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: ~~MOCKUP/PROTO~~/PRODUCTION

11

2-⌀4 THRU HOLES

M 36

73 △2

85 △2
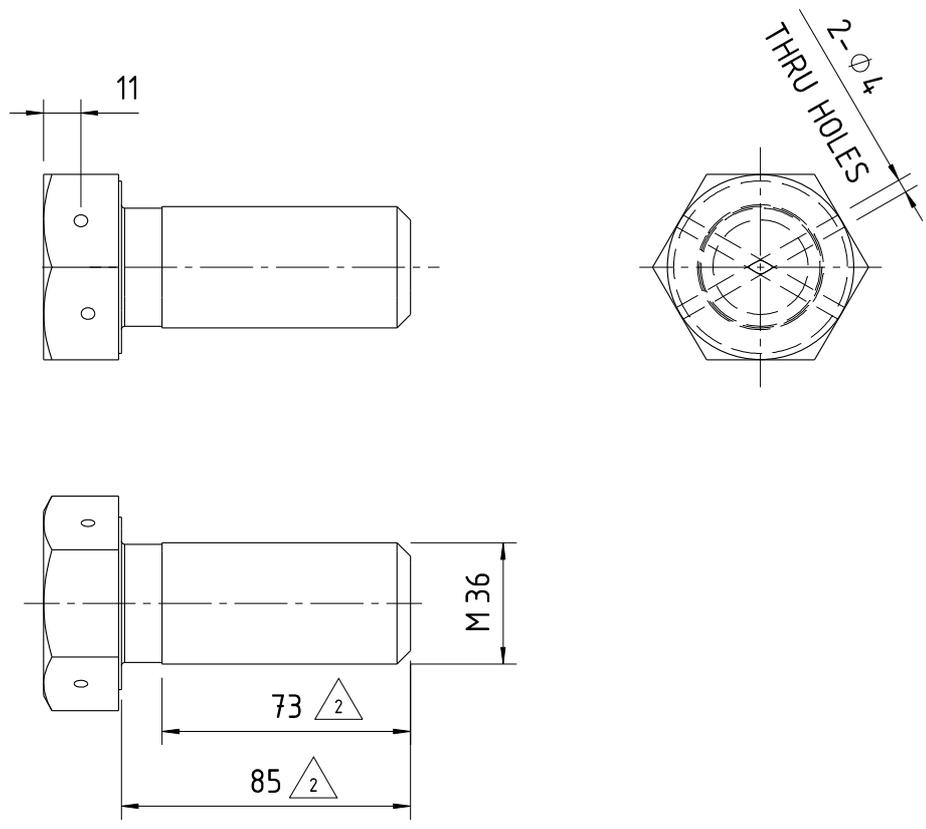
UN CONTROLLED COPY

NOTE:-
    THE PART SHALL BE MADE TO SPEC IS:1364(PART 2)-02, PC-10.9 GEOMET COATING
    TO SPEC. ASTM F1136 Gr.6 WITH BLACK TOP COAT

M36x85L △2

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

PRODUCT: **BMRCL METRO CARS**

REF DRG

MATERIAL: SAE J404/AISI 4140

HEAT TREAT.		APPD	MS	21.08.2019
SURFACE TREAT.		REVD	DB	19.08.2019
TITLE		CHKD	JC	17.08.2019

TITLE: **SCREW, HEX, PIN HOLE IN HEAD**

DRWN ILYAS

SCALE	1:2	SHEET 1 OF 1	Wt.(kg) 1.2

DRG No. **926-82114**   ALT △2

GRADE No.	VALUE	SYMBOL			DATE	BY	CHKD	APPD
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	~	△2	LENGTH 90 WAS 85 ECN : 92610293	06.11.2020	JC		
			△1	MATERIAL DETAILS UPDATED, REVISED & REDRAWN ECN : 92610281	19.09.2020	ILYAS	DB	MS

SURFACE ROUGHNESS

ALT.NO. | ECN NO/CHANGES

beml BEML LIMITED
NEW FRONTIERS. NEW DREAMS.

A4