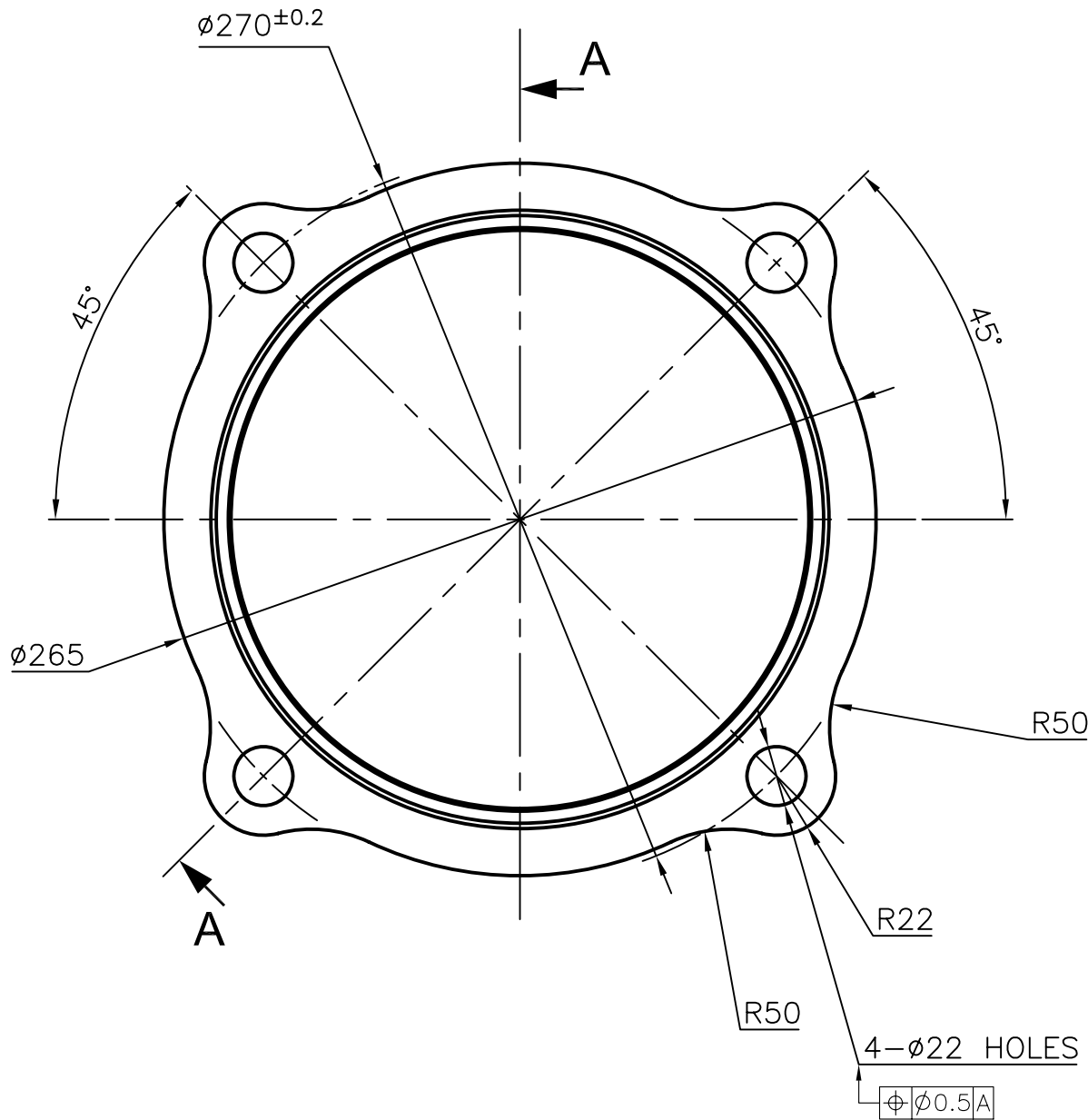


GRADE No.	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12
VALUE	0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50
SYMBOL												
SURFACE ROUGHNESS												

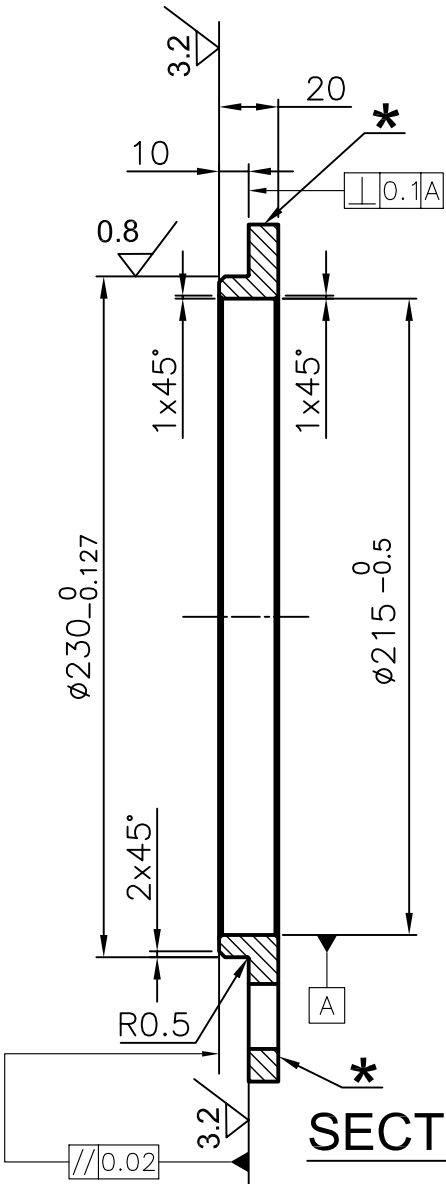


NOTE

1. REMOVE ALL SHARP CORNERS AND BURRS.
2. THE MACHINED SURFACES SHALL BE COATED WITH RUST PREVENTIVE FLUID TO IS:1154-2000.
2. MARKED \* THUS SHALL BE SHOT BLASTED TO SA 2 1/2 AND PRIMER PAINTED WITH M/s KCC EPOXY PAINT TO Gr. EP-1119 & 024 THINNER TO GREY COLOR. THE PRIMER PAINTED ITEM SHALL BE FINISH PAINTED WITH POLYURETHANE FINISH PAINT OF COLOR NCS 8500N TO Gr. UT 5119 & THINNER 0370 OF M/s KCC PAINTS CHENNAI

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.						<del>PROTO / PILOT /</del> PRODUCTION			
QUALITY OF WELD JOINTS REF, ISO 5817									

SURFACE TEXTURE 3.2 (0.8)



SECTION A-A

UN CONTROLLED COPY

C110101025		270X270X25THK.		45C8 IS:1570(PT. II)-79	
SL No.	QTY	DRG. / STOCK No.	DESCRIPTION	SIZE	COMPANY.STD/IS.STD   Wt.Kg
DETAIL PARTS			MATERIAL		
PRODUCT			METRO BOGIE		
			SURFACE TREATMENT		
			APPROVED	S JAYAPRAKASH	5.1.08
			CHECKED	KSRR	5.1.08
			DRAWN	ILYAS	4.1.08
			REF DRG	1112	
1	REVISED AND REDRAWN	2.5.11	ILYAS	909	
ALT	CHANGES / ECN No.	DATE	BY	CKD APP	QTY
TITLE			COVER, REAR		
BEML LIMITED R&D, BANGALORE COMPLEX BANGALORE 560 075			DRG No. 909-81136		
			SCALE 1:2.5	SHEET OF	Wt (Kg) 2.3
			ALT 1		