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	~

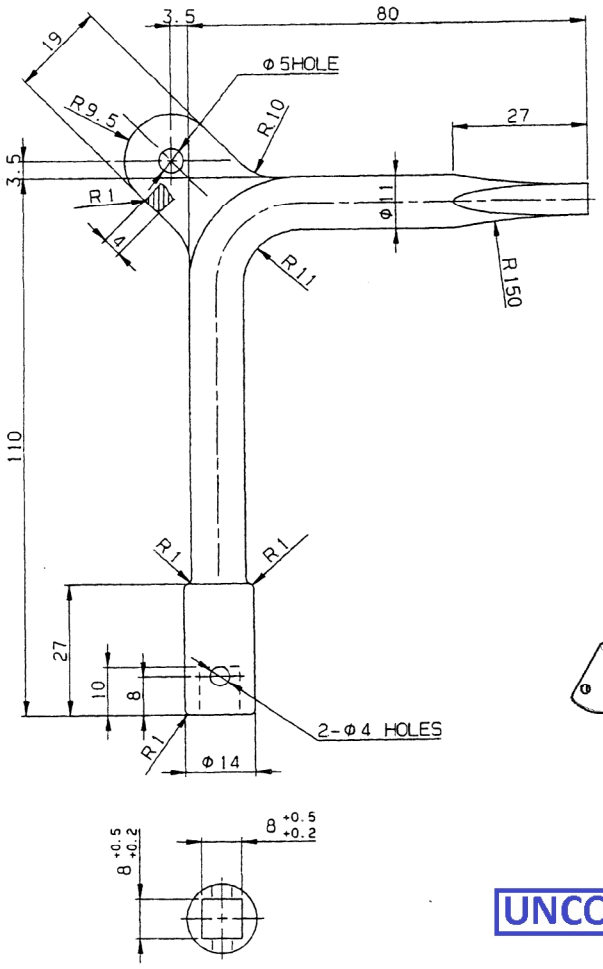
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

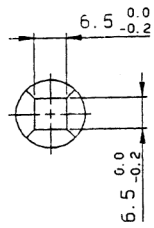
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM) | QUALITY OF WELD JOINTS REF, RD 230 MEDIUM

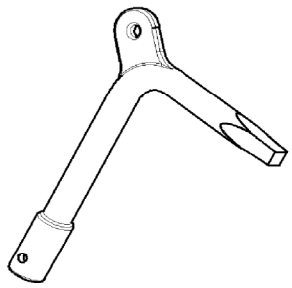
VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS. 1012.C.

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

STATUS:







ISOMETRIC VIEW

UNCONTROLLED

NOTE
1. THE SURFACE SHOULD BE BUFF-FINISHED.
2. SAMPLE APPROVAL SHALL BE OBTAINED BEFORE MASS PRODUCTION.

AUSTENITIC STAINLESS STEEL AISI304/SUS304

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
					MATERIAL	

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

PRODUCT	DMRC BG METRO CARS		
REF DRG			
MATERIAL			
HEAT TREAT.		APPD	9/12/15
SURFACE TREAT.		REVD	
TITLE	SQUARE KEY	CHKD	7.12.15
		DRWN	VISHWA 26/11/2015
		SCALE	SHEET / OF / Wt.(Kg)
	BEML LIMITED	DRG No.	909-19636
		ALT	-

A4

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

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