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

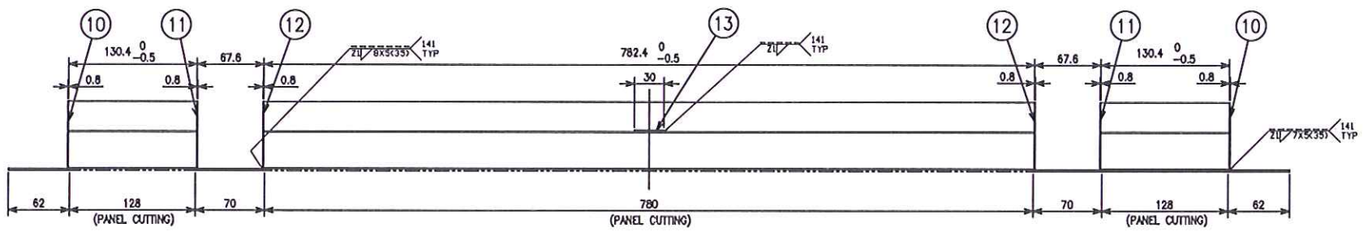
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

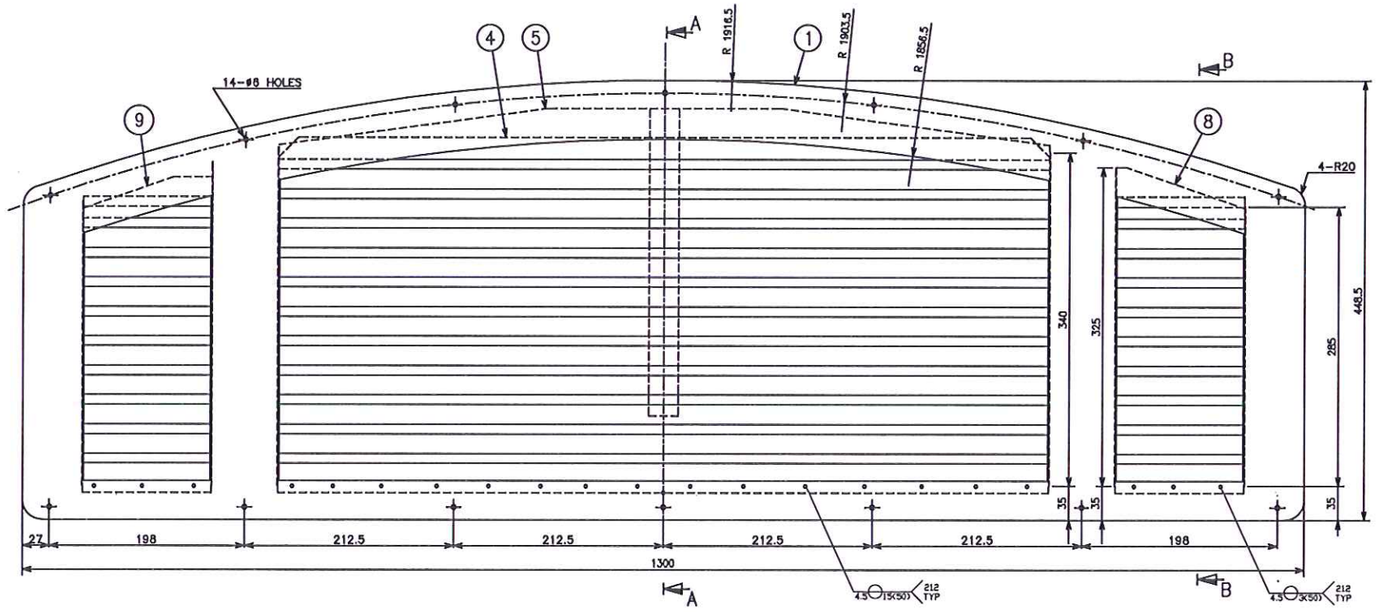
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM)

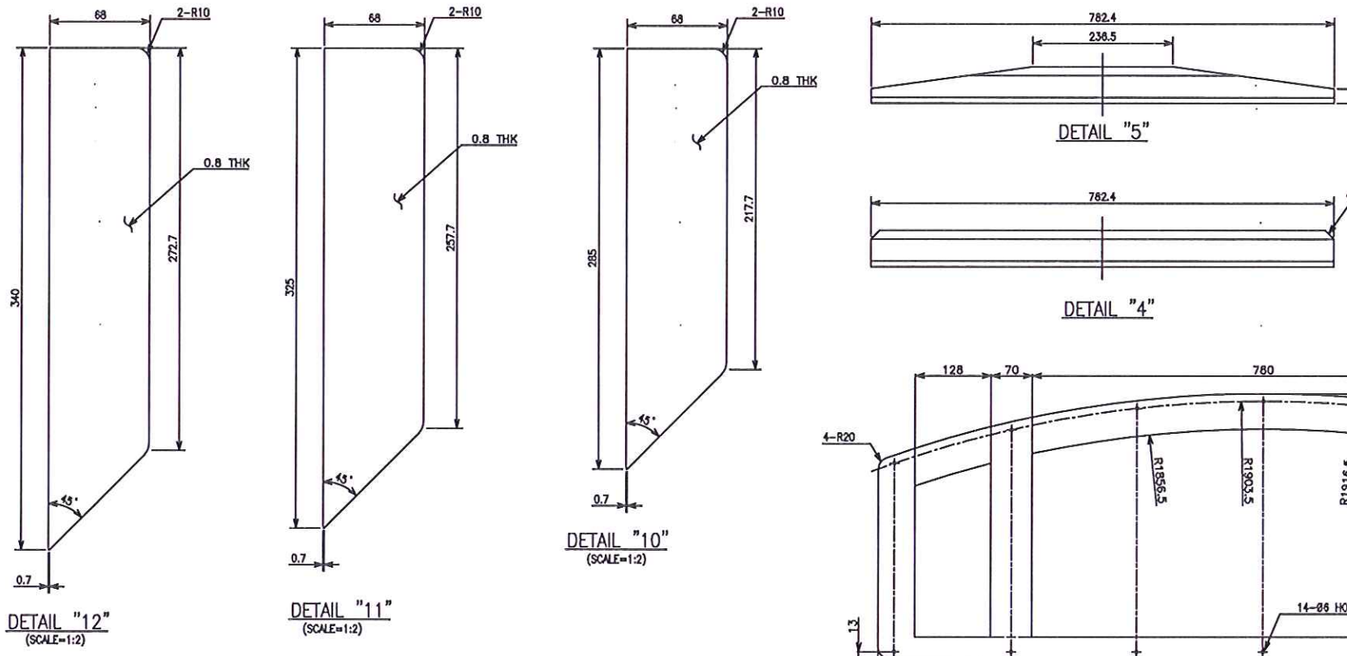
VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DIS. 1012.C.

QUALITY OF WELD JOINTS REF, RD-230 MEDIUM

~~PROTO~~ / ~~PILOT~~ / PRODUCTION







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DETAIL "11"
(SCALE=1:2)

DETAIL "10"
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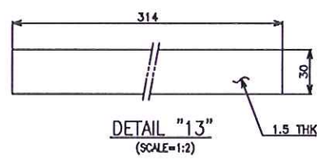

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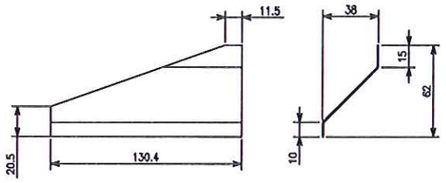

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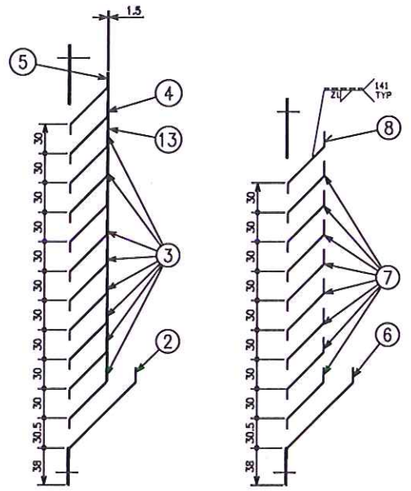
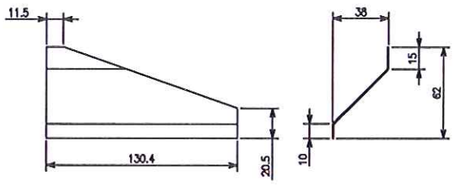


SECTION A–A

SECTION B–B



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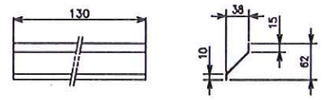

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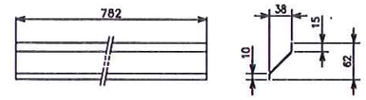
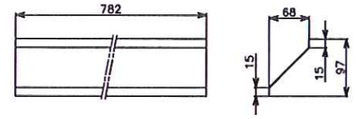


DETAIL '3'

DETAIL '6'



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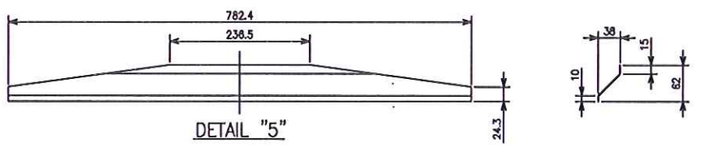

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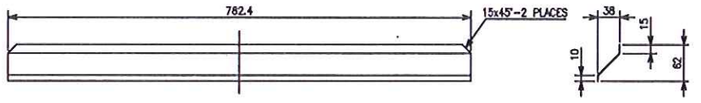

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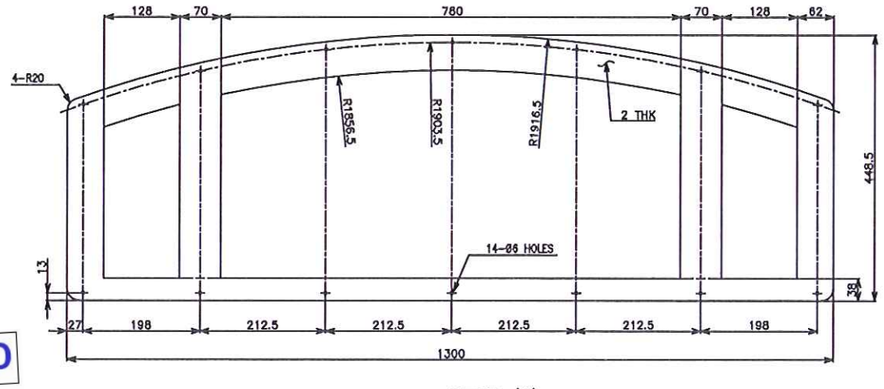

DETAIL '1'

SR No.	QTY	DRG. / STOCK No.	DESCRIPTION	SIZE	COMPANY STD/IS STD WT(Kg)
		DETAIL PARTS		MATERIAL	
13	1	909-22036-13	GRILLE SUPPORT PLATE	SUS304/AISI304	t1.5x30x314L
12	2	909-22036-12	GRILLE SUPPORT PANEL	SUS304/AISI304	t-0.8
11	2	909-22036-11	GRILLE SUPPORT PANEL	SUS304/AISI304	t-0.8
10	2	909-22036-10	GRILLE SUPPORT PANEL	SUS304/AISI304	t-0.8
9	1	909-22036-09	GUIDE PANEL	SUS304/AISI304	t-0.8, L=130
8	1	909-22036-08	GUIDE PANEL	SUS304/AISI304	t-0.8, L=130
7	8	909-22036-07	GUIDE PANEL	SUS304/AISI304	t-0.8, L=130
6	2	909-22036-06	GUIDE PANEL	SUS304/AISI304	t-0.8, L=130
5	1	909-22036-05	GUIDE PANEL	SUS304/AISI304	t-0.8, L=130
4	1	909-22036-04	GUIDE PANEL	SUS304/AISI304	t-0.8, L=782
3	9	909-22036-03	GUIDE PANEL	SUS304/AISI304	t-0.8, L=782
2	1	909-22036-02	GUIDE PANEL	SUS304/AISI304	t-0.8, L=782
1	1	909-22036-01	GRILLE BODY PANEL	SUS304/AISI304	t-2

PRODUCT: DMRC BG METRO CARS

SURFACE TREATMENT

SCALE | SHEET OF | WT(Kg)

1 | 909-22035 | DT/M/T

QTY | NEXT ASSY | MODEL | REF DRG: EC05676-000

TITLE: VENT GRILLE ASSY

APPROVED	KRKR	27.4.11
CHECKED	KRKR	27.4.11
DRAWN	HARI KUMAR	27.4.11

DRG No. 909-22036 | ALT

BEML LIMITED
R&D BANGALORE COMPLEX
BANGALORE 560 075

ALT	CHANGE/ECN No.	DATE	BY	CKD	APP
	NOTES UPDATED WELDING DETAILS UPDATED ECN NO. 80800408	1-3-15			

GRADE No.	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12
VALUE	25	50	63	100	125	200	250	400	500	800	1600	3200
SYMBOL												

SURFACE ROUGHNESS

⚠ NOTE:
1. REMOVE SHARP EDGES AND BURRS
2. WELD AREAS SHALL BE PICKLED AND PASSIVATED
3. WELD SYMBOLS : ACCORDING TO ISO 2553

UN CONTROLLED