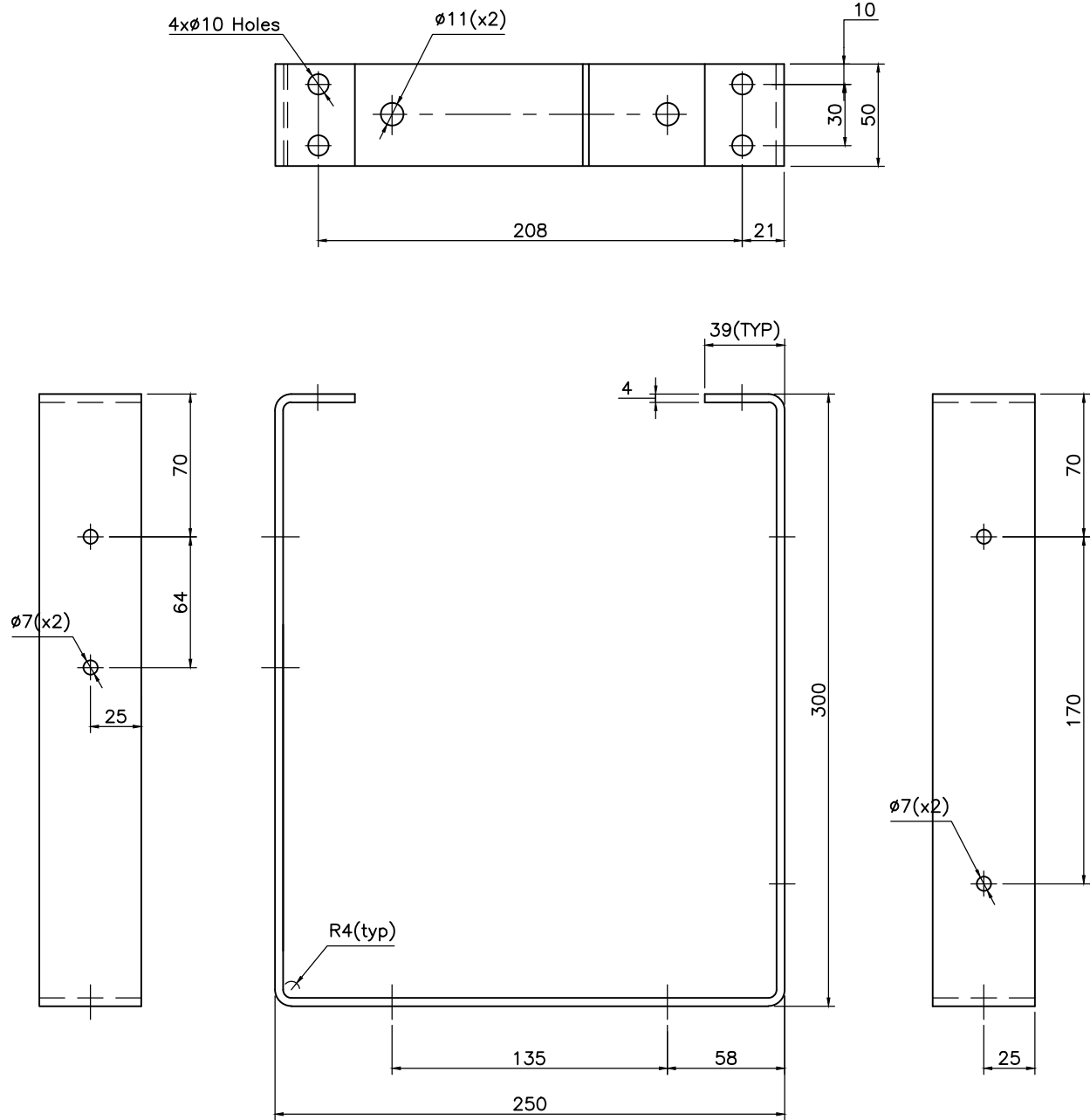


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GRADE No.	VALUE	SYMBOL
N1	0.025	
N2	0.05	
N3	0.1	
N4	0.2	
N5	0.4	
N6	0.8	
N7	1.6	
N8	3.2	
N9	6.3	
N10	12.5	
N11	25	
N12	50	

ALT.NO.	ECN NO/CHANGES	DATE	BY	CHKD	APPD

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

						902X50X4t		AISI304	
SL.No.		QTY		PART / STOCK No.		DESCRIPTION		SIZE	
								COMPANY STD./I.S	
								MATERIAL	
						PRODUCT		MUMBAI METRO CARS L2&L7	
						REF DRG			
						MATERIAL			
						HEAT TREAT.		APPD VS	
						SURFACE TREAT.		REVD SNH	
						TITLE		CHKD SNH	
						BRACKET-COUPLER		DRWN VISHNU	
								26.06.2020	
						SCALE		SHEET OF	
								Wt.(Kg)	
								0	
						DRG No.		ALT	
						BEML LIMITED		525-56250	