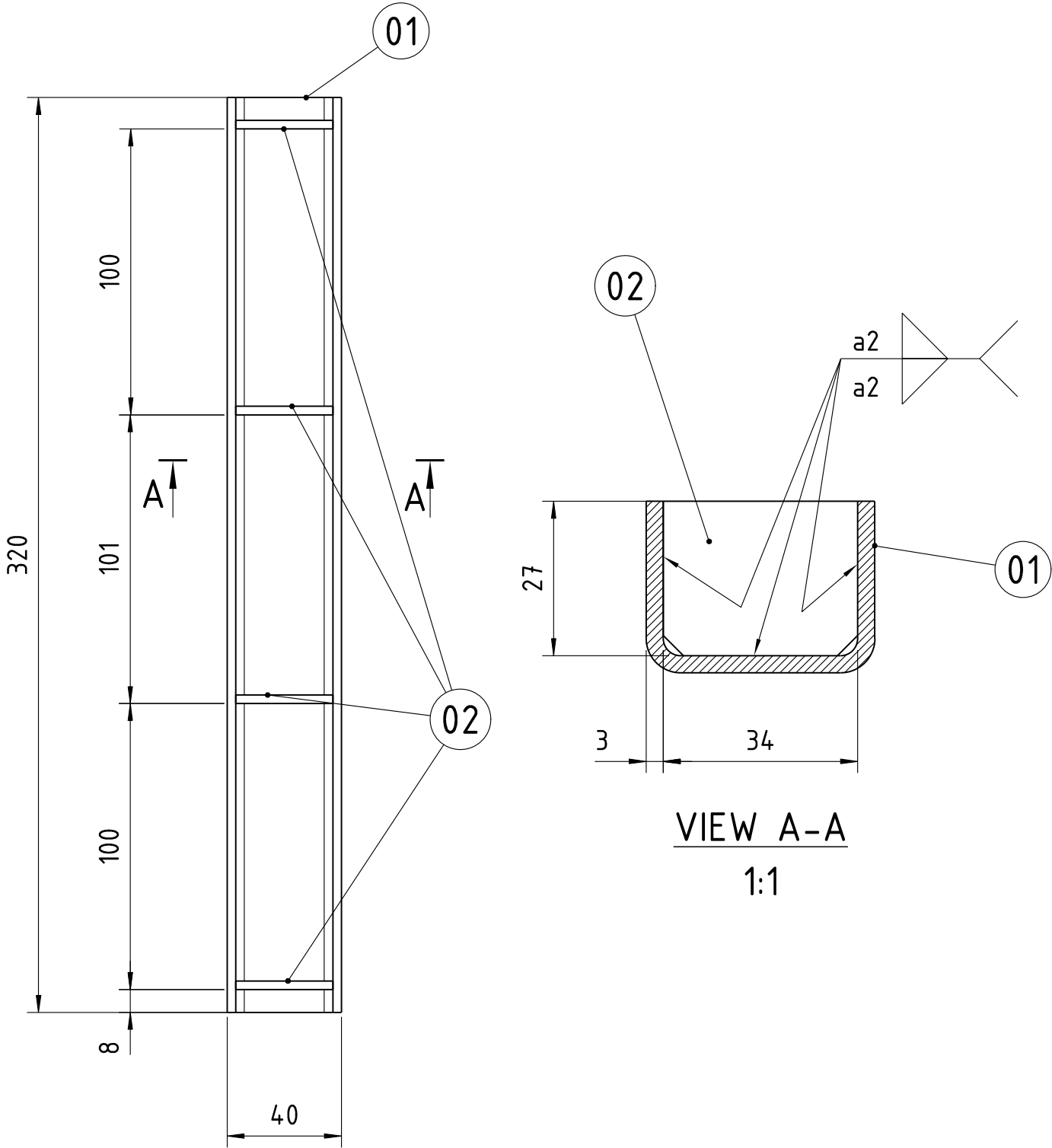


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GRADE No.	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12	SYMBOL
VALUE	0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50	
ROUGHNESS													





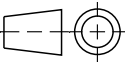




		2						1			
MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 – 6	6 – 30	30 – 120	120 – 315	315-1000	1000-2000	2000-4000	ABOVE 4000	RA	
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	~	
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227											
UNSPECIFIED TOLERANCE 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

NOTES:-

1. WELDING SYMBOLS SHALL BE AS PER ISO 2553
2. WELDING PROCESS ACCORDING TO DIN EN ISO 4063
3. WELDDING SHALL BE PERFORMED AS PER DIN EN 15085-3 AND WELD PERFORMANCE CLASS - CP C2
4. # WELD AND GRIND TO MERGE THE WELD SMOOTHLY
5. ## FULL PENETRATION WELDING
6. REMOVE ALL SPATTERS AFTER WELDING
7. RUN-ON & RUN-OFF PLATES SHALL BE USED AT THE BEGINNING & AT THE END OF WELD

2	4	525-56261	STIFFNER									
1	1	525-56255	BRACKET-A									
SL.No.	QTY	PART / STOCK No.	DESCRIPTION					SIZE		COMPANY STD./I.S	Wt. (Kg)	
										MATERIAL		
							PRODUCT	MUMBAI METRO CARS L2 & L7				
							REF DRG					
							MATERIAL	-				
							HEAT TREAT.			APPD	MS	
SURFACE TREAT.	REVD	RSS										
							TITLE	CHKD	VSE			
							BRACKET ASS'Y-A	DRWN	MM			
							SCALE		SHEET	Wt.		
							1:2		1 OF 1	0.76Kg		
							DRG No.				ALT	
							525-56051					
ALT.NO.	ECN NO/CHANGES		DATE	BY	CHKD	APPD	 <b>BEM</b> LIMITED <small>NEW FRONTIERS. NEW DREAMS</small>					



BEML LIMITED

525-56051

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