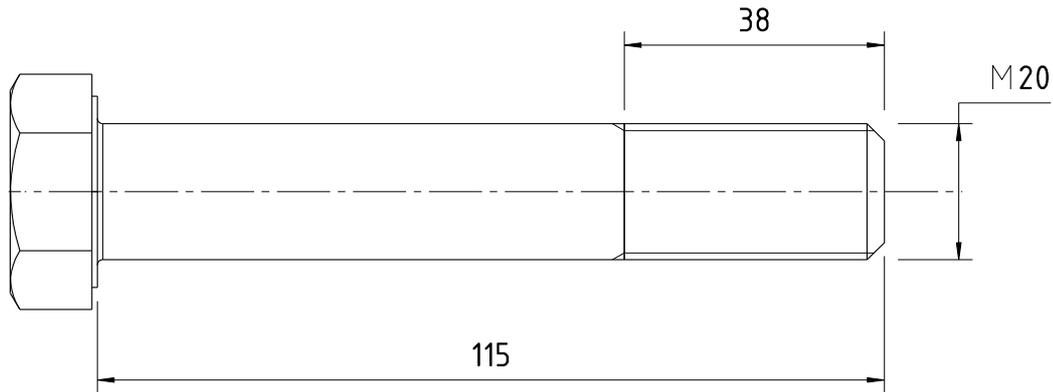


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MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000	RA
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	~
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER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



UN CONTROLLED COPY

NOTE:- 2

THE PART SHALL BE MADE TO SPEC IS:1364(PART 1)-02, PC-10.9 GEOMET COATING TO SPEC. ASTM F1136 Gr.6 WITH BLACK TOP COAT

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

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE (mm)	M20x115L	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	
BOLT, HEX HEAD				DRWN	ILYAS		
				SCALE	1:1	SHEET	1 OF 1
DRG No.				926-83240			ALT
BEML LIMITED				NEW FRONTIERS. NEW DREAMS			2
ALT.NO.	ECN NO/CHANGES		DATE	BY	CHKD	APPD	
			15.09.2020	ILYAS	DB	MS	