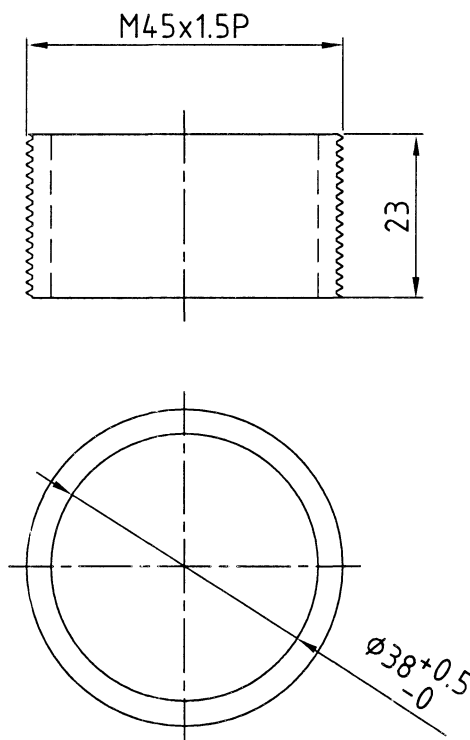


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MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000	RA
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	~
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER 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	PRODUCTION		
WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96										



NOTE:

1. REMOVE ALL SHARP EDGES AND BURRS.

UNCONTROLLED

N1	0.025	N2	0.05	N3	0.1	N4	0.2	N5	0.4	N6	0.8	N7	1.6	N8	3.2	N9	6.3	N10	12.5	N11	25	N12	50		
GRADE No.	VALUE	SYMBOL	SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./IS	wt. (Kg)																
										MATERIAL															
						PRODUCT	DMRC BG METRO CARS																		
						REF DRG	-																		
						MATERIAL	AISI 304																		
						HEAT TREAT.	-	APPD																24.10.15	
						SURFACE TREAT.	-	REVD																	
						TITLE	PIPE, COLLAR																		
						CHKD																20.10.15			
						DRWN	PURUSHOTHAMAN															17/06/2015			
						SCALE	1:1		SHEET	1 OF 1														Wt (Kg)	-
						DRG No.	909-29140															ALT			
SURFACE ROUGHNESS						ALT NO.	ECN NO/CHANGES				DATE	BY	CHKD	APPD	BEML LIMITED				909-29140						