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

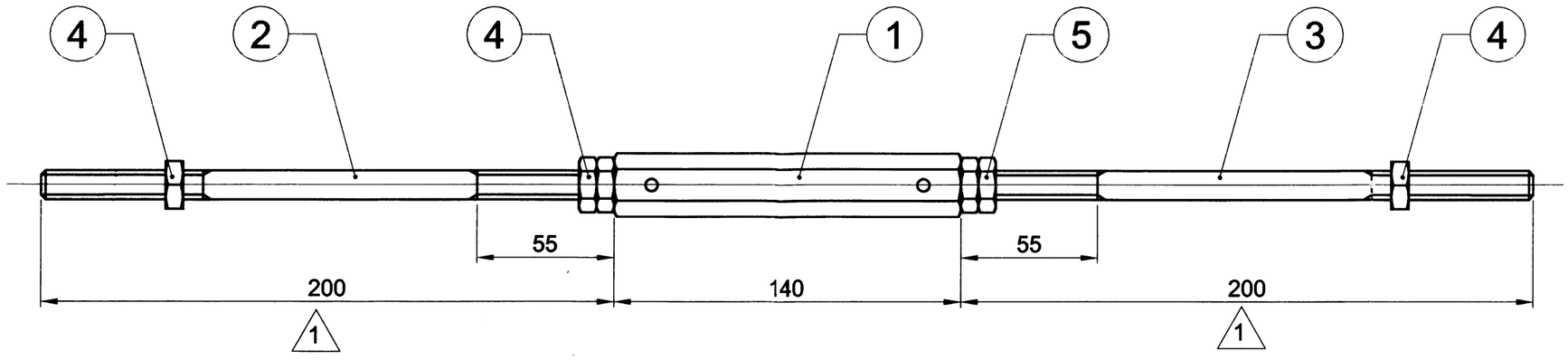
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD–227

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

SL No.	QTY	DRG. / STOCK No.	DESCRIPTION	SIZE	COMPANY.STD/IS.STD	Wt.Kg
		DETAIL PARTS		MATERIAL		
5	2	RFN5261211	M12, NUT HEX. (L.H THREAD) TO IS: 1364 (PART-3)-02, MATL. IS: 1367 (P-14)-84, Gr.A2-70, SS			
4	4	RFN3861211	M12, NUT HEX. (R.H THREAD) TO IS: 1364 (PART-3)-02, MATL. IS: 1367 (P-14)-84, Gr.A2-70, SS			
3	1	909-84110	SCREW ROD			
2	1	909-84109	SCREW ROD			
1	1	909-84108	TURN BUCKLE			

ALT	CHANGES / ECN No.	DATE	BY	CKD	APP
1	DIMN. 200 WAS 230 ECN No. 90900278	10.7.12	ILYAS		

QTY	NEXT ASSY	MODEL
1	909-84020	909

PRODUCT: METRO BOGIE

SURFACE TREATMENT

APPROVED	JP	18.5.11
CHECKED	KSRR	18.5.11
DRAWN	ILYAS	10.5.11
REF DRG	1148	

SCALE 1:2.5 | SHEET OF | Wt (Kg)

BEML LIMITED
R&D, BANGALORE COMPLEX
BANGALORE 560 075

TITLE: TURN BUCKLE ASS'Y

DRG No. 909-84024

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	