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

SURFACE ROUGHNESS

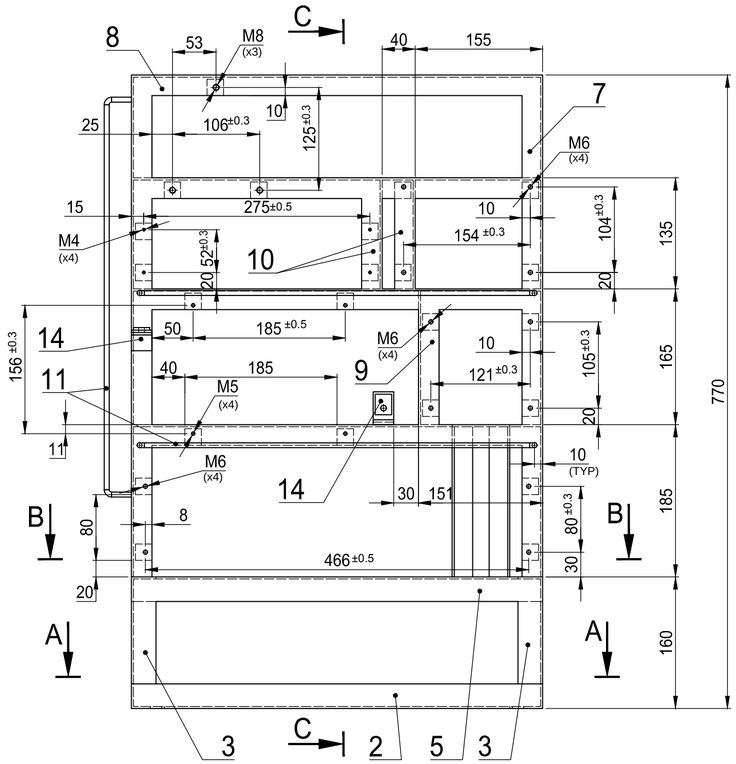
MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000	RA
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	~

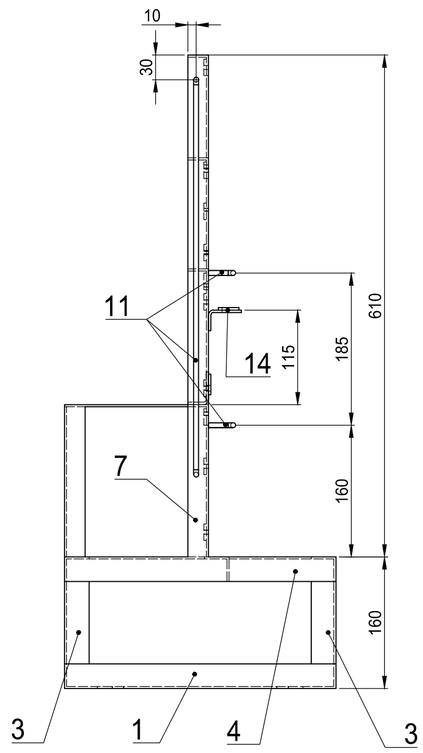
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

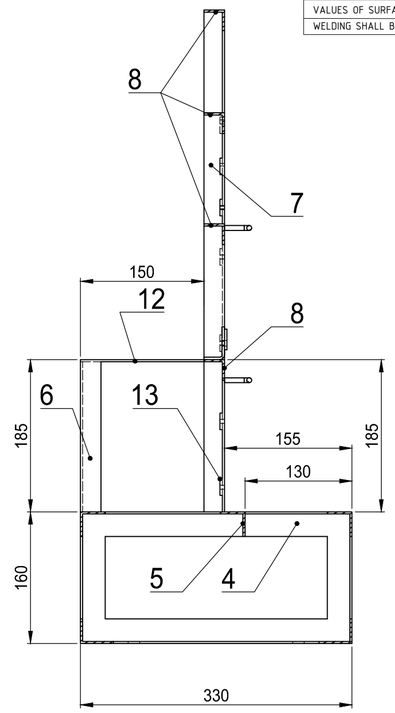
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM) | QUALITY OF WELD JOINTS REF, RD 230 MEDIUM

VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS. 1012.C. | STATUS: PROTO

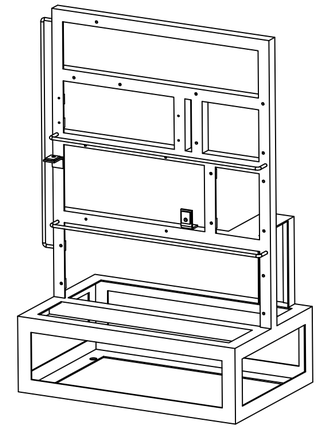
WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96



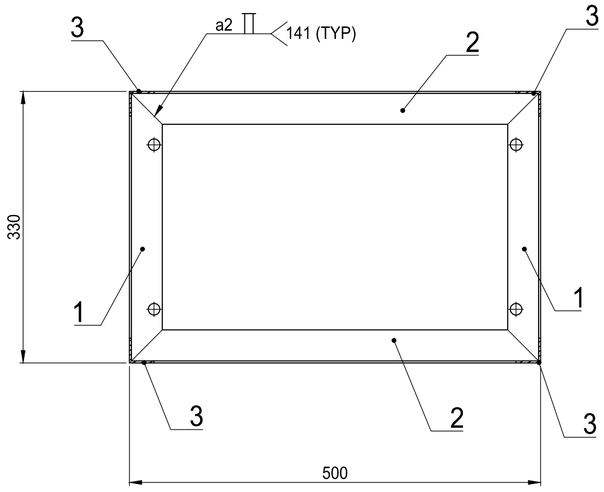




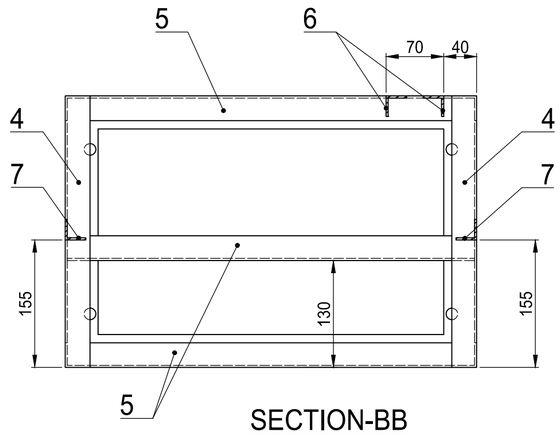
SECTION-CC



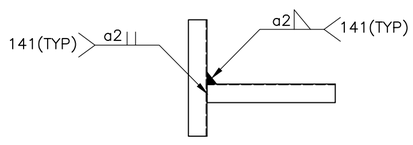
UN CONTROLLED



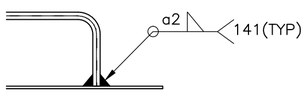
SECTION-AA



SECTION-BB



TO WELD ANGLES



TO WELD STIFFENERS

NOTE:

1. CONTINUOS SS TIG WELDING TO BE DONE AT ALL JOINTS
2. CONSISTENCY IN PERPENDICULARITY,PARALLELALITY & RIGIDITY IN THE STRUCTURE SHALL BE MAINTAINED.
3. ALL HOLE PITCH DIMENSIONS TO BE MAINTAINED AS PER TOLERANCES GIVEN
4. REMOVE ALL SHARP EDGES AND BURRS

WELD SPECIFICATIONS

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
					MATERIAL	
14	2	525-40193-02	EARTH PAD			
13	23	525-50019-16	NUT PAD			
12	1	525-50019-15	PLATE			
11	3	525-50019-14	WIRE SUPPORT			
10	2	525-50019-12	ANGLE			
9	1	525-50019-10	ANGLE			
8	4	525-50019-09	ANGLE			
7	2	525-50019-08	ANGLE			
6	2	525-50019-06	ANGLE			
5	3	525-50019-05	ANGLE			
4	2	525-50019-04	ANGLE			
3	4	525-50019-03	ANGLE			
2	2	525-50019-02	ANGLE			
1	2	525-50019-01	ANGLE			

ALT.NO.	ECN NO/CHANGES	DATE	BY	CHKD	APPD

PRODUCT: MUMBAI METRO CARS L2 & L7
REF DRG:
MATERIAL:
HEAT TREAT.:
SURFACE TREAT.:

APPD	V.SYLAJA	30.08.2020
REVD	HARISH S.N	30.08.2020
CHKD	KIRAN	29.08.2020
DRWN	KIRAN	29.08.2020

TITLE: M-CAR CUBICLE FRAME (REAR-RH)

SCALE 1:5 | SHEET 1 OF 1 | Wt.(Kg) 0

BEML LIMITED

DRG No. 525-50017 | ALT 0

A2