| 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:

**UNCONTROLLED**

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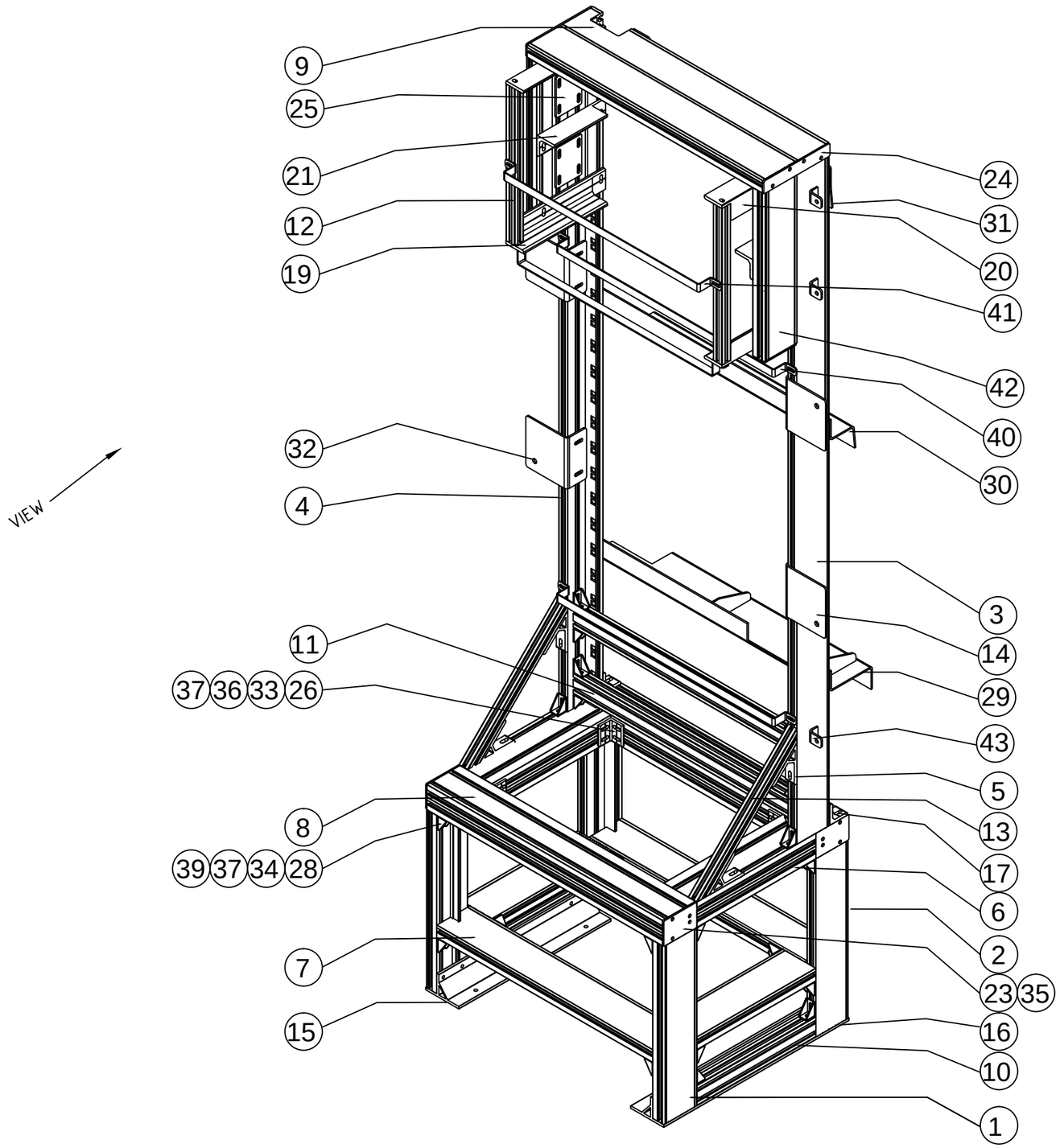


| SL.No. | QTY | PART / STOCK No. | DESCRIPTION | SIZE | COMPANY STD./LS / MATERIAL | Wt. (Kg) |
|---|---|---|---|---|---|---|
| 43 | 3 | 942-50262 | EARTHING BRACKET | | THK-3,Alu5052 | |
| 42 | 2 | 942-50304-1 | FRAME-LH RH | L-330 | EXTRUSION REF 942-50202 | |
| 41 | 2 | 942-50236-2 | WIRE SUPPORT | | THK-2.5,SS304 | |
| 40 | 4 | 942-50236-1 | WIRE SUPPORT | | THK-2.5,SS304 | |
| 39 | 40 | RFS5960508 | Hex.Soc head cap allen Bolt M5X8 to IS:2269/ Matl:IS-1367 (P-14) Gr-A2-70 Stainless steel | | | |
| 38 | 80 | RFS5960616 | Hex.Soc head cap allen Bolt M5X16 to IS:2269/ Matl:IS-1367 (P-14) Gr-A2-70,Stainless steel | | | |
| 37 | 230 | RFW0920512 | SPRING WASHER-B5 TO IS:3063-(TAB-1)/MATL:AISI-304,STAINLESS STEEL | | | |
| 36 | 110 | RFS5960512 | Hex.Soc head cap allen Bolt M5X12 to IS:2269/ Matl:IS-1367 (P-14) Gr-A2-70,Stainless steel | | | |
| 35 | 20 | RFS7420512 | Cross recessed CSK head screw M5X12 to IS:7485/ Matl:ISO-3506-79 Gr-A2-70,Stainless steel | | | |
| 34 | 100 | 942-50231-1 | NUT PAD-M5 | | THK-2.5,SS304 | |
| 33 | 130 | 942-50230 | NUT PAD-M5 | | THK-3,SS304 | |
| 32 | 4 | 942-50231-2 | NUT PAD-M8 | | THK-3,SS304 | |
| 31 | 1 | 942-50249 | BACK PLATE RH | | SM ,THK-3,SS304 | |
| 30 | 1 | 942-50248 | Z-PLATE-2 RH | | SM ,THK-3,SS304 | |
| 29 | 1 | 942-50247 | Z-PLATE-1 RH | | SM ,THK-3,SS304 | |
| 28 | 40 | 942-50245 | SUPPORT BRACKET ASSY, | | SM ,THK-2,SS304 / CASTING | |
| ~~27~~ | ~~2~~ | ~~942-50244-1~~ | ~~BASE PLATE LH-RH~~ | ~~L-420~~ | ~~SM ,THK-5,ALU5052~~ | |
| 26 | 4 | 942-50242 | L-ANGLE | L-40 | EX NO-942-50210-1 | |
| 25 | 4 | 942-50241 | WALL PLATE LH-RH | | SM ,THK-3,ALU5052 | |
| 24 | 2 | 942-50315 | END CAP PLATE-2 LH&RH | L-150 | SM ,THK-3,ALU5052 | |
| 23 | 4 | 942-50239 | END CAP PLATE-1 LH&RH | L-75 | SM ,THK-3,ALU5052 | |
| ~~22~~ | ~~10~~ | ~~942-50236~~ | ~~WIRE SUPPORT~~ | | ~~SM ,THK-15,ALU5052~~ | |
| 21 | 2 | 942-50313 | L-ANGLE LH-RH | L-150 | EX NO-942-50210 | |
| 20 | 2 | 942-50312 | L-ANGLE LH RH | L-220 | | |
| 19 | 2 | 942-50311 | L-ANGLE LH RH | L-220 | | |
| ~~18~~ | ~~4~~ | ~~942-50310~~ | ~~L-ANGLE LH-RH~~ | ~~L-25~~ | | |
| 17 | 1<br>1 | 942-50228<br>942-50229 | L-ANGLE-LH-RH | L-25 | | |
| 16 | 1 | 942-50226 | BASE -RH | L-420 | EX NO-942-50209 | |
| 15 | 1 | 942-50309 | BASE- LH | L-420 | | |
| 14 | 4 | 942-50308-1 | L-ANGLE PLATE | | SM ,THK-3,SS304 | |
| 13 | 2 | 942-50307 | FRAME | L-321 | EXTRUSION REF, 942-50204 | |
| 12 | 2 | 942-50032-12 | FRAME LH RH | L=308 | | |
| 11 | 2 | 942-50032-11 | FRAME | L=499.5 | EXTRUSION REF, 942-50206 | |
| 10 | 2 | 942-50032-10 | FRAME LH RH | L=270 | EXTRUSION REF, 942-50206 | |
| 9 | 1 | 942-50219 | FRAME RH TOP | L=534 | | |
| 8 | 5 | 942-50032-8 | FRAME FRONT & BACK,& TOP | L=534 | EXTRUSION REF 942-50203 | |
| 7 | 2 | 942-50032-7 | FRAME FRONT& BACK | L=490 | | |
| 6 | 6 | 942-50032-6 | FRAME LH RH | L=270 | | |
| 5 | 4 | 942-50306 | SUPPORT ANGLE | L-20 | EX NO-942-50208 | |
| 4 | 1 | 942-50305 | FRAME-LH RH | L-1315 | EXTRUSION REF 942-50202 | |
| 3 | 1 | 942-50304 | FRAME-LH RH | L-1315 | | |
| 2 | 2 | 942-50303 | FRAME-LH RH | L-350 | | |
| 1 | 2 | 942-50302 | FRAME-LH RH | L-350 | | |

| ALT.NO. | ECN NO/CHANGES | DATE | BY | CHKD | APPD |
|---|---|---|---|---|---|
| 2 | REVISED & REDRAWN ECN:92610057 | 21.03.18 | SCV | SNH | KCS |
| 1 | REVISED & REDRAWN ECN:92610027 | 10.01.18 | SCV | SNH | KCS |

PRODUCT: BMRCL METRO CARS

REF. DRG #: PP8950012CEO

MATERIAL

HEAT TREAT

SURFACE TREAT

APPD: KCS

REVD:

CHKD: SNH

DRWN: KIRAN

TITLE: RACK,MC REAR-RH

SCALE | SHEET: 2 OF 2 | WT.(Kg): 0

DRG No.: 926-50038 | ALT: 2

BEML LIMITED

NOTE:

1. ALL DIMENSIONS ARE IN mm
2. ALL ALUMINIUM PARTS SHALL BE ANODISED TO Gr.AC15 of IS:1868.

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

SURFACE ROUGHNESS