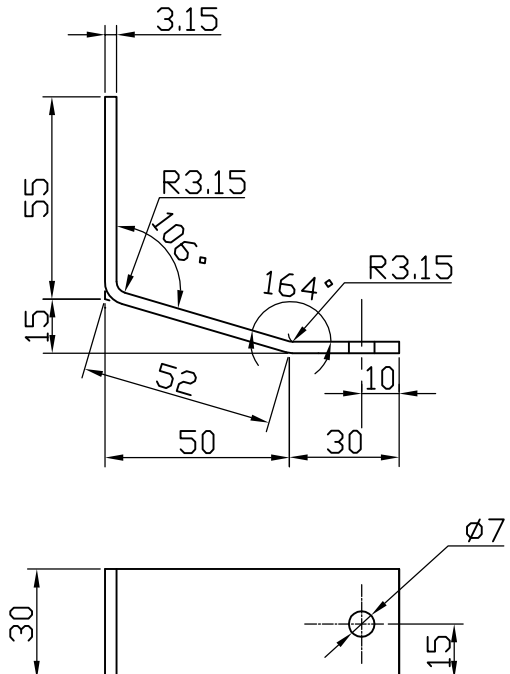


MACHINING DEVIATIONS FOR LINEAR DIMENSIONS		RANGE	0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000	RA																
		TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	~																
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227																											
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																											
																											
GRADE No.		N1		N2		N3		N4		N5		N6		N7		N8		N9		N10		N11		N12		SURFACE ROUGHNESS	
VALUE		0.025		0.05		0.1		0.2		0.4		0.8		1.6		3.2		6.3		12.5		25		50		ALT. NO.	
SYMBOL																										ECN NO/CHANGES	
																										DATE	
																										BY	
																										CHKD	
																										APPD	
																										BEML LIMITED	
																										849-56150	
																										ALT	
																										A4	