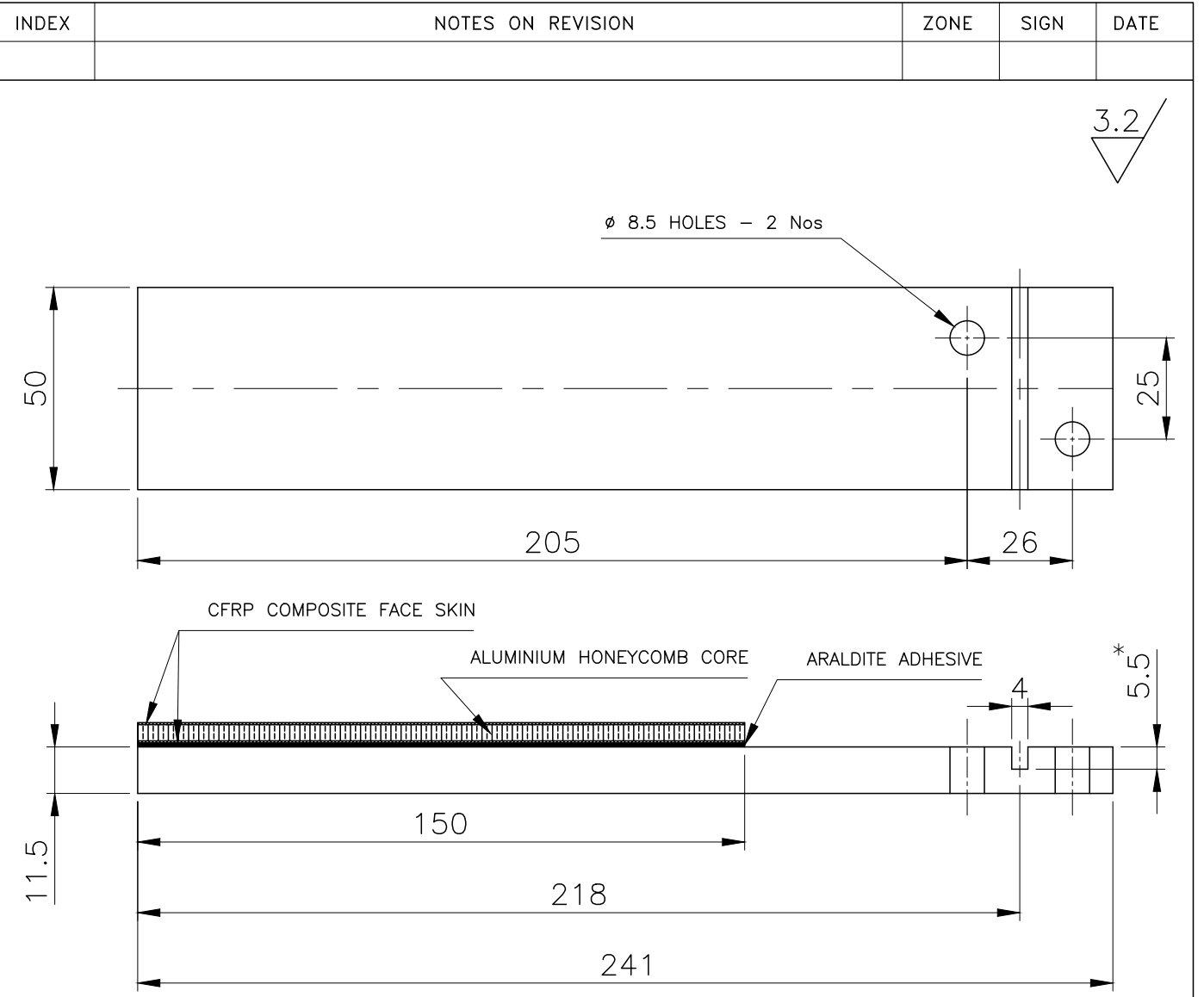


DEVIATIONS FOR NON TOLERANCED DIMENSIONS (IS: 2102 MEDIUM)

MACHINING FINISH: MICRONS

UP TO 6	6-30	30-120	120-400
6	30	120	315
30	120	315	1000
1000	2000	4000	ABOVE
±0.1	±0.2	±0.3	±0.5
±0.8	±1.2	±2.0	±3.0
1°	30'	20'	10'



NOTES:

1. HONEYCOMB CORE, CFRP FACE SKIN AND ARALDITE TO BE REMOVED BY MILLING.
2. MAXIMUM PARENT MATERIAL REMOVAL ALLOWED IS 50 MICRONS.
3. PARENT MATERIAL IS AA B51.
4. DIMENSIONS ARE GIVEN FOR THE PURPOSE OF INFORMATION ONLY. HOWEVER
 "*" MARKED DIMENSION TO BE MAINTAINED BY MILLING AFTER EACH EMERYING OPERATION.
5. REMOVE BURRS AFTER THE EMERYING / MILLING OPERATION

SR-23/01	MILLING OF PLATE SHEAR TEST BLOCKS	AS PER P O	NA	--	--	--
PART NO.	DESCRIPTION	QTY	MATL.	WT.	SIZE	REMARKS
DO NOT SCALE THE DRAWING. UNLESS OTHERWISE STATED DIMENSIONS ARE IN MM. REMOVE SHARP EDGES.		MILLING OF PLATE SHEAR TEST BLOCKS				SCALE NTS
PROJECT: GENERAL						
DIVISION	DESIGN	MANUFACTURING		STRUCTURES GROUP U R RAO SATELLITE CENTRE GOVERNMENT OF INDIA, DEPARTMENT OF SPACE BANGALORE, INDIA		
DESIGNED/ DRAWN		DRAWING CHECKED				
DESIGN CHECKED		CHECKED FOR MFG.				
DESIGN APPROVED		APPROVED FOR MFG.				
		DRG.No.		SR-23/01		
		NAME		SIGN.		PROJECTION
		NAME		SIGN.		SHEET
						- OF -