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												

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)
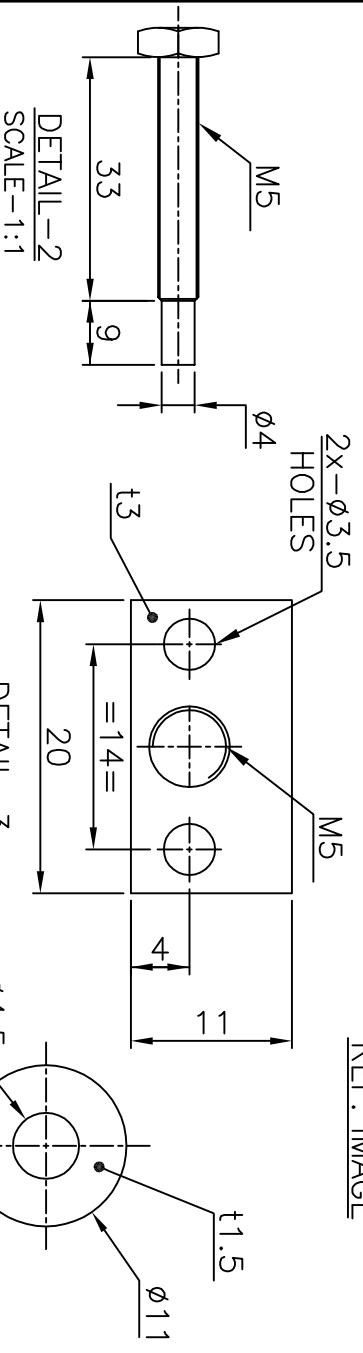VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS. 1012.C.
WELDING SHALL BE CARRIED OUT AS PER IS- 9595-96

QUALITY OF WELD JOINTS REF, RD 230 MEDIUM   RA
STATUS:
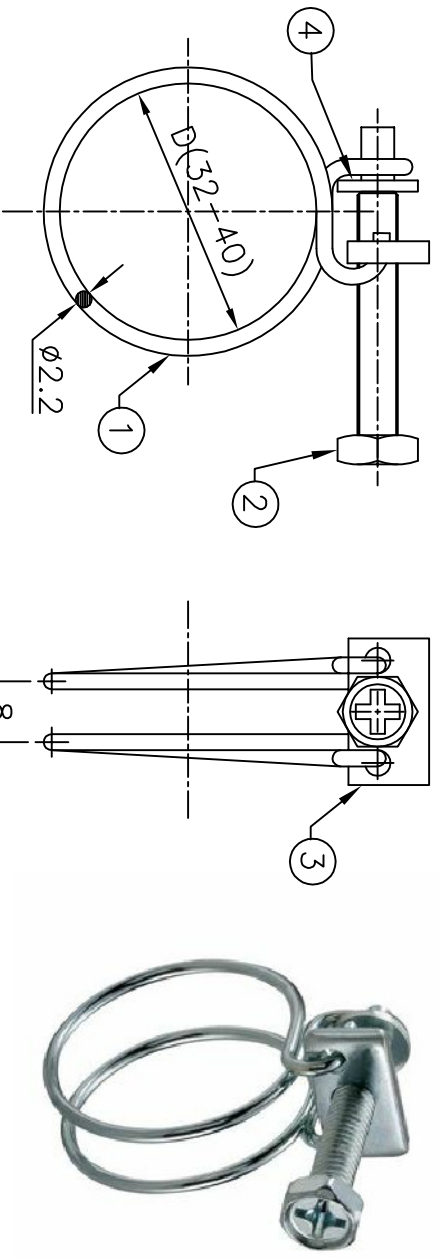
NOTE:
1. REMOVE ALL SHARP EDGES & BURRS.
2. ITEM SHALL COMPLY TO TDC DOC NO.5113

DETAIL-2 SCALE-1:1
M5   33   9   ∅4

D(32-40)   ∅2.2

2x-∅3.5 HOLES
DETAIL-3 SCALE-2:1
t3   20   =14=   M5   4   11

DETAIL-4 SCALE-2:1
∅4.5   t1.5   ∅11

8

REF. IMAGE

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	MATERIAL
4	1	–	WASHER	t1.5	SUS304/AISI304
3	1	–	NUT PLATE	t3	SUS304/AISI304
2	1	–	CRS RESS'D HEX HD BOLT	M5	SUS304/AISI304
1	1	–	CLAMP WIRE	∅2.2	SUS304/AISI304

PRODUCT: MUMBAI METRO CAR L2 & L7
TITLE: DOUBLE WIRE HOSE CLAMP
BEML LIMITED

APPD	PVG	20.01.2020
REVD	DINESH	20.01.2020
CHKD	DINESH	20.01.2020
DRWN	LOHITH	20.01.2020

SCALE 1:1   SHEET 1 OF 1   Wt.(Kg)
DRG No. 525-22163   ALT –

A4