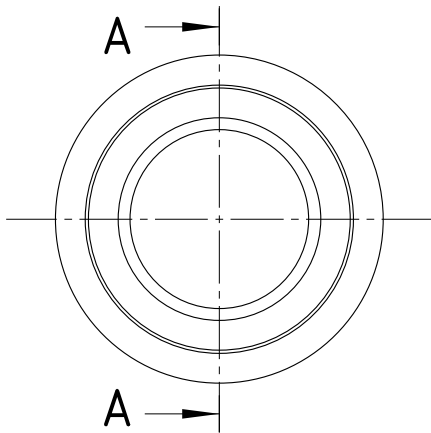


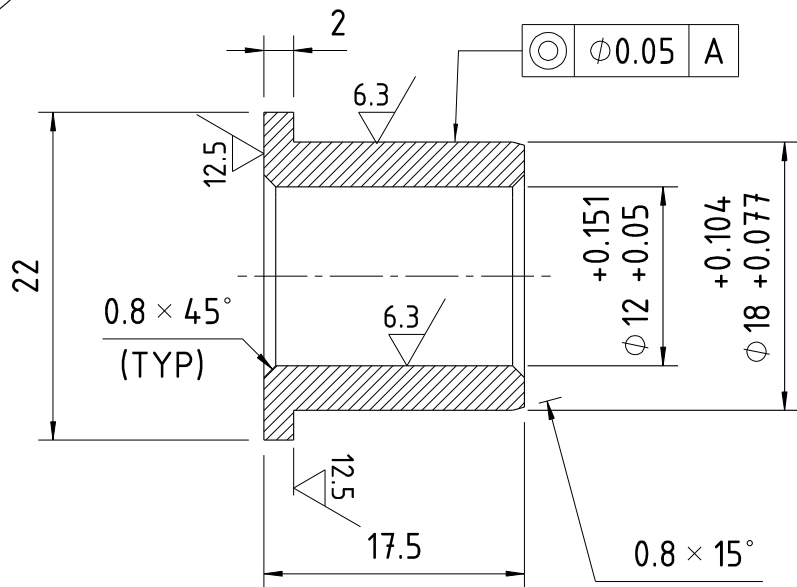
COPY RIGHT & CONFIDENTIAL
THIS DOCUMENT IS THE EXCLUSIVE PROPERTY OF BEML & CONTAINS CONFIDENTIAL INFORMATION. THIS DOCUMENT OR ITS CONTENTS SHALL NOT BE USED, REPRODUCED OR DISCLOSED IN WHOLE OR IN PART, WITHOUT PRIOR WRITTEN PERMISSION OF BEML. THIS DOCUMENT & ALL ITS COPIES SHALL BE RETURNED TO BEML ON DEMAND
DRAWING RELEASED FROM PLM, PHYSICAL SIGNATURE NOT REQUIRED

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										



PRELIMINARY DRAWING



SECTION A-A

HEAT TREATMENT:
CASE CARBURISE TO A CASE DEPTH OF 0.8-1.2 mm.
CASE HARDNESS: 58-62 HRC.

				Ø22X17.5 L		CASE HARDENING STEEL Gr.16Mn5 Cr4 TO IS:4432-88	
				SIZE (mm)		COMPANY STD./I.S	Wt. (Kg)
						MATERIAL	
SL.No.	QTY	PART / STOCK No.		DESCRIPTION		MUMBAI METRO CARS L2 & L7	
1				PRODUCT			
				REF DRG			
2				MATERIAL		CAP BUSH - L17.5	
				HEAT TREAT.			
				SURFACE TREAT.			
1				TITLE		APPD	MS
						REVD	RSS
2						CHKD	RSS
						DRWN	VSE
1						SCALE	
						2:1	
2						SHEET	
						1 OF 1	
1						Wt.	
						0.06kg	
2						ALT	
						2	



BEML LIMITED

525-84107