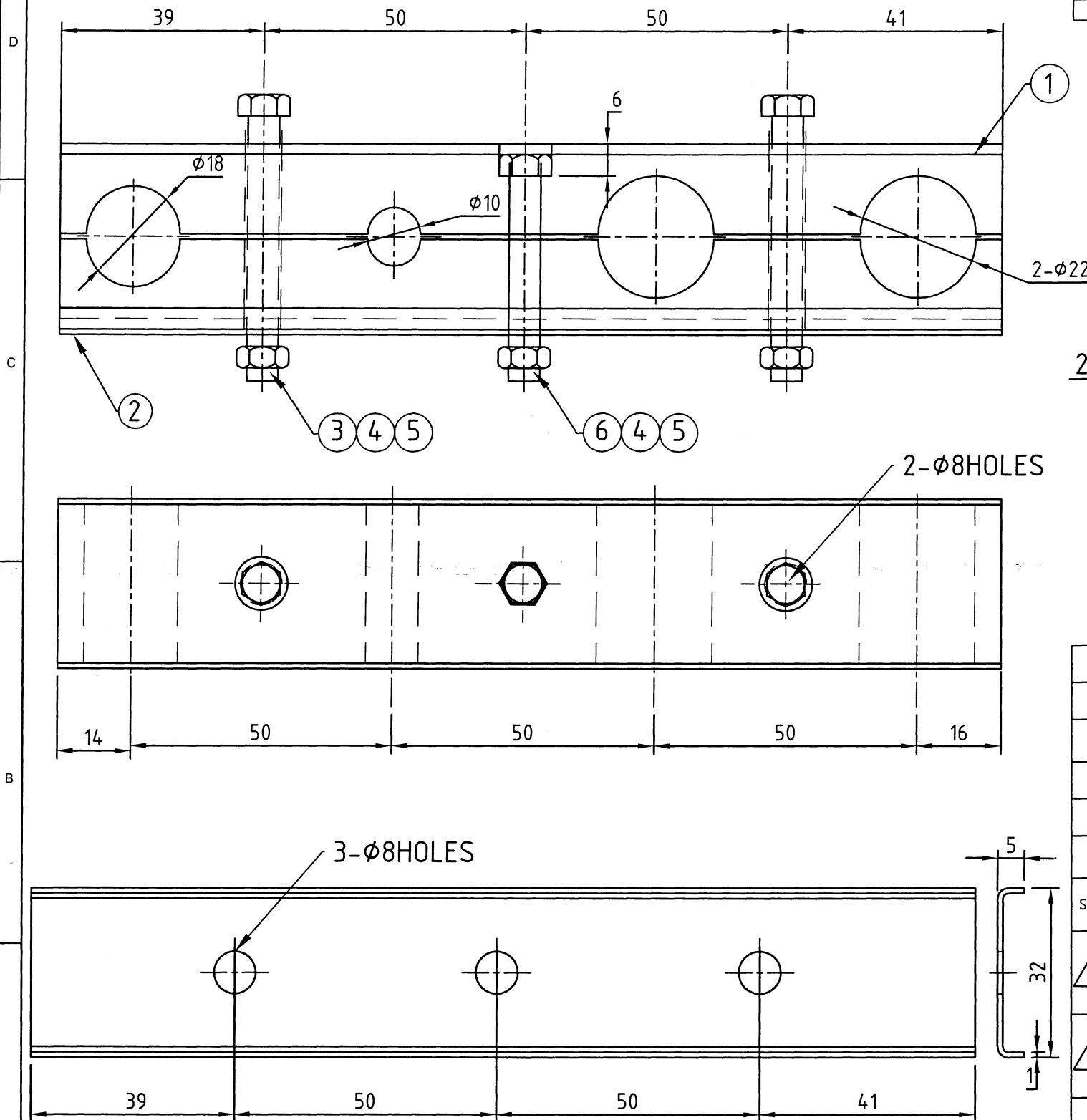


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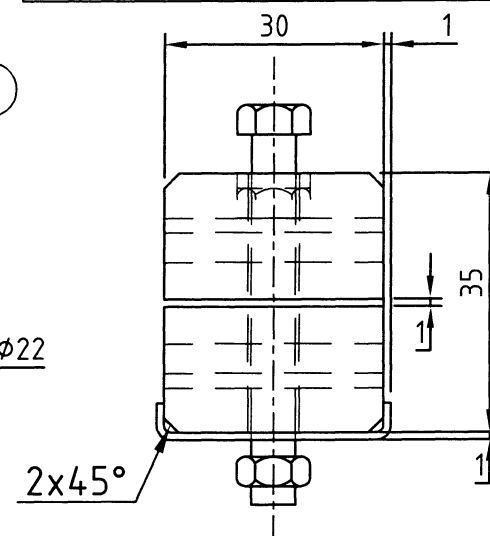
GRADE No.	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12
VALUE	0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50
SYMBOL												

SURFACE
ROUGHNESS



DETAIL P2

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



NOTE

1. THE GRADE OF BOLT AND NUT : BOLT = GRADE 8.8, NUT= GRADE 8
2. THE NYLOCK SHALL BE APPLIED TO BOLT FOR LOCK TIGHT
3. THE FIRST REMOVAL PREVAILING TORQUE OF NYLOCK IS 4.5 (kg.CM) FOR M6 BOLT
4. NYLON 6 GRADE 1011SW (OR EQUIVALENT) FLAME RETARDANT TO V-0 OF UL- 94

UNCONTROLLED COPY

6	1	RFB3850645	HEXAGONAL HEAD BOLT	M6X45 WITH NYLOCK BLUE PATCH PREAPPLIED ADHESIVE TO IS:1364(P.T-1)-02/MATL:IS:1367(P.T-14)-84,GR-A2-70	
5	3	RFW0920616	SPRING WASHER	B6 TO IS.3063-94 / MATL.AISI.304	
4	3	RFN3860652	HEXAGONAL HEAD NUT	M6 TO IS.1364(P.T-3)-02/MATL. IS.3506-79, Gr-A2-70	
3	2	RFB3850650	HEXAGONAL FLANGE BOLT	M6X50 WITH NYLOCK BLUE PATCH PREAPPLIED ADHESIVE TO IS:1364(P.T-1)-02/MATL:IS:1367(P.T-14)-84,GR-A2-70	
2	1		PLATE		SUS304
1	1 SET		CLEAT		SEE NOTE 4
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	MATERIAL
			PRODUCT	KMRC RS(3R) METRO CARS	
			REF DRG		
			MATERIAL		
			HEAT TREAT.	APPD	KP
			SURFACE TREAT.	REVD	MS
			TITLE	CHKD	GD
				DRWN	SK
				SCALE	1:1
				SHEET	1 OF 1
				DRG No.	942-60075
				ALT	-
ALT.No.	ECN NO/CHANGES	DATE	BY	CHKD	APPD

BEML LIMITED

942-60075