





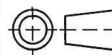


GRADE No.	VALUE	SYMBOL
SURFACE ROUGHNESS		

N12	N11	N10	N9	N8	N7	N6	N5	N4	N3	N2	N1
50	25	12.5	6.3	3.2	1.6	0.8	0.4	0.2	0.1	0.05	0.025

## 1. REMOVE ALL SHARP EDGES AND BURRS



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:	MOCKUP/PROTO/PRODUCTION			
WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96										

5	2	RFN5261211	M12, NUT HEX. (L.H THREAD) TO IS:1364(PART-3)-02, MATL. IS:1367(P-14)-84,Gr.A2-70,SS				
4	4	RFN3861211	M12, NUT HEX. (R.H THREAD) TO IS:1364(PART-3)-02, MATL. IS:1367(P-14)-84,Gr.A2-70,SS				
3	1	926-84117	SCREW ROD				
2	1	926-84116	SCREW ROD				
1	1	926-84118	TURN BUCKLE				
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE (mm)	COMPANY STD./I.S	Wt. (Kg)	
			MATERIAL				
			PRODUCT	BMRCL METRO CARS			
			REF DRG				
			MATERIAL	-			
			HEAT TREAT.	APPD	MS	21-08-19	
			SURFACE TREAT.	REVD	DB	19-08-19	
			TITLE	CHKD	DB	17-08-19	
			TURN BUCKLE, ASS'Y	DRWN	JC	1	
				SCALE		SHEET	Wt.(kg)
				1:2		1 OF 1	0.79
ALT.NO.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	DRG No.	ALT
						926-84009	
 BEML LIMITED NEW FRONTIERS. NEW DREAMS							