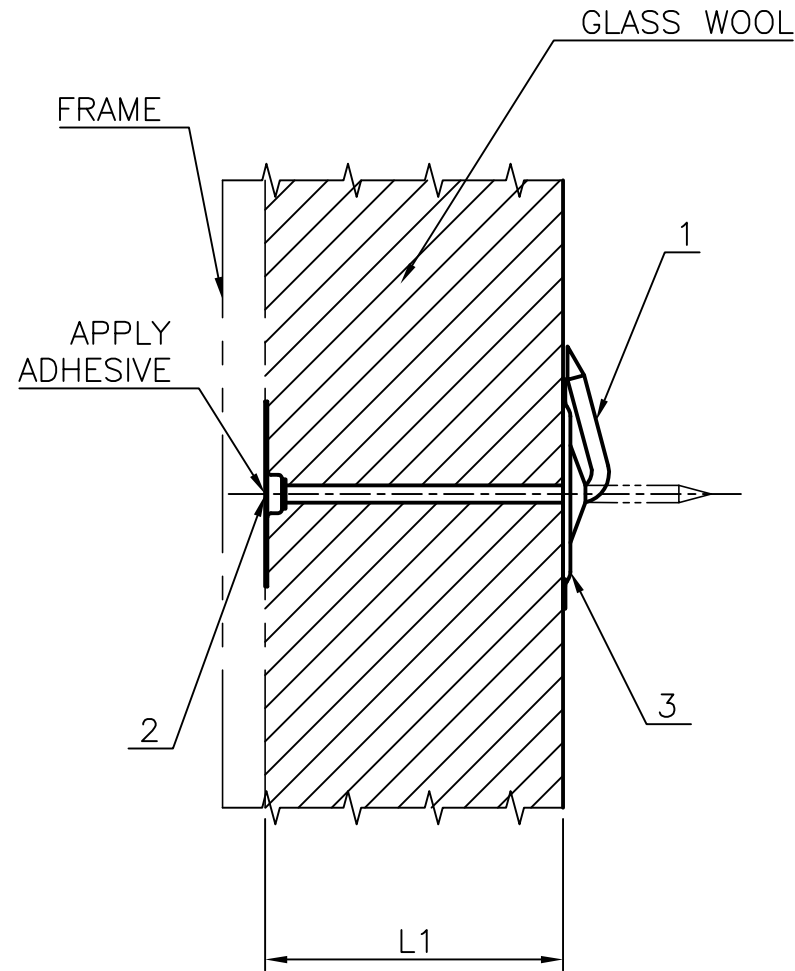
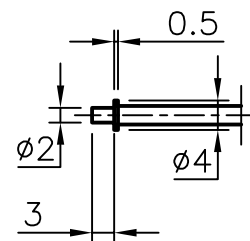


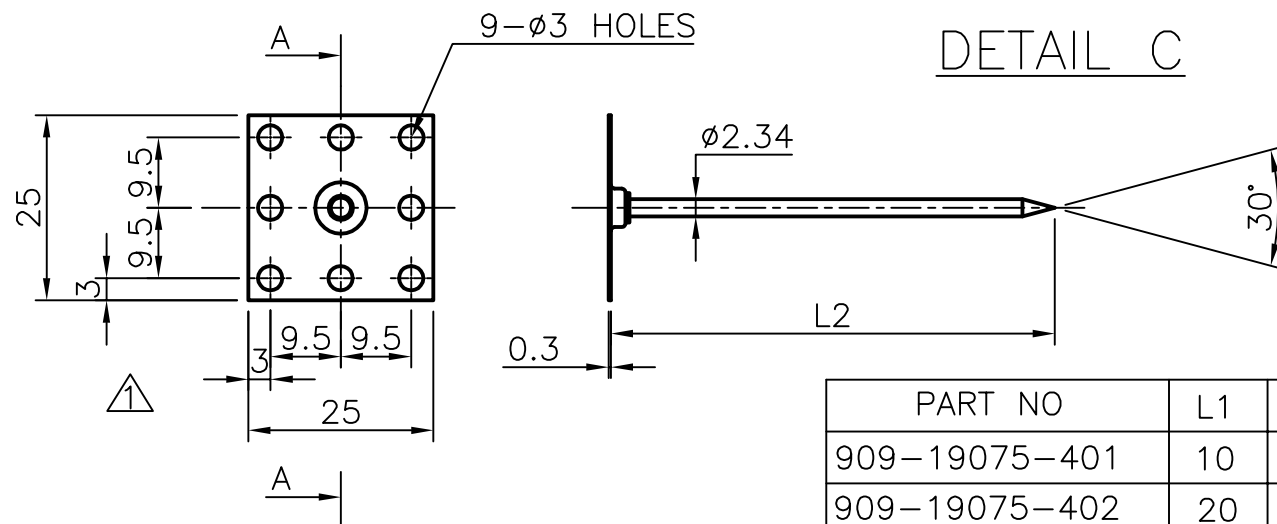
GRADE No.	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12
VALUE	0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50
SYMBOL												
SURFACE ROUGHNESS												



SECTION A-A
SCALE 2:1



DETAIL C

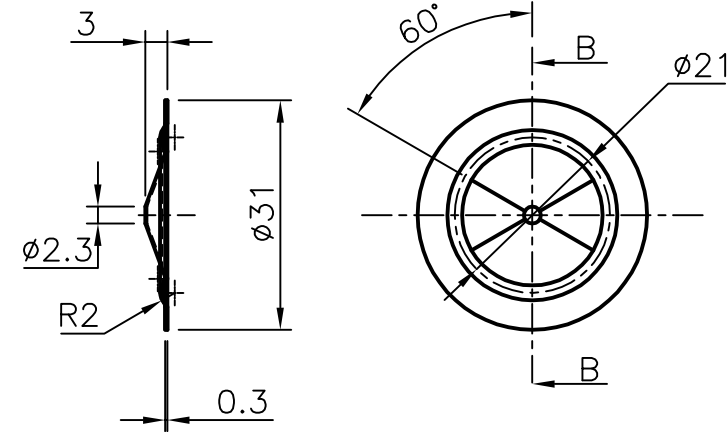


DETAIL 1,2

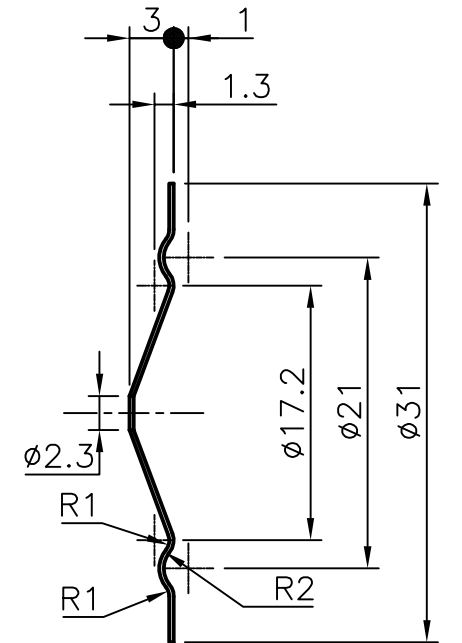
UNCONTROLLED

PART NO	L1	L2
909-19075-401	10	30
909-19075-402	20	40
909-19075-403	30	50
909-19075-404	40	60
909-19075-405	50	70

MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	2				1			
		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.						QUALITY OF WELD JOINTS REF, ISO: 5817			
PAINTING SHALL BE DONE AS PER RD - 38						—PROTO/PILOT/PRODUCTION			
WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96									



DETAIL 3



SECTION B-B
SCALE 2:1

- NOTE:
- 1.SURFACE TREATMENT FOR PLATE & WASHER ELECTROPLATED ZINC COATING TO CLASS Fe/Zn7.5 WITH CHROMATE CONVERSION COATING TYPE 'A' CLEAR TO I.S:1573-86
 - 2.GLASS WOOL PIN ASSEMBLY SHALL CONFROM TO TDC DOC NO.GR/TD/5120.

3	1	909-19075-03	WASHER	0.3t	COLD ROLLED STEEL SHEET TO GRADE 'EDD' I.S:513-94
2	1	909-19075-02	PLATE	0.3t	COLD ROLLED STEEL SHEET TO GRADE 'd' I.S:513-94
1	1	909-19075-01	PIN	2.34	AL ALLOY WIRE TO GRADE A52000 CONDITION 'O' I.S:739-1992
SL.No.	QTY	DRG. / STOCK No.	DESCRIPTION	SIZE	COMPANY.STD/IS.STD Wt.Kg.
DETAIL PARTS					
PRODUCT METRO CARS					
SURFACE TREATMENT					
ECN NO. 90900432 NOTE 2 ADDED				SCALE 1:1	Wt.(Kg)
ECN NO. 90900432 REVISED & REDRAWN				QTY	NEXT ASSY
ECN NO. 9090061 REVISED & REDRAWN				MODEL	REF DRG
X1				TITLE	
ALT				GLASS WOOL PIN ASSY.	
CHANGES				APPROVED AMIT BANERJEE	
DATE BY CKD APP				CHECKED THIPANNA	
				DRAWN RAJKOHAD	
				DRG No.	
				909-19075	
				ALT	
				3	