

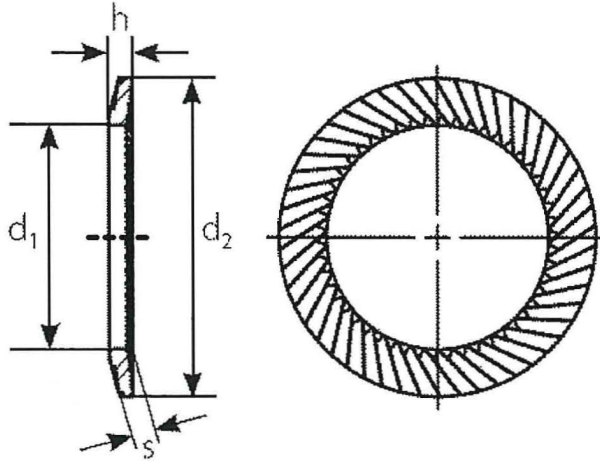
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MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 – 6	6 – 30	30 – 120	120 – 315	315-1000	1000-2000	2000-4000	ABOVE 4000	RA
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	~
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER 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.							STATUS:	MOCKUP/PROTO/PRODUCTION		
WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96										



NOTE:

PART IS AS PER DIN 6796

UN CONTROLLED COPY

N1	0.025	3	M20	21.0	30.0	1.9	2.1	2.8	VS	BLACKENED / (Zn8M + PASSIVATION)		
N2	0.05	2	M12	13.0	18.0	1.4	1.55	2.1	VS	BLACKENED / (Zn8M + PASSIVATION)		
N3	0.1	1	M10	10.5	16	1.4	1.5	2.0	VS	BLACKENED / (Zn8M + PASSIVATION)		
N4	0.2	Sl.No.	NOMINAL SIZE	d1 (mm)	d2 (mm)	s (mm)	h _{min} (mm)	h _{max} (mm)	TYPE	REMARKS		
N5	0.4											
N6	0.8											
N7	1.6	SL.No.	QTY	PART / STOCK No.		DESCRIPTION			SIZE (mm)	COMPANY STD./I.S	Wt. (Kg)	
N8	3.2									MATERIAL		
N9	6.3					PRODUCT	BMRCL METRO CARS					
N10	12.5					REF DRG						
N11	25					MATERIAL						
N12	50					HEAT TREAT.	APPD MS			21.08.19		
GRADE No.	VALUE					SURFACE TREAT.	REVD DB			19.08.19		
SYMBOL						TITLE	CHKD JC			17.08.19		
						SCHNORR WASHER	DRWN ILYAS					
							SCALE			SHEET	Wt.(kg)	
SURFACE ROUGHNESS		ALT.NO.	ECN NO/CHANGES		DATE	BY	CHKD	APPD	NTS		1 OF 1	-
BEML LIMITED										926-82118		ALT