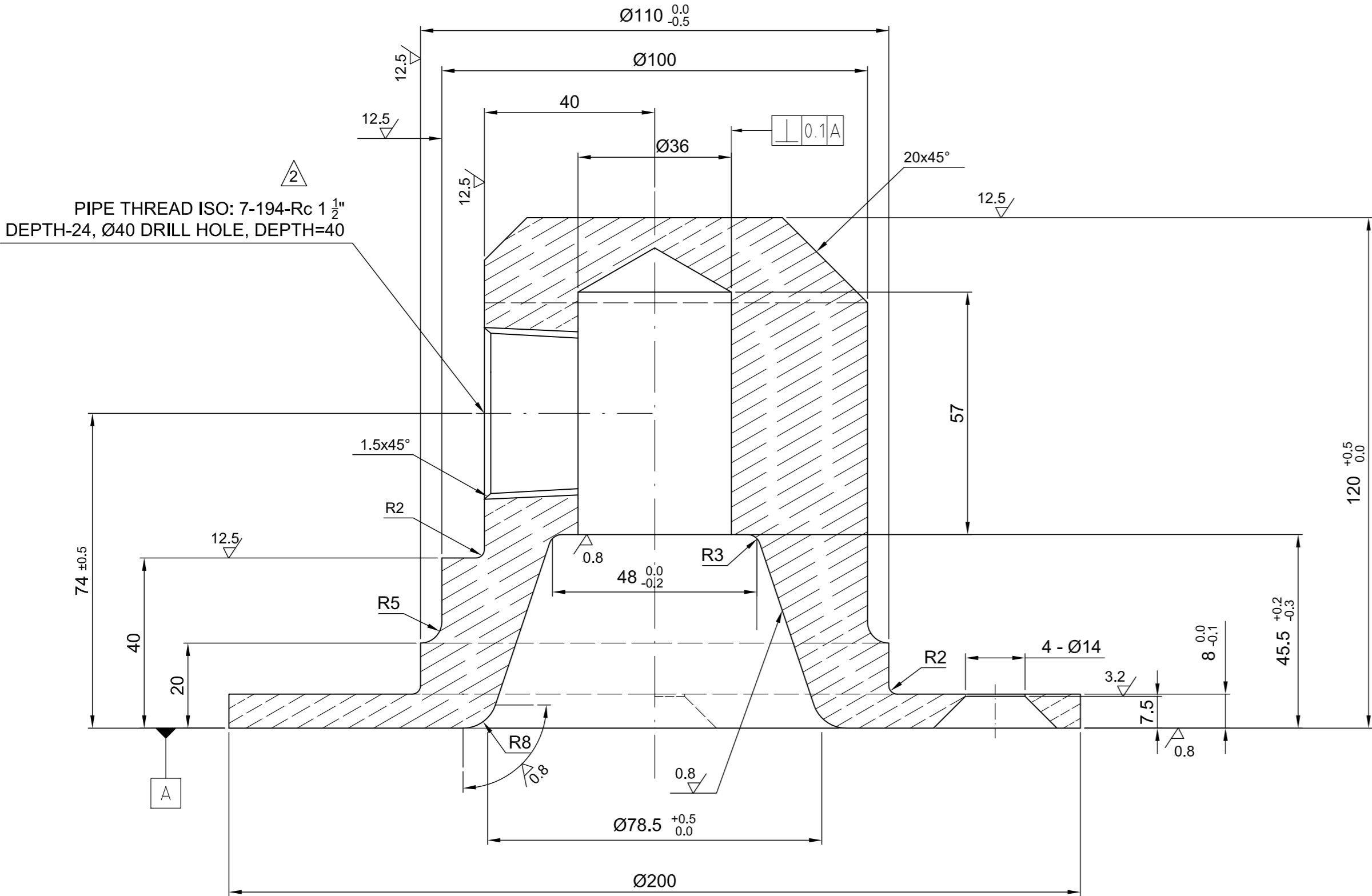
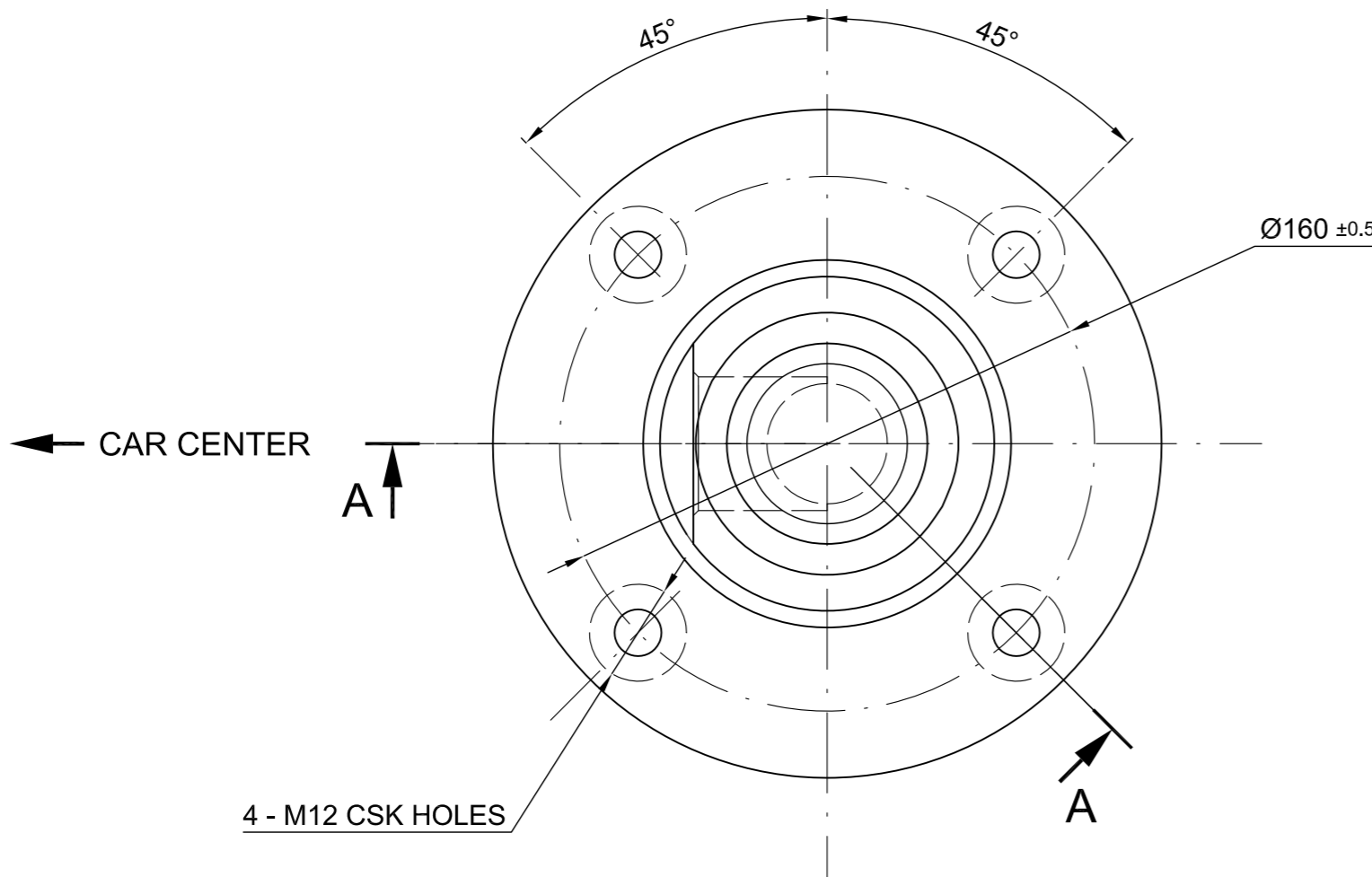


GRADE No.	N12	N11	N10	N9	N8	N7	N6	N5	N4	N3	N2	N1
VALUE	50	25	12.5	6.3	3.2	1.6	0.8	0.4	0.2	0.1	0.05	0.025
SYMBOL												
SURFACE ROUGHNESS												

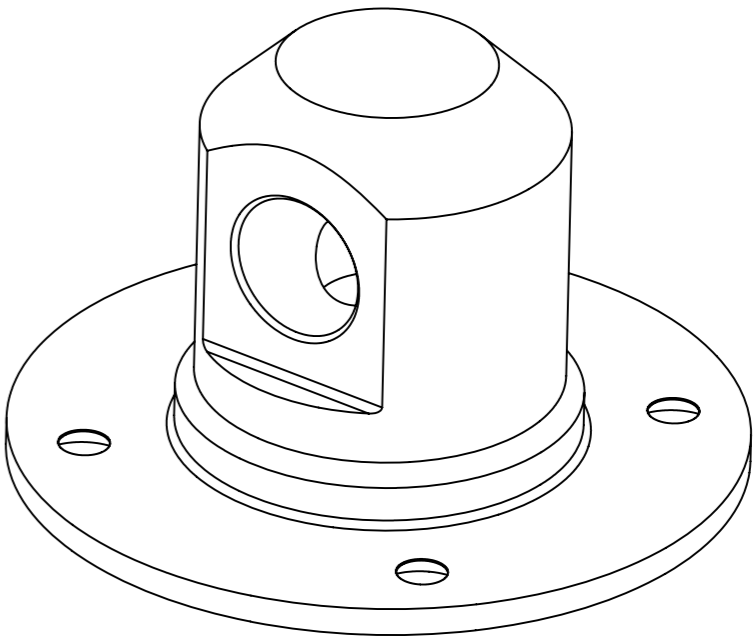


SECTION A-A
1:1



4 - M12 CSK HOLES

3		2					1		
MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 – 6	6 – 30	30 – 120	120 – 315	315–1000	1000–2000	2000–4000	ABOVE 4000
	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)									
VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS. 1012.C.						PROTO / PILOT / PRODUCTION			
QUALITY OF WELD JOINTS REF. ISO:5817									



ISOMETRIC VIEW

NOTE:-

1. ROUND OFF SHARP CORNERS.
2. THE FLOW LINES SHALL FOLLOW THE CONTOUR OF THE FORGING. THE FLOW LINES SHALL NOT CUT THE CONTOUR.
3. MANUFACTURER MUST FURNISH TEST CERTIFICATES FOR CHEMICAL COMPOSITION AND MECHANICAL PROPERTIES FOR EACH BATCH OF SUPPLY.
4. FORGINGS SHALL BE SUPPLIED IN NORMALISED CONDITION.
5. THE MACHINED SURFACES SHALL BE COATED WITH RUST PREVENTIVE FLUID TO IS: 1154-2000
6. FAI: ONE NO. OF FINISH MACHINED SAMPLE OF AIR SPRING SEAT SHALL BE SUPPLIED FREE ALONG WITH ALL MECHANICAL & CHEMICAL TEST REPORTS AND DIMENSIONS CHECKSHEET FOR APPROVAL BY BEML BEFORE BULK PRODUCTION.
7. THE FORGINGS SHALL STRICTLY CONFORM TO BEML PTS DOC.NO. GR/TD/1480.

UN CONTROLLED COPY

		4						SF 440A, JIS G 3201/ IS: 2004-91, CL-2 CARBON STEEL FORGING		
SL No.	QTY	DRG. / STOCK No.		DESCRIPTION				SIZE	COMPANY STD/IS STD Wt.Kg	
		DETAIL PARTS						MATERIAL		
							PRODUCT	METRO BOGIE		
								SURFACE TREATMENT		
2X1		STANDARD FOR PIPE THREAD ISO: 7-1-94-Rc 1.12" WAS PIPE THREAD ISO: 7-1-94-Rg 1 1/2" ECN No. 90900616	21.07.16	ILYAS	22-11-18	Handwritten		APPROVED	S JAYAPRAKASH	
								CHECKED	PAVAN	
1X1		NOTE REVISED	25.4.11	PRATEEK	KSRR	JP		DRAWN	A SRINIVAS	
								REF	DRG	
							4	909-80001	909	
ALT	CHANGES / ECN No.		DATE	BY	CKD	APP	QTY	NEXT ASSY	MODEL	