| MACHINING DEVIATIONS FOR LINEAR DIMENSIONS | RANGE | 0 – 6 | 6 – 30 | 30 – 120 | 120 – 315 | 315–1000 | 1000–2000 | 2000–4000 | ABOVE 4000 |
|---|---|---|---|---|---|---|---|---|---|
| | TOLERANCE | ±0.1 | ±0.2 | ±0.3 | ±0.5 | ±0.8 | ±1.2 | ±2 | ±3 |

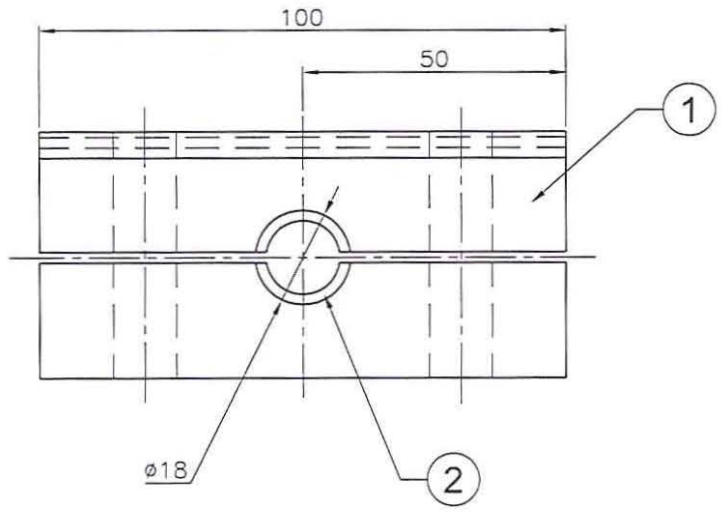
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD–227

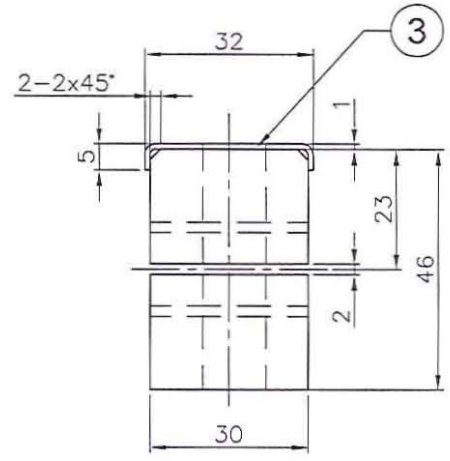
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT–1) (MEDIUM)

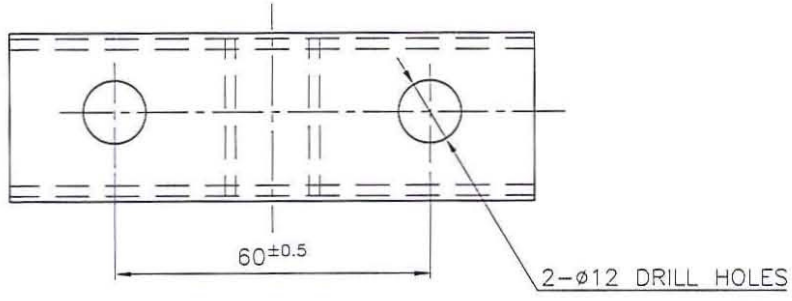
VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS. 1012.C.

QUALITY OF WELD JOINTS REF. ISO:5817

~~PROTO / PILOT /~~ PRODUCTION




**UN CONTROLLED COPY**

NOTE:

1. REMOVE ALL SHARP EDGES
2. CLEAT SHALL BE FIRE RETARDANT TO V–0 GRADE OF UL – 94

| SL No. | QTY | DRG. / STOCK No. | DESCRIPTION | SIZE | COMPANY.STD/IS.STD | Wt.Kg. |
|---|---|---|---|---|---|---|
| | | DETAIL PARTS | | MATERIAL | | |
| 3 | 1 | | PLATE | 100x39x1THK. | AISI 304 | |
| 2 | 2 | | PROTECTOR RUBBER | 23x30x2THK. | EPDM | |
| 1 | 2 | | CLEAT | 100x30x23 | NYLON 6 | |

| ALT | CHANGES / ECN No. | DATE | BY | CKD | APP |
|---|---|---|---|---|---|
| 1 | NOTE ADDED, NEXT ASSY DETAILS & BOM UPDATED ECN No.90900479 | 29/8/08 | ILYAS | | |

PRODUCT: METRO BOGIE

| QTY | NEXT ASSY | MODEL |
|---|---|---|
| 1 | 909-81016 | 909 |
| 1 | 909-81013 | 909 |
| 1 | 909-81012 | 909 |
| 1 | 909-81011 | 909 |
| 2 | 909-81009 | 909 |
| 2 | 909-81008 | 909 |

SURFACE TREATMENT

| | | |
|---|---|---|
| APPROVED | JP | 30.4.08 |
| CHECKED | KSSR | 29.4.08 |
| DRAWN | ILYAS | 18.4.08 |
| REF DRG | | |
| SCALE | 1:1 | |
| SHEET | 1 OF 1 | |
| Wt (Kg) | - | |

BEML LIMITED
R&D, BANGALORE COMPLEX
BANGALORE 560 075

TITLE: CLEAT ASSY

DRG No. 909-81024

ALT 1

| SURFACE ROUGHNESS | GRADE No. | VALUE | SYMBOL |
|---|---|---|---|
| | 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 | |