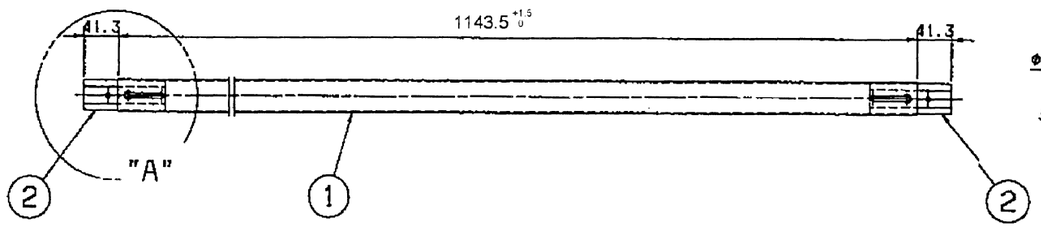
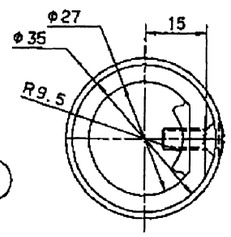
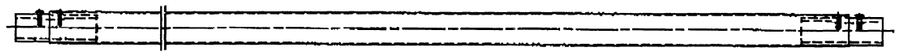
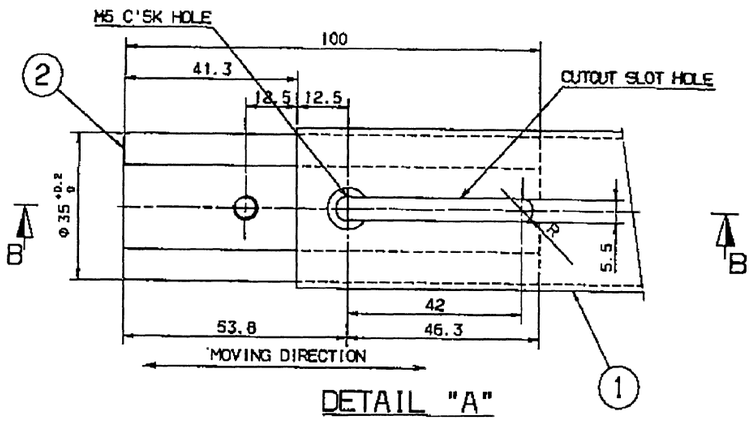
| MACHINING DEVIATIONS FOR LINEAR DIMENSIONS | RANGE | 0 - 6 | 6 - 30 | 30 - 120 | 120 - 315 | 315 - 1000 | 1000-2000 | 2000-4000 | ABOVE 4000 | RA |
|---|---|---|---|---|---|---|---|---|---|---|
| | TOLERANCE | ±0.1 | ±0.2 | ±0.3 | ±0.5 | ±0.8 | ±1.2 | ±2 | ±3 | ~ |
| FOR DIMENSIONAL TOLERANCES OF SHEET 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 | | | | | | | | | | |

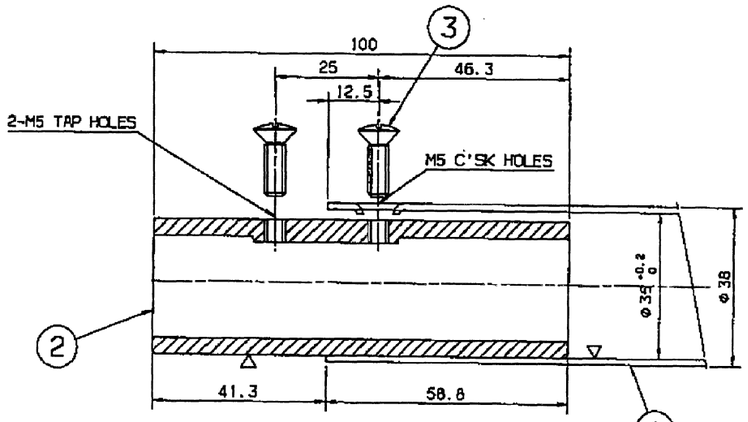





DETAIL "A"




SECTION B-B

UNCONTROLLED

NOTE:

1. ASSEMBLY SHALL CONFORM TO PTS DOC. No. GR/TD/3015.
2. THE FIRST REMOVAL PREVAILING TORQUE OF NYLOK IS 3.5 kg.cm FOR M5 SCREW.

| SL.No. | QTY | PART / STOCK No. | DESCRIPTION | SIZE | COMPANY STD./I.S. | Wt. (Kg) |
|---|---|---|---|---|---|---|
| | | | | | MATERIAL | |
| 3 | 4 | RFS8160516 | HEX. SOCKET RAISED CSK HEAD SCREW WITH PRE APPLIED NYLOK BLUE PATCH | M5x16 | IS: 7486-2005 FOR HEX SOCKET M4 HEAD IS: 6761-94 / MATL. IS: 1367-(P14)-84, GR:A2-70 | |
| 2 | 2 | 909-29048-02 | JOINT, PIN | Φ35 | SUS 304 | |
| 1 | 1 | 909-29048-01 | PIPE | Φ38x1.5THK | SUS 304 | |

| ALT.NO | ECN NO/CHANGES | DATE | BY | CHKD | APPD |
|---|---|---|---|---|---|
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |

| | |
|---|---|
| PRODUCT | DMRC BG METRO CARS |
| REF DRG | |
| MATERIAL | - |
| HEAT TREAT | - |
| SURFACE TREAT | - |
| APPD | 24/10/15 |
| REVD | |
| CHKD | 20/10/15 |
| DRWN | PURUSHOTHAMAN 05/09/2015 |
| SCALE | NTS |
| SHEET | 1 OF 1 |
| Wt.(Kg) | - |
| TITLE | GRAB RAIL (H) |
| DRG No. | 909-29048 |
| ALT | - |

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| SURFACE ROUGHNESS | 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 | | | | | | | | | | | | |