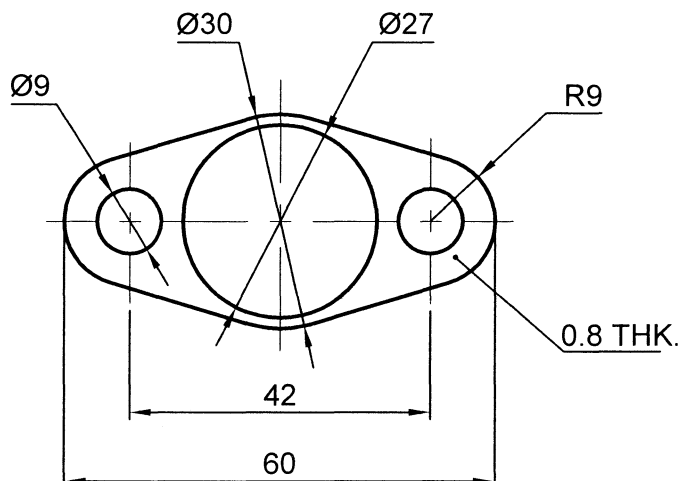


MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0-6	6-30	30-120	120-315	315-1000	1000-2000	2000-4000	ABOVE 4000
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227									
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM)									
VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS.1012.C.						PROTO/PILOT /PRODUCTION			
QUALITY OF WELD JOINTS REF. ISO: 5817									



NOTE

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

UN CONTROLLED COPY

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
GRADE No.	
VALUE	
SYMBOL	
SURFACE ROUGHNESS	

1	1	C100603080		60x30x0.8 THK.	IS: 513-94, Gr.-O	
SL.No.	QTY	DRG. / STOCK No.	DESCRIPTION	SIZE	COMPANY STD/IS STD	Wt.Kg.
DETAIL PARTS			MATERIAL			
PRODUCT			METRO BOGIE			
SURFACE TREATMENT						
1	909-81009	909	SCALE	Wt.(Kg)		
1	909-81008	909	1:1	0.005		
QTY	NEXT ASSY	MODEL	REF DRG			
TITLE			APPROVED	21.6.11		
SPACER			CHECKED	21.6.11		
			DRAWN	20.06.11		
			DRG No.	ALT		
			909-81153			
			BEML LIMITED R&D, BANGALORE COMPLEX BANGALORE 560 075			
ALT	CHANGES	DATE BY CKD APP				