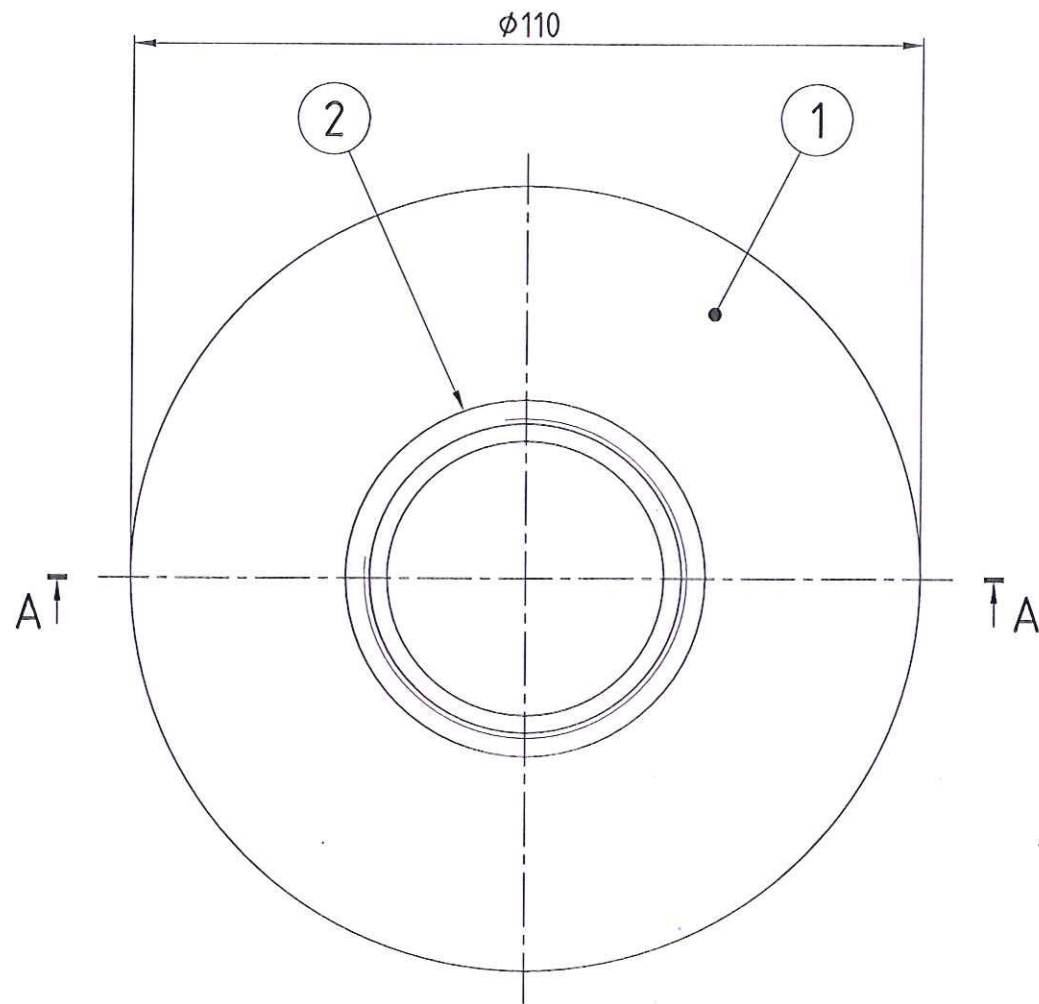


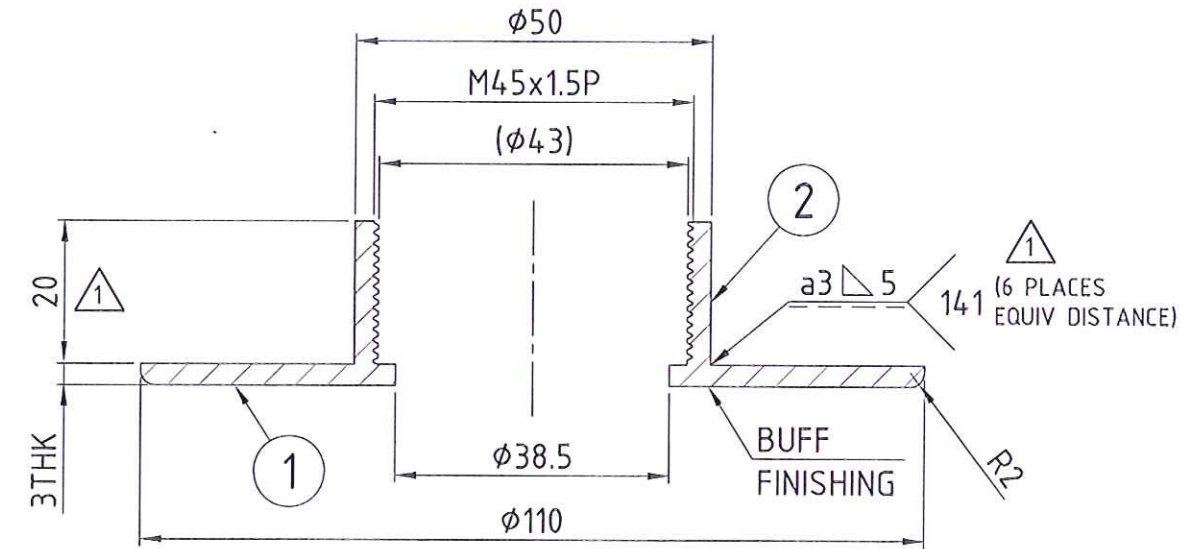
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GRADE No.	VALUE	SYMBOL
N1	0.025	
N2	0.05	
N3	0.1	
N4	0.2	
N5	0.4	
N6	0.8	
N7	1.6	
N8	3.2	
N9	6.3	
N10	12.5	
N11	25	
N12	50	

SURFACE
ROUGHNESS



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





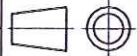



SECTION-AA

UNCONTROLLED

NOTE:

1. THE ASSEMBLY SHALL CONFORM TO PTS DOC. No. GR/TD/3015.

2	1	909-29014-02	PIPE	Ø50x3.5WT,L=20	AISI 304	
1	1	909-29014-01	COVER PLATE	Ø110x3THK	AISI 304	
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
					MATERIAL	
				PRODUCT	DMRC BG METRO CARS	
				REF DRG	-	
				MATERIAL	-	
				HEAT TREAT.	-	APPD PV GAYATHRI 24/10/2015
				SURFACE TREAT.	-	REVD KRISHNA PRASAD 20/10/2015
				TITLE	CHKD KRISHNA PRASAD 20/10/2015	
					DRWN PURUSHOTHAMAN 16/06/2015	
	x2	DIM 20 WAS 15. WELDING DETAIL REVISED.		SCALE		SHEET 1 OF 1
		ECN: 90900528		1:1		Wt.(Kg) -
ALT.NO.	ECN NO/CHANGES		DATE 01/12/15	BY PURUSHOTH	CHKD	APPD
					BEML LIMITED	
			DRG No.		ALT	
			909-29014		