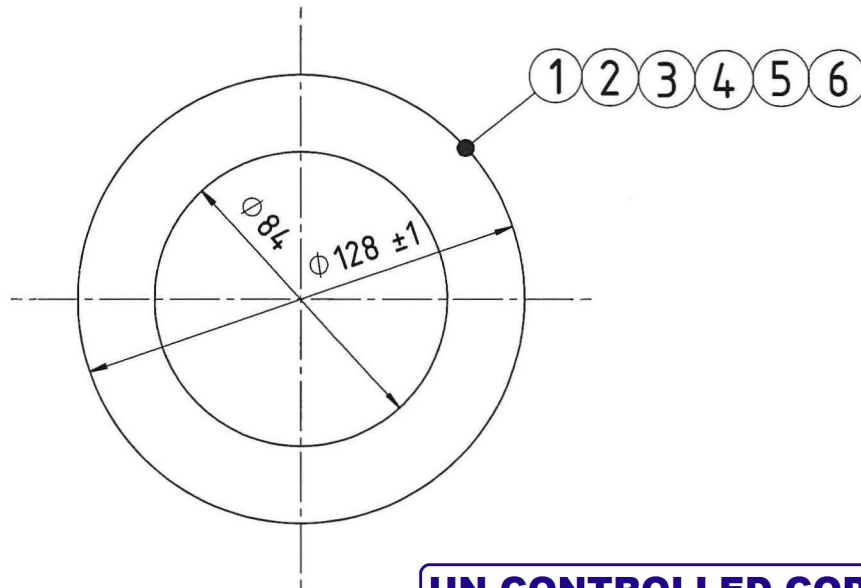


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| | | | | | | | | | | |
|--|-----------|-------|--------|----------|-----------|----------|---|-------------------------|------------|----|
| MACHINING DEVIATIONS FOR LINEAR DIMENSIONS | RANGE | 0 - 6 | 6 - 30 | 30 - 120 | 120 - 315 | 315-1000 | 1000-2000 | 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: | MOCKUP/PROTO/PRODUCTION | | |
| WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96 | | | | | | | | | | |



NOTE:-

PART SHALL BE ZINC PLATED AS PER SERVICE GRADE No.2 OF IS:1573-86 & CHROMATE PASSIVATED TO COLOUR IRIDESCENT YELLOW.

| | | | | | | | | | | | | | | |
|--|-------|--------|---------------------------|-----|------------------|----------------------|--------------|-----------------------|--|----------|--|--|--|--|
| CHROMATE PASSIVATED TO COLOUR IRIDESCENT YELLOW. | | | | | | | | | | | | | | |
| N1 | 0.025 | ▽ | 6 | 1 | R105201006 | ADJUSTING LINER, PSA | Φ128x6THK | IS:2062-06,Gr E 250WA | | | | | | |
| N2 | 0.05 | ▽ | 5 | 1 | C100603400 | ADJUSTING LINER, PSA | Φ128x4THK | IS:513-94, Gr-0 | | | | | | |
| N3 | 0.1 | ▽ | 4 | 1 | C100502315 | ADJUSTING LINER, PSA | Φ128x3.15THK | IS:513-94, Gr-0 | | | | | | |
| N4 | 0.2 | ▽ | 3 | 1 | C100603200 | ADJUSTING LINER, PSA | Φ128x2THK | IS:513-94, Gr-0 | | | | | | |
| N5 | 0.4 | ▽ | 2 | 1 | C100603160 | ADJUSTING LINER, PSA | Φ128x1.6THK | IS:513-94, Gr-0 | | | | | | |
| N6 | 0.8 | ▽ | 1 | 1 | C100603100 | ADJUSTING LINER, PSA | Φ128x1THK | IS:513-94, Gr-0 | | | | | | |
| N7 | 1.6 | ▽ | SL.No. | QTY | PART / STOCK No. | DESCRIPTION | SIZE (mm) | COMPANY STD./I.S | | Wt. (Kg) | | | | |
| N8 | 3.2 | ▽ | MATERIAL | | | | | | | | | | | |
| N9 | 6.3 | ▽ | PRODUCT BMRCL METRO CARS | | | | | | | | | | | |
| N10 | 12.5 | ▽ | REF DRG | | | | | | | | | | | |
| N11 | 25 | ▽ | MATERIAL - | | | | | | | | | | | |
| N12 | 50 | ▽ | HEAT TREAT. | | | | | | | | | | | |
| GRADE No. | VALUE | SYMBOL | SURFACE TREAT. | | | | | | | | | | | |
| | | | TITLE | | | | | | | | | | | |
| SURFACE ROUGHNESS | | | ADJUSTING LINER, PSA | | | | | | | | | | | |
| | | | PSA | | | | | | | | | | | |
| ALT.No. | | | SCALE 1:2 | | | | | | | | | | | |
| | | | SHEET 1 OF 1 | | | | | | | | | | | |
| ECN NO/CHANGES | | | Wt.(kg) 0 | | | | | | | | | | | |
| | | | ALT | | | | | | | | | | | |
| DATE | | | BY | | | | | | | | | | | |
| | | | CHKD | | | | | | | | | | | |
| APPD | | | DRG No. | | | | | | | | | | | |
| | | | 926-81131 | | | | | | | | | | | |
| SURFACE ROUGHNESS | | | BMRCL BEML LIMITED | | | | | | | | | | | |
| | | | NEW FRONTIERS. NEW DREAMS | | | | | | | | | | | |