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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

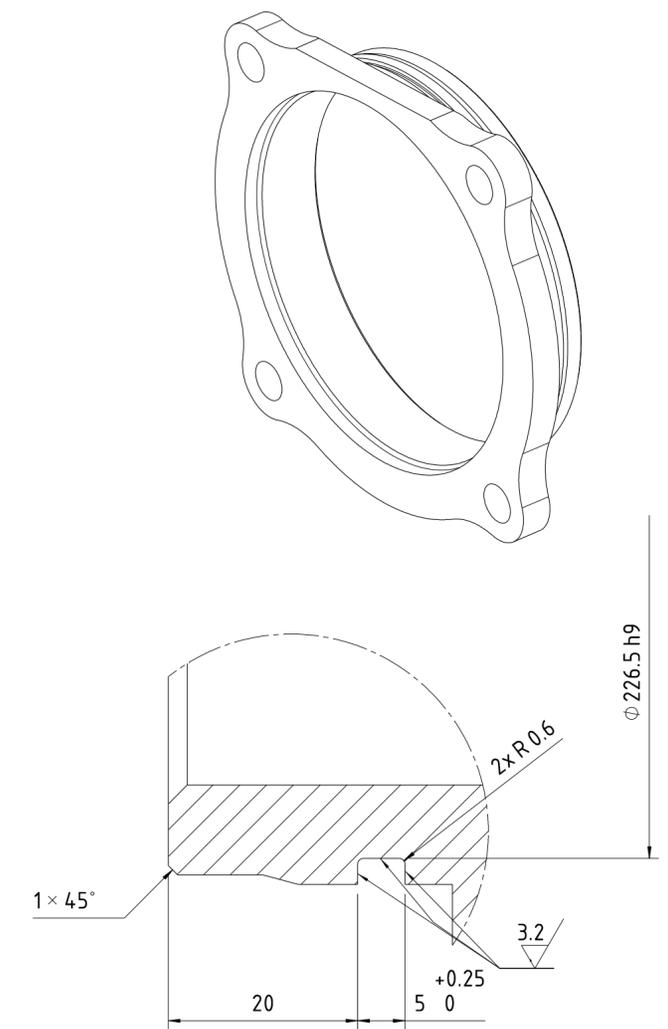
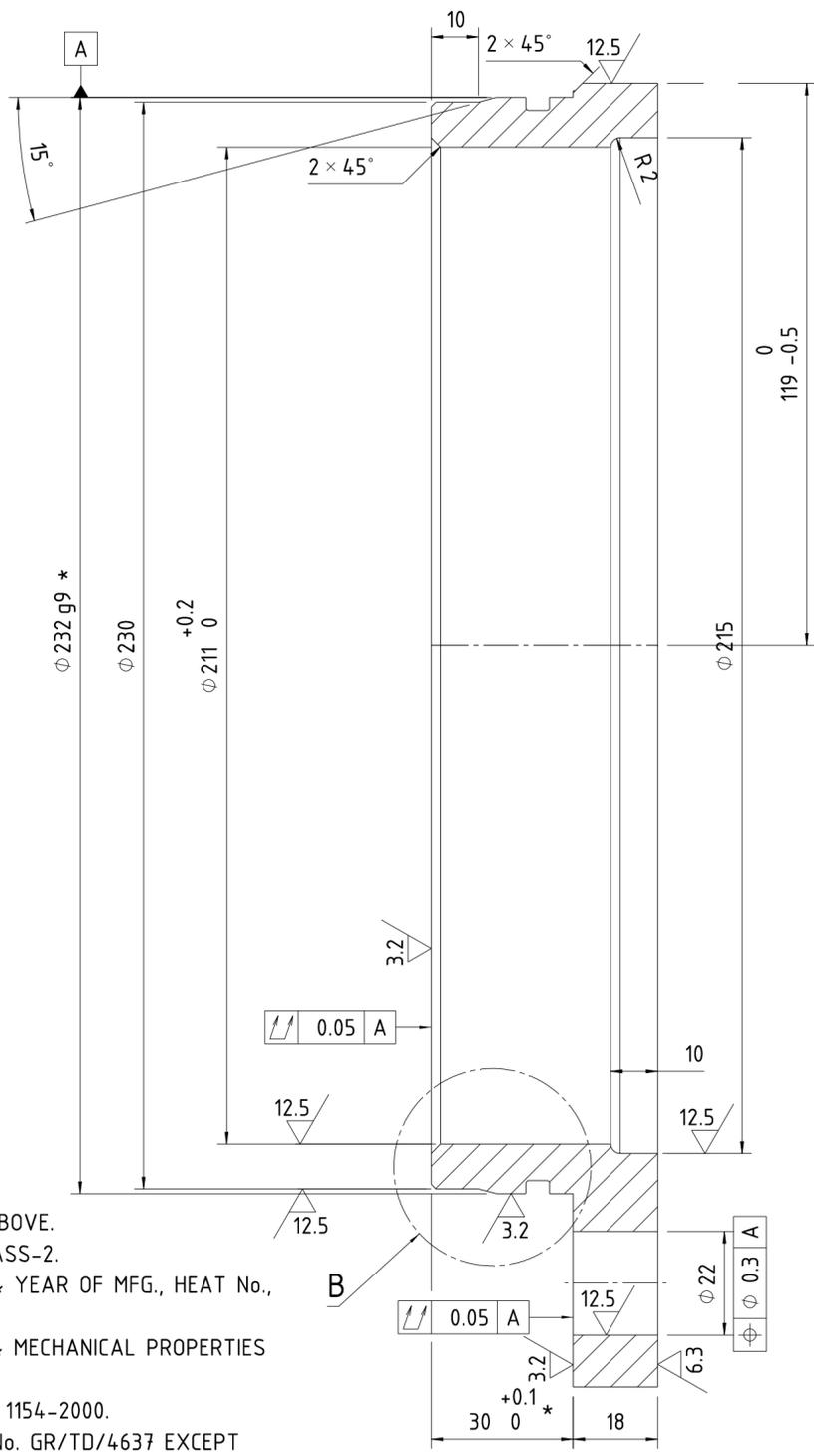
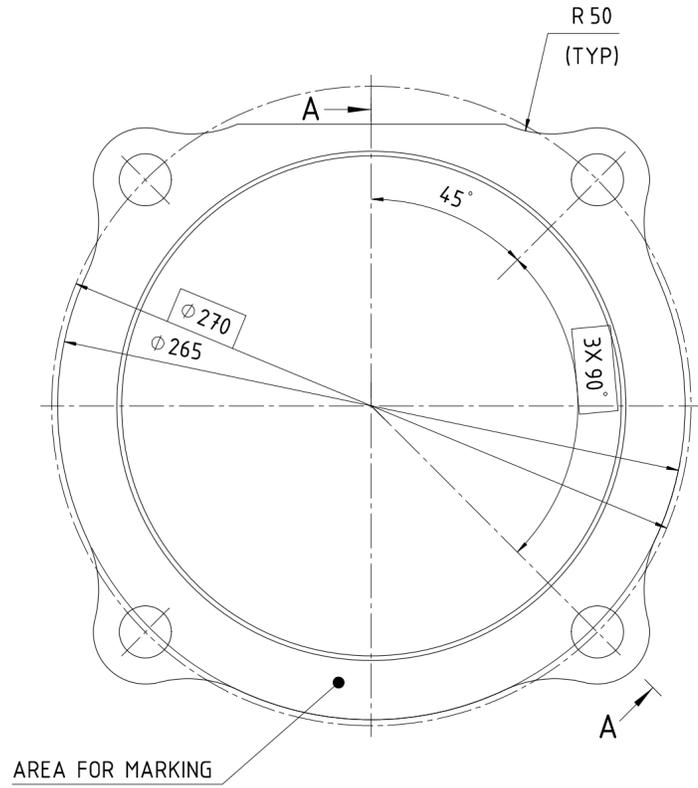
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

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

WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96

STATUS: **PROTO**



**NOTES:**

1. CONSIDER R3 FOR UNSPECIFIED RADIUS ON CASTING.
2. SCREW MACHINING SHOULD BE DONE ACCORDING TO ISO 261 NORMAL GRADE OR ABOVE.
3. DEVIATIONS ON UNTOLERENCED CAST DIMENSIONS SHALL BE TO IS:4897-1994, CLASS-2.
4. EMBOSS IN 10mm HIGH, 15mm RAISED LETTERS PART No., VENDOR CODE, MONTH & YEAR OF MFG., HEAT No., & SL. No., ON THE CASTING AS SHOWN IN THE DWG.
5. MANUFACTURER MUST FURNISH TEST CERTIFICATES FOR CHEMICAL COMPOSITION & MECHANICAL PROPERTIES FOR EACH BATCH OF SUPPLY.
6. THE MACHINED SURFACE SHALL BE COATED WITH RUST PREVENTIVE FLUID TO IS: 1154-2000.
7. OUTSIDE: TO BE PAINTED ACCORDING TO PAINTING MENTIONED IN BEML PTS DOC No. GR/TD/4637 EXCEPT MACHINED SURFACES.
8. FAI: ONE No. OF FINISH MACHINED SAMPLE SHALL BE SUPPLIED FREE ALONG WITH ALL MECHANICAL & CHEMICAL TEST REPORTS & DIMENSION CHECK SHEETS FOR EACH BATCH OF SUPPLY FOR APPROVAL BY BEML BEFORE BULK PRODUCTION.
9. THE CASTINGS SHALL CONFORM TO BEML PTS DOC. No. GR/TD/4637.
10. FOR SG-IRON OBTAINED BY SAND CASTING, MOULDING TOOLING DEFINITION & DRAFT VALUES MUST COMPLY WITH EN 12890
11. REMOVE ALL SHARP EDGES AS BURRS AND CLEAN THE PARTS.
12. DIAMETER CONCENTRICITY OF 0.10 TO BE MAINTAINED
13. PERPENDICULARITY OF 0.10 TO BE MAINTAINED W.R.T. DIAMETERS
14. PARALLELISM OF 0.10 TO BE MAINTAINED W.R.T. AXIS LINE

**SECTION A-A**

**DETAIL B**  
2:1

\* : IMPORTANT PARAMETER

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./IS	Wt. (Kg)
			PRODUCT	MUMBAI METRO CARS L2 & L7		
			REF DRG			
			MATERIAL	EN-GJS-400-15 OF EN 1563		
			HEAT TREAT.	APPD	MS	
			SURFACE TREAT.	REVD	RSS	
			TITLE	CHKD	DB	
				DRWN	VSE	
				SCALE	1:1	
				SHEET	1 OF 1	4.2 kg
				DRG No.		
ALT.No.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	

**BEML LIMITED**      **525-81105**