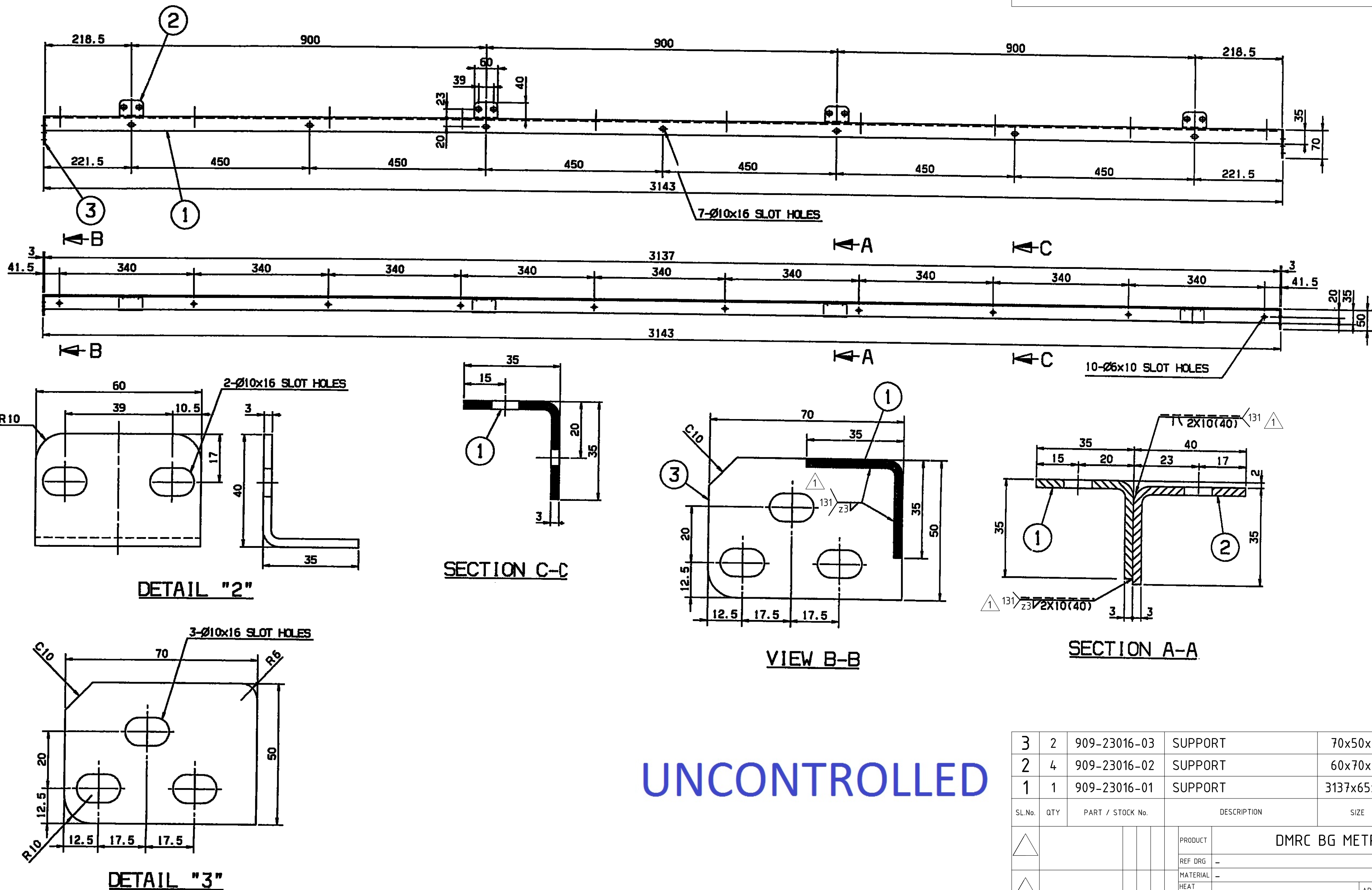


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GRADE No.	VALUE	SYMBOL
N1	0.025	
N2	0.05	
N3	0.1	
N4	0.2	
N5	0.4	
N6	0.8	
N7	1.6	
N8	3.2	
N9	6.3	
N10	12.5	
N11	25	
N12	50	

SURFACE
ROUGHNESS



NOTE:

1. WELDING SYMBOLS ACCORDING TO ISO 2553.
2. REMOVE ALL SHARP EDGES AND BURRS.
3. ALL WELD AREAS SHALL BE PICKLED AND PASSIVATED.

3			2					1			
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:	PRODUCTION			
WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96											

3	2	909-23016-03	SUPPORT	70x50x3THK	SUS 304	
2	4	909-23016-02	SUPPORT	60x70x3THK	SUS 304	
1	1	909-23016-01	SUPPORT	3137x65x3THK	SUS 304	
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
					MATERIAL	
			PRODUCT	DMRC BG METRO CARS		
			REF DRG	-		
			MATERIAL	-		
			HEAT TREAT.	-		
			SURFACE TREAT.	-		
			TITLE	SUPPORT (7 SEAT)		
			APPD	PV GAYATHRI	14/09/2015	
			REVD	KRISHNA PRASAD	12/09/2015	
			CHKD	KRISHNA PRASAD	12/09/2015	
			DRWN	PURUSHOTHAMAN	10/08/2015	
			SCALE	1 OF 1	SHEET	Wt.(Kg)
			NTS	1 OF 1		-
			DRG No.	909-23016		
			ALT	1		



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