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

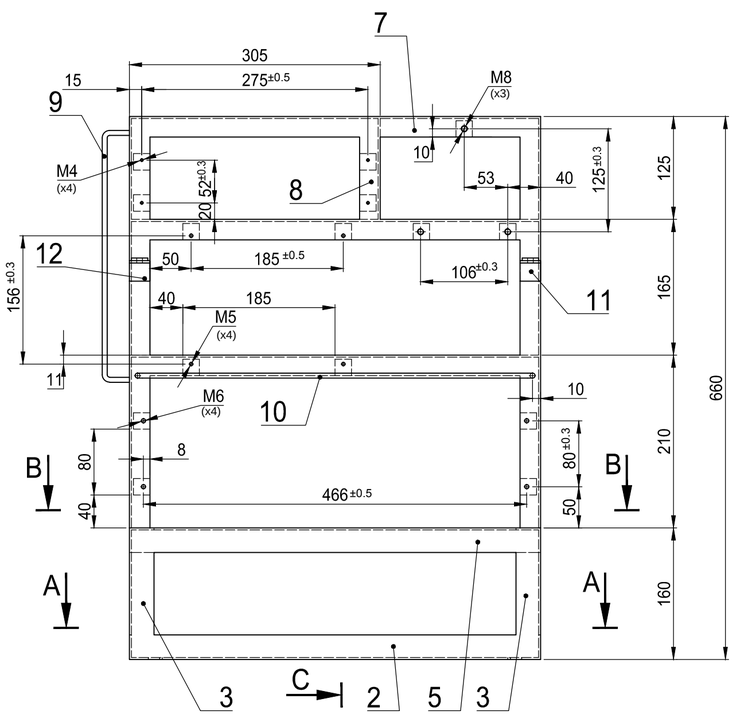
MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000	RA
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	~

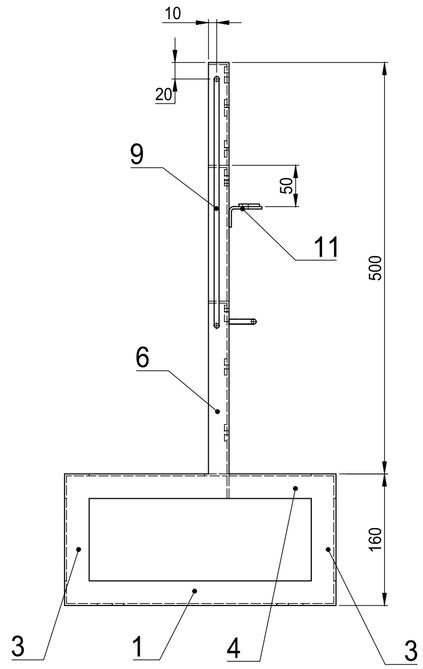
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

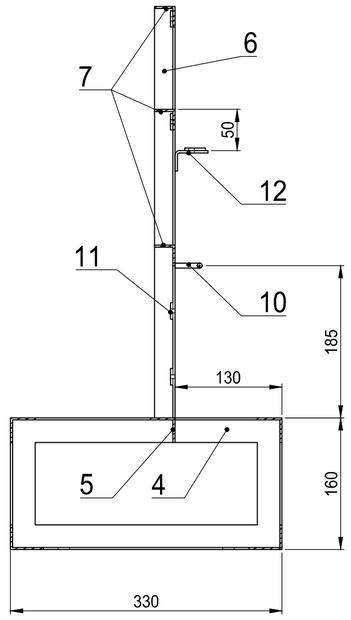
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM) | QUALITY OF WELD JOINTS REF, RD 230 MEDIUM

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







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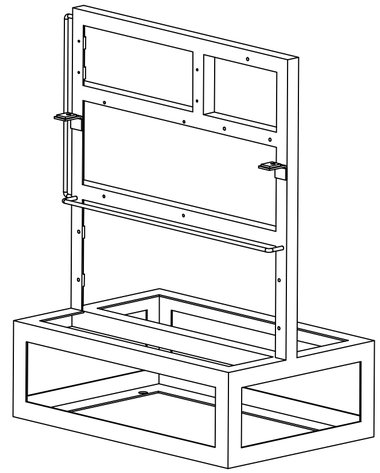
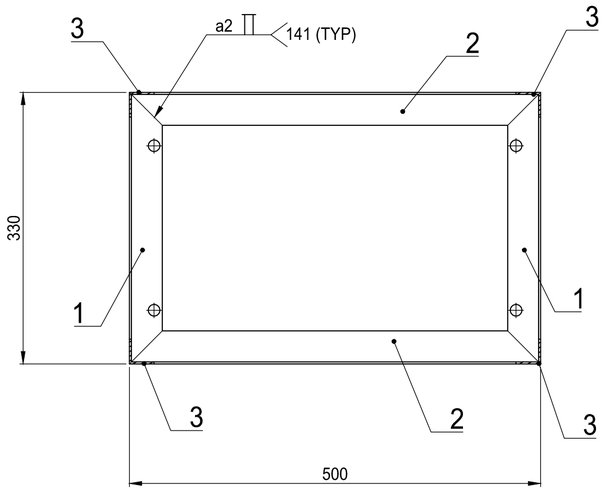
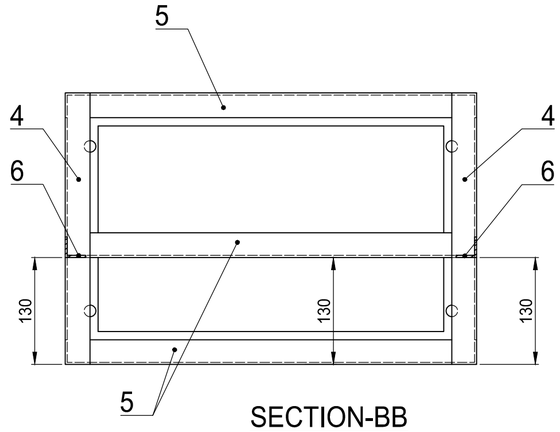
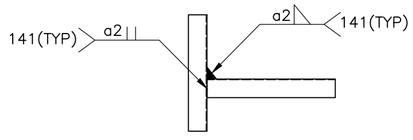




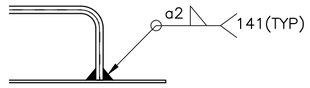
SECTION-AA



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

UN CONTROLLED

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S.	Wt. (Kg)
					MATERIAL	
12	2	525-40193-02	EARTH PAD			
11	15	525-50019-16	NUT PAD			
10	1	525-50019-14	WIRE SUPPORT			
9	1	525-50019-13	WIRE SUPPORT			
8	1	525-50019-11	ANGLE			
7	3	525-50019-09	ANGLE			
6	2	525-50019-07	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	09.09.2020
REVD	HARISH S.N	09.09.2020
CHKD	KIRAN	09.09.2020
DRWN	KIRAN	08.09.2020

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

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

BEML LIMITED

DRG No. 525-50018 | ALT 0 | A2