| 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 |

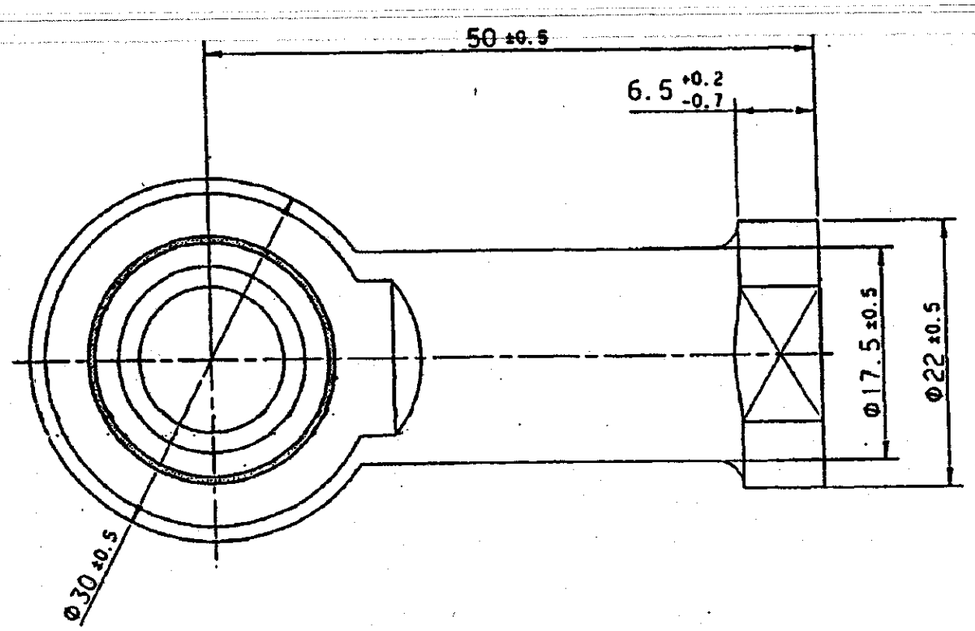
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

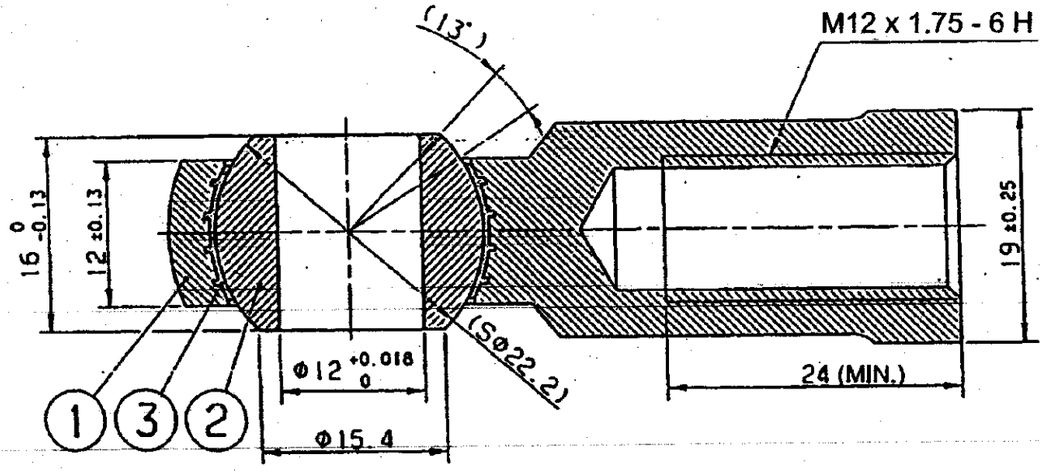
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM)

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. SURFACE FINISH : BALL SPH. O.D 0.2 µ Ra.
   : BALL I.D. AND ENDS 0.8 µ Ra.
   : ALL OTHER MACHINE SURFACES 3.2 µ Ra.
   : FORGING SURFACE ∇
2. DIMENSIONS ARE IN METRIC. ALL DIMENSIONS SHALL BE MET AFTER PLATING.
3. NO BURRS, NICKS, RUST ARE ALLOWED
4. PACKAGE : BEARING SHALL BE SHIPPED COATED WITH LUBE OIL AND PACKAGED IN SEALED POLY BAGS WITH PROPER PACKING TO AVOID TRANSIT DAMAGES.
5. LOAD CAPACITY : DYNAMIC LOAD : 6.52 kN
   : RADIAL STATIC LIMIT LOAD : 18.14 kN
7. NO LOAD ROTATIONAL BREAKAWAY TORQUE : 0.12 N.m MAX
8. CLEARANCE : R / P 0.05 mm MAX.
9. APPROX WEIGHT : 120 g

PART No. : RBM12 OF M/s MINEBEA Co. LTD. / PTF 12 OF M/s BUMPER INDIA

**UN CONTROLLED COPY**

| SL No. | QTY | DRG. / STOCK No. / DETAIL PARTS | DESCRIPTION | SIZE / MATERIAL | COMPANY.STD/IS.STD | Wt.Kg |
|---|---|---|---|---|---|---|
| 3 | 1 | | HOLD LINER | MINELON / PTF | | |
| 2 | 1 | | BALL | BEARING STEEL-EN31 WITH HARD CHROME PLATING 5µ MIN, HRC-56 MIN. | | |
| 1 | 1 | | BODY | STEEL-EN8, WITH Zn PLATING 12.5 µ MIN. | | |

| ALT | CHANGES / ECN No. | DATE | BY | CKD | APP |
|---|---|---|---|---|---|
| 1 | NOTE REVISED ECN No. 90900348 Dt. 4.12.12 | 4.12.12 | ILYAS | KSRR | |

| QTY | NEXT ASSY | MODEL |
|---|---|---|
| 2 | 909-84020 | 909 |

PRODUCT: METRO BOGIE

SURFACE TREATMENT

| | | |
|---|---|---|
| APPROVED | JP | 30.4.08 |
| CHECKED | KSRR | 30.4.08 |
| DRAWN | ILYAS | 4.1.08 |
| REF DRG | | |

SCALE 1:2.5 | SHEET OF | Wt (Kg) 2.3 | ALT 1

BEML LIMITED
R&D, BANGALORE COMPLEX
BANGALORE 560 075

TITLE: ROD END BEARING

DRG No. 909-84111

| 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 | ~ |