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GRADE No.

VALUE

SYMBOL

SURFACE ROUGHNESS

ALT.NO.

ECN NO/CHANGES

DATE

BY

CHKD

APPD

N1

N2

N3

N4

N5

N6

N7

N8

N9

N10

N11

N12

0.025

0.05

0.1

0.2

0.4

0.8

1.6

3.2

6.3

12.5

25

50

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:

1000

50

4

SELF ADHESIVE RELEASE TAPE

UNCONTROLLED

NOTE: 1. ALL TECHNICAL REQUIREMENT SHALL BE AS PER EN45545 HL-3

2. COLOUR:BLACK

MATL:EPDM

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)	
			PRODUCT	DMRC BG METRO CARS			
			REF DRG				
			MATERIAL				
			HEAT TREAT.	APPD	VS	01.07.2020	
			SURFACE TREAT.	REVD	SNH	07.07.2020	
			TITLE	CHKD	SNH	01.07.2020	
			PACKING-T4	DRWN	VISHNU	01.07.2020	
				SCALE		SHEET OF	Wt.(Kg)
						0	
			DRG No.			ALT	
			909-56825				

BEML LIMITED

909-56825

ALT