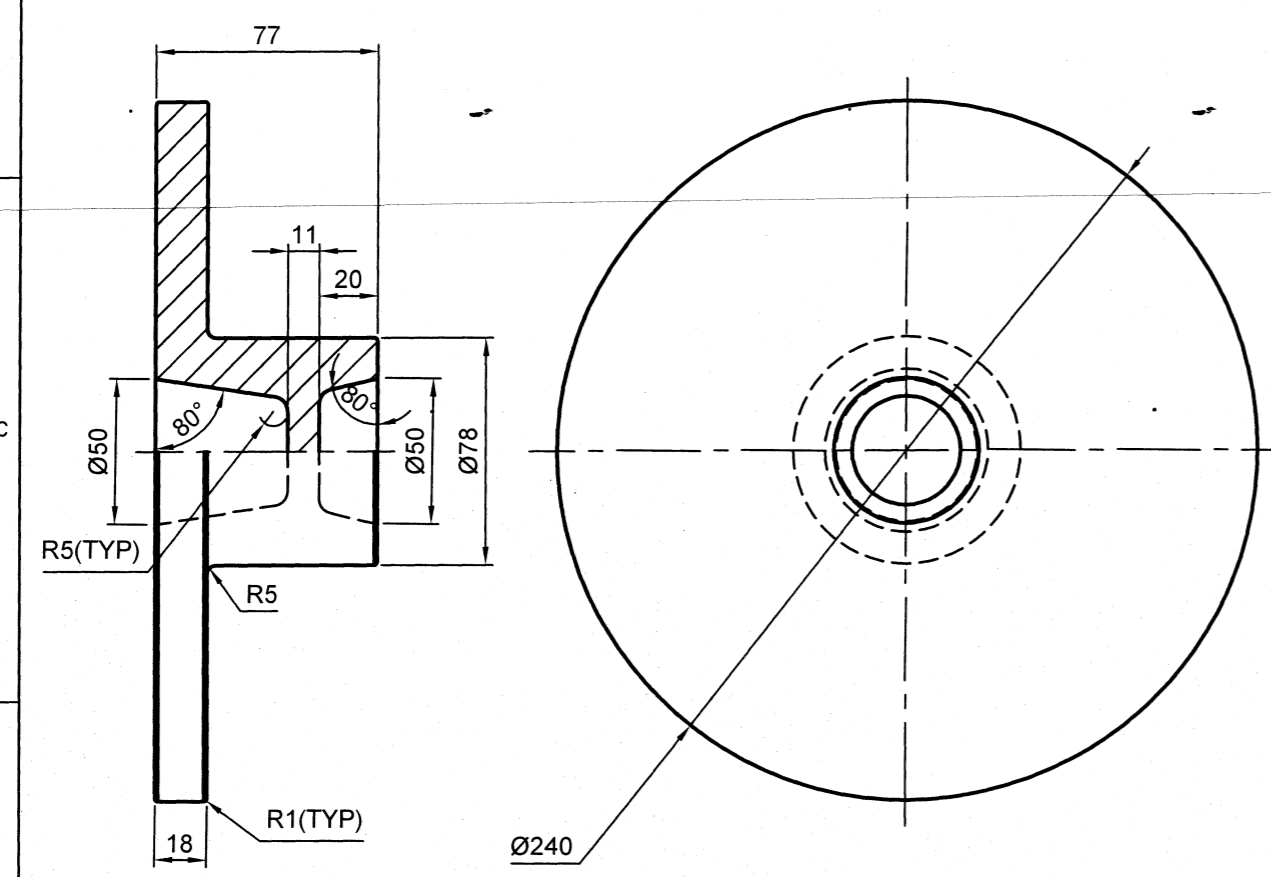
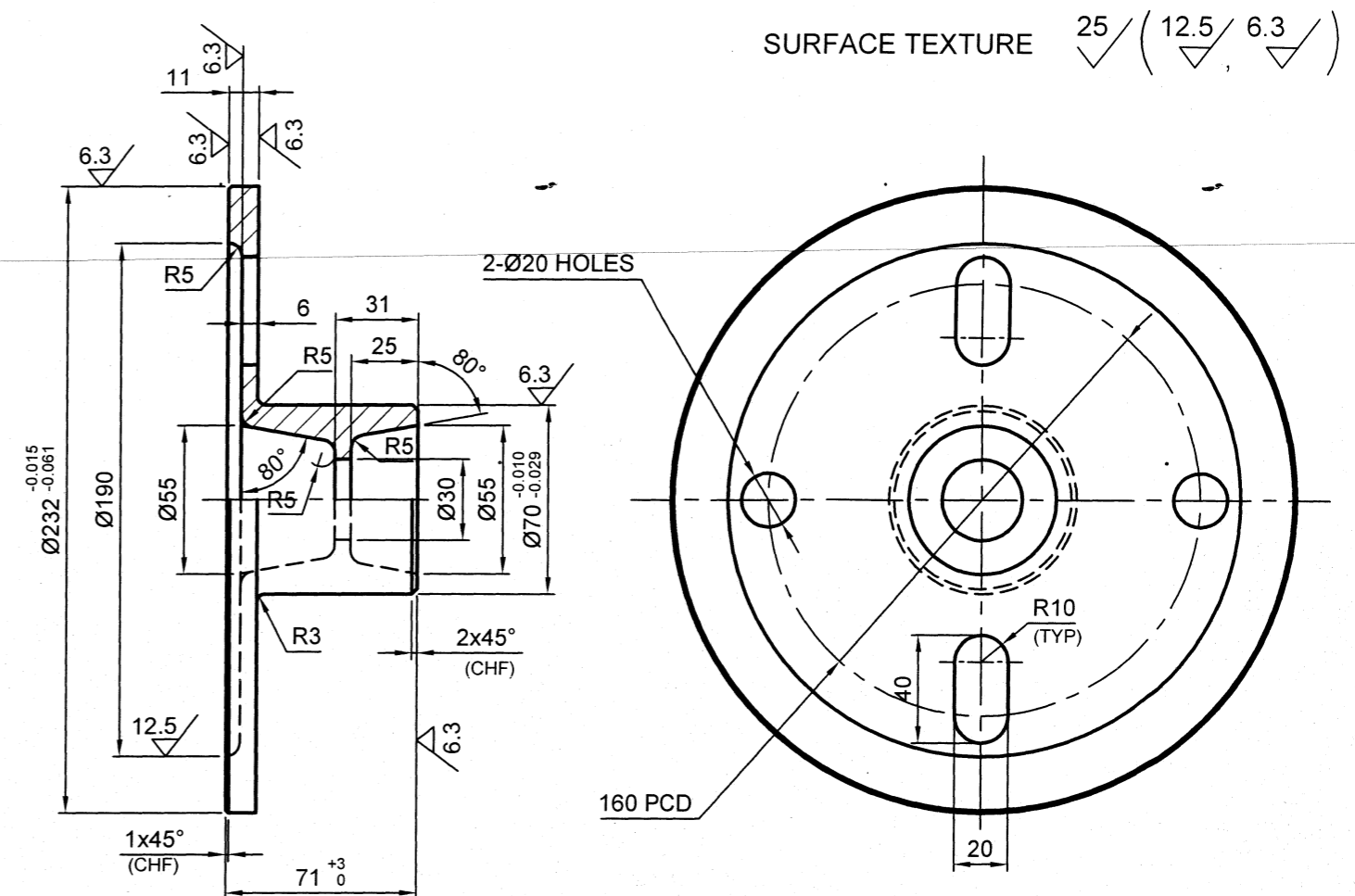


MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 – 6	6 – 30	30 – 120	120 – 315	315–1000	1000–2000	2000–4000	ABOVE 4000
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227									
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM)									
VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS. 1012.C.						PROTO / PILOT / PRODUCTION			
QUALITY OF WELD JOINTS REF, ISO 5817									

SURFACE TEXTURE  $\sqrt{25} \left( \sqrt{12.5} \sqrt{6.3} \right)$



AS FORGED



MACHINED

UN CONTROLLED COPY

NOTE

1. ROUND OFF SHARP EDGES.
2. THE FLOW LINES SHALL FOLLOW THE CONTOUR OF THE FORGING, THE FLOW LINES SHALL NOT CUT THE CONTOUR.
3. MANUFACTURER MUST FURNISH TEST CERTIFICATES FOR CHEMICAL COMPOSITION AND MECHANICAL PROPERTIES FOR EACH BATCH OF SUPPLY.
4. FORGINGS SHALL BE SUPPLIED IN NORMALSED CONDITION.
5. THE MACHINED SURFACES SHALL BE COATED WITH RUST PREVENTIVE FLUID TO IS : 1154 - 2000.
6. FAI:- ONE NO. OF MACHINED SAMPLE FORGING SHALL BE SUPPLIED FREE ALONG WITH ALL THE TEST REPORTS FOR APPROVAL BEFORE BULK PRODUCTION.

						TO SPECIFICATION IS: 2004-91, CLASS - 2	
SL No.	QTY	DRG. / STOCK No.	DESCRIPTION	SIZE	COMPANY STD/IS STD	Wt. Kg	
DETAIL PARTS				MATERIAL			
PRODUCT				METRO BOGIE			
				SURFACE TREATMENT			
				APPROVED	S JAYAPRAKASH	10.3.06	
				CHECKED	RANGANNA	9.3.06	
				DRAWN	S MOHANA	8.3.06	
				REF DRG			
				SCALE	1:2.5	SHEET	Wt (Kg)
ALT	CHANGES / ECN No.	DATE	BY	CKD	APP	OF	ALT
BEML LIMITED R&D, BANGALORE COMPLEX BANGALORE 560 075				TITLE AXLE SPRING SEAT (F)		DRG No. 909-83149	