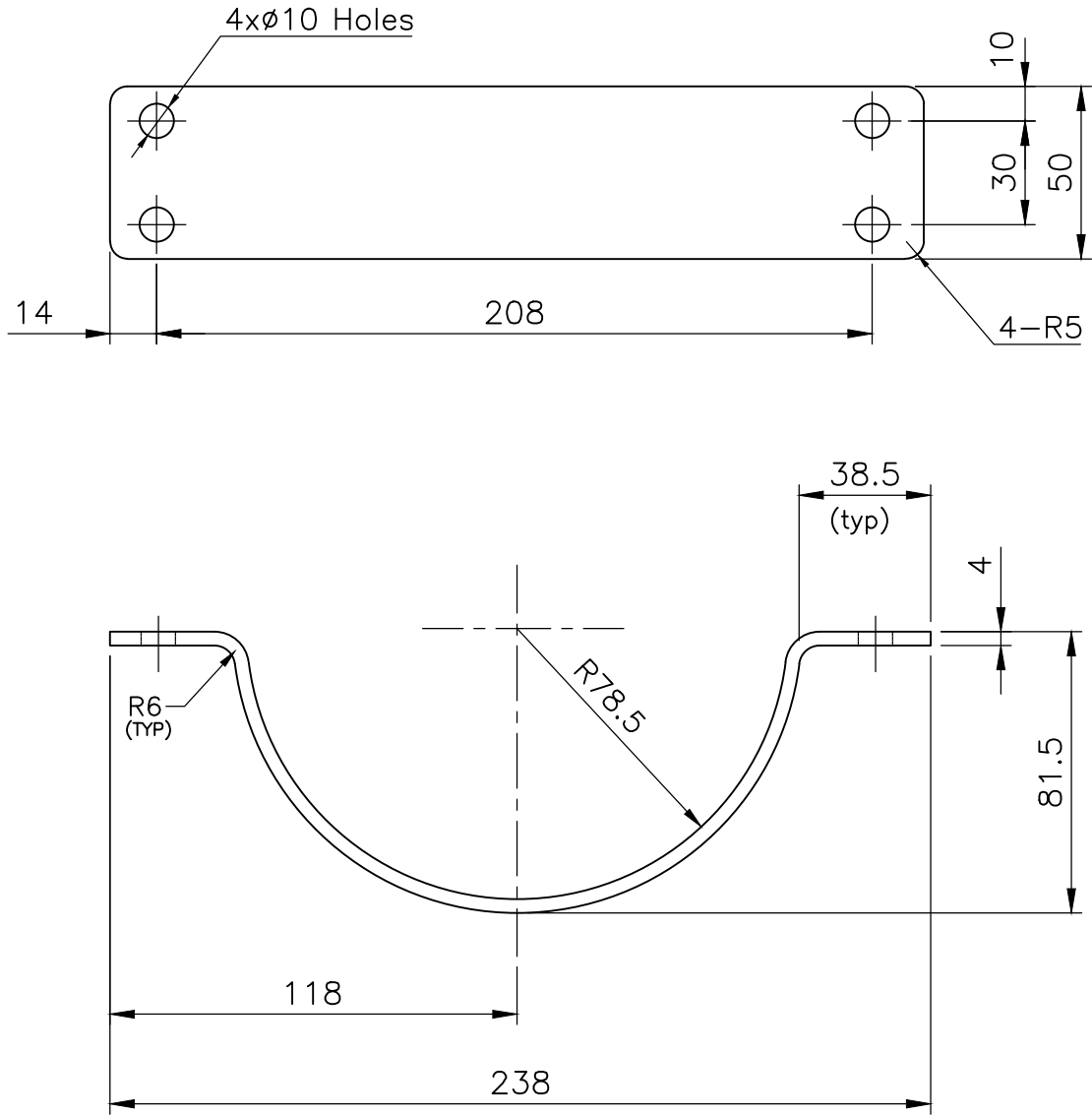


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GRADE No.	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12
VALUE	0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50
SYMBOL												
SURFACE ROUGHNESS												

NOTE: REMOVE ALL SHARP EDGES & DEBURR.



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.						STATUS:				
WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96										

UNCONTROLLED

				318X50X4t		AISI304	
SL.No.	QTY	PART / STOCK No.		DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
				MATERIAL			
				PRODUCT	MUMBAI METRO CARS L2&L7		
				REF DRG			
				MATERIAL			
				HEAT TREAT.	APPD	VS	
				SURFACE TREAT.	REVD	SNH	
				TITLE	CHKD	SNH	
				CLAMP T4		DRWN	VISHNU
						SCALE	26.06.2020
						SHEET	Wt.(Kg)
						OF	0
						DRG No.	ALT
ALT.NO.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	BEML LIMITED	
						525-56251-1	