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

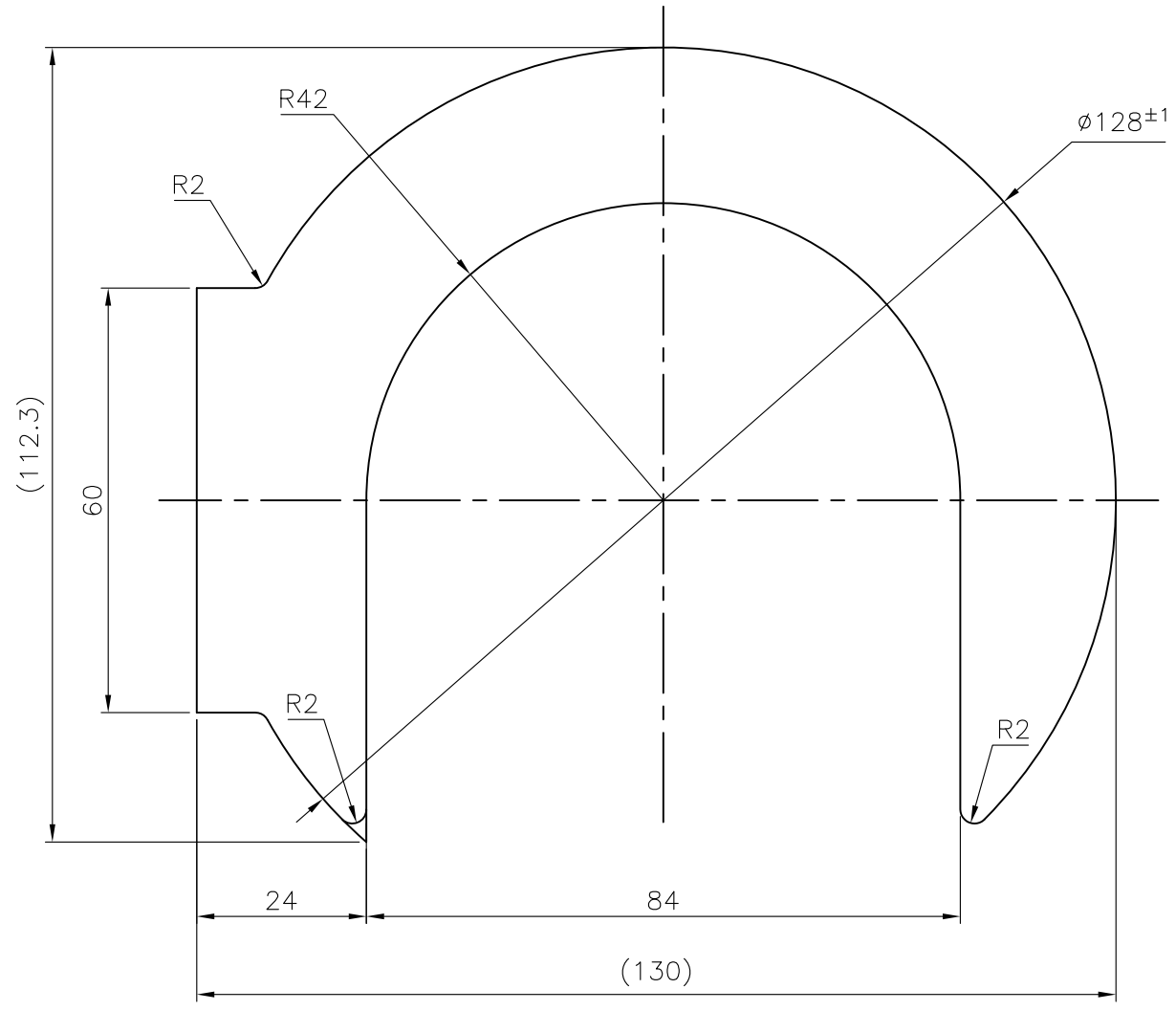
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD–227

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



NOTE

1. PART SHALL BE ZINC PLATED AS PER SERVICE GRADE No. 2 OF IS: 1573-86 AND CHROMATE PASSIVATED TO COLOUR IRIDESCENT YELLOW

SL No.	QTY	DRG. / STOCK No.	DESCRIPTION	SIZE	COMPANY.STD/IS.STD	Wt.Kg
		DETAIL PARTS		MATERIAL		
4	2	909-81120-04	LINER ADJUSTING	130x112.5x4	IS: 513-94, Gr.-O TO STOCK NO.C100603400	0.19
3	2	909-81120-03	LINER ADJUSTING	130x112.5x3.15	IS: 513-94, Gr.-O TO STOCK NO. C100603315	0.14
2	2	909-81120-02	LINER ADJUSTING	130x112.5x1.6	IS: 513-94, Gr.-O TO STOCK NO. C100603160	0.07
1	2	909-81120-01	LINER ADJUSTING	130x112.5x1	IS: 513-94, Gr.-O TO STOCK NO. C100603100	0.04

UN CONTROLLED COPY

ALT	CHANGES / ECN No.	DATE	BY	CKD	APP
1	NEXT ASSY QTY. 1 WAS 2	12.4.11	ILYAS	KSRR	JP

PRODUCT: METRO BOGIE

SURFACE TREATMENT

APPROVED	JAYAPRAKASH	18.04.08
CHECKED	SIVARAMI REDDY	18.04.08
DRAWN	ILYAS	4.1.08
REF DRG		

QTY	NEXT ASSY	MODEL
1	909-81001	909

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

BEML LIMITED
R&D, BANGALORE COMPLEX
BANGALORE 560 075

TITLE: LINER ADJUSTING

DRG No. 909-81120

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	