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GRADE No.	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12	VALUE	SYMBOL	SURFACE ROUGHNESS
	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

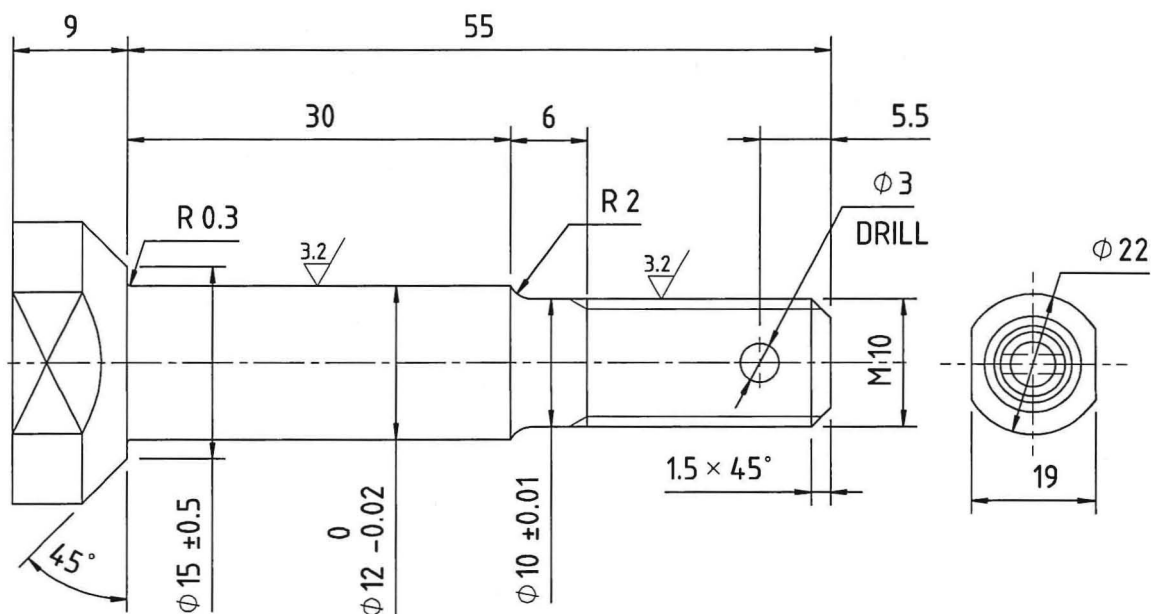
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM)

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: **PROTO/PILOT/PRODUCTION**



**UN CONTROLLED COPY**

NOTE:-

SCREW MACHINING SHALL BE DONE ACCORDING TO ISO 261 NORMAL GRADE OR ABOVE.

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE (mm)	COMPANY STD./I.S	Wt. (Kg)
				Ø22x64L	AISI 304	
					MATERIAL	
			PRODUCT	BMRCL METRO CARS		
			REF DRG			
			MATERIAL			
			HEAT TREAT.	APPD	MS	21.08.19
			SURFACE TREAT.	REVD	DB	19.08.19
			TITLE	CHKD	DB	17.08.19
				DRWN	JC	
				SCALE	2:1	
				SHEET	1 OF 1	
				Wt (Kg)	0.065	
				DRG No.	926-84105	
				ALT	0	



BEML LIMITED

926-84105

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