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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

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	~

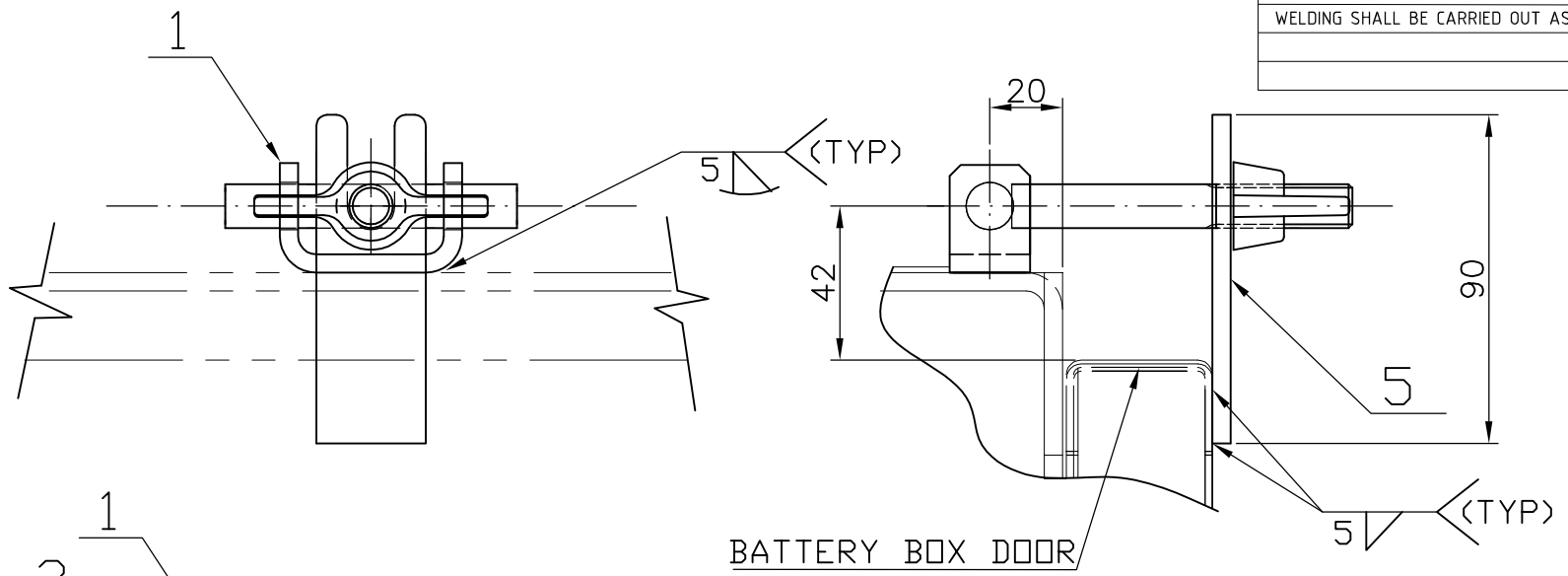
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

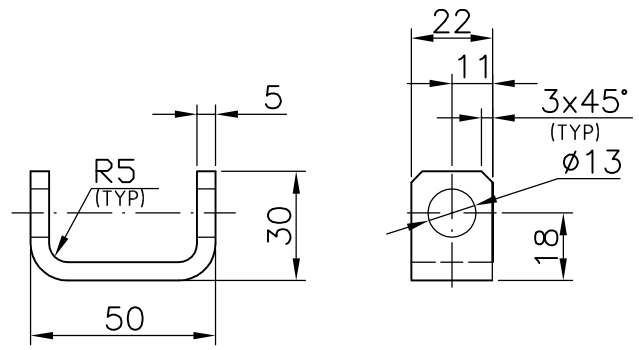
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM) | QUALITY OF WELD JOINTS REF, RD 230 MEDIUM

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

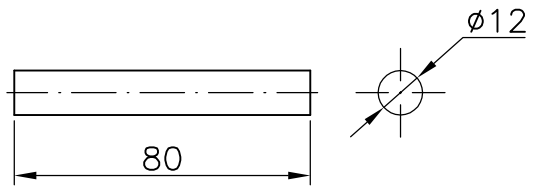
WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96

STATUS:

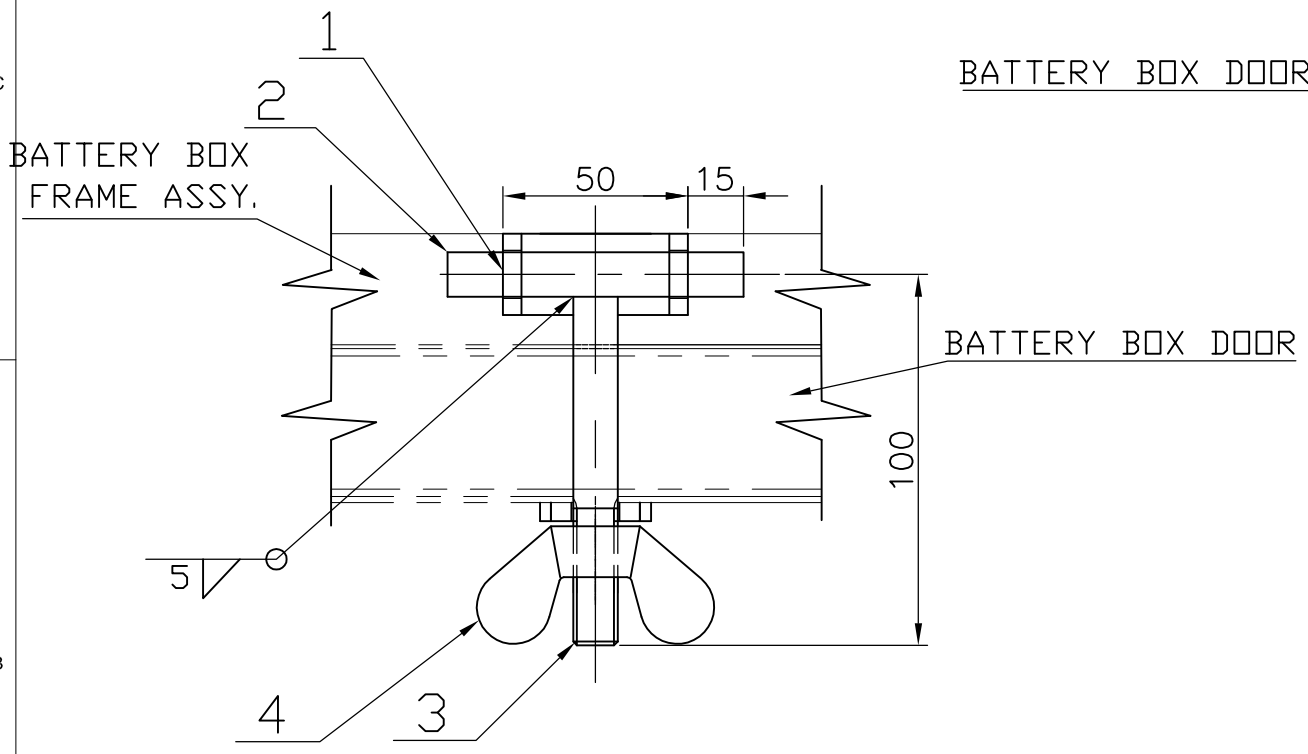


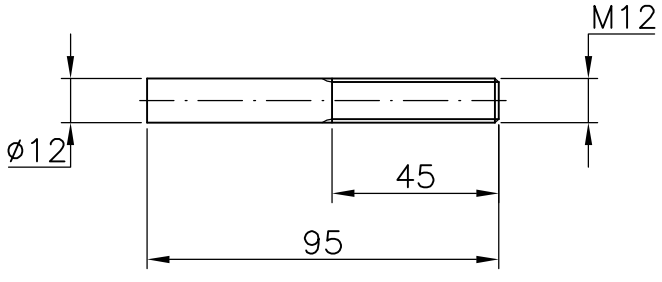


DETAIL- 1

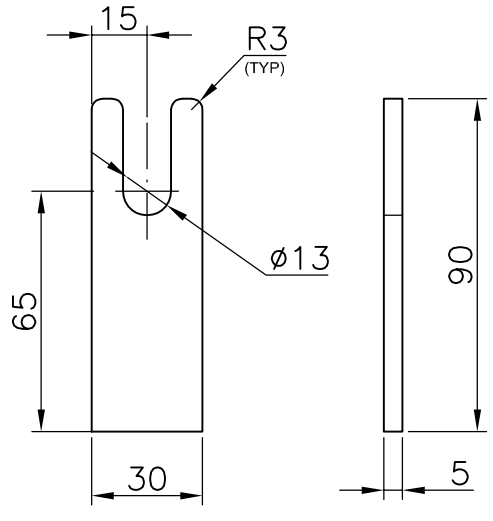


DETAIL- 2





DETAIL- 3



DETAIL- 5

NOTE:

1. ONE PROTOTYPE SAMPLE SHALL BE SUBMITTED FOR APPROVAL BEFORE MANUFACTURING/ EFFECTING BULK SUPPLY.

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S Wt. (Kg) / MATERIAL
5	1	R101588001	LOCK PLATE	5x30x90	IS: 2062-06 Gr.E 250 C
4	1	RFN1211200	WING NUT	M12	IS: 2636-1972 TYPE 'A'/ MATL: GR A2-70, SS
3	1	R1052 08012	FIXING BOLT	ø12x95	IS: 2062-06 Gr.E 250 C
2	1	R1052 08012	PIN	ø12X80	IS: 2062-06 Gr.E 250 C
1	1	R1015 88001	LUG	93x22x5	IS: 2062-06 Gr.E 250 C

ALT.NO.	ECN NO/CHANGES	DATE	BY	CHKD	APPD

PRODUCT: MEMU-3PHASE

REF DRG: 849-21017

MATERIAL:

HEAT TREAT.:

SURFACE TREAT.:

TITLE: LOCK ASSY. FOR BATTERY BOX 110V

APPD	VS. LAKSHMI	22.9.19
REVD	V. SANTHA	21.9.19
CHKD	JAIRAM S	21.9.19
DRWN	JAGADISHA M	21.9.19

SCALE 1:2 | SHEET 1 OF 1 | Wt.(Kg) -

BEML LIMITED NEW FRONTIERS. NEW DREAMS

DRG No. 849-21018 ALT -

A3