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	~

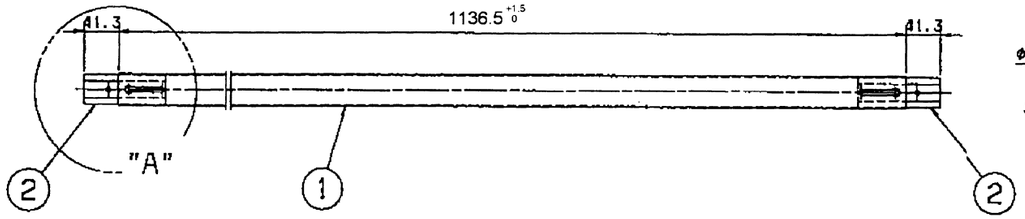
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD RD-227

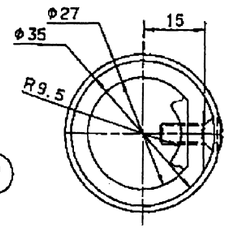
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM) | QUALITY OF WELD JOINTS REF. RD 230 MEDIUM

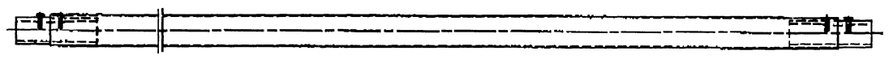
VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS 1012 C

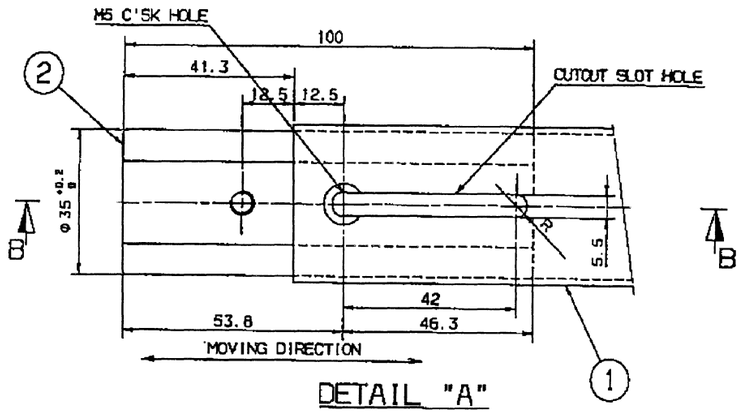
WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96

STATUS: PRODUCTION

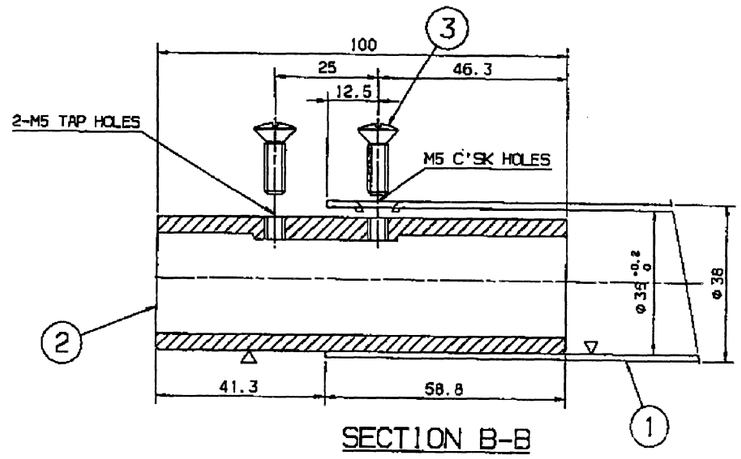








DETAIL "A"



SECTION B-B

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.

UNCONTROLLED

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-(PT4)-84, GR.A2-70	
2	2	909-29049-02	JOINT, PIN	Φ35	SUS 304	
1	1	909-29049-01	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

TITLE: GRAB RAIL (K)

SCALE: NTS | SHEET: 1 OF 1 | Wt.(Kg): -

BEML LIMITED

DRG No. 909-29049 | ALT: -

A2

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DRAWING RELEASED FROM PLM. PHYSICAL SIGNATURE NOT REQUIRED

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