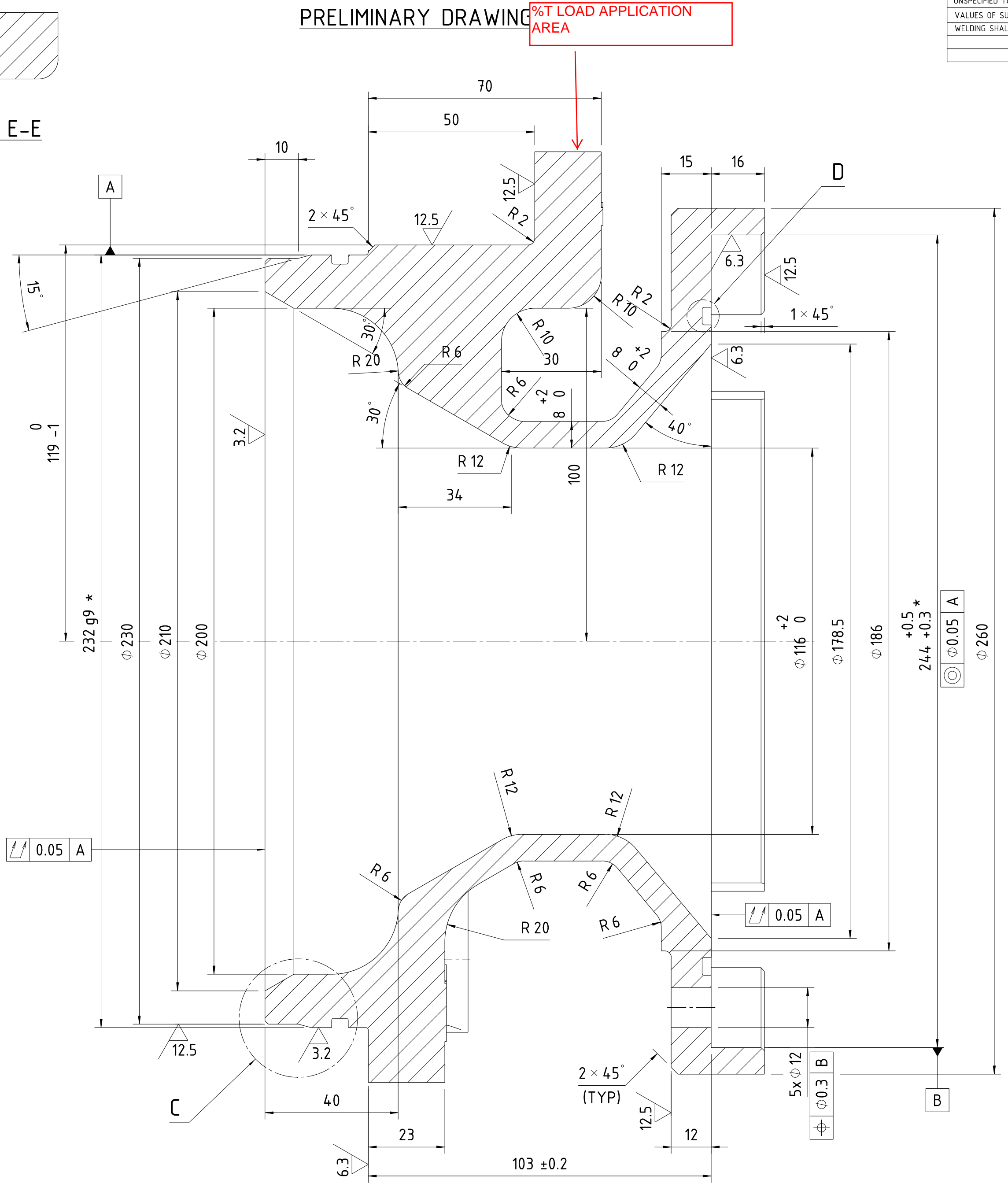
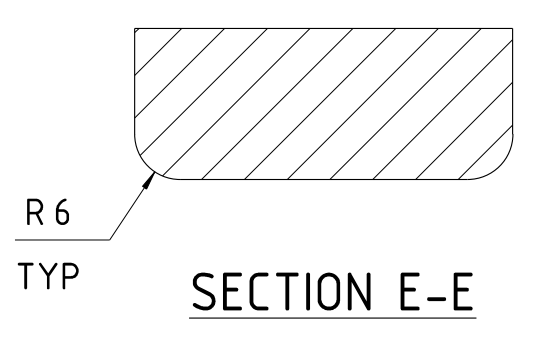
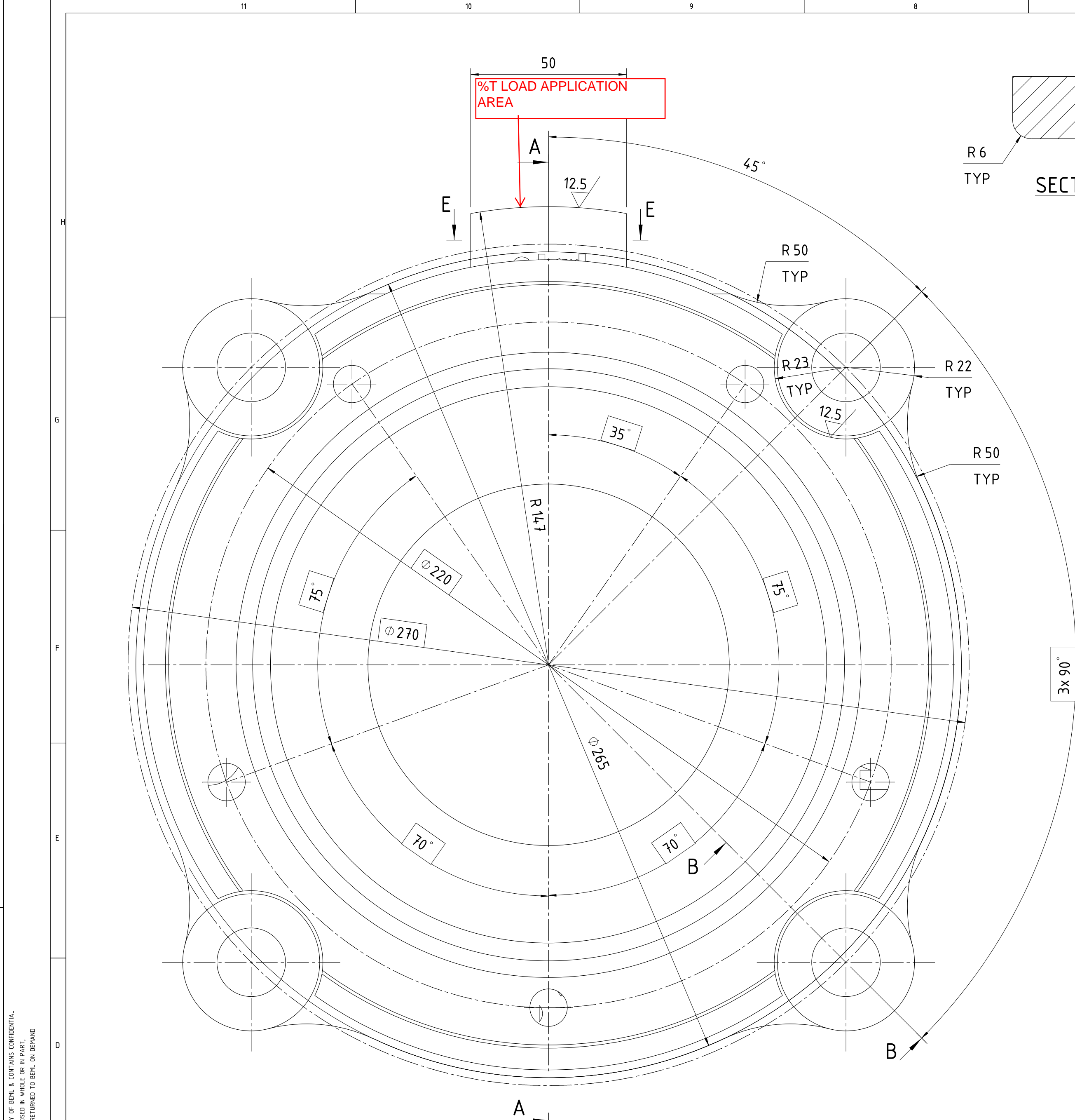
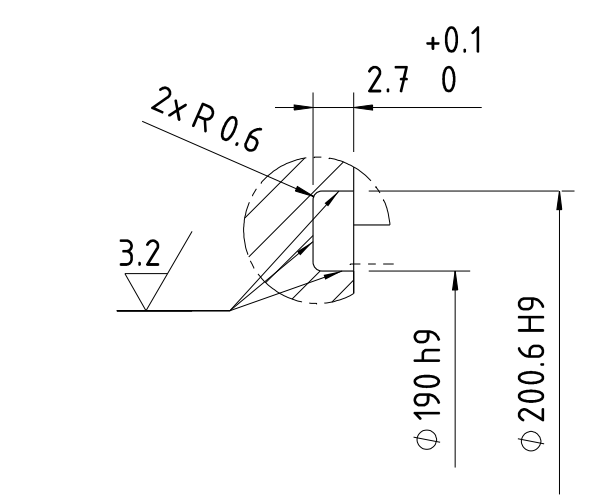


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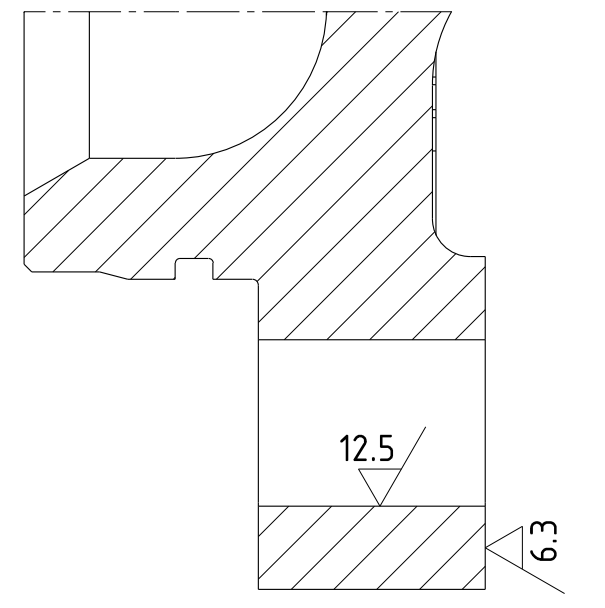
GRADE No.	INT2	INT1	INT0	INT3	INT4	INT5	INT6	INT7	INT8	INT9	INT10	INT11
SURFACE	50	20	12.5	6.3	3.2	1.6	0.8	0.4	0.2	0.1	0.05	0.025
SYMBOL	▽	▽	▽	▽	▽	▽	▽	▽	▽	▽	▽	▽



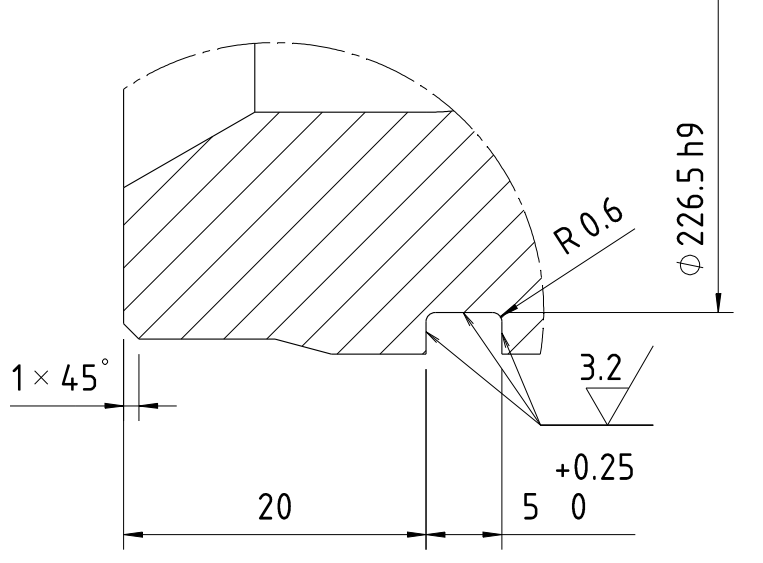
SECTION A-A



DETAIL D (2:1)



SECTION B-B



DETAIL C (2:1)


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, 1.5mm 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. MOULDING TOOLING DEFINITION & DRAFT VALUES MUST COMPLY WITH THIS STANDARD FOR SG-IRON OBTAINED BY SAND CASTING AS PER 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.
- 15a. CAST/EMBOSSMENT OF BEML LOGO AS PER BEML STANDARD DS 1019-C. COPY OF THE EXTRACT TO BE SHARED WITH THE VENDOR.
- 15b. LOGO LENGTH SHALL BE L=15mm(at the top-1 place) AT DEPTH OF 0.5mm & L=50mm (at the sides-2 places & at bottom - 1 place) AT DEPTH OF 1mm.
- 15c. THE EXACT POSITION OF THE LOGO IS SHOWN IN SHEET-2.

BEML LOGO TO BE EMBOSSED

\* : IMPORTANT PARAMETER

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./IS	Wt. (Kg)
					MATERIAL	
			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 2
				DRG No.		Wt. 15kg
						ALT 0
ALT.NO.	ECH NO/CHANGES	DATE	BY	CHKD	APPD	

**BEML LIMITED**

525-81102