












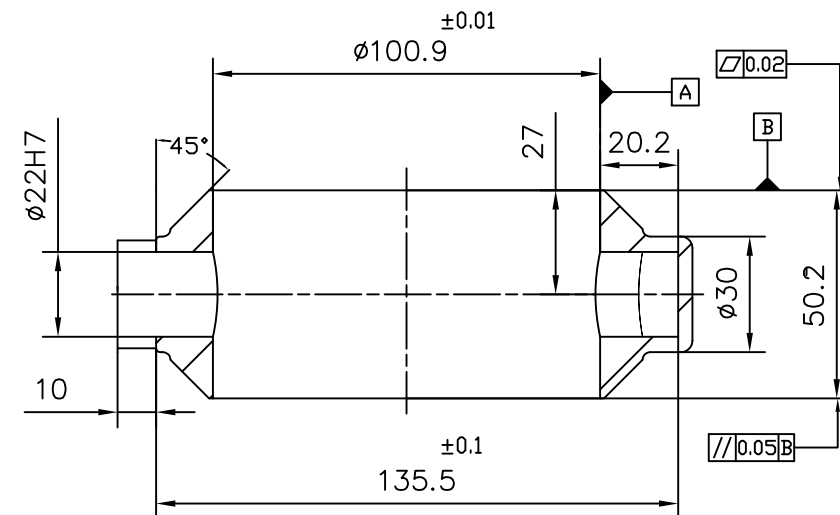
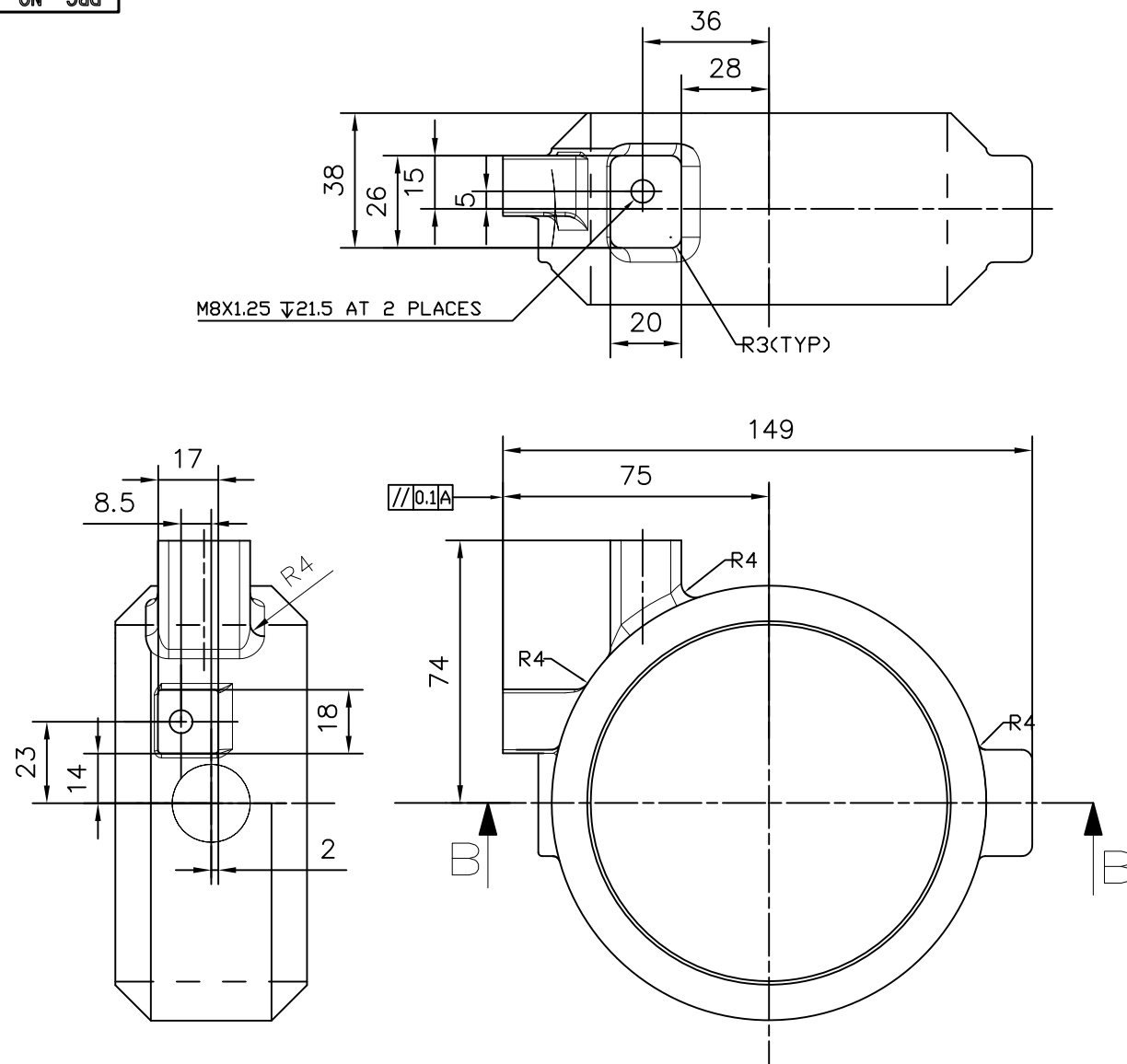


SURFACE ROUGHNESS	GRADE No.	N12	N11	N10	N9	N8	N7	N6	N5	N4	N3	N2	N1
VALUE	50	✓	25	12.5	6.3	3.2	1.6	0.8	0.4	0.2	0.1	0.05	0.025
SYMBOL													

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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
	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.						<del>PROTO / PILOT / PRODUCTION</del>			
QUALITY OF WELD JOINTS REF, ISO 5817									

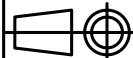



SEC B-B

MATERIAL SPECIFICATION: SG400/15 (IS:1865-1991)

NOTE :

1. Aluminium Metal Spray, BSEN: 22063-94, 150 Microns.
2. Aluminium Heat Resistant Paint, Gr-1, IS: 13183-91 30 Microns.
3. Avoid ID:  $\phi 100.90 \pm 0.01$  Area Aluminizing.
4. Dimensions specified are in mm.
5. Remove all sharp corners.

SL No.	QTY	DRG. / STOCK No.	DESCRIPTION				SIZE	COMPANY.STD/IS.STD		Wt.Kg.				
		DETAIL PARTS						MATERIAL						
							PRODUCT							
							BEML TATRA VEHICLE							
										SURFACE TREATMENT				
										—				
										APPROVED	RAJASEKARAN	26.05.20		
CHECKED	RAJASEKARAN	26.05.20												
							DRAWN	UDAYA RAVI	26.05.20					
							REF DRG	—						
							01	151170001002	TATRA	SCALE 1:5		SHEET OF	Wt (Kg) 1.564	
ALT	CHANGES / ECN No.		DATE	BY	CKD	APP	QTY	NEXT ASSY		MODEL	DRG No.		ALT	
 BEML LIMITED R&D, DEFENCE PALAKKAD							TITLE ENGINE BRAKE BODY					151172003003		