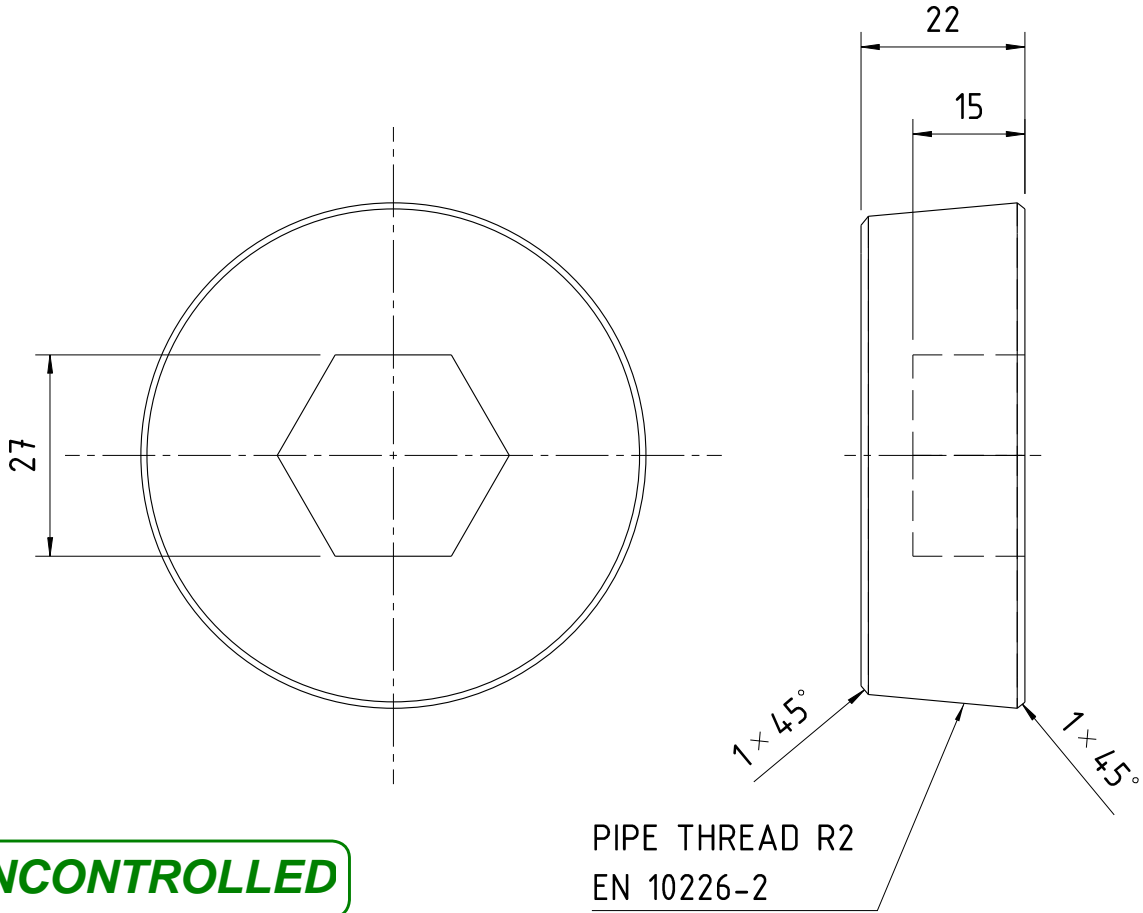


MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 – 6	6 – 30	30 – 120	120 – 315	315-1000	1000-2000	2000-4000	ABOVE 4000	RA
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	~
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227										
UNSPECIFIED TOLERANCE FOR LINEAR 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:	PROTO			
WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96										

PRELIMINARY DRAWING



UNCONTROLLED

NOTE:

- PART SHALL BE ZINC PLATED AS PER SERVICE GRADE NO. 2 OF IS 1573-86 AND CHROMATE PASSIVATED TO COLOR IRIDESCENT YELLOW
- REMOVE ALL SHARP EDGES AND BURRS

N6	N7	N8	N9	N10	N11	N12	GRADE No.	VALUE	SYMBOL	SURFACE	ROUGHNESS	ALT.NO.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	PRODUCT		MUMBAI METRO CARS L2 & L7		REF DRG	MATERIAL		20C8 AS PER IS 1570 (PART2/SEC1)		HEAT TREAT.	APPD	MS		SURFACE TREAT.		REVD	RSS		CHKD	VSE		DRWN	AKSHAY		SCALE			SHEET	1 OF 1		Wt.	0.5kg		DRG No.	525-81126		ALT																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
0.8	1.6	3.2	6.3	12.5	25	50												DESCRIPTION		SIZE		COMPANY STD./I.S		Wt. (Kg)																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																															