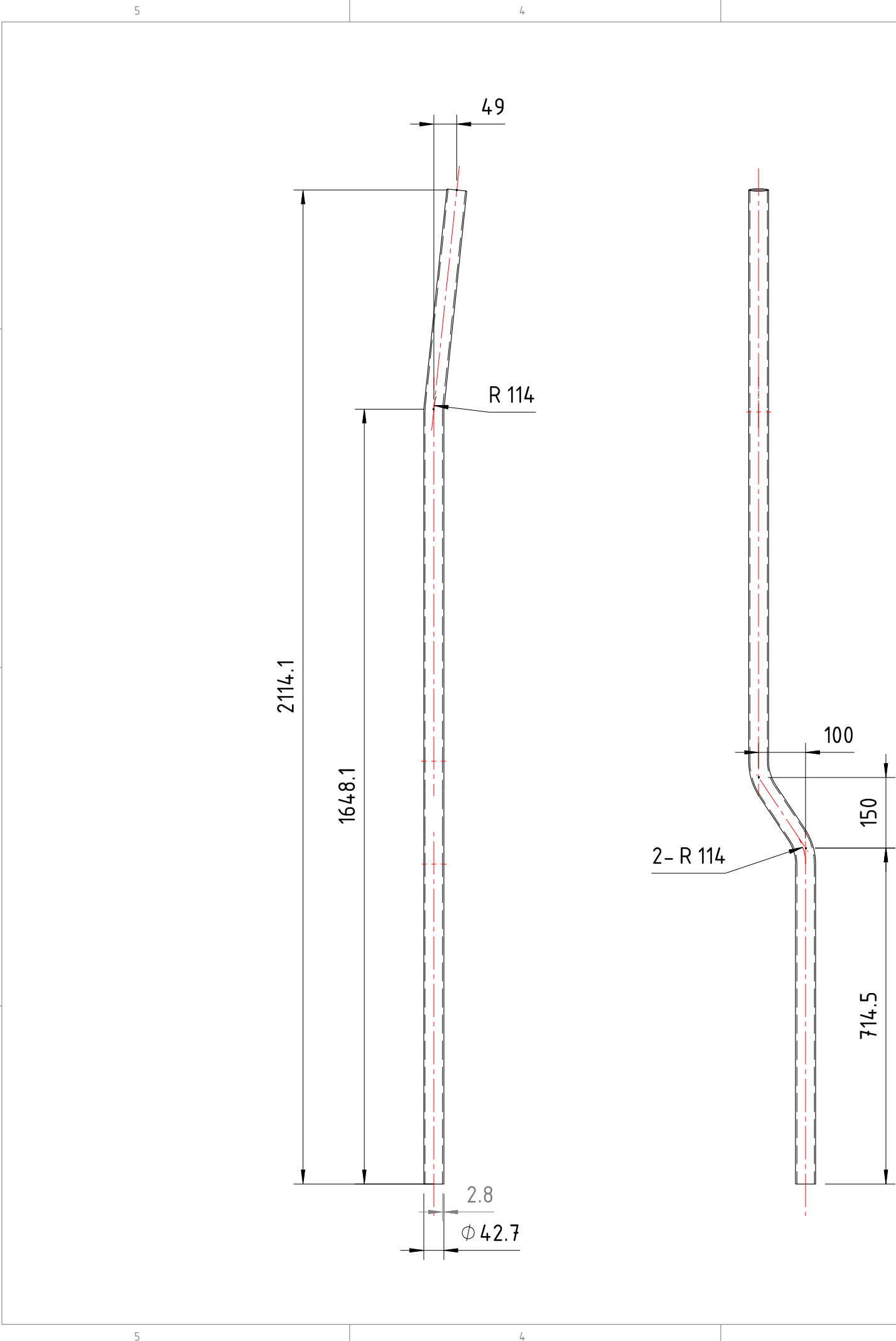


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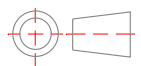

GRADE No.	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12	
VALUE	0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50	
SYMBOL													
SURFACE ROUGHNESS													



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

UN CONTROLLED

- NOTE:-
1. MANUFACTURE PART AS PER GR/TD/1276.
  2. REMOVE ALL SHARP EDGES AND BURRS.

							PIPE Ø42.7 OD x 2.8 W/T					
SL.No.	QTY	PART / STOCK No.				DESCRIPTION	SIZE (mm)	COMPANY STD./I.S		Wt. (Kg)		
								MATERIAL				
						PRODUCT	DMRC BG METRO CARS					
						REF DRG						
						MATERIAL	SUS304 (SEAMLESS SS PIPE)					
						HEAT TREAT.		APPD	BMT	02.05.2018		
						SURFACE TREAT.		REVD	BMT	02.05.2018		
						TITLE		CHKD	PS	01.05.2018		
						DRAIN PIPE		DRWN	AC	01.05.2018		
							SCALE		SHEET	Wt.		
							1:10		1 OF 1	6Kg		
							DRG No.	909-40208				ALT
ALT.NO.	ECN NO/CHANGES				DATE	BY	CHKD	APPD	 BEML LIMITED NEW FRONTIERS. NEW DREAMS		