UNCONTROLLED

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:

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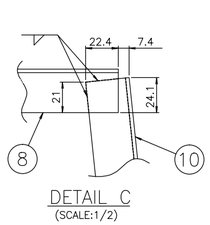
GRADE No. / VALUE / SYMBOL / SURFACE ROUGHNESS

N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12	
0.8	1.6	3.2	6.3	12.5	25	50	100	200	400	800	1600	
▽	▽▽	▽▽▽	▽▽▽▽	▽▽▽▽▽	▽▽▽▽▽▽	▽▽▽▽▽▽▽	▽▽▽▽▽▽▽▽	▽▽▽▽▽▽▽▽▽	▽▽▽▽▽▽▽▽▽▽	▽▽▽▽▽▽▽▽▽▽▽	▽▽▽▽▽▽▽▽▽▽▽▽	



DETAIL C
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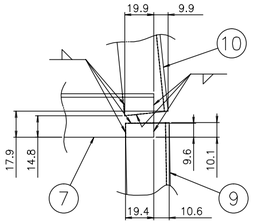

DETAIL D
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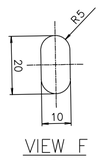
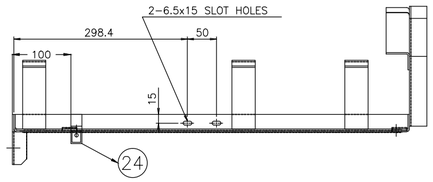
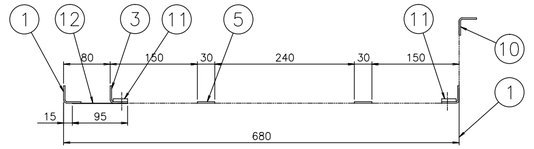
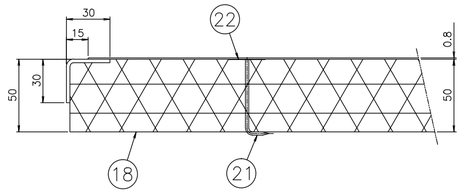


VIEW F
(SCALE:1/1)





SECTION B–B



SECTION H–H
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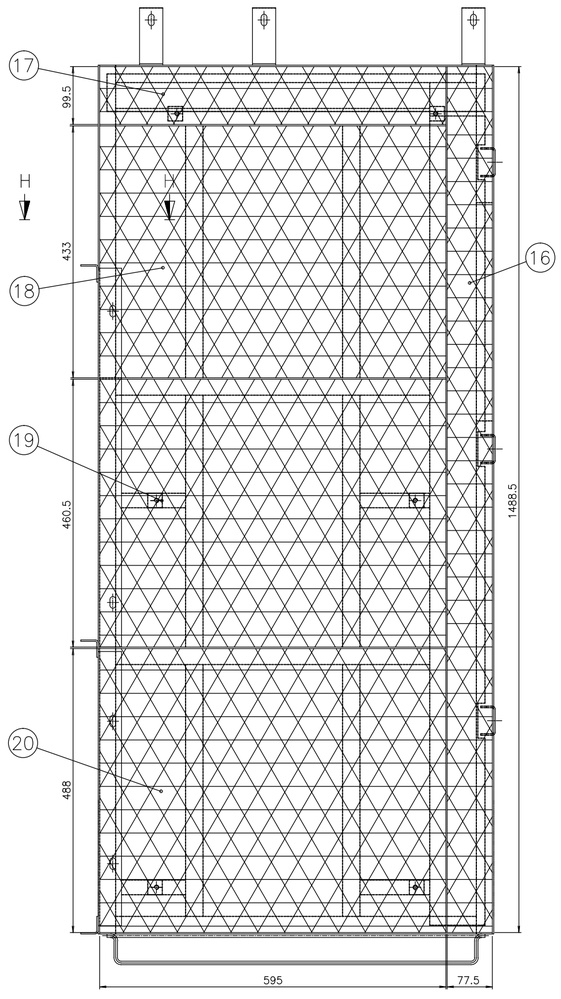
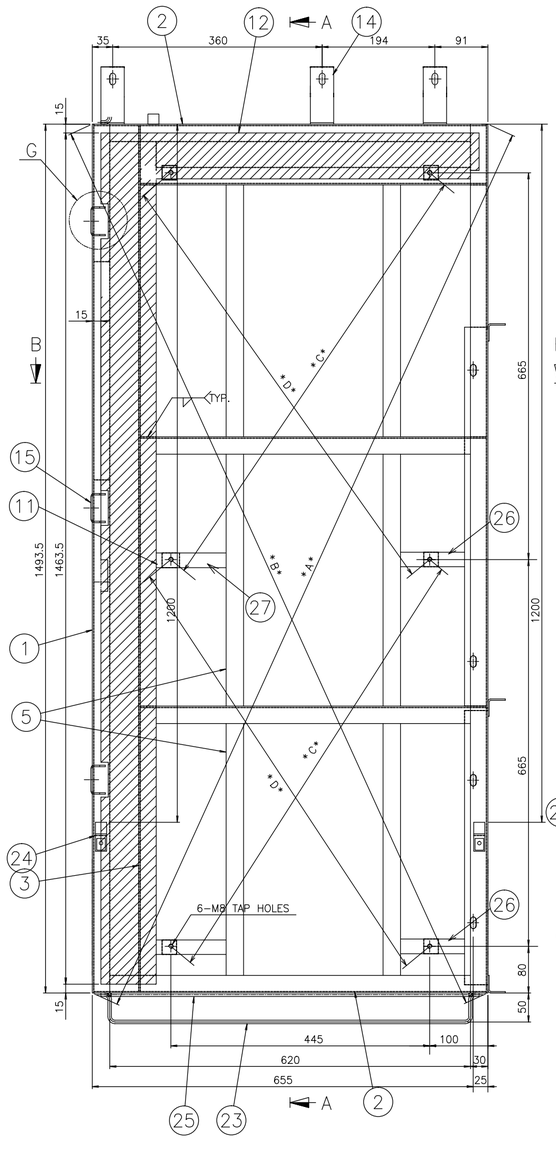
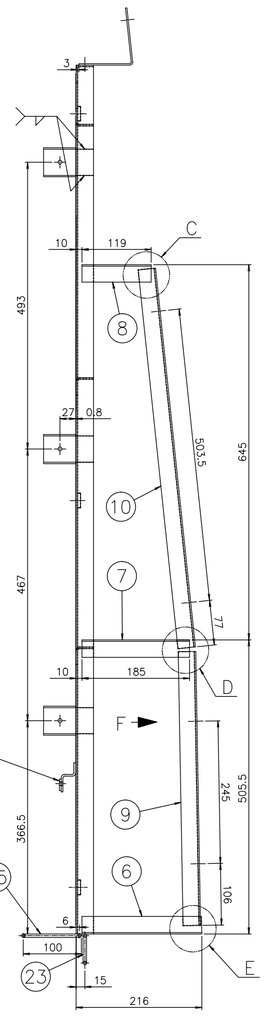
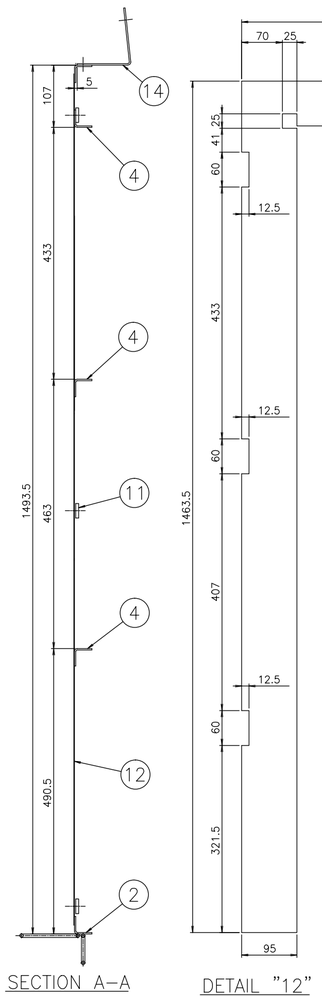
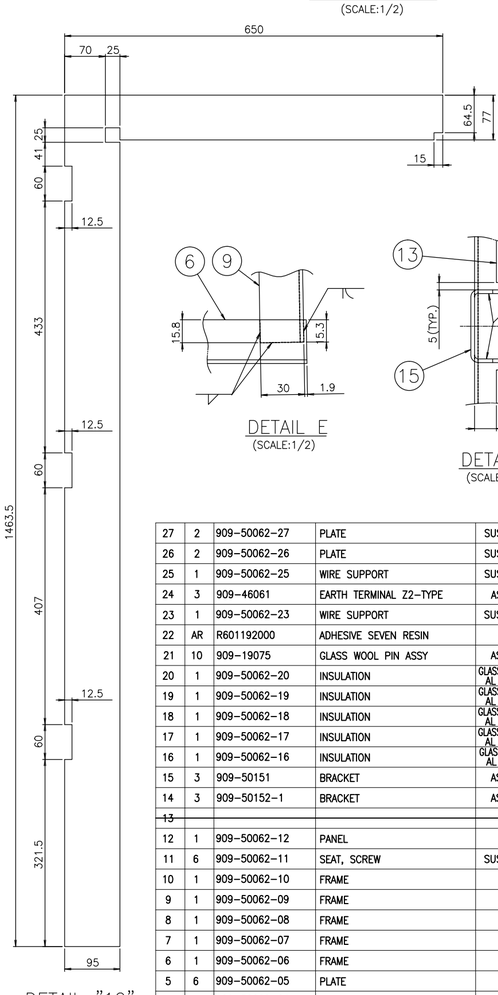






SECTION A–A





DETAIL "12"

DETAIL E
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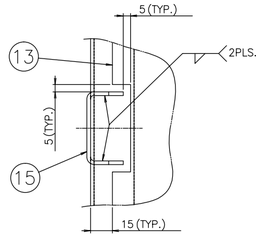
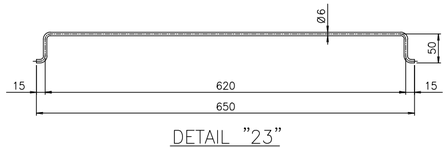


DETAIL G
(SCALE:1/2)

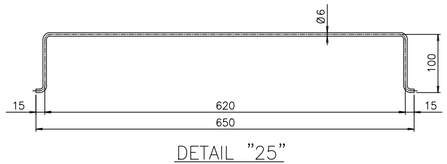
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	WT. (Kg)
					MATERIAL	
27	2	909-50062-27	PLATE	SUS304	t3x30x120	
26	2	909-50062-26	PLATE	SUS304	t3x30x110	
25	1	909-50062-25	WIRE SUPPORT	SUS304	Ø6	
24	3	909-46061	EARTH TERMINAL Z2-TYPE	ASSY		
23	1	909-50062-23	WIRE SUPPORT	SUS304	Ø6	
22	AR	R601192000	ADHESIVE SEVEN RESIN	–		
21	10	909-19075	GLASS WOOL PIN ASSY	ASSY		
20	1	909-50062-20	INSULATION	GLASS WOOL AL FOIL	t50x488x595	
19	1	909-50062-19	INSULATION	GLASS WOOL AL FOIL	t50x460.5x595	
18	1	909-50062-18	INSULATION	GLASS WOOL AL FOIL	t50x433x595	
17	1	909-50062-17	INSULATION	GLASS WOOL AL FOIL	t50x99.5x595	
16	1	909-50062-16	INSULATION	GLASS WOOL AL FOIL	t50x77.5x1488.5	
15	3	909-50151	BRACKET	ASSY	t2.5	
14	3	909-50152-1	BRACKET	ASSY	t2.5	
13						
12	1	909-50062-12	PANEL			
11	6	909-50062-11	SEAT, SCREW	SUS304	t3x25x25	
10	1	909-50062-10	FRAME			
9	1	909-50062-09	FRAME			
8	1	909-50062-08	FRAME			
7	1	909-50062-07	FRAME			
6	1	909-50062-06	FRAME			
5	6	909-50062-05	PLATE			
4	3	909-50062-04	FRAME			
3	1	909-50062-03	FRAME			
2	2	909-50062-02	FRAME			
1	2	909-50062-01	FRAME			

NOTE

1. ITEM NO.12 SHALL BE WELDED ON FRAME BY SPOT WELDING.(PITCH=100)
2. FLATNESS OF ITEM NO.12 SHALL BE MAXIMUM 3 AFTER SPOT WELDING.
3. A–B=±3
4. C–D=±1
5. REMOVE ALL EDGES AND BURRS.
6. WELDING AREAS IN FRONT SURFACE SHALL BE CLEANED WITH SUS CLEANER.
7. UNSPECIFIED WELDING PARTS SHALL BE INNER WELDING.
8. INSULATION SHALL BE FITTED WITH GLASS WOOL PIN WITH APPROX. PITCH OF 300.
9. WELDING SYMBOLS ACCORDING TO IS0:2553.
10. STOCK NO. FOR 50 THK GLASS WOOL IS R347988005.



DETAIL "23"



DETAIL "25"

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

PRODUCT: DMRC BG METRO CARS
REF. DRG
MATERIAL
HEAT TREAT.
SURFACE TREAT.
TITLE: FRAME (T/M-D TYPE)
APPD: KCS
REVD.
CHKD: SNH
DRWN: VISHNU — 18.05.18
SCALE — SHEET — OF — WT.(Kg)
BEML LIMITED
DRG No.: 909-50062
ALT: -
A1