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

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	~

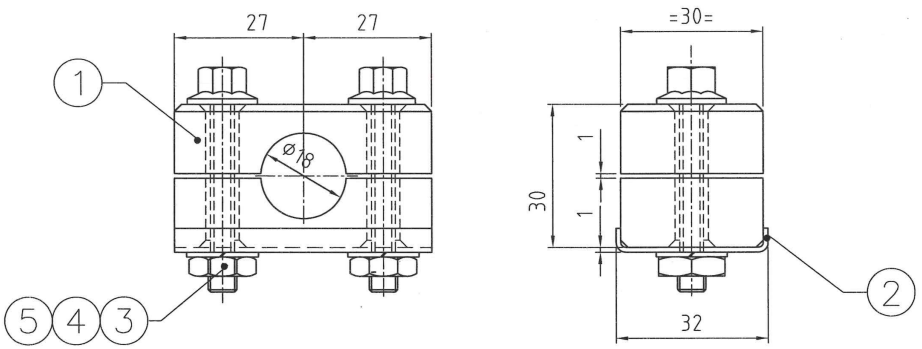
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

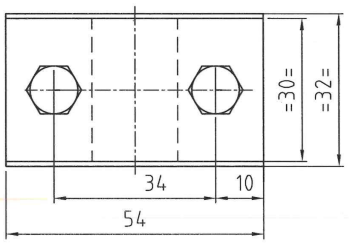
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM) | QUALITY OF WELD JOINTS REF. RD 230 MEDIUM

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

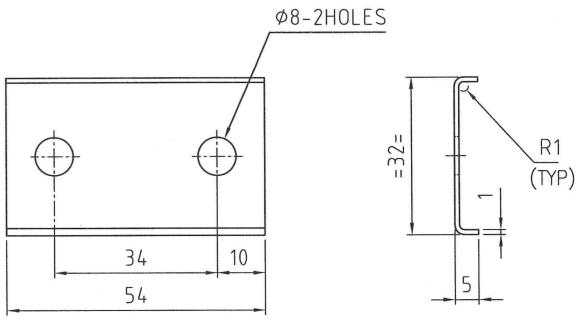
WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96

STATUS:

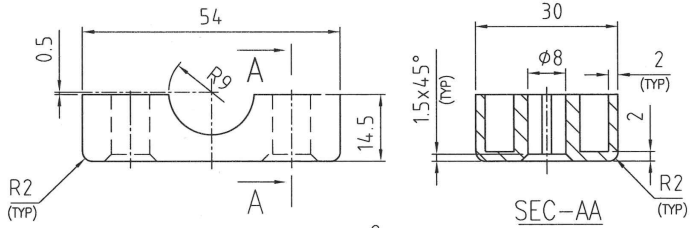




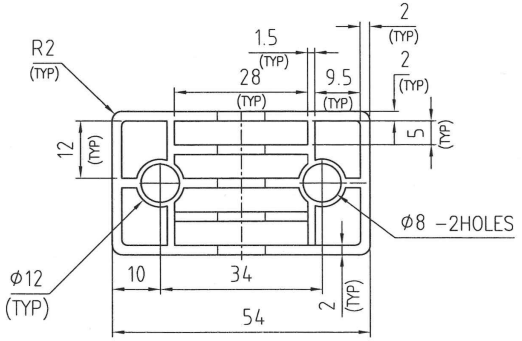
UNCONTROLLED COPY



DETAIL–P2



SEC–AA



DETAIL–P1

NOTE:

1. NYLOCK SHALL BE APPLIED TO ALL BOLTS FOR LOCK TIGHT.
2. FIRST REMOVAL PREVAILING TORQUE OF NYLOCK IS 4.5 (kg.cm) FOR M6 BOLT.
3. NYLON 6 GRADE 1011SW SHALL COMPLY TO FIRE STANDARD EN45545 HL3

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
					MATERIAL	
5	2	RFW09 20616	SPRING WASHER	B6 TO IS:3063-94/ MATL: AISI-304		
4	2	RFN38 60652	HEX. HEAD NUT	HEX HEAD NUT M6 TO IS: 1364 (PART-3)-2002, / MATL. : ISO:3506-79,Gr-A2-70,STAINLESS STEEL		
3	2	RFB38 50645	HEX. FLANGE BOLT FULL THREAD	M6x45 TO ISO 4162-90,Gr-A2-70, STAINLESS STEEL, WITH PRE-APPLIED ADHESIVE.		
2	1		PLATE	SUS304		
1	1SET		CLEAT	SEE NOTE 3		

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

PRODUCT: MUMBAI METRO CARS L2 & L7

REF DRG:

MATERIAL:

HEAT TREAT.:

SURFACE TREAT.:

APPD	MS	31.01.2020
REVD	MS	31.01.2020
CHKD	SK	31.01.2020
DRWN	MR	31.01.2020

TITLE: CLEAT(D18)

SCALE | SHEET: 1 OF 1 | Wt.(Kg): –

BEML LIMITED

DRG No.: 525-60080

ALT: 0

A3