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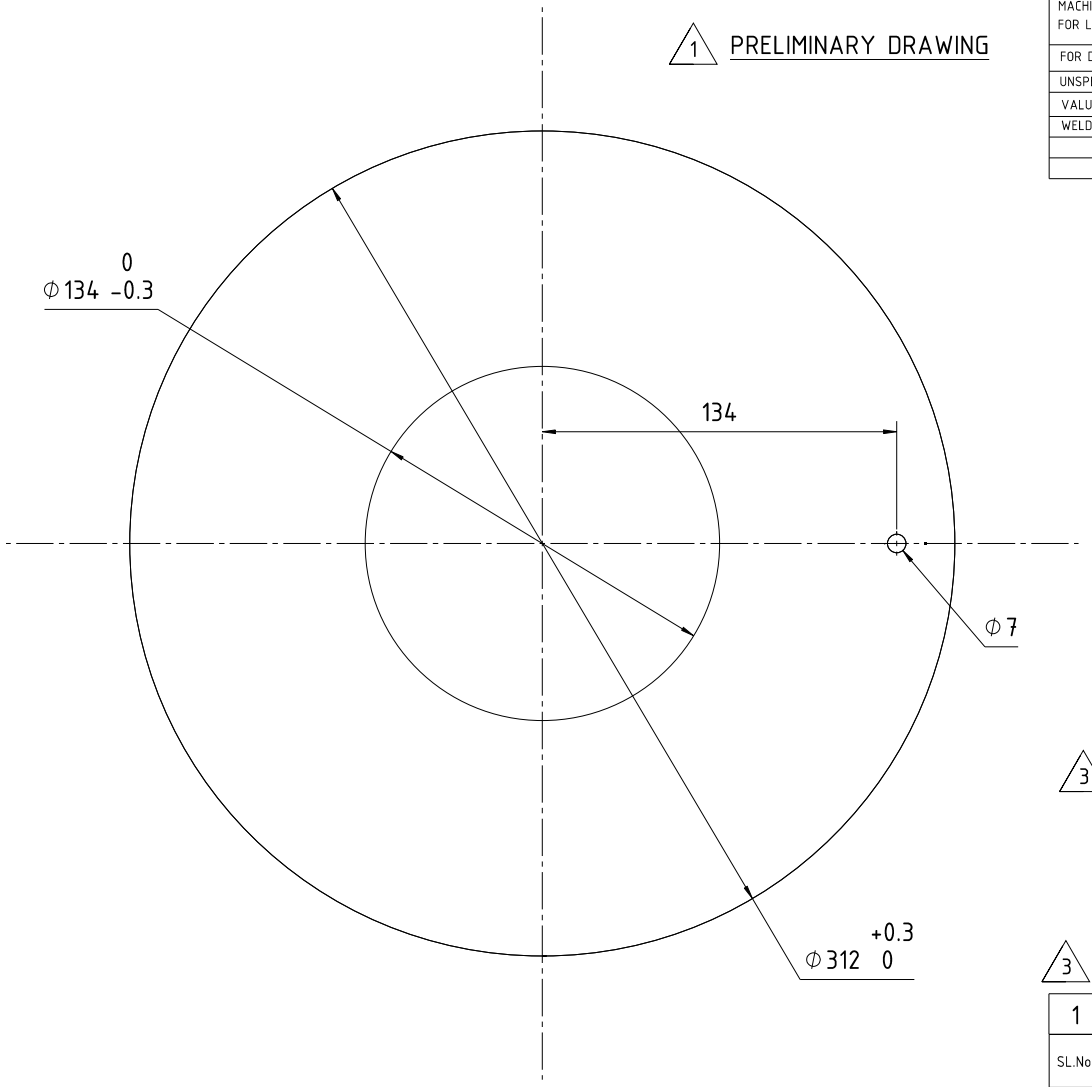
GRADE No.	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12
VALUE	0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50
SYMBOL												

SURFACE ROUGHNESS

1 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.

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

STATUS: PROTO

UNCONTROLLED COPY

3

Sl. No.	Description	Thickness (mm)	Quantity
1	525-81117-01	1	2
2	525-81117-02	1.5	4

NOTE:-
1. PART SHALL BE ZINC PLATED AS PER SERVICE GRADE NO. 2 OF IS 1573-86 AND CHROMATE PASSIVATED TO COLOR IRIDESCENT YELLOW
2. REMOVE ALL SHARP EDGES AND BURRS

3

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
					MATERIAL	
1	1	C100603100	-	Φ312x1mm THK	-	

ALT.NO.	ECN NO/CHANGES	DATE	BY	CHKD	APPD
3	ECN: 52510311 TABLE REMOVED & PART DESCRIPTION ADDED	05-10-2020	VSE	RSS	MS
2	ECN: 52510159 REVISED AND REDRAWN	10-02-2020	VSE	RSS	MS
1	ECN: 52510123 PRELIMINARY DRAWING COMMENT ADDED	10-02-2020	VSE	RSS	MS

PRODUCT: MUMBAI METRO CARS L2 & L7
REF DRG:
MATERIAL: IS 513-94 GR-O
HEAT TREAT.:
SURFACE TREAT.:
TITLE: LINER UPPER

APPD	MS
REVD	RSS
CHKD	VSE
DRWN	VSE

SCALE 1:2 | SHEET 1 OF 1 | Wt. 0.5kg

BEML LIMITED
NEW FRONTIERS. NEW DREAMS

DRG No. 525-81117 | ALT 3

A3