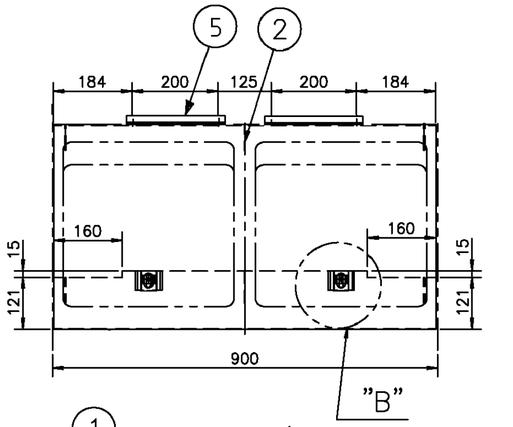
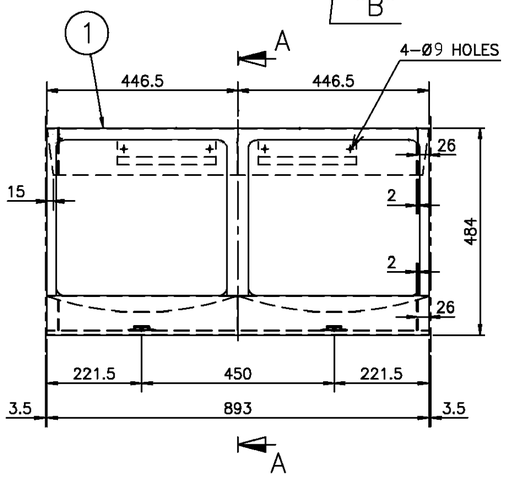
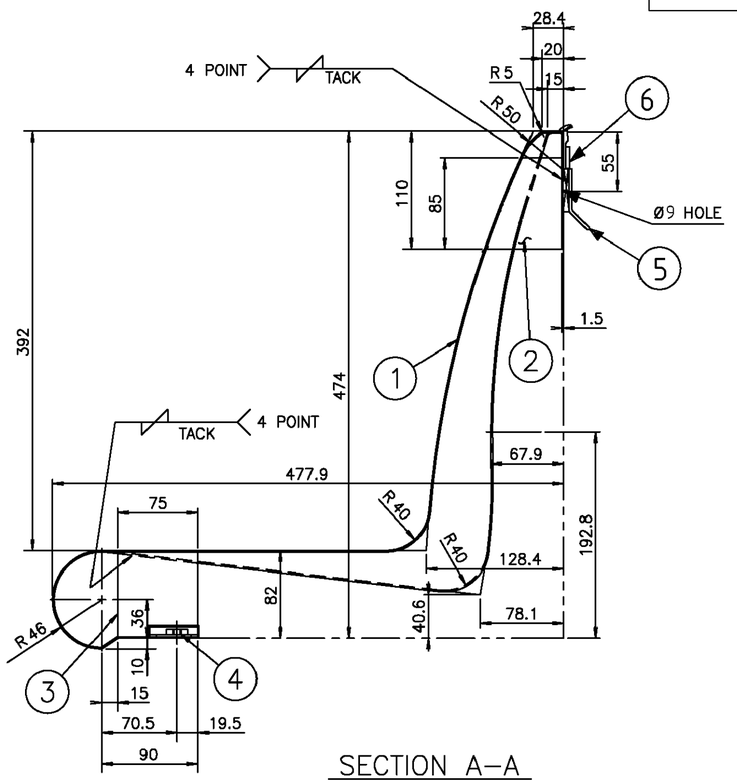
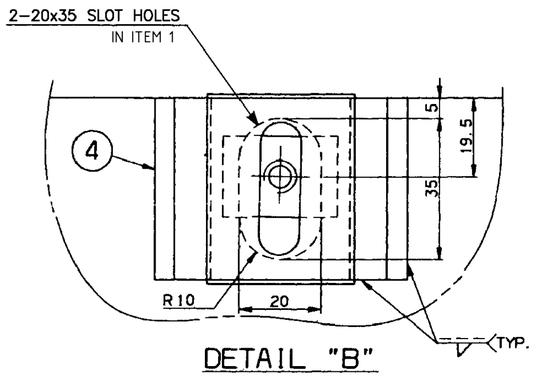


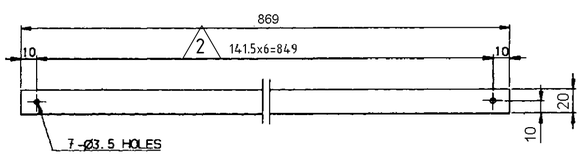




SECTION A–A



DETAIL "B"



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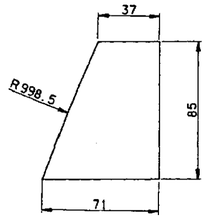

DETAIL "2"

NOTE:

1. THE ASSEMBLY SHALL BE FREE OF DIE MARKS, SCRATCHES AND VISUAL DEFECTS.
2. REMOVE ALL BURRS AND SHARP EDGES.
3. ALL WELD AREAS SHALL BE PICKLED AND PASSIVATED.
4. THE VENDOR SHALL SUPPLY ITEM 5 & 6 IN LOOSE CONDITION.

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
					MATERIAL	
6	1	909-23029-06	STIFFENER	869x20x2THK	SUS 304	
5	2	909-23025	SEAT BRACKET			
4	2	909-23013	NUT CASE			
3	3	909-23029-03	STIFFENER	75x79x2THK	SUS 304	
2	3	909-23029-02	STIFFENER	71x85x2THK	SUS 304	
1	1	909-23029-01	SALOON SEAT	1.5THK	SUS 304	

ALT.NO.	ECN NO/CHANGES	DATE	BY	CHKD	APPD
2	DIM 141.5 WAS 283. ECN: 90900677	19/07/17	PURUSHOTH	KP	PVG
1	Ø9 HOLE AND PITCH DETAILS SHOWN. ECN: 90900531	05/12/15	PURUSHOTH	KP	PVG

PRODUCT	DMRC BG METRO CARS
REF DRG	
MATERIAL	–
HEAT TREAT.	–
SURFACE TREAT.	–

APPD	GAYATHRI PV	15/09/2015
REVD	KRISHNA PRASAD	15/09/2015
CHKD	KRISHNA PRASAD	15/09/2015
DRWN	PURUSHOTHAMAN	03/09/2015

TITLE: SALOON SEAT (2 SEAT)

SCALE	SHEET	Wt.(Kg)
NTS	1 OF 1	–

BEML LIMITED

DRG No. 909-23029 ALT 2

A2

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: PRODUCTION

UNCONTROLLED

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