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

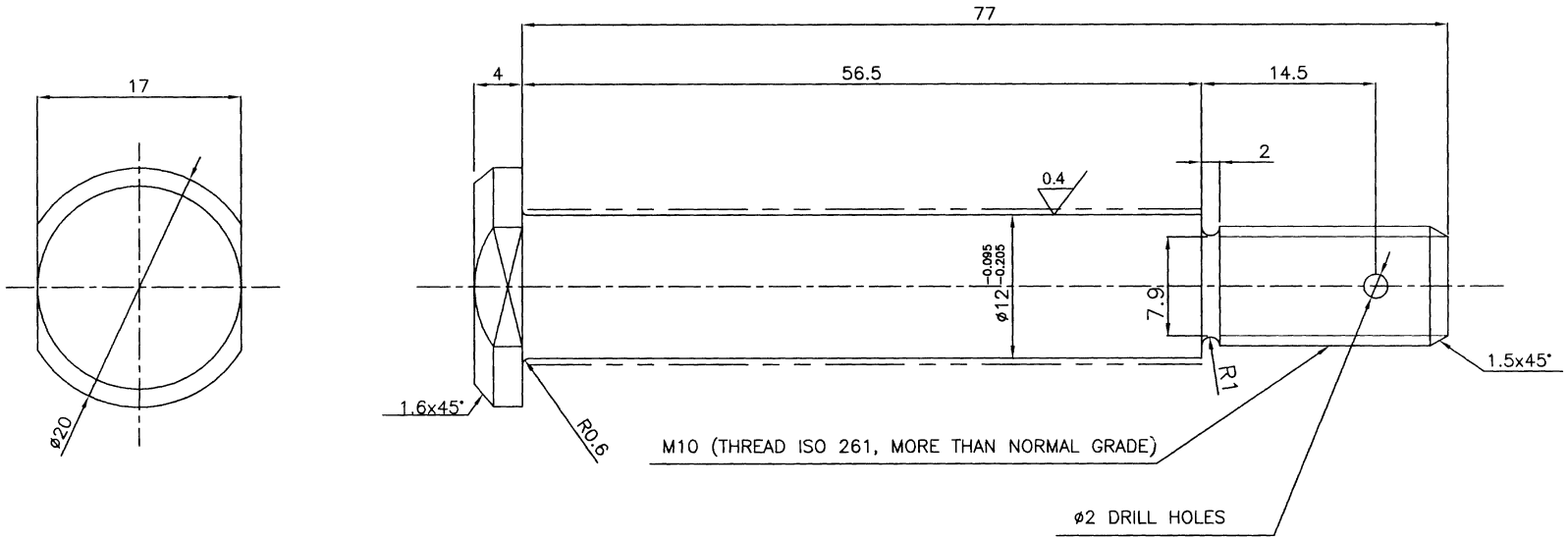
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT–1) (MEDIUM)

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

QUALITY OF WELD JOINTS REF, ISO:5817

PROTO / ~~PILOT / PRODUCTION~~

SURFACE TEXTURE 3.2 (0.4)



UN CONTROLLED COPY

NOTE

1. THE MACHINED SURFACES SHALL BE COATED WITH RUST PREVENTIVE FLUID TO IS:1154-2000.
2. INDUCTION HARDENING SHOULD BE DONE IN THE MARKED —— – – – —— AREA. CASE DEPTH: 1.2 TO 1.5 mm. CASE HARDNESS: 55-57 HRC.

SURFACE ROUGHNESS	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	

SL No.	QTY	DRG. / STOCK No.	DESCRIPTION	SIZE	COMPANY.STD/IS.STD	Wt.Kg
		DETAIL PARTS		MATERIAL		
			Ø22x84 LONG STEEL ROUND		Gr.45C8, IS:5517-93	

PRODUCT: METRO BOGIE

SURFACE TREATMENT

APPROVED			30.4.08
CHECKED			30.4.08
DRAWN	ILYAS		4.4.08
REF DRG			

ALT	CHANGES / ECN No.	DATE	BY	CKD	APP	QTY	NEXT ASSY	MODEL	SCALE	SHEET	Wt (Kg)
						4	909-84101	M / DT / T	1:1	1 OF1	0.11

BEML LIMITED
R&D, BANGALORE COMPLEX
BANGALORE 560 075

TITLE: BOLT, SPECIAL

DRG No. 909-84103

ALT