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: PROTO/PRODUCTION

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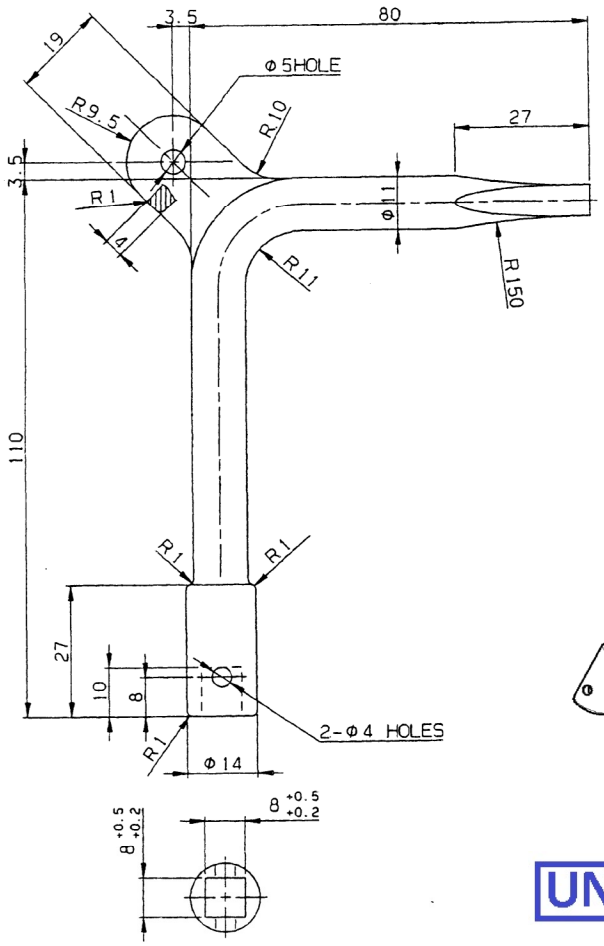

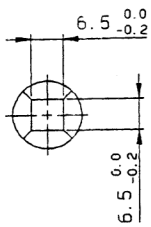

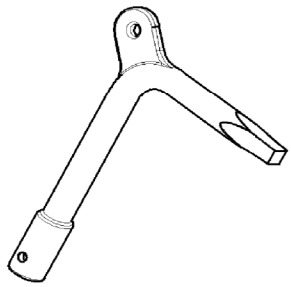

ISOMETRIC VIEW

UNCONTROLLED

NOTE
1. THE SURFACE SHOULD BE BUFF-FINISHED.
2. SAMPLE APPROVAL SHALL BE OBTAINED BEFORE MASS PRODUCTION.
3. THE SQUARE KEY SHALL CONFORM TO TDC DOC NO. GR/TD/5111.

AUSTENITIC STAINLESS STEEL AISI304/SUS304

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
					MATERIAL	

PRODUCT	METRO CARS				
REF DRG					
MATERIAL					
HEAT TREAT.		APPD			
SURFACE TREAT.		REVD		9/12/15	
TITLE	SQUARE KEY	CHKD		7-12-15	
		DRWN	VISHWA	26/11/2015	
		SCALE	NTS	SHEET 1 OF	Wt.(Kg) -
		DRG No.	909-19636		ALT 1

ALT.NO.	ECN NO/CHANGES	DATE	BY	CHKD	APPD
1	ECN NO. 90900717 NOTE 3 ADDED	14.05.2020	VISHWA		

BEML LIMITED

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

SURFACE ROUGHNESS

A4