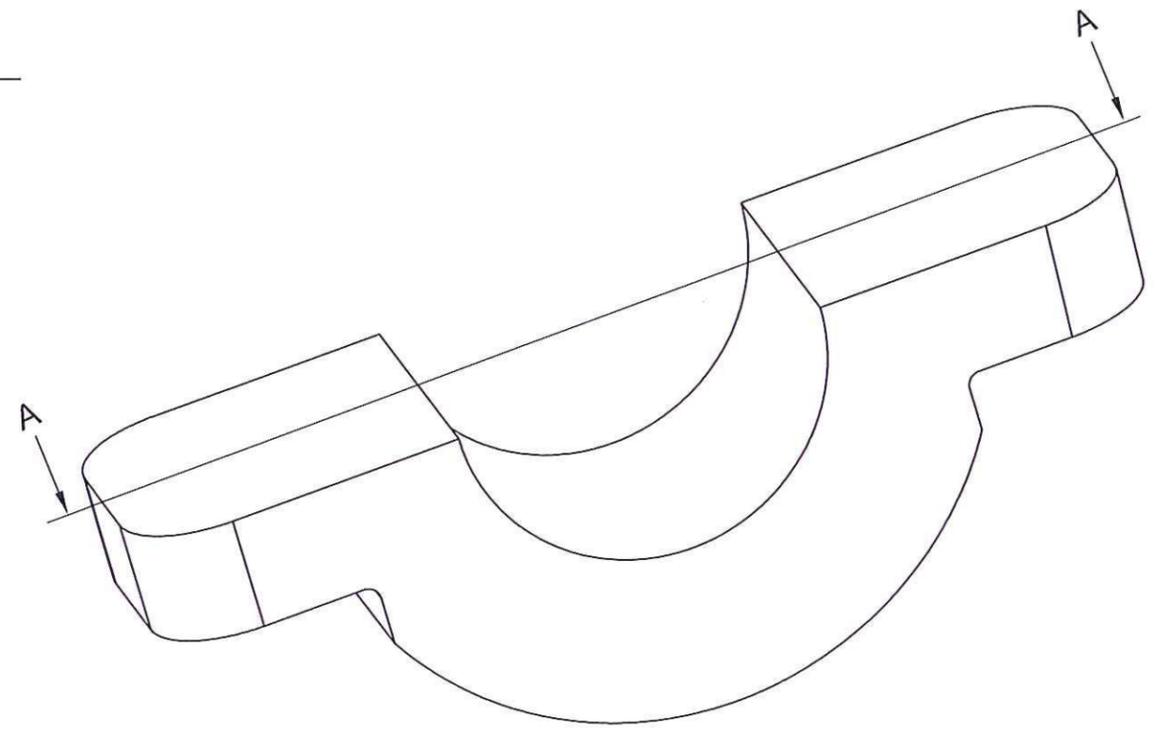
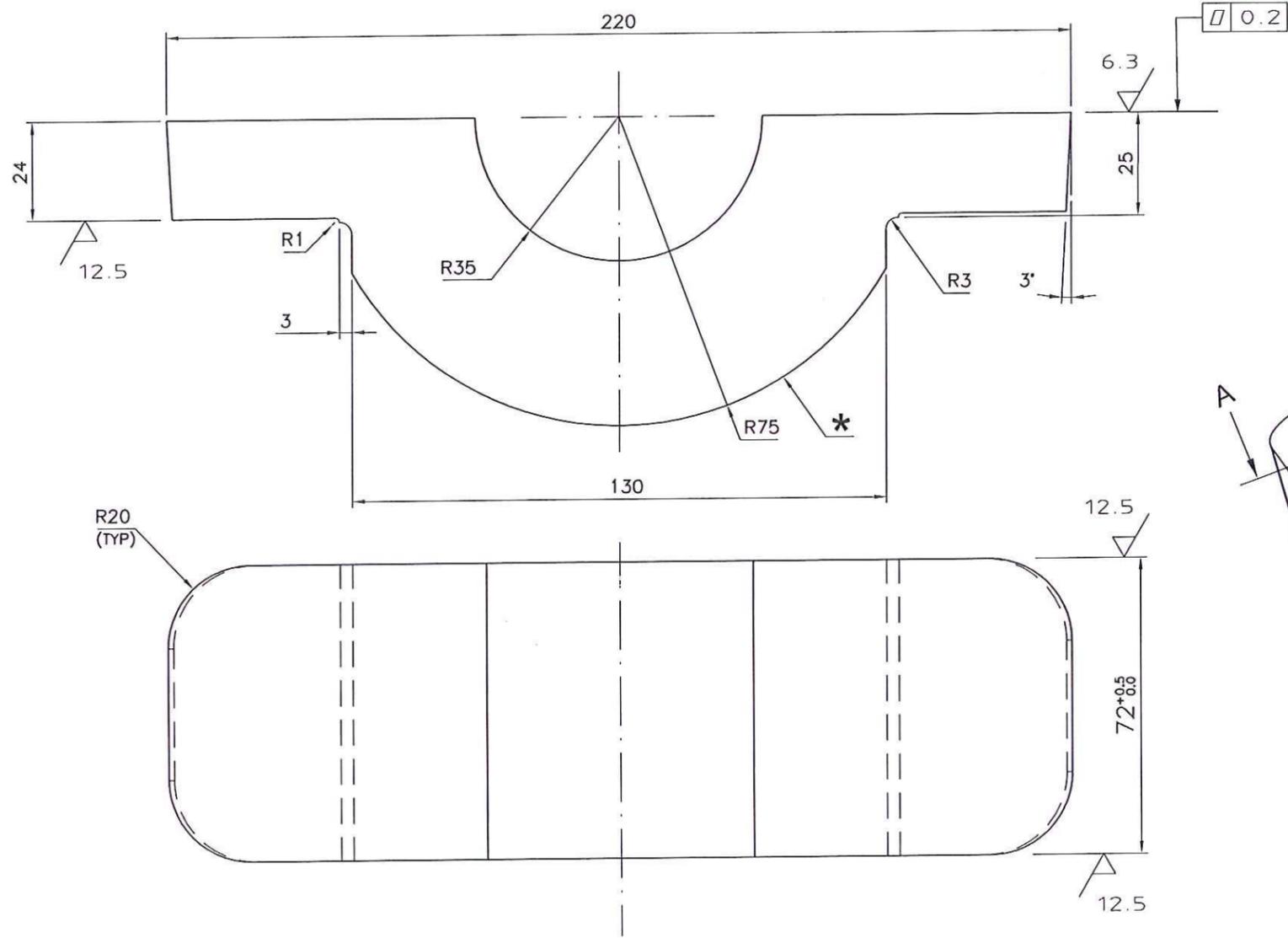


MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	TOLERANCE							
		0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000
		±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227									
UNSPECIFIED TOLERANCE FOR 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. RD-230 MEDIUM									



RADIOGRAPHY TEST HAS TO BE DONE AT SECTION A-A

**UN CONTROLLED COPY**

**1** NOTES:-

- CONSIDER R4 FOR UNSPECIFIED RADIUS ON CASTING.
- FURTHER MACHINING SHALL BE CARRIED OUT AFTER ASSEMBLY WITH PART NO. 909-82105 (ANTI-ROLL BRACKET-TOP).
- DEVIATIONS ON UNTOLERANCED CAST DIMENSIONS SHALL BE TO IS:4897-1994, CLASS-2.
- \*4. EMBOSS IN 10mm HIGH, 1.5mm RAISED LETTERS PART NO., VENDOR CODE, MONTH & YEAR OF MFG., HEAT NO. & SL.NO. ON THE CASTING AS INDICATED IN THE DWG.
- RADIOGRAPHIC EXAMINATIONS:- THE ANTI-ROLL BRACKET (BOTTOM) SHALL BE SUBJECTED TO RADIOGRAPHIC EXAMINATION FOR 100% OF THE CASTING. THE ACCEPTABLE RADIOGRAPHY STANDARD SHALL BE AS PER ASTM-E-446/186 LEVEL II
- THE X-RAY RADIATION BEAM SHALL BE FOCUSED ON THE CASTING IN THE DIRECTION AS SHOWN IN THE DWG.
- FAI: ONE NO. OF FINISH MACHINED SAMPLE ASSY. OF ANTI-ROLL BRACKET (BOTTOM) & ANTI-ROLL BRACKET (TOP) TO DWG.NO. 909-82017 (DOUBLE BEARING ASSY.) SHALL BE SUPPLIED FREE ALONG WITH ALL MECHANICAL & CHEMICAL TEST REPORTS AND DIMENSIONS CHECKSHEETS FOR APPROVAL BY BEML BEFORE BULK PRODUCTION.
- \*8. THE CASTINGS SHALL STRICTLY CONFORM TO BEML PTS DOC.NO. GR/TD/1477 (REFER LATEST REVISION).

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

SL No.	QTY	DRG. / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./S.STD	Wt.Kg
1					AAR-M-201 Gr. 'C'	
METRO BOGIE						
SURFACE TREATMENT						
APPROVED JP 5.1.08						
CHECKED GSK 5.1.08						
DRAWN ILYAS 4.1.08						
REF DRG 1207						
SCALE 1207						
SHEET OF 3.5						
ALT CHANGES / ECN No. DATE BY CKD APP						
BEML LIMITED R&D, BANGALORE COMPLEX BANGALORE 560 075						
TITLE ANTI ROLL BRACKET (BOTTOM)						
DRG No. 909-82106						