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FORDIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES. REFER STD. BD-227

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

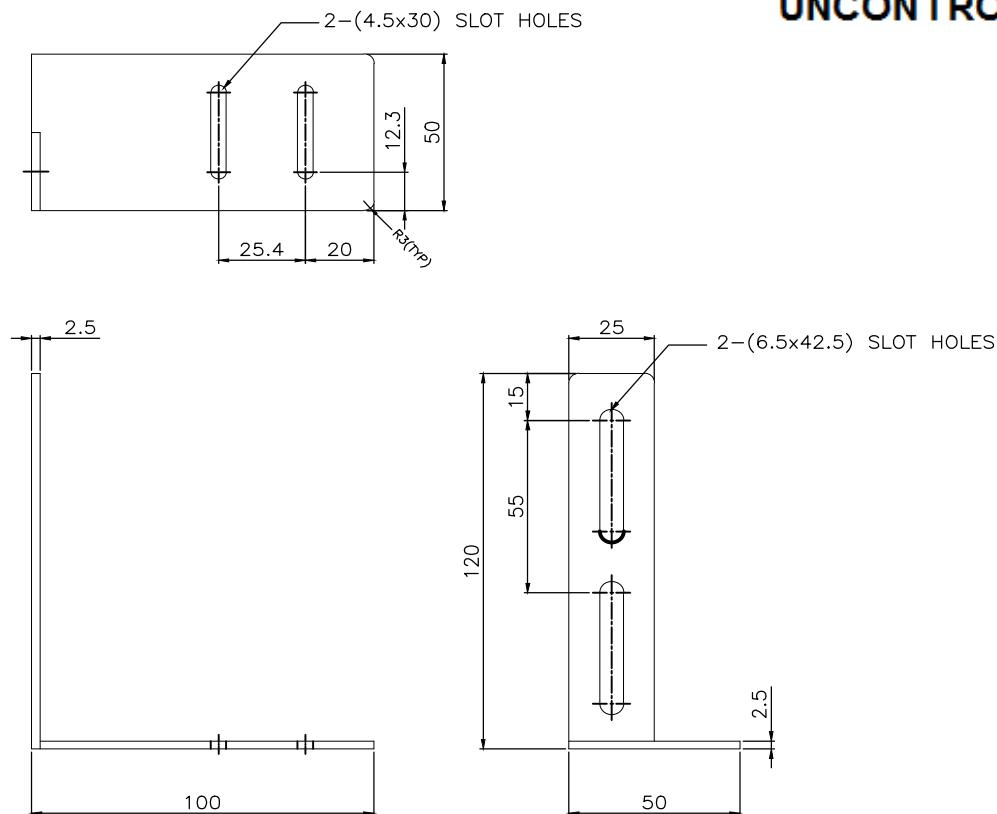
QUALITY OF WELD JOINTS REF. RD230 MEDIUM

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

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

STATUS:

UNCONTROLLED



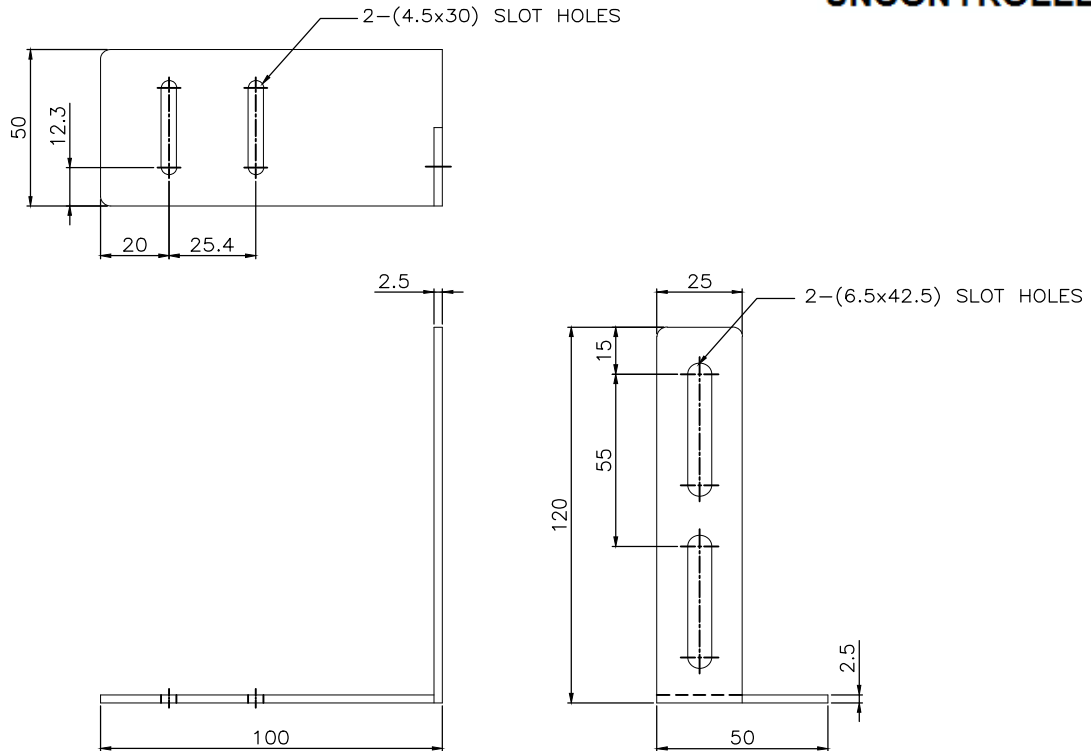
NOTE: REMOVE ALL SHARP EDGES & DEBURR.

GRADE No.	VALUE	SYMBOL
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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. S. 1012.C.							STATUS:			
WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96										

UNCONTROLLED



NOTE: REMOVE ALL SHARP EDGES & DEBURR.

215x50x2.5THK	SUS304AISI304,2Bfinish
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SL.No.	QTY	PART STOCK No.	DESCRIPTION	SIZE	COMPANY STD. I.S	Wt.(Kg)
MATERIAL						
DMRC BG METRO CARS						
REF DRG						
MATERIAL						
HEAT TREAT.				APPD	KCS	14.1.16
SURFACE TREAT.				REVD		
TITLE				CHKD	SNH	13.1.16
LIMIT SWITCH BRACKET-LH				DRWN	Jagadish	13.1.16
				SCALE	1:2	
ALT. NO.				SHEET OF		Wt.(Kg)
				0		0
ECN NO CHANGES				DRGN No.		ALT
DATE				909-55117		
BY						
CHKD						
APPD						
SURFACE ROUGHNESS						

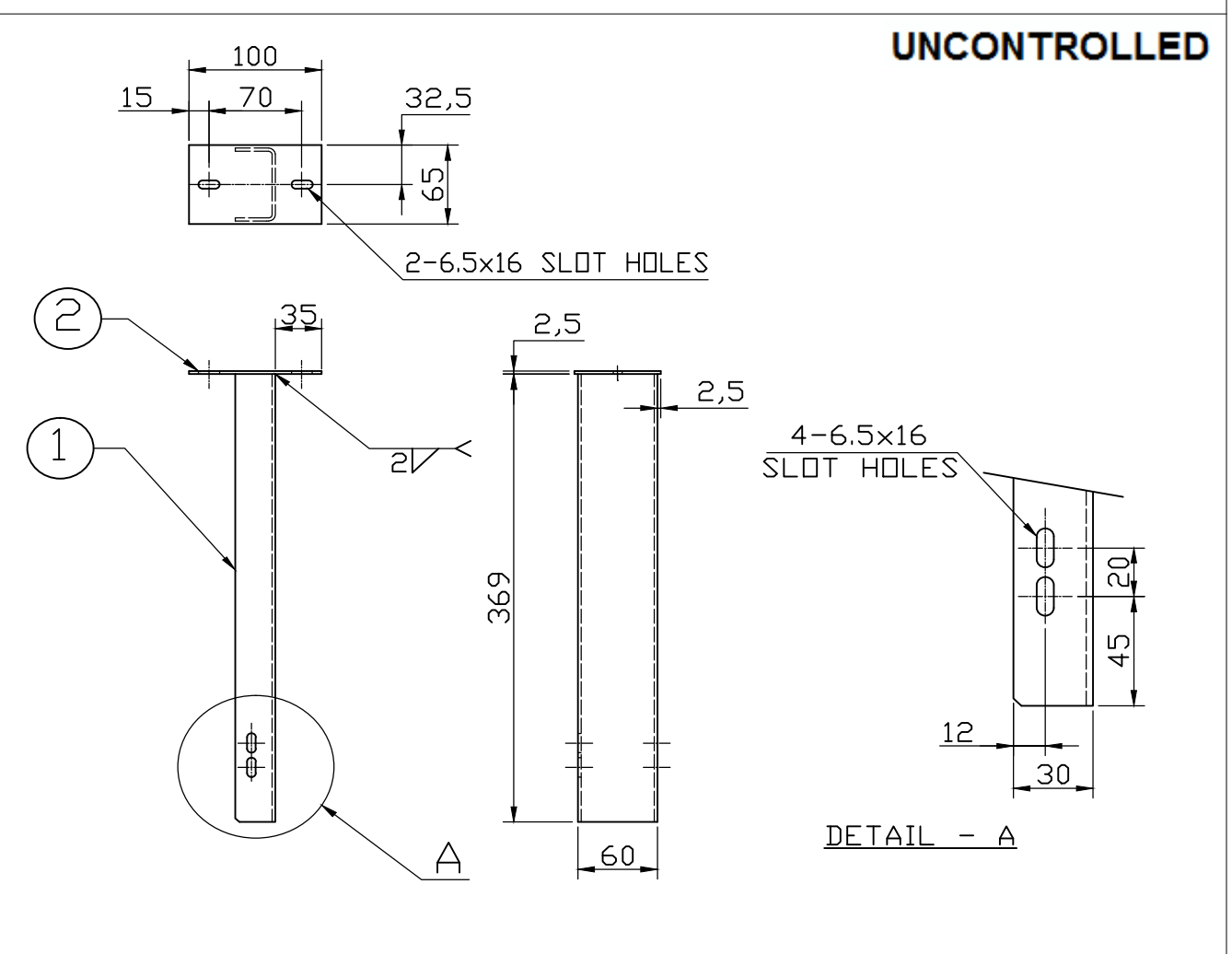










BEML LIMITED

909-55117

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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 STANDARDS. 1012.C.							STATUS:			
WELDINGS SHALL BE CARRIED OUT AS PER IS: 9595-96										



2	1	909-50164-2				PLATE				t=2.5			SUS304/AISI304				
1	1	909-50164-1				FRAME				t=2.5			SUS304/AISI304				
SL.No.	QTY	PART STOCK No.				DESCRIPTION				SIZE			COMPANY STD. I.S		Wt.(Kg)		
													MATERIAL				
						PRODUCT											
						REF DRG											
						MATERIAL											
						HEAT TREAT.					APPD	KCS		09.11.16			
						SURFACE TREAT.					REVD						
						TITLE	BRACKET ASSY.				CHKD	SNH		6.11.16			
											DRWN	JAGADISH		5.11.16			
											SCALE			SHEET	Wt.(Kg)		
												OF		0			
ALT.NO.	ECNNCHANGES				DATE	BY	CHKD	APPD	 BEM LIMITED <small>NEW FRONTIERS NEW DREAMS</small>				DRG No. 909-50164				ALT 

SURFACE ROUGHNESS

ALT. NO. ECN NO CHANGES DATE BY CHKD APPD

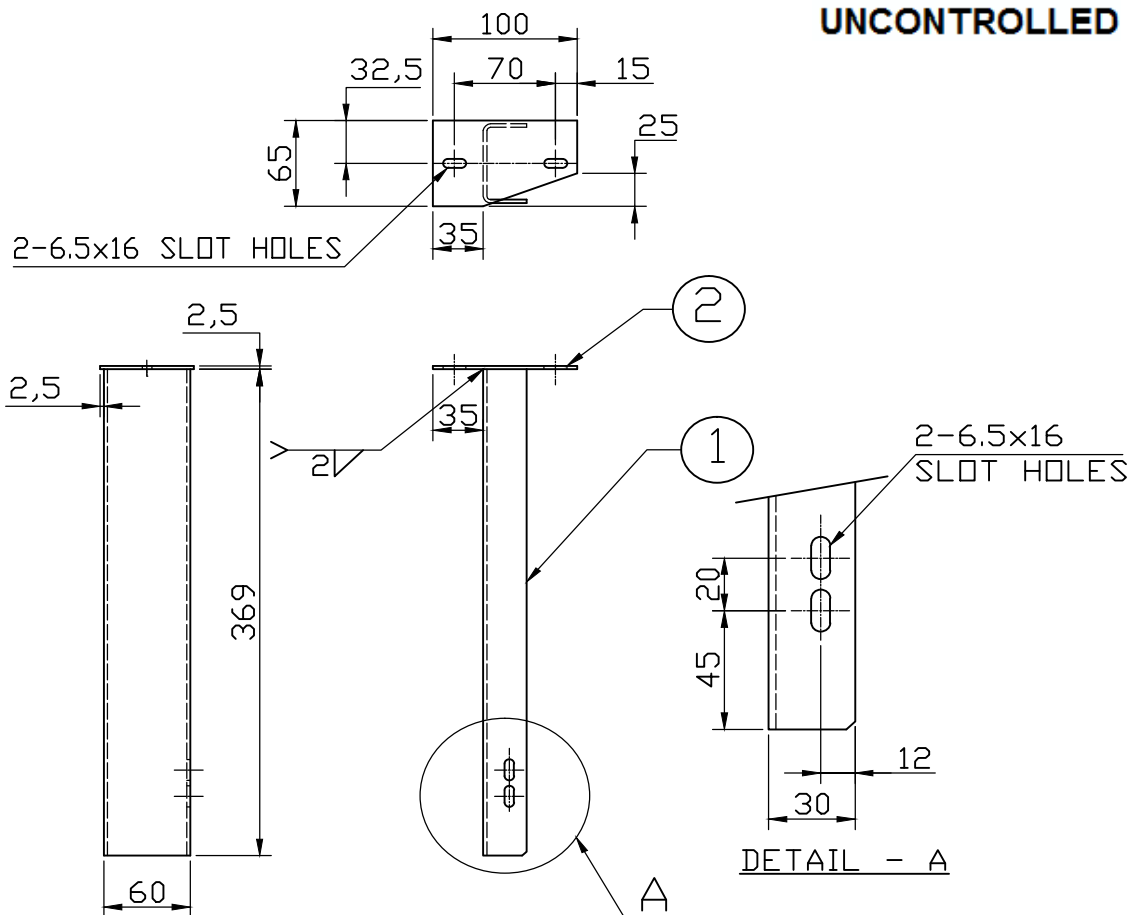










909-50164

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GRADE No.	VALUE	SYMBOL
12	50	
11	25	
10	12.5	
9	6.3	
8	3.2	
7	1.6	
6	0.8	
5	0.4	
4	0.2	
3	0.1	
2	0.05	
1	0.025	
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	
ALT. NO.	ECN NO CHANGES	DATE BY CHKD APPD

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	~
FORDIMENSIONAL 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 STANDARDS. 1012.C.							STATUS:			
WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96										



2	1	909-50163-2	PLATE			t=2.5		SUS304/AISI304						
1	1	909-50163-1	FRAME			t=2.5		SUS304/AISI304						
SL.No.	QTY	PART STOCK No.		DESCRIPTION			SIZE		COMPANY STD. I.S	Wt.(Kg)				
MATERIAL														
					PRODUCT									
					REFDRG	EC05517-000								
					MATERIAL									
					HEAT TREAT.		APPD	KCS	9.11.16					
					SURFACE TREAT.		REVD							
					TITLE	CHKD	SNH		6.11.16					
					BRACKET ASSY.	DRWN	JAGADISH		5.11.16					
						SCALE			SHEET	Wt.(Kg)				
								OF	0					
ALT.NO.					ECNNCHANGES		DATE	BY	CHKD	APPO	DRGNo.	909-50163		ALT
 BEML LIMITED														

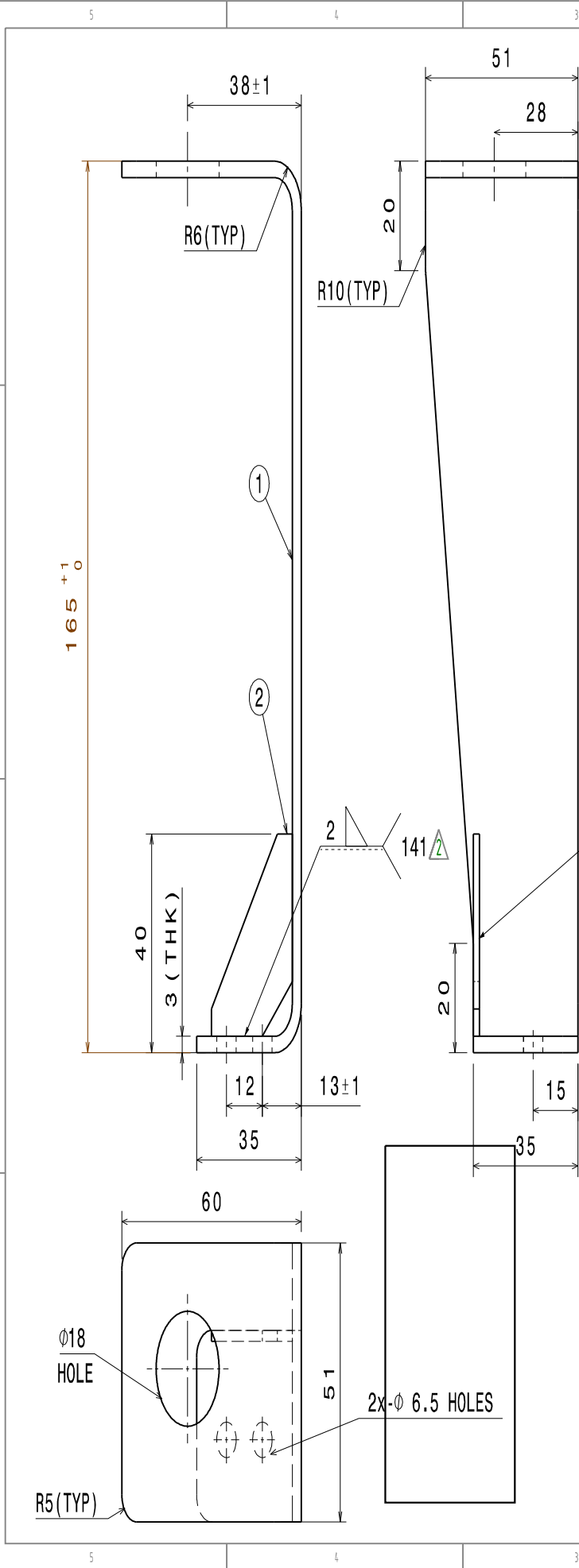


BEML LIMITED

909-50163

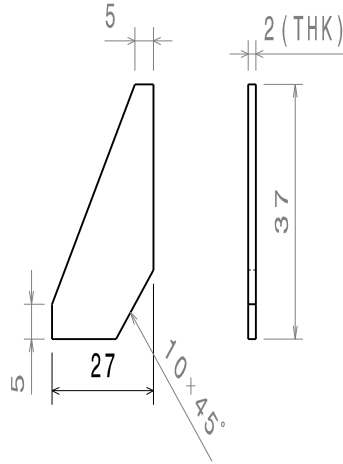
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GRADE No.	VALUE	SYMBOL
N1	0.025	
N2	0.05	
N3	0.1	
N4	0.2	
N5	0.4	
N6	0.8	
N7	1.6	
N8	3.2	
N9	6.3	
N10	12.5	
N11	25	
N12	50	
ROUGHNESS		



		2					1			
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:			
WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96										

UNCONTROLLED



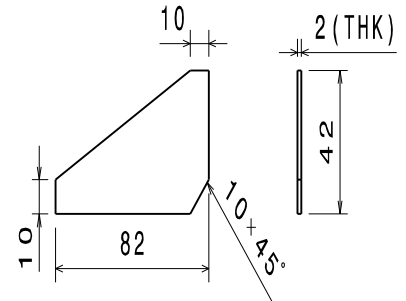
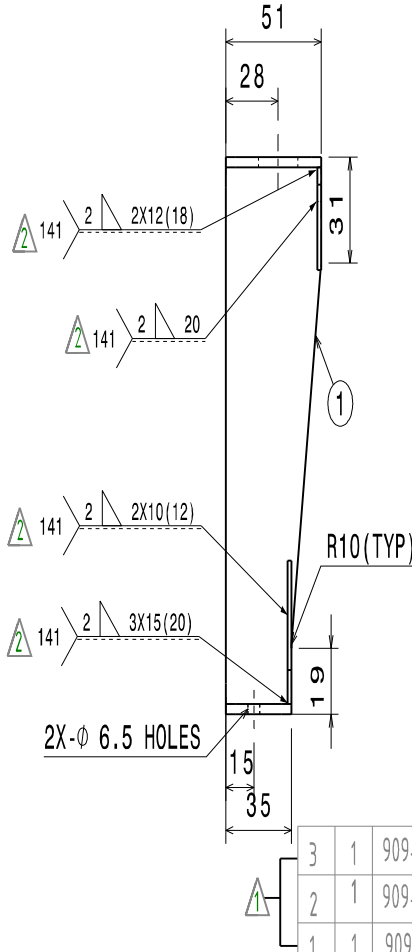
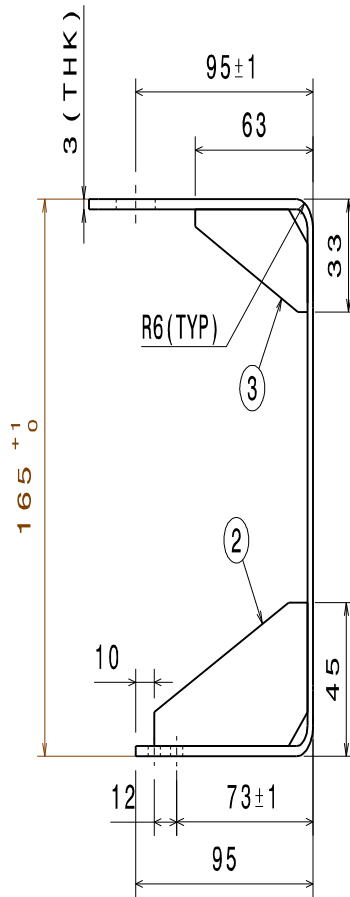
DETAIL-2

NOTE:

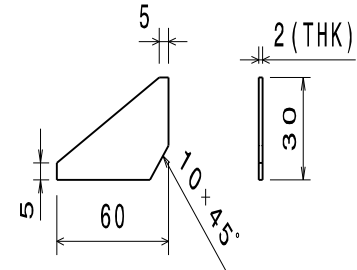
- 1) ALL SHARP EDGES SHALL BE DEBURRED
- 2) THE WELD AREAS SHALL BE PICKLED AND PASSIVATED
- 3) SAMPLE APPROVAL SHALL BE OBTAINED BEFORE MASS PRODUCTION

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./S	Wt. (Kg)
2	1	909-47185-02	GUSSET	37X27X2	SUS304 / AISI304, 2B FINISH	
1	1	909-47185-01	BRACKET	248X51X3	SUS304 / AISI304, 2B FINISH	
MATERIAL						
DMRC BG METRO CARS						
DOOR COVING BRACKET						
WELD TYPE 141 WAS 131 ECN 90900622					APPD	PVG
1) MATL. CHANGED FOR ITEM 1 & 2 2) NOTE 3 ADDED ECN 90900592					REVD	PVG
DATE 22.03.16 BY Guru KP					CHKD	KP
APPD PVG					DRWN	GURUPRASAD N.C.
ALT.No.					SCALE	1:1
ECN NO/CHANGES					SHEET	1 OF 1
DATE 25.08.16 BY Guru KP					Wt.	-
APPD PVG					DRG No.	909-47185
BEML LIMITED					ALT	2

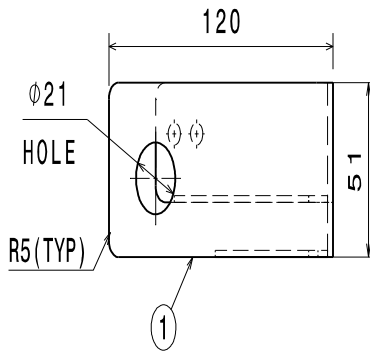
GRADE No.	VALUE	SYMBOL
N1	0.25	
N2	0.5	
N3	0.7	
N4	0.7	
N5	0.7	
N6	0.8	
N7	1.6	
N8	3.2	
N9	6.3	
N10	12.5	
N11	25	
N12	50	



DETAIL-2









DETAIL-3



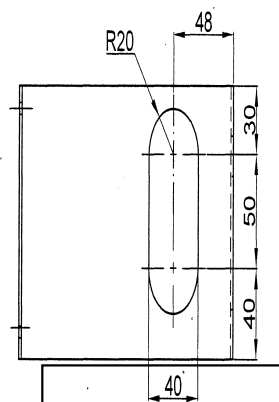
- NOTE:
- 1) ALL SHARP EDGES SHALL BE DEBURRED
 - 2) THE WELD AREAS SHALL BE PICKLED AND PASSIVATED
 - 3) SAMPLE APPROVAL SHALL BE OBTAINED BEFORE MASS PRODUCTION

UNCONTROLLED

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

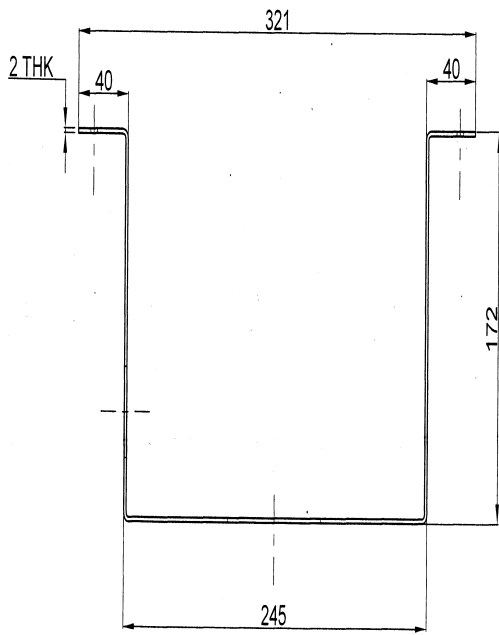
3	1	909-47184-03	GUSSET		60X30X2	SUS304 / AISI304, 2B FINISH	
2	1	909-47184-02	GUSSET		82X42X2	SUS304 / AISI304, 2B FINISH	
1	1	909-47184-01	GUSSET		368X51X3	SUS304 / AISI304, 2B FINISH	
SL.No.	QTY	PART / STOCK No.		DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
						MATERIAL	
				PRODUCT	DMRC BG METRO CARS		
				REF DRG			
				MATERIAL	-		
				HEAT TREAT.	APPD	PVG	15.07.16
				SURFACE TREAT.	REVD	PVG	15.07.16
				TITLE	CHKO	KP	15.07.16
					DRWN	GURUPRASAD N.C.	15.07.16
					SCALE	1:2	SHEET 1 OF 1
					DRG No.		ALT
					909-47184		



BEML LIMITED





~~NOTE: ALL SHARP EDGES SHALL BE DEBURRED~~

UNCONTROLLED




						656x120x2 THK	SUS304 / AISI304, 2B FINISH	
SL No.	QTY	DRG / STOCK No.		DESCRIPTION		SIZE	COMPANY STD/IS STD	Wt (Kg)
DETAIL PARTS						MATERIAL		
					PRODUCT	DMRC BG METRO CARS		
						SURFACE TREATMENT		
						SCALE		Wt (Kg)
						NTS		
					QTY	NEXT ASSY	MODEL	REF DRG
					TITLE		APPROVED	JAYA PRAKASH 30-05-12
					HANDLE, BRACKET-2		CHECKED	KRISHNA PRASAD 30-05-12
							DRAWN	SUNIL 23-05-12
							DRG No.	ALT
							909-47122	

1) MATL. CHANGED 2) NOTE UPDATED EON:90900592	22/5/16 Gautam N
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BEML LIMITED
R&D, BANGALORE COMPLEX
BANGALORE 560 075



ALT

CHANGES

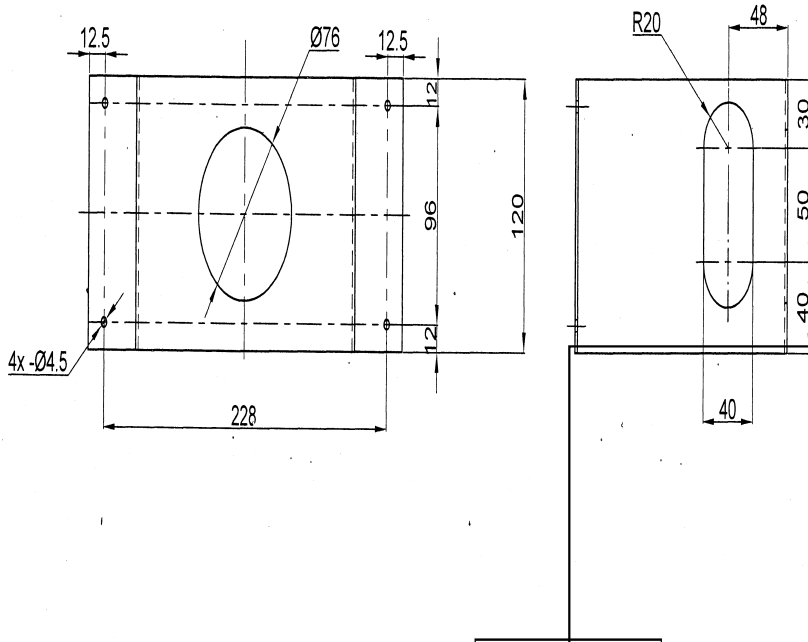
DATE

BY

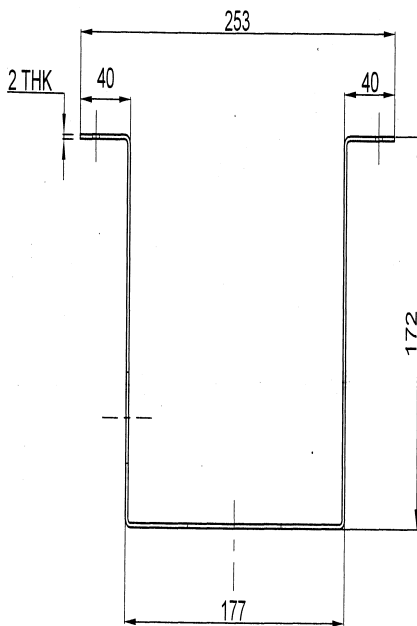
OKD

APP

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 DS. 1012.C.							PROTO / PILOT / PRODUCTION		
QUALITY OF WELD JOINTS REF. ISO 5817									



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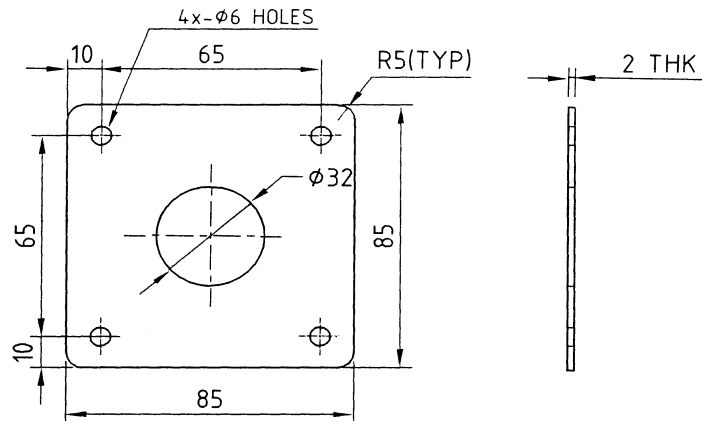
NOTE: ALL SHARP EDGES SHALL BE DEBURRED

		588x120x2 THK		SUS304 / AISI304, 2B FINISH	
SL No.	QTY	DRG. / STOCK No.	DESCRIPTION	SIZE	COMPANY STD/IS STD
DETAIL PARTS			MATERIAL		
PRODUCT DMRC BG METRO CARS					
SURFACE TREATMENT					
				SCALE NTS	Wt.(Kg)
QTY				NEXT ASSY	MODEL
TITLE HANDLE, BRACKET-1				REF DRG	
APPROVED				JAYA PRAKASH	31-05-12
CHECKED				KRISHNA PRASAD	31-05-12
DRAWN				SUNIL	23-05-12
DRG No				ALT	
82/13/16				909-47121	
<div> BEM LIMITED R&D, BANGALORE COMPLEX BANGALORE 560 075 </div>					

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		

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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										



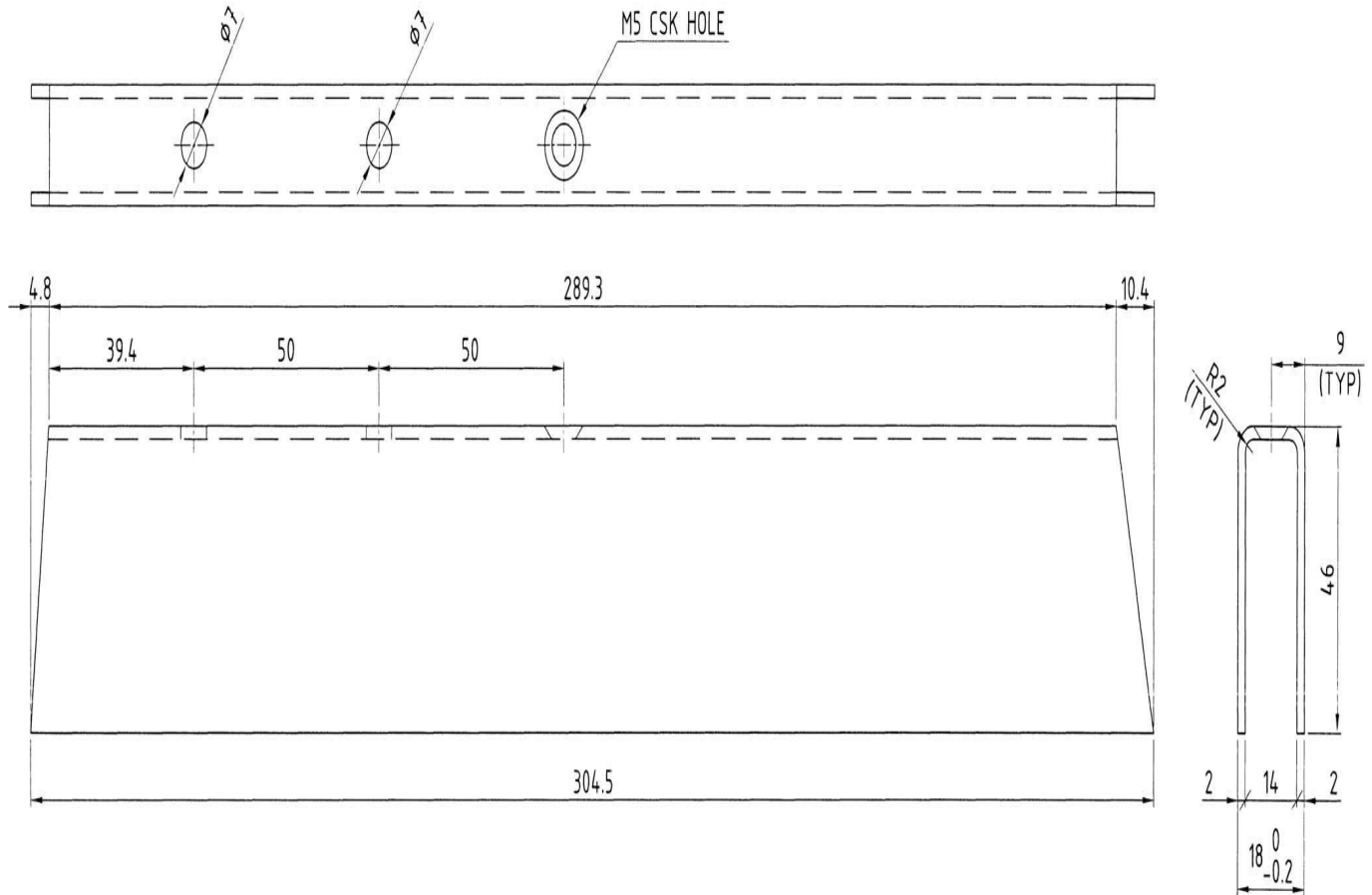
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NOTE:
REMOVE ALL SHARP EDGES AND BURRS.

N1	10.025	✓
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	✓
GRADE No.		
VALUE		
SYMBOL		
SURFACE ROUGHNESS		
ALT. NO.	ECN NO/CHANGES	DATE
BY	CHKD	APPD
PRODUCT	DMRC BG METRO CARS	
REF DRG		
MATERIAL	SUS304 / AISI304 ,2B FINISH	
HEAT TREAT.		APPD
SURFACE TREAT.		REVD
TITLE	BRACKET,DOOR LAMP	
SCALE	1:2	CHKD
DRWN	SUNIL	11.03.2016
SCALE	1:2	DRWN
DRG No.	909-39138	ALT
BEML LIMITED		

SURFACE		N12	N11	N10	N9	N8	N7	N6	N5	N4	N3	N2	N1
GRADE No.	VALUE	50/25	12.5/25	6.3/12.5	3.2/6.3	1.6/3.2	0.8/1.6	0.4/0.8	0.2/0.4	0.1/0.2	0.05/0.1	0.025/0.05	
SYMBOL													
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 202 (PT-1) (MEDIUM)							QUALITY OF WELD JOINTS REF. RD 230 MEDIUM			
VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS 10127						STATUS	PRODUCTION			
WELDING SHALL BE CARRIED OUT AS PER IS. 9595-96										



UNCONTROLLED

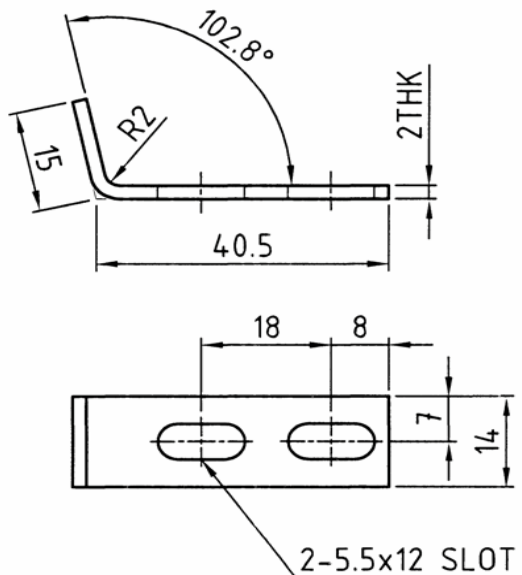
NOTE:

1. REMOVE ALL SHARP EDGES AND BURRS.

						305x103x2THK			
SL.No	QTY	PART / STOCK No.		DESCRIPTION	SIZE	COMPANY STD./S		Wt. (Kg)	
						MATERIAL			
△				PRODUCT	DMRC BG METRO CARS				
				REF DRG					
△				MATERIAL	SUS 304 / AISI 304, ZB FINISH				
				HEAT TREAT.	-	APPD	Ajgathv	30/10/15	
				SURFACE TREAT.	-	REV'D			
△				TITLE		CHKD	KLad	30/10/15	
					SUPPORT	DRWN	PURUSHOTHAMAN	30/10/2015	
						SCALE	1:1	SHEET Wt.(Kg)	
△							1 OF 1	-	
AL.T.NO	ECONO/CHANGES	DATE	BY	CHKD	APPRD	DRG No		ALT	
						909-29145		△ -	
					Beml BEML LIMITED				
					(INCORPORATED IN INDIA)				

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



UNCONTROLLED

NOTE:

1. REMOVE ALL SHARP EDGES AND BURRS.

N1	0.075	▽
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	▽
GRADE No.		
VALUE		
SYMBOL		
SURFACE ROUGHNESS		

							53x14x2HK				
SL.No.	QTY	PART / STOCK No.	DESCRIPTION				SIZE	COMPANY STD./I.S		Wt. (Kg)	
								MATERIAL			
△							PRODUCT	DMRC BG METRO CARS			
							REF DRG				
△							MATERIAL	SUS 304 / AISI 304, 2B FINISH			
							HEAT TREAT.	-	APPD	Agarwal	30.10.15
							SURFACE TREAT.	-	REVD		
△							TITLE	SUPPORT			
							CHKD	KT			30.10.15
							DRWN	PURUSHOTHAMAN		30/10/2015	
△							SCALE		SHEET	Wt. (Kg)	
							1:1		1 OF 1	-	
							DRG No.		ALT		
							909-29144				
ALT.NO.	ECN NO/CHANGES		DATE	BY	CHKD	APPD	BEML LIMITED <small>NEW FORTMANS NEW DELHI</small>				









 **BEML LIMITED**
NEW FRONTIERS NEW DREAMS

SURFACE	ROUGHNESS												
	GRADE No.	N12	N11	N10	N9	N8	N7	N6	N5	N4	N3	N2	N1
VALUE	20	25	30	35	40	45	50	55	60	65	70	75	80
SYMBOL													

Technical drawing of a mechanical part, likely a shaft or rod, showing dimensions and callouts:

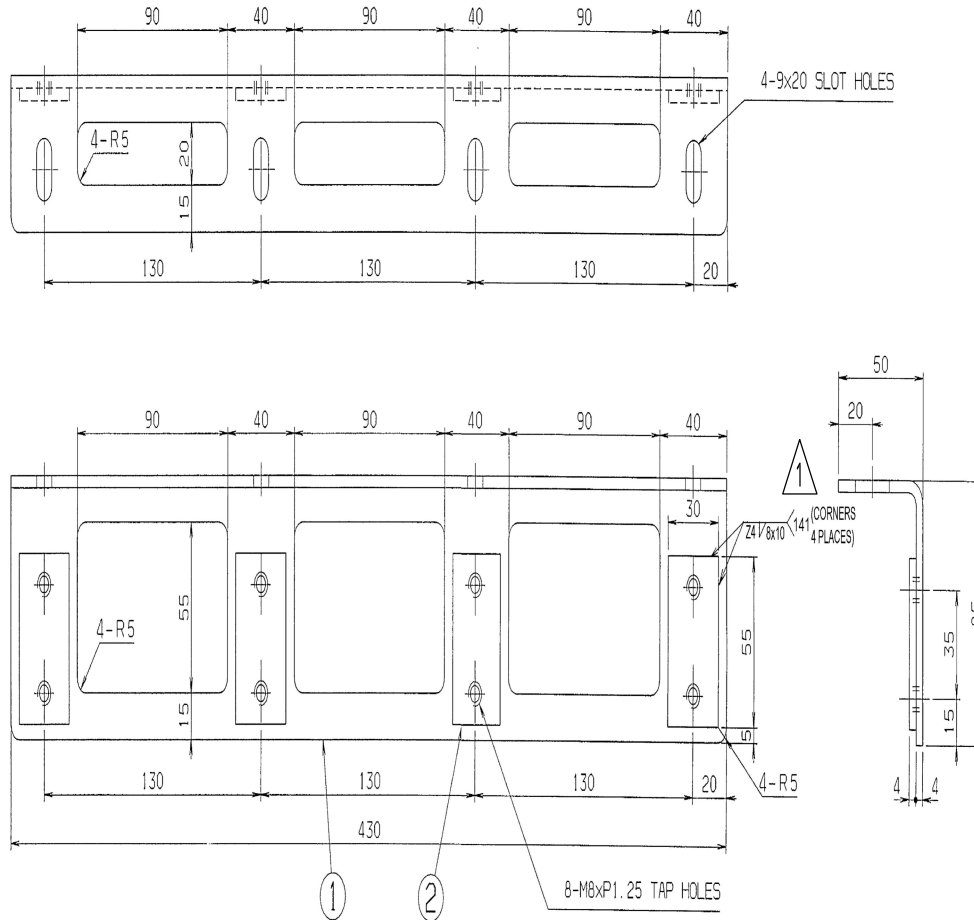
- Overall length: 145
- Section 1: A central section of length 50, containing 3-M5 TAP HOLES.
- Section 2: A left section of length 40, containing an M8xP1.25 thread.
- Section 3: A right section of length 50, containing a 4-C1 thread.
- Dimensions: 55 (total length of Section 2 and Section 1), 35 (distance from left end to start of Section 1), 50 (length of Section 1), 50 (length of Section 3), 10 (height of Section 2), 20 (height of Section 1 and Section 3).
- Callouts: C1, C1.5, C3, 4-C1, 10.0, 1, 2, 3.

1. REMOVE ALL SHARP EDGES AND BURRS.
2. ALL WELD AREAS SHALL BE PICKLED AND PASSIVATED.

2	1	909-29035-02	STUD BOLT		SUS 304		
1	1	909-29035-01	BRACKET		SUS 304		
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./S	Wt. (Kg)	
					MATERIAL		
			PRODUCT	DMRC BG METRO CARS			
			REF DRG				
			MATERIAL	-			
			HEAT TREAT.	-	APPO	PV GAYATHRI 30/10/2017	
			SURFACE TREAT.	-	REVD	KRISHNA PRASAD 30/10/2017	
			TITLE	CHKD	KRISHNA PRASAD	30/10/2017	
			BRACKET, DRAUGHT SCREEN	DRWN	PURUSHOTHAMAN	20/10/2017	
	x1	TIG WELDING ADDED.		SCALE		SHEET	Wt.(Kg)
		ECN: 90900603		NTS		1 OF 1	-
ALT.NO.	ECN NO/CHANGES	DATE	BY	CHKD	APPO	P.V.G	
		25/08/16	PURUSHOTH				
			 BEML LIMITED		909-29035		
			DRG No.		ALT		
							

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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
GRADE No.	
VALUE	
SYMBOL	
SURFACE	
ROUGHNESS	



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NOTE:

1. REMOVE ALL SHARP EDGES AND BURRS.
2. ALL WELD AREAS SHALL BE PICKLED AND PASSIVATED.

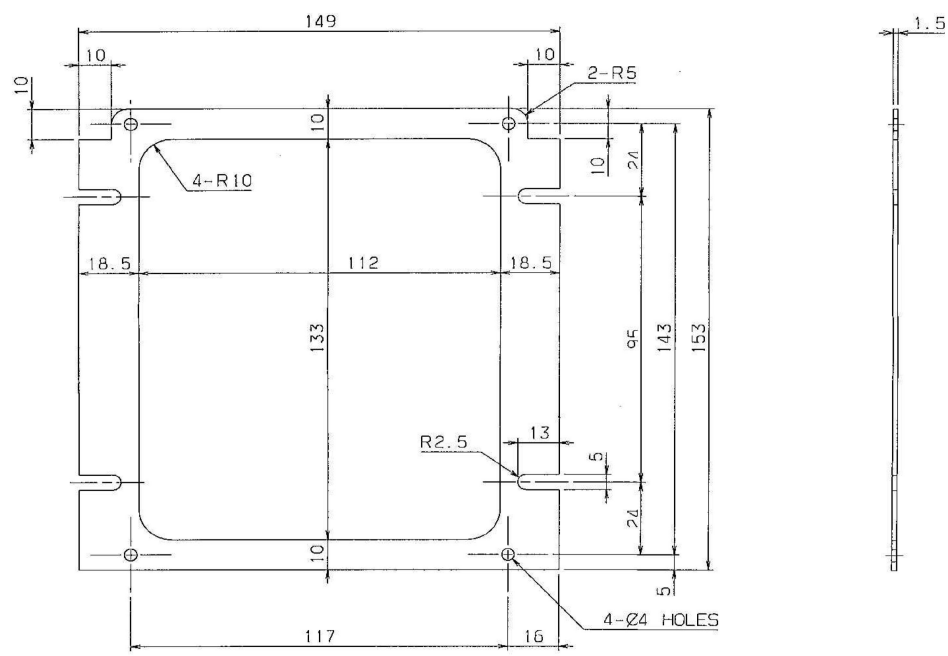
MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000	RA
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	~
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227										
UNSPECIFIED TOLERANCE FOR LINEAR 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										

2	4	909-29034-02	SEAT, SCREW	30x55x4THK	SUS 304	
1	1	909-29034-01	BRACKET	430x128x4THK	SUS 304	
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./IS	Wt. (Kg)
DMRC BG METRO CARS						
PRODUCT						
REF. DRG						
MATERIAL						
HEAT TREAT.				APPD	PV GAYATHRI	30.10.2015
SURFACE TREAT.				REVD	KRISHNA PRASAD	30.10.2015
TITLE				CHKD	KRISHNA PRASAD	30.10.2015
BRACKET, BULK HEAD PANEL				DRWN	PURUSHOTHAMAN	20/10/2015
SCALE				NTS		
SHEET				1 OF 1		
DRG No.						
909-29034						
ALT						
1						

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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 TEXTURES SHALL BE AS PER COMPANY STD. 1012.C.						STATUS:	PROTO/PRODUCTION			
WELDINGS SHALL BE CARRIED OUT AS PER IS: 9595-96										



NOTE
REMOVE ALL SHARP EDGES & BURRS.

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	▽	▽
GRADE No.	VALUE	SYMBOL	
SURFACE ROUGHNESS	ALT. No.	ECN NO CHANGES	DATE BY CHKD APPD
PRODUCT: DMRC BG METRO CARS			
REF DRG:			
MATERIAL: SUS 304 - 2B FINISH			
HEAT TREAT:			
SURFACE TREAT:			
TITLE: BRACKET, ETU			
SCALE: NTS			
SHEET: 1 OF 1			
Wt. (Kg): -			
DRG No. 909-19666			
ALT: -			
beml BEML LIMITED			

