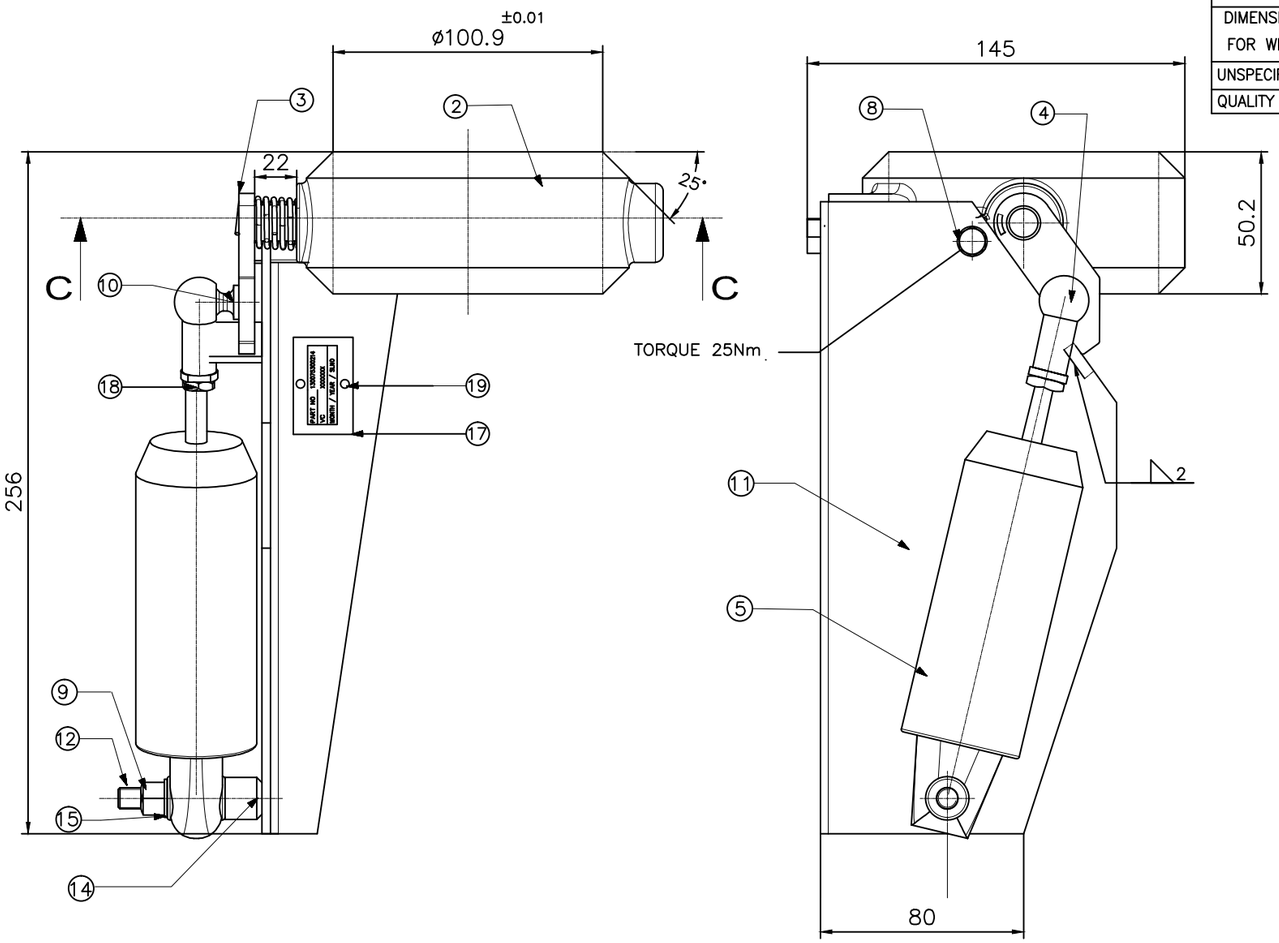
MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 – 6	6 – 30	30 – 120	120 – 315	315–1000	1000–2000	2000–4000	ABOVE 4000
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3
DIMENSIONAL TOLERANCE FOR WELDED STUCTURES	RANGE	0–30	30–120	120–315	315–1000	1000–2000	2000–4000	4000–8000	8000–12000	ABOVE 12000
	TOLERANCE	±1	±2	±2	±3	±4	±6	±8	±10	±12

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

QUALITY OF WELD JOINTS REF, ISO:5817 CLASS-C, FOR SPOT WELDING JIS Z-3140

PROTO ~~/ PILOT / PRODUCTION~~

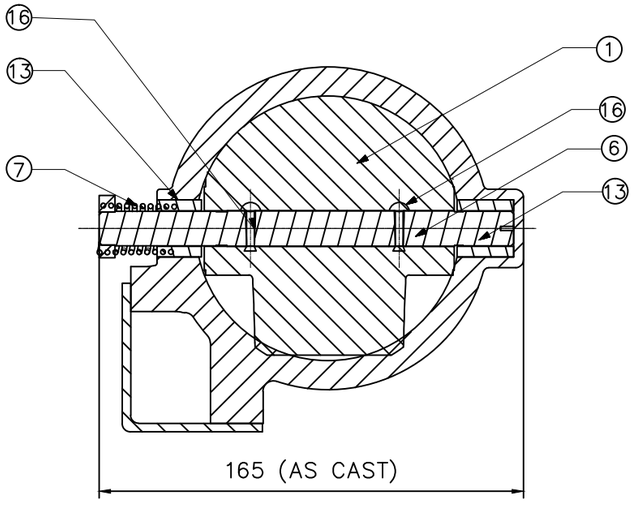


TECHNICAL DATA	
AMBIENT TEMP	–40 to +80°c
AIR CYLINDER STROKE LENGTH	40 MM
OPERATING PRESSURE	8 BAR

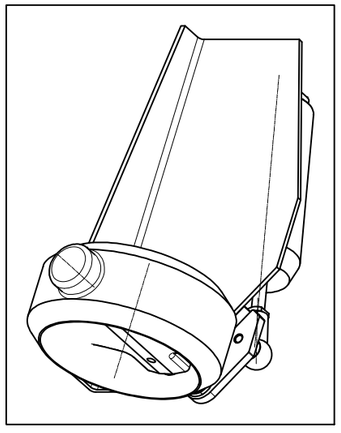
NOTE: –

1. SURFACE PROTECTION FOR ITEMS 2 (OUTER SURFACE ONLY), 3 ,6, 10, 11, 14(PROJECTED AREA) WITH ALUMINIUM HEAT RESISTANT PAINT Gr 1, IS: 13183–91, 30 MICRONS.
2. ALUMINIUM METAL SPRAY, BSEN : 22063–94, 150 MICRONS.
3. ALL DIMENSIONS ARE IN MM.

SL No.	QTY	DRG. / STOCK No.	DESCRIPTION / DETAIL PARTS	SIZE / MATERIAL	COMPANY.STD/IS.STD	Wt.Kg.
19	2	107112684000	SNAP HD RIVET 2.5X4.9 (IS: 2998–1982)Gr–1		STD	
18	1	107110205000	HEX THIN NUT M8 IS: 1364(P–2)2002–8.8		STD	
17	1	151172018003	NAME PLATE		ALUMINIUM	
16	2	107112684000	SNAP HD RIVET 5X30 (IS: 2998–1982)Gr–1		STD	
15	3	107110601000	WASHER MACHINED 8.4, IS: 2016–67 STEEL		STD	
14	1	151171015003	THREADED BUSH		EN8 (BS: 970–1955)	
13	2	151171014003	BUSH		EN8 (BS: 970–1955)	
12	1	151171013003	STUD M8x1.25		EN8 (BS: 970–1955)	
11	1	151171012003	PLATE		Gr–O (IS: 1079–94)	
10	1	151171011003	SPIRAL PIN		EN8 (BS: 970–1955)	
9	1	151171010003	PREVAILING TORQUE TYPE HEX NUT M8X1.25–8 IS: 7002–2005		STD	
8	2	106114718000	HEX HD SCREW M8X16IS: 1364(P–2) 2002,8.8		STD	
7	1	151171008003	SPRING		SPRING STEEL (IS: 4454–1)	
6	1	151171007003	SHAFT		EN8 (BS: 970–1955)	
5	1	151170006003	AIR CYLINDER		—	
4	1	151171005003	KNOB		EN8 (BS: 970–1955)	
3	1	151171004003	PLATE		Gr–O (IS: 1079–94)	
2	1	151172003003	ENGINE BRAKE BODY		SG400/15 (IS: 1865/1991)	
1	1	151172002003	DISC		SG400/15 (IS: 1865/1991)	



SECTION C-C



ALT	CHANGES / ECN No.	DATE	BY	CKD	APP

PRODUCT: BEML – TATRA

SURFACE TREATMENT

APPROVED	RAJASEKARAN	12.06.20
CHECKED	UDAYA RAVI	12.06.20
DRAWN	UDAYA RAVI	12.06.20
REF DRG		

QTY	NEXT ASSY	MODEL	SCALE	SHEET	Wt (Kg)
			NTS	2 OF 2	3.5

BEML LIMITED
PRODUCT DESIGN
PALAKKAD COMPLEX

TITLE: ENGINE BRAKE

DRG No. 130 0 7530 021 4

ALT

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	

A2