

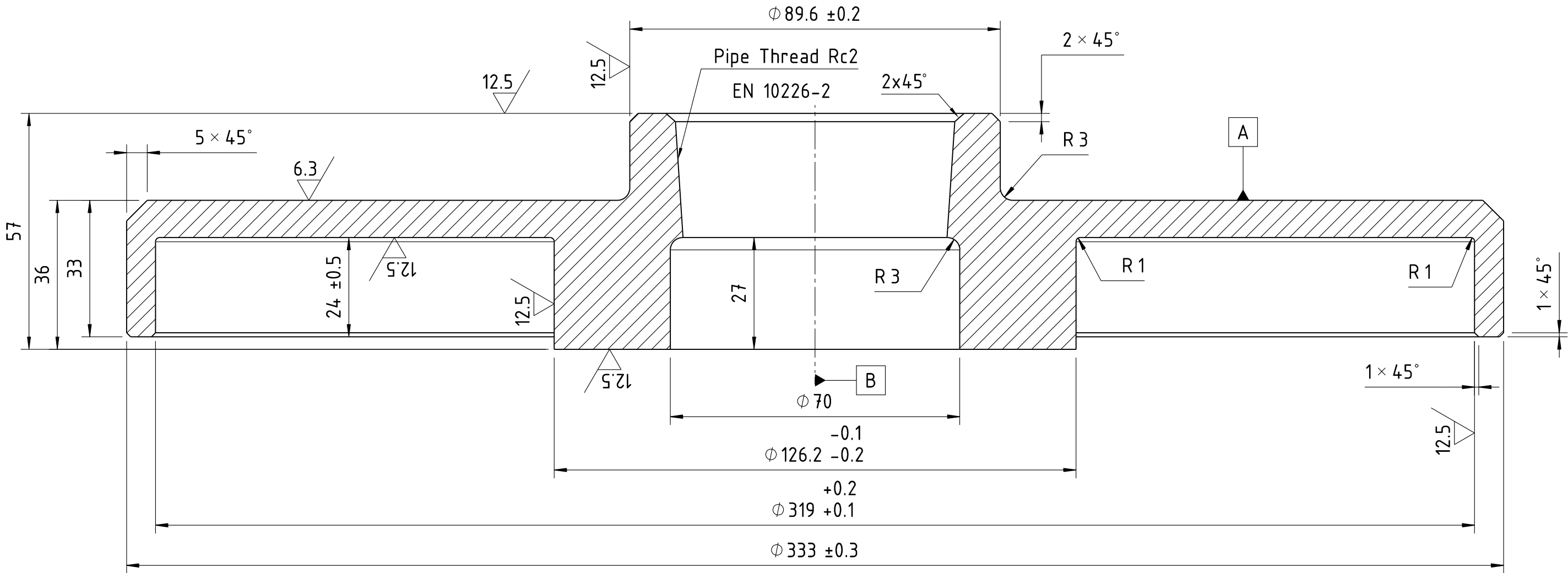
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GRADE No.	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12	SYMBOL
VALUE	0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50	
SURFACE ROUGHNESS													

PRELIMINARY DRAWING

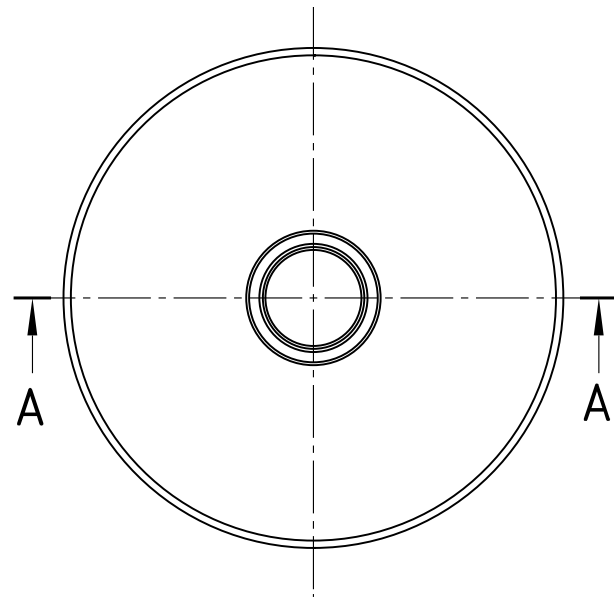
MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 – 6	6 – 30	30 – 120	120 – 315	315-1000	1000-2000	2000-4000	ABOVE 4000	RA
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	~
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227										
UNSPECIFIED TOLERANCE FOR LINEAR 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										

UNCONTROLLED







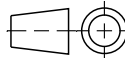


SECTION A-A

1:1



NOTE:

1. REMOVE ALL SHARP EDGES AND BURRS
2. PAINTING TO BE DONE AS PER PAINTING SPECIFICATION GR/TD/4390 EXCEPT SCREW.
3. TO BE PLATED WITH PHOSPHATE CLASS B AS PER IS 3618
4. THE PERPENDICULARITY & PARALLEISM SHALL BE WITHIN 0.1 W.R.T. DATUM A, CONCENTRICITY SHALL BE WITHIN 0.1 W.R.T DATUM B
5. THE RAW MATERIAL FOR PLATE SHALL BE 100% UT AND REPORTS SHALL BE SUBMITTED.
6. THE PART SHALL BE MANUFACTURED USING ONLY BAR STOCK /PLATE STOCK MATERIAL.

							PLATE Ø333X57			
SL.No.	QTY	PART / STOCK No.				DESCRIPTION		SIZE	COMPANY STD./I.S	Wt. (Kg)
									MATERIAL	
						PRODUCT	MUMBAI METRO CARS L2 & L7			
						REF DRG				
						MATERIAL	E410BR AS PER IS 2062-2011 IMPACT TEST REQUIRED			
						HEAT TREAT.		APPD	MS	
						SURFACE TREAT.		REVD	RSS	
						TITLE		CHKD	VSE	
						UPPER PLATE		DRWN	AKSHAY	
								SCALE		SHEET
								1:5	1 OF 1	9.5kg
						DRG No.		525-81124		ALT
ALT.No.	ECN NO/CHANGES				DATE	BY	CHKD	APPD	 BEM LIMITED <small>NEW FRONTIERS- NEW DREAMS</small>	
										



BEML LIMITED

525-81124

