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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)

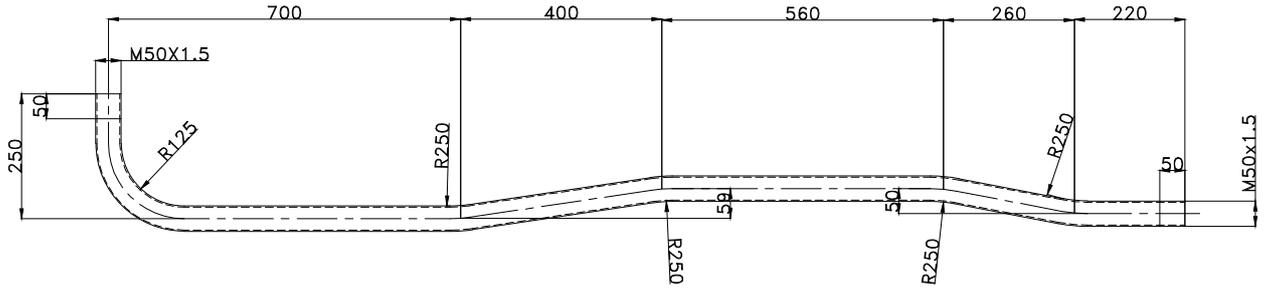
QUALITY OF WELD JOINTS REF, RD 230 MEDIUM

VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS. 1012.C.

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

STATUS:

UNCONTROLLED



NOTE:

1. WELD JOINTS ARE NOT PERMITTED.
2. CONDUIT PIPE TO BE ANODISED TO Gr.AC15 OF IS:1868
3. WRINKLES AT BEND REGIONS ARE NOT PERMITTED
4. PIPE THREADS SHALL MATCH TO THE RESPECTIVE END BUSHING/COUPLER/LOCK NUT THREADS

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	▽
SURFACE ROUGHNESS	ALT.NO.	ECN NO/CHANGES

					Ø50x2333x2.5w/t	A6063-T5	
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)	
					MATERIAL		

PRODUCT	MUMBAI METRO CARS L2&L7						
REF DRG							
MATERIAL							
HEAT TREAT.	APPD	VS					14.11.19
SURFACE TREAT.	REVD						
TITLE	CHKD	SNH					14.11.19
CONDUIT PIPE-1 51C-DMC	DRWN	VISHNU					14.11.19
	SCALE		SHEET	Wf.(Kg)			
			OF	0			
	DRG No.	525-56172				ALT	
BEML LIMITED <small>NEW FRONTIERS. NEW DREAMS</small>							

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	~

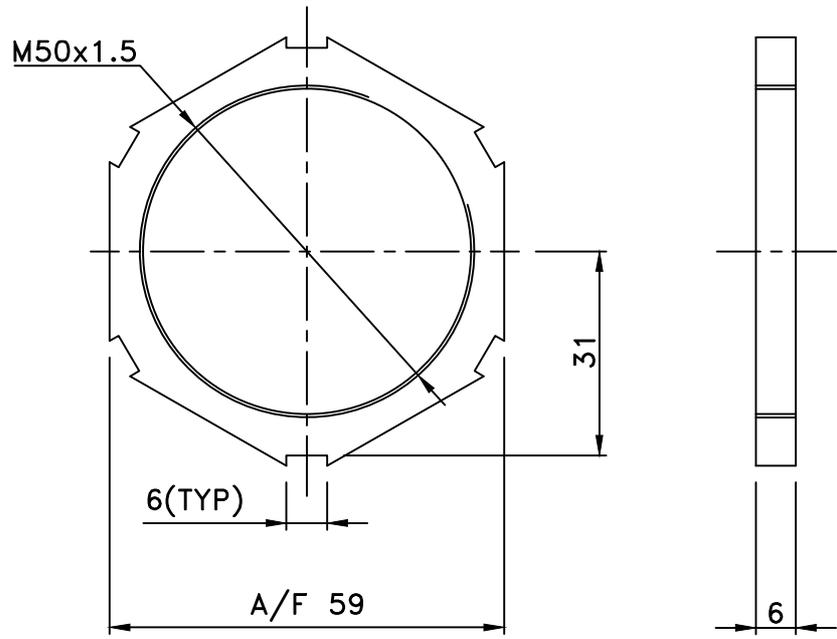
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

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:

UNCONTROLLED



NOTE: REMOVE SHARP EDGES AND BURRS

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

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	MATERIAL	Gr.52000 condition 'O' to IS:737-2008	Wt. (Kg)
					69x59x6 THK AL. PLATE		
			PRODUCT	MUMBAI METRO CARS L2&L7			
			REF DRG				
			MATERIAL				
			HEAT TREAT.	APPD	VS	14.11.19	
			SURFACE TREAT.	REVD			
			TITLE	CHKD	SNH	14.11.19	
			LOCK NUT-51C	DRWN	VISHNU	14.11.19	
				SCALE		SHEET OF	Wt.(Kg)
				DRG No.	525-56174		ALT
SURFACE ROUGHNESS	ALT.NO.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	
							BEML LIMITED
							NEW FRONTIERS. NEW DREAMS

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	~

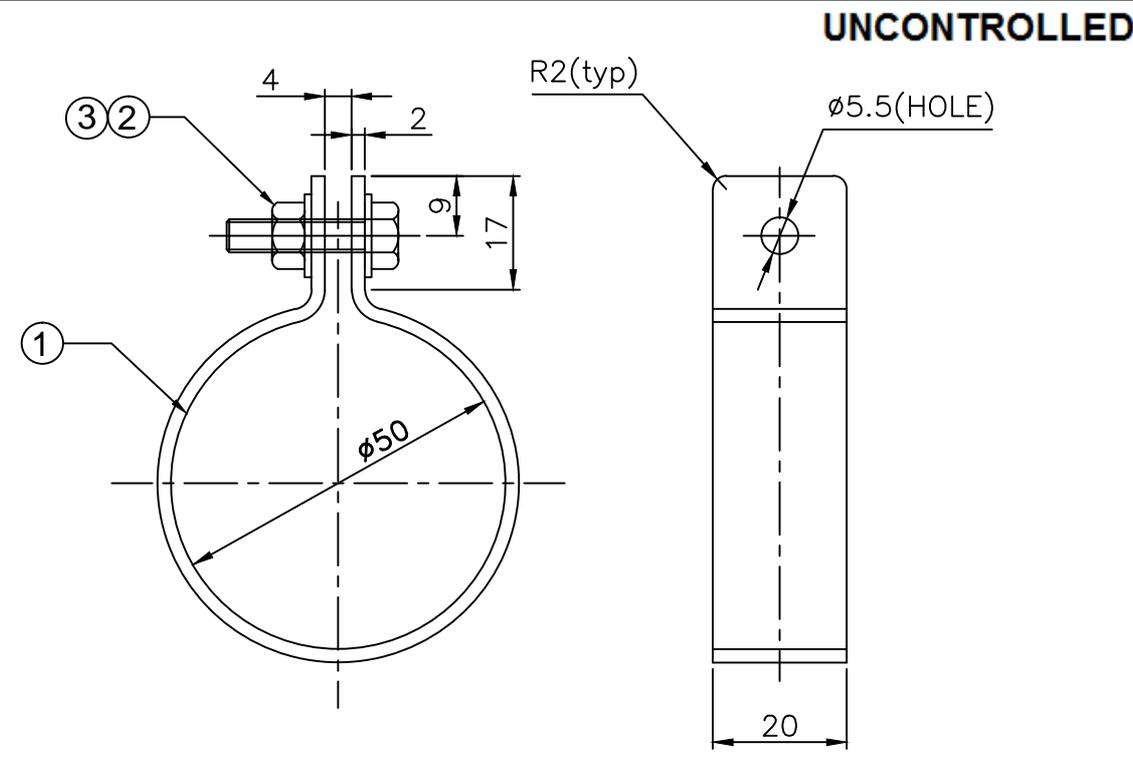
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

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:

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UNCONTROLLED

NOTE: REMOVE ALL SHARP EDGES & DEBURR.

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
GRADE No.	
VALUE	
SYMBOL	
SURFACE ROUGHNESS	

3	1	RFN5850547	HEX HD NUT WITH FLANGE M5 TO ISO:4161-83 / MATL-ISO:3506,Gr-A2-70,SS
2	1	RFB3850520	HEX HEAD FLANGE BOLT FULL THREAD M5x20 TO ISO : 4162-90 / MATL : IS-1367(P-14) Gr-A2-70, SS WITH NYLOK BLUE PATCH PRE APPLIED ADHESIVE
1		CLAMP	196x20x2 thk
			Gr.52000 condition 'O' to IS:737-2008
			COMPANY STD./I.S
			Wt. (Kg)
			MATERIAL

PRODUCT	MUMBAI METRO CARS L2&L7		
REF DRG			
MATERIAL			
HEAT TREAT.	APPD	VS	14.11.19
SURFACE TREAT.	REVD		
TITLE	CHKD	SNH	14.11.19
	DRWN	VISHNU	14.11.19
	SCALE		SHEET OF
			Wf.(Kg) 0
	DRG No.	525-56175	
		ALT	

BEML LIMITED
NEW FRONTIERS. NEW DREAMS

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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	~

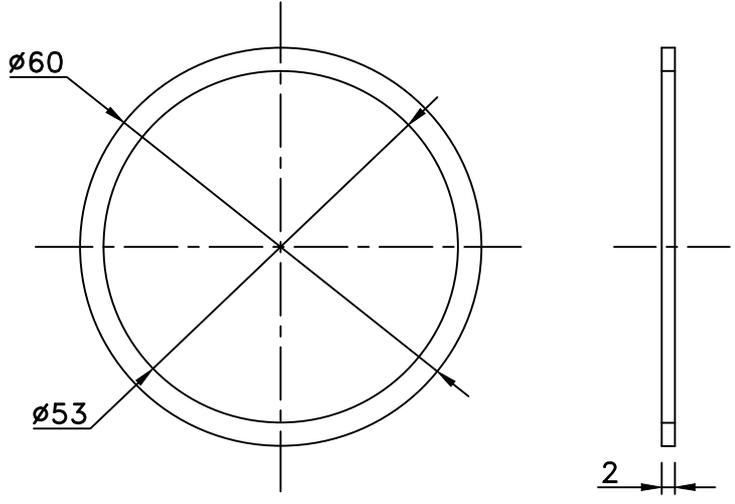
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

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:

UNCONTROLLED



NOTE: REMOVE SHARP EDGES AND BURRS

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	▽
GRADE No.		▽
VALUE		▽
SYMBOL		▽
SURFACE ROUGHNESS		▽

					60x60x2 THK AL.SHEET	Gr.52000 condition'O' to IS:737-2008	condition'O' to
						COMPANY STD./I.S	Wt. (Kg)
						MATERIAL	
					MUMBAI METRO CARS L2&L7		
					PRODUCT		
					REF DRG		
					MATERIAL		
						APPD	VS
							14.11.19
						REVD	
						CHKD	SNH
							14.11.19
						DRWN	VISHNU
							14.11.19
						SCALE	Wf.(Kg)
							0
						DRG No.	ALT
							▽
						525-56177	


BEML LIMITED
NEW FRONTIERS. NEW DREAMS

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

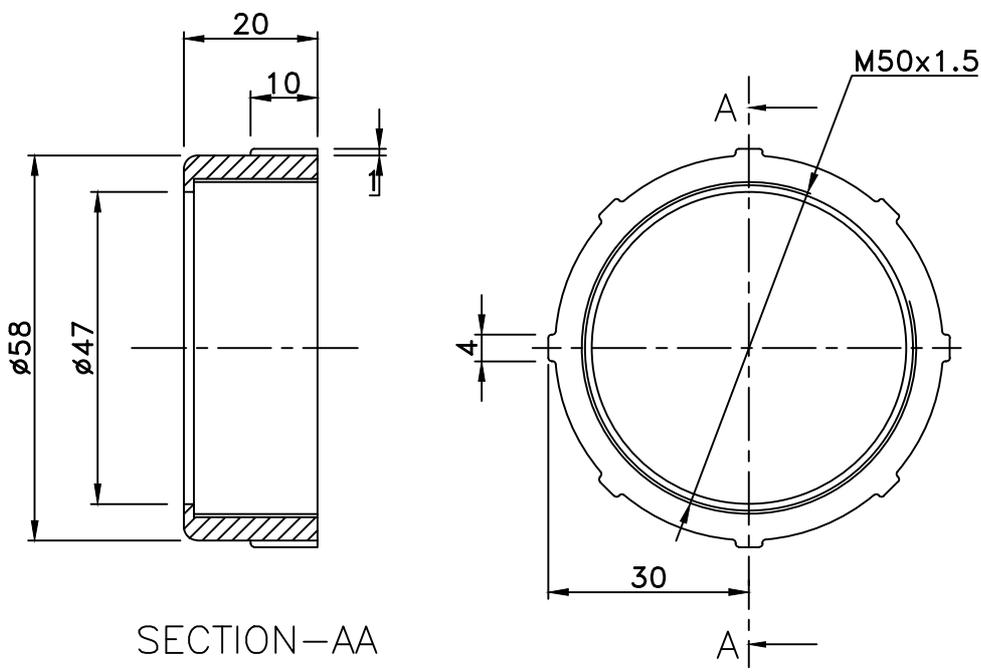
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM) QUALITY OF WELD JOINTS REF, RD 230 MEDIUM

VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS. 1012.C.

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

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UNCONTROLLED



NOTE: REMOVE SHARP EDGES AND BURRS

MATERIAL: - Zinc die casting to alloy Zn Al4 cu1 IS:742-1981

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	▽
GRADE No.		▽
VALUE		▽
SYMBOL		▽
SURFACE ROUGHNESS		▽

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
			PRODUCT	MUMBAI METRO CARS L2&L7		
			REF DRG			
			MATERIAL			
			HEAT TREAT.	APPD	VS	14.11.19
			SURFACE TREAT.	REVD		
			TITLE	CHKD	SNH	14.11.19
			END BUSHING-51C	DRWN	VISHNU	14.11.19
				SCALE		SHEET OF
			BEML LIMITED <small>NEW FRONTIERS. NEW DREAMS</small>	DRG No.	525-56178	
				ALT		

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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)

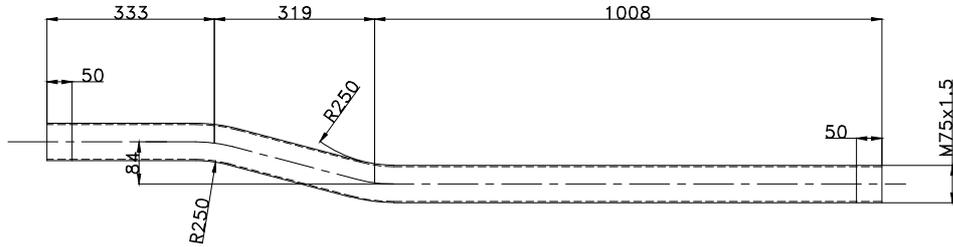
QUALITY OF WELD JOINTS REF, RD 230 MEDIUM

VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS. 1012.C.

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

STATUS:

UNCONTROLLED



NOTE:

1. WELD JOINTS ARE NOT PERMITTED.
2. CONDUIT PIPES TO BE SUPPLIED WITH BRIGHT FINISH.
3. WRINKLES AT BEND REGIONS ARE NOT PERMITTED
4. PIPE THREADS SHALL MATCH TO THE RESPECTIVE END BUSHING/COUPLER/LOCK NUT THREADS

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	▽
GRADE No. VALUE		
SYMBOL		
SURFACE ROUGHNESS		

					Ø76x1670x2.5w/t	AISI 304-ERW TUBE
						COMPANY STD./I.S
						Wt. (Kg)
						MATERIAL

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	
			PRODUCT	MUMBAI METRO CARS L2&L7	
			REF DRG		
			MATERIAL		
			HEAT TREAT.	APPD	VS
			SURFACE TREAT.	REVD	
			TITLE	CHKD	SNH
			CONDUIT PIPE-2 75C-UF	DRWN	VISHNU
				SCALE	
					0
				DRG No.	ALT
				525-56188	



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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	~

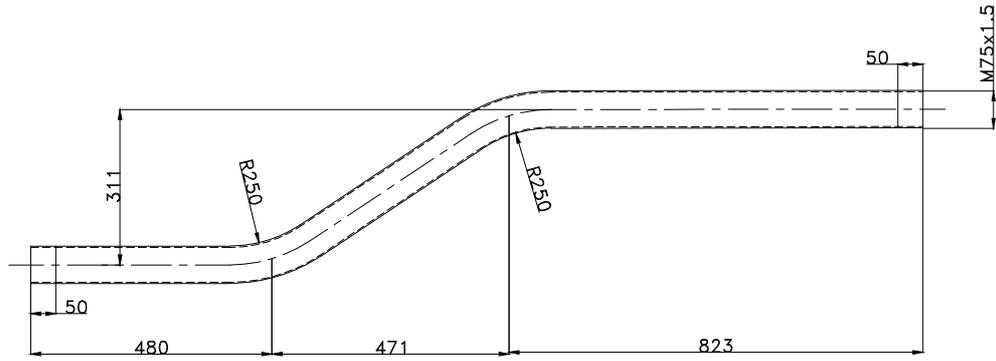
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

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:

UNCONTROLLED



NOTE:

1. WELD JOINTS ARE NOT PERMITTED.
2. CONDUIT PIPES TO BE SUPPLIED WITH BRIGHT FINISH.
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4. PIPE THREADS SHALL MATCH TO THE RESPECTIVE END BUSHING/COUPLER/LOCK NUT THREADS

N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12	GRADE No. VALUE	SYMBOL	SURFACE ROUGHNESS																																																																																									
0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50		△																																																																																										
<table border="1"> <tr> <td>SL.No.</td> <td>QTY</td> <td>PART / STOCK No.</td> <td>DESCRIPTION</td> <td>SIZE</td> <td>Ø76x1858x2.5w/t</td> <td>AISI 304-ERW TUBE</td> </tr> <tr> <td colspan="5"></td> <td>COMPANY STD./I.S</td> <td>Wt. (Kg)</td> </tr> <tr> <td colspan="5"></td> <td colspan="2">MATERIAL</td> </tr> <tr> <td colspan="4">PRODUCT</td> <td colspan="3">MUMBAI METRO CARS L2&L7</td> </tr> <tr> <td colspan="4">REF DRG</td> <td colspan="3"></td> </tr> <tr> <td colspan="4">MATERIAL</td> <td colspan="3"></td> </tr> <tr> <td colspan="4">HEAT TREAT.</td> <td>APPD</td> <td>VS</td> <td>14.11.19</td> </tr> <tr> <td colspan="4">SURFACE TREAT.</td> <td>REVD</td> <td></td> <td></td> </tr> <tr> <td colspan="4">TITLE</td> <td>CHKD</td> <td>SNH</td> <td>14.11.19</td> </tr> <tr> <td colspan="4" rowspan="2">CONDUIT PIPE-3 75C-UF</td> <td>DRWN</td> <td>VISHNU</td> <td>14.11.19</td> </tr> <tr> <td>SCALE</td> <td></td> <td>SHEET OF</td> <td>Wf.(Kg)</td> <td>0</td> </tr> <tr> <td colspan="4">ALT.NO.</td> <td colspan="2">ECN NO/CHANGES</td> <td>DATE</td> <td>BY</td> <td>CHKD</td> <td>APPD</td> <td colspan="2"> BEML LIMITED <small>NEW FRONTIERS. NEW DREAMS</small> </td> <td>DRG No.</td> <td>525-56189</td> <td>ALT</td> </tr> </table>														SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	Ø76x1858x2.5w/t	AISI 304-ERW TUBE						COMPANY STD./I.S	Wt. (Kg)						MATERIAL		PRODUCT				MUMBAI METRO CARS L2&L7			REF DRG							MATERIAL							HEAT TREAT.				APPD	VS	14.11.19	SURFACE TREAT.				REVD			TITLE				CHKD	SNH	14.11.19	CONDUIT PIPE-3 75C-UF				DRWN	VISHNU	14.11.19	SCALE		SHEET OF	Wf.(Kg)	0	ALT.NO.				ECN NO/CHANGES		DATE	BY	CHKD	APPD	BEML LIMITED <small>NEW FRONTIERS. NEW DREAMS</small>		DRG No.	525-56189	ALT
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	Ø76x1858x2.5w/t	AISI 304-ERW TUBE																																																																																																	
					COMPANY STD./I.S	Wt. (Kg)																																																																																																	
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TITLE				CHKD	SNH	14.11.19																																																																																																	
CONDUIT PIPE-3 75C-UF				DRWN	VISHNU	14.11.19																																																																																																	
				SCALE		SHEET OF	Wf.(Kg)	0																																																																																															
ALT.NO.				ECN NO/CHANGES		DATE	BY	CHKD	APPD	BEML LIMITED <small>NEW FRONTIERS. NEW DREAMS</small>		DRG No.	525-56189	ALT																																																																																									

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	~

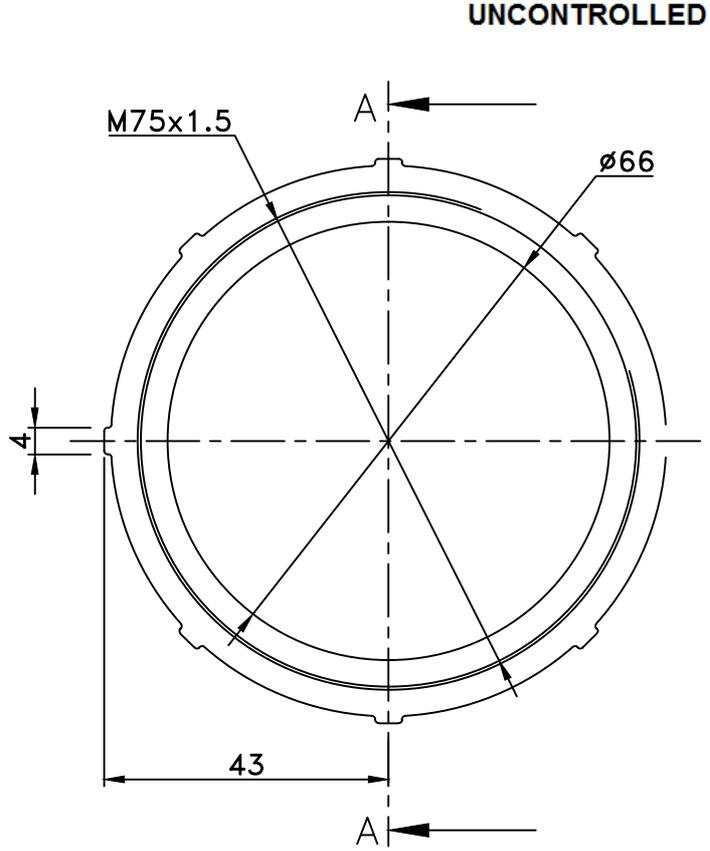
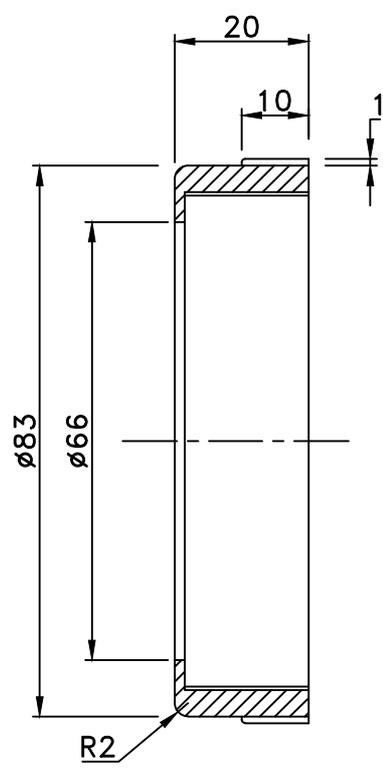
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

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:

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SECTION-AA

NOTE: REMOVE SHARP EDGES AND BURRS

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	▽
GRADE No.		▽
VALUE		▽
SYMBOL		▽
SURFACE ROUGHNESS		▽

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	AISI 304	Wt. (Kg)
					COMPANY STD./I.S	
					MATERIAL	

PRODUCT	MUMBAI METRO CARS L2&L7					
REF DRG						
MATERIAL						
HEAT TREAT.	APPD	VS				14.11.19
SURFACE TREAT.	REVD					
TITLE	CHKD	SNH				14.11.19
	DRWN	VISHNU				14.11.19
	SCALE		SHEET	Wf.(Kg)		
			OF	0		

END BUSHING-75C

BEML LIMITED
NEW FRONTIERS. NEW DREAMS

DRG No. **525-56191** ALT

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	~

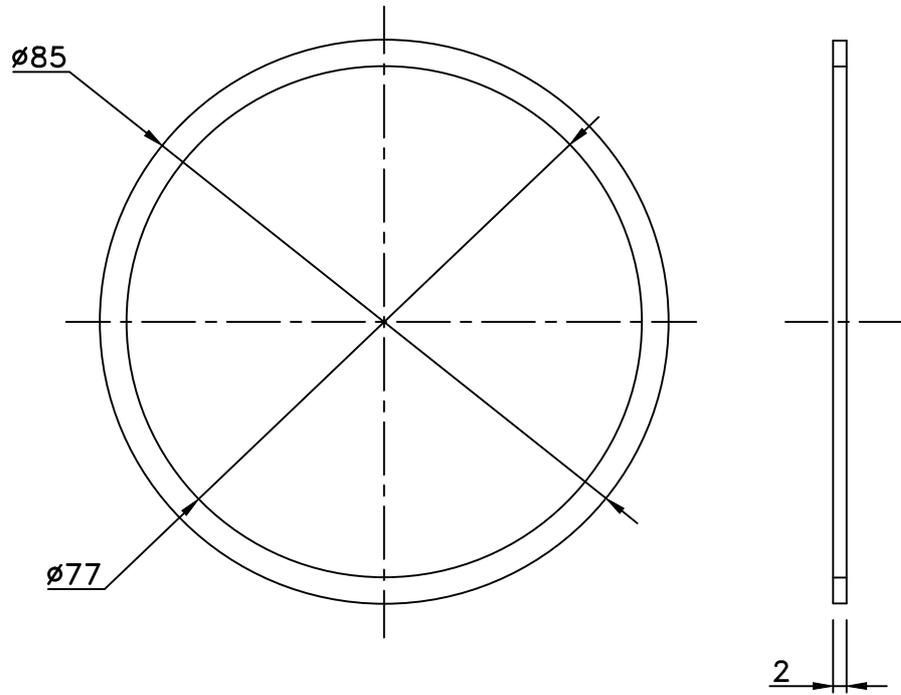
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

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:

UNCONTROLLED



NOTE: REMOVE SHARP EDGES AND BURRS

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

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	85x85x2 THK SS PLATE	AISI 304	COMPANY STD./I.S	Wt. (Kg)
					MATERIAL			
			PRODUCT	MUMBAI METRO CARS L2&L7				
			REF DRG					
			MATERIAL					
			HEAT TREAT.	APPD	VS	14.11.19		
			SURFACE TREAT.	REVD				
			TITLE	CHKD	SNH	14.11.19		
			PLAIN WASHER-75C	DRWN	VISHNU	14.11.19		
				SCALE		SHEET OF	Wt.(Kg)	0
			BEML LIMITED	DRG No.	525-56194			ALT
				ALT				



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	~

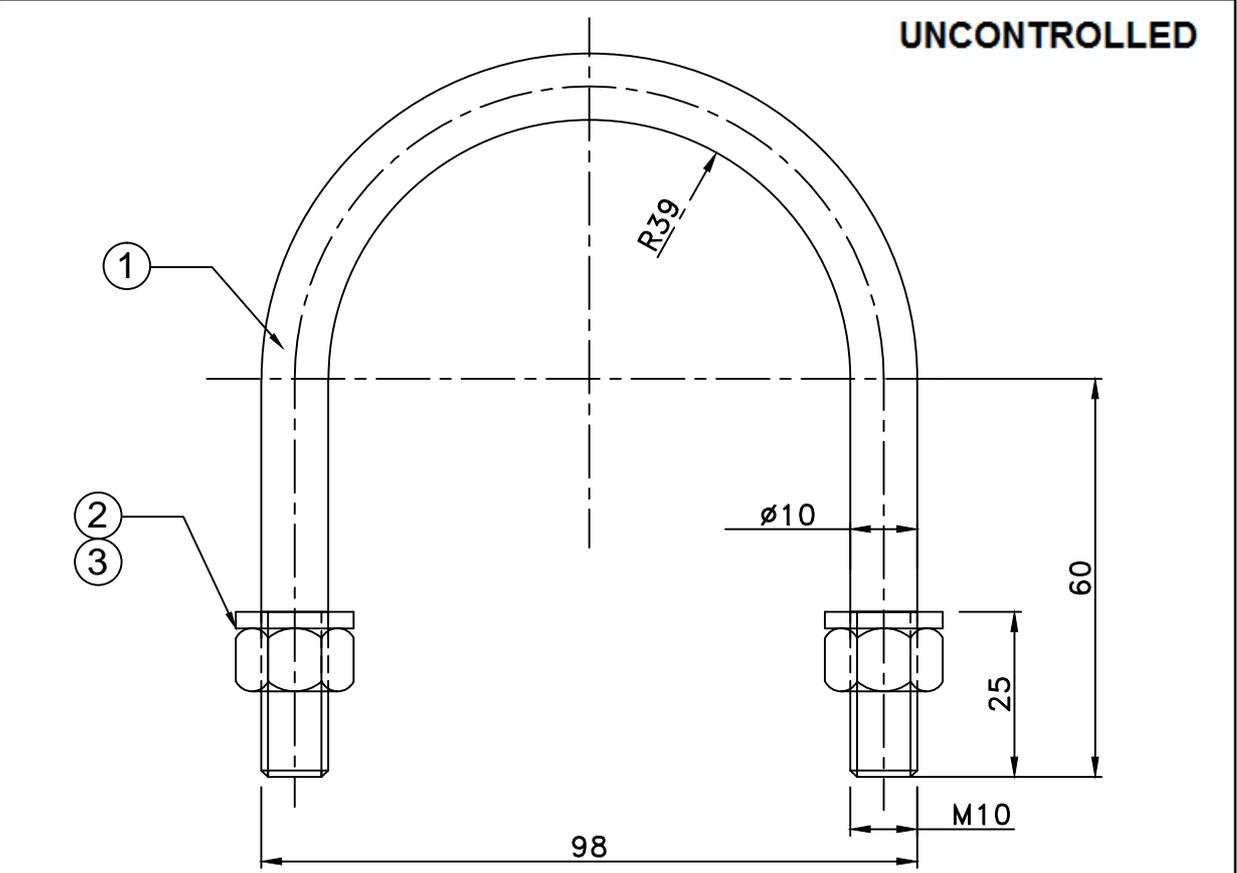
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

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:

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UNCONTROLLED

NOTE: REMOVE ALL SHARP EDGES & DEBURR.

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	▽
GRADE No.		▽
VALUE		▽
SYMBOL		▽
SURFACE ROUGHNESS		▽

3	2	RFW0921022	Spring Washer-B10 to IS:3063(P-3)-2002/Matl:1367(P-14),SS
2	2	RFN3861084	Hex.head nut M10 to IS:1364(P-3)-2002/Matl:IS-1367(P-14)Gr-A2-70,SS
1	1		U-BOLT

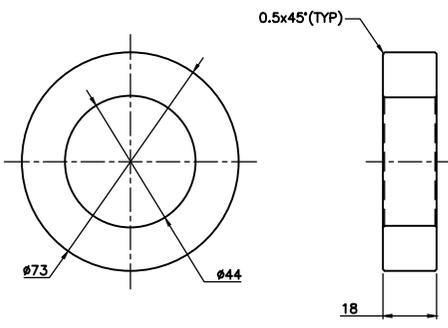
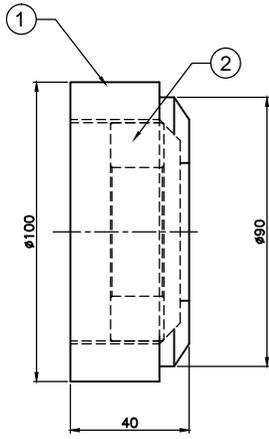
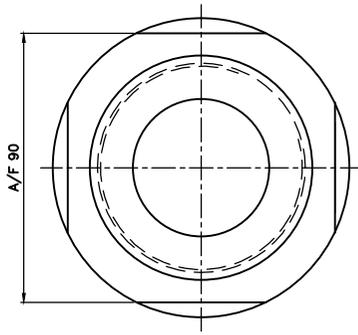
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)

PRODUCT	MUMBAI METRO CARS L2&L7					
REF DRG						
MATERIAL						
HEAT TREAT.		APPD	VS	14.11.19		
SURFACE TREAT.		REVD				
TITLE	U BOLT-75C			CHKD	SNH	14.11.19
				DRWN	VISHNU	14.11.19
				SCALE	1:1	SHEET OF
						Wt.(Kg)
						0
				DRG No.	525-56197	
					ALT	▽

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NEW FRONTIERS. NEW DREAMS

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GRADE No.	NT1	NT2	N1
VALUE	0.025	0.05	0.1
SYMBOL	N2	N3	N4
	N3	N4	N5
	N4	N5	N6
	N5	N6	N7
	N6	N7	N8
	N7	N8	N9
	N8	N9	N10
	N9	N10	N11
	N10	N11	N12
	N11	N12	50
ROUGHNESS			

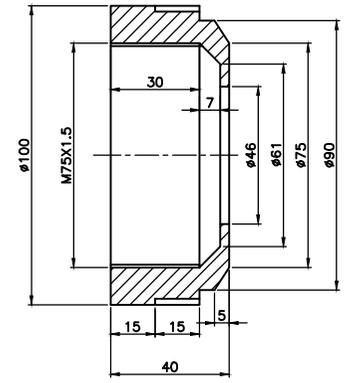
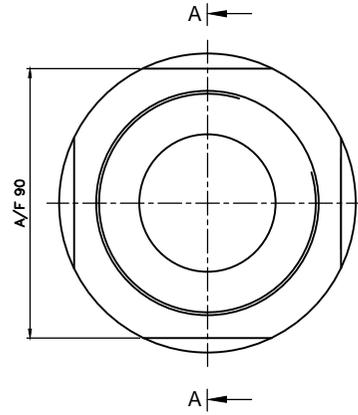


DETAIL-2

- NOTE:**
- REMOVE ALL SHARP EDGES & DEBURR.
 - ITEM-2, REQUIREMENTS SHALL BE AS PER EN45545 HL-3 SPECIFICATION

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



SECTION-AA

DETAIL-1

2	1	525-56198-2	SPACER		EPDM	
1	1	525-56198-1	BUSH		A 6061	
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./IS	Wt. (Kg)
					MATERIAL	
			PRODUCT	MUMBAI METRO CARS L2&L7		
			REF DRG			
			MATERIAL			
			HEAT TREAT.	APPD	KCS	14.11.19
			SURFACE TREAT.	REVD		
			TITLE	CHKD	SNH	14.11.19
				DRWN	VISHNU	14.11.19
				SCALE		Wt.(Kg)
						0
				DRG No.		ALT
ALT.No.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	
BEML LIMITED <small>NEW PRINTERS, NEW DELHI</small>					525-56198	

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	~

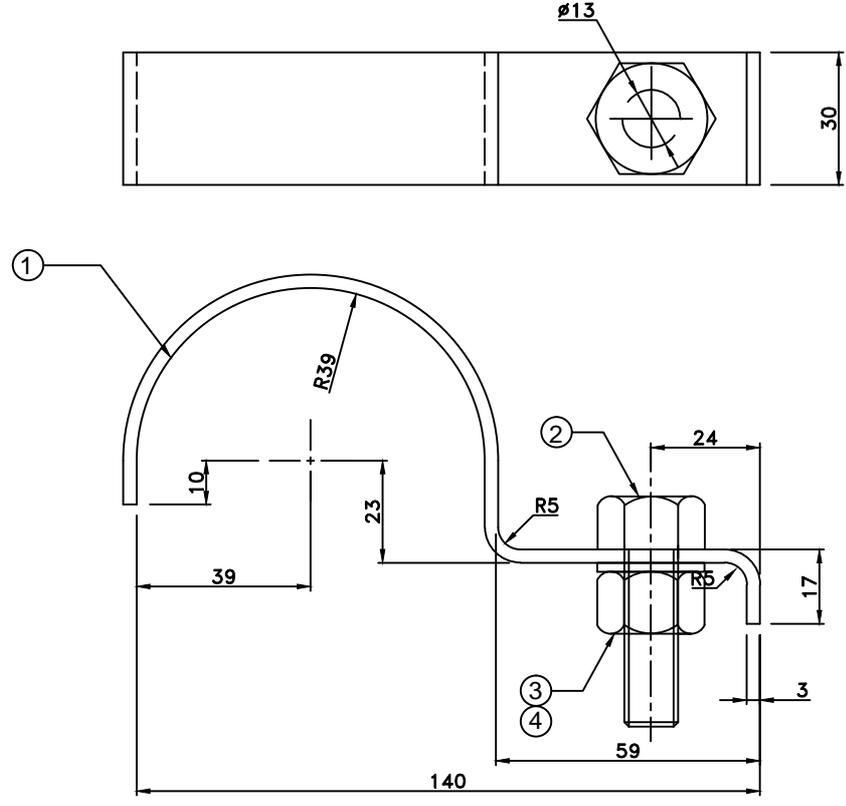
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

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:

UNCONTROLLED



NOTE: REMOVE ALL SHARP EDGES & DEBURR.

N1	0.025	4	1	RFW0921225	SPRING WASHER B12 TO IS:3063-1994/MATL-AISI-304,SS			
N2	0.05	3	1	RFN3861211	HEX HD NUT M12 TO IS:1364-(PT-2)2002 / MATL-IS:1367(P-14),Gr-A2-70,SS			
N3	0.1	2	1	RFB1461240	HEX HD BOLT M12x40 TO IS:1364-(PT-1)2002 / MATL-IS:1367(P-14),Gr-A2-70,SS			
N4	0.2	1	1		BRACKET			
N5	0.4				277x30x3THK SS SHEET			
N6	0.8				AISI 304			
N7	1.6	SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
N8	3.2						MATERIAL	

N9	6.3				PRODUCT	MUMBAI METRO CARS L2&L7		
N10	12.5				REF DRG			
N11	25				MATERIAL			
N12	50				HEAT TREAT.	APPD	VS	14.11.19
GRADE No.					SURFACE TREAT.	REVD		
VALUE					TITLE	CHKD	SNH	14.11.19
SYMBOL	▲				CLAMP ASSY-75C	DRWN	VISHNU	14.11.19
						SCALE		SHEET OF
SURFACE ROUGHNESS	ALT.NO.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	DRG No.	525-56199
								ALT



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GRADE No.								
VALUE								
SYMBOL	▲							
SURFACE ROUGHNESS								

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	~

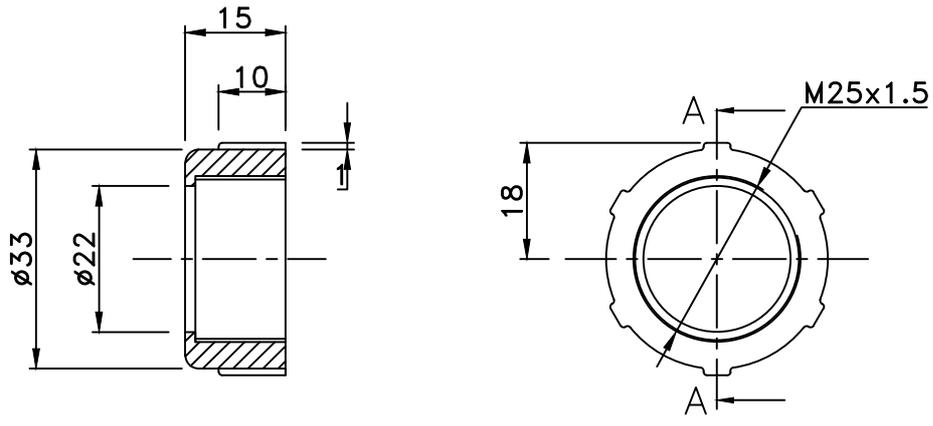
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

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:

UNCONTROLLED



SECTION-AA

NOTE: REMOVE SHARP EDGES AND BURRS

MATERIAL:-Zinc die casting to alloy Zn Al4 cu1 IS:742-1981

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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	▽
GRADE No.		▽
VALUE		▽
SYMBOL		▽
SURFACE ROUGHNESS	ALT.NO.	ECN NO/CHANGES
	DATE	BY
	CHKD	APPD

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
			PRODUCT	MUMBAI METRO CARS L2&L7		
			REF DRG			
			MATERIAL			
			HEAT TREAT.	APPD	VS	14.11.19
			SURFACE TREAT.	REVD		
			TITLE	CHKD	SNH	14.11.19
			END BUSHING-25C	DRWN	VISHNU	14.11.19
				SCALE		SHEET OF
						0
			DRG No.	525-56203		ALT
			BEML LIMITED <small>NEW FRONTIERS. NEW DREAMS</small>			

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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	~

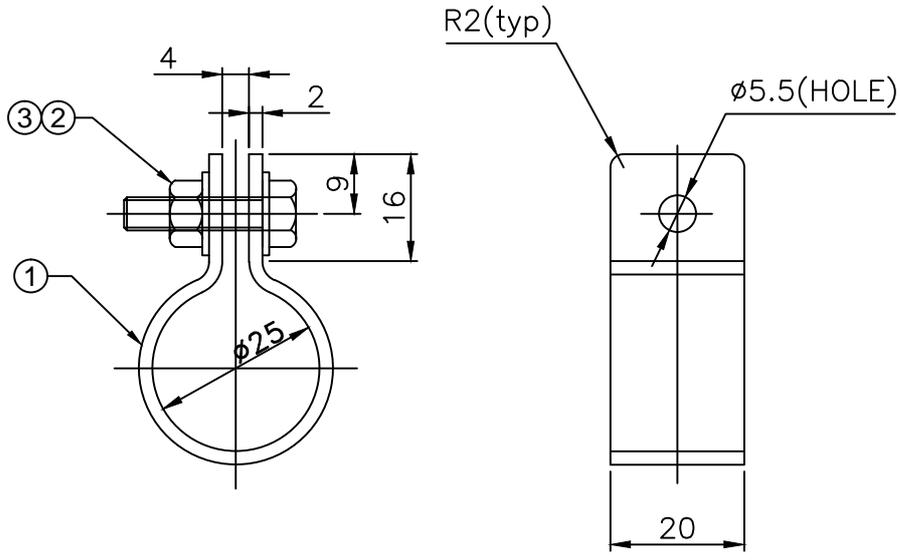
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

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:

UNCONTROLLED



NOTE: REMOVE ALL SHARP EDGES & DEBURR.

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
GRADE No.	
VALUE	
SYMBOL	
SURFACE ROUGHNESS	

3	1	RFN5850547	HEX HD NUT WITH FLANGE M5 TO ISO:4161-83 / MATL-ISO:3506,Gr-A2-70,SS
2	1	RFB3850520	HEX HEAD FLANGE BOLT FULL THREAD M5x20 TO ISO : 4162-90 / MATL : IS-1367(P-14) Gr-A2-70, SS WITH NYLOK BLUE PATCH PRE APPLIED ADHESIVE
1			CLAMP
			116x20x2 thk
			Gr.52000 condition 'O' to IS:737-2008
			COMPANY STD./I.S
			Wt. (Kg)
			MATERIAL

PRODUCT	MUMBAI METRO CARS L2&L7		
REF DRG			
MATERIAL			
HEAT TREAT.	APPD	VS	14.11.19
SURFACE TREAT.	REVD		
TITLE	CHKD	SNH	14.11.19
	DRWN	VISHNU	14.11.19
	SCALE		
		SHEET	Wt.(Kg)
		OF	0
	DRG No.	ALT	
		525-56204	

beml BEML LIMITED
NEW FRONTIERS. NEW DREAMS

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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	~

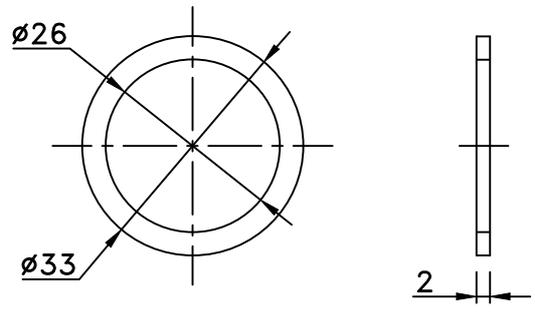
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

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: _____

UNCONTROLLED



NOTE: REMOVE SHARP EDGES AND BURRS

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	▽
GRADE No.		▽
VALUE		▽
SYMBOL		▽
SURFACE ROUGHNESS		▽

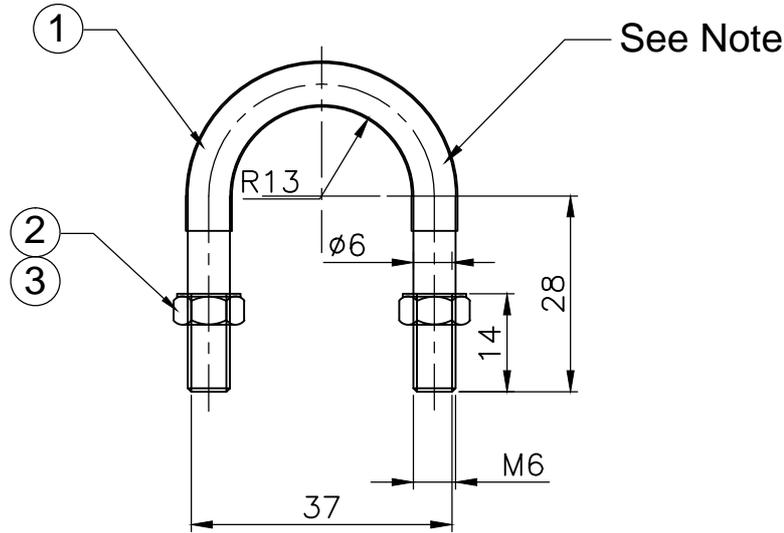
					33x33x2 THK AL.SHEET	Gr.52000 condition'O' to IS:737-2008	Wt. (Kg)
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	MATERIAL		
			PRODUCT	MUMBAI METRO CARS L2&L7			
			REF DRG				
			MATERIAL				
			HEAT TREAT.	APPD	VS	14.11.19	
			SURFACE TREAT.	REVD			
			TITLE	CHKD	SNH	14.11.19	
			PLAIN WASHER-25C	DRWN	VISHNU	14.11.19	
				SCALE		SHEET OF	Wt.(Kg)
						0	
				DRG No.	525-56206		ALT

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NEW FRONTIERS. NEW DREAMS

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

UNCONTROLLED



NOTE:

- REMOVE ALL SHARP EDGES AND BURRS
- FLAME RETARDANT HEAT SHRINK SLEEVE TO BE PROVIDED AS PER DIMENSION & TO BE HEAT SHRICKED.

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	▽
GRADE No.		▽
VALUE		▽
SYMBOL		▽
SURFACE ROUGHNESS	ALT.NO.	

3	2	RFW0920616	Spring Washer-B6 to IS:3063(P-3)-2002/Matl:1367(P-14),SS
2	2	RFN3860652	Hex.head nut M6 to IS:1364(P-3)-2002 / Matl:IS-1367(P-14)Gr-A2-70,SS
1	1		U-BOLT
			Ø6 x105 L
			AISI 304
			COMPANY STD./I.S
			Wt. (Kg)
			MATERIAL

PRODUCT	MUMBAI METRO CARS-L2&L7		
REF DRG			
MATERIAL			
HEAT TREAT.	APPD	VS	14.11.19
SURFACE TREAT.	REVD		
TITLE	CHKD	SNH	14.11.19
U BOLT-25C	DRWN	VISHNU	14.11.19
	SCALE		SHEET
			OF
	DRG No.	525-56207	ALT

BEML LIMITED
NEW FRONTIERS. NEW DREAMS

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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	~

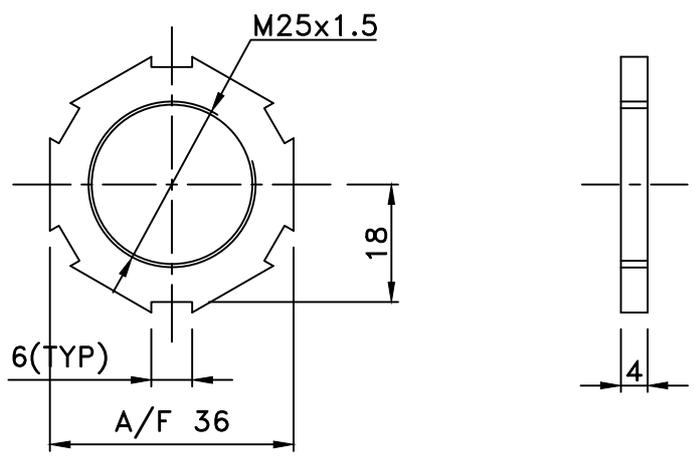
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

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:

UNCONTROLLED



NOTE: REMOVE SHARP EDGES AND BURRS

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	▽
GRADE No.		▽
VALUE		▽
SYMBOL		▽
SURFACE ROUGHNESS		▽

					42x36x4 THK AL. PLATE	Gr.52000 condition 'O' to IS:737-2008	
					SIZE	COMPANY STD./I.S	Wt. (Kg)
						MATERIAL	
				PRODUCT	MUMBAI METRO CARS L2&L7		
				REF DRG			
				MATERIAL			
				HEAT TREAT.	APPD	VS	14.11.19
				SURFACE TREAT.	REVD		
				TITLE	CHKD	SNH	14.11.19
					DRWN	VISHNU	14.11.19
					SCALE	OF	Wt.(Kg)
							0
					DRG No.	ALT	
						525-56208	▽

LOCK NUT-25C

beml BEML LIMITED
NEW FRONTIERS. NEW DREAMS

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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

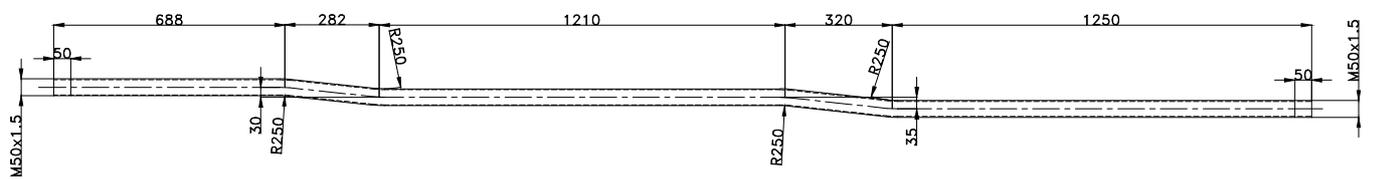
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM) QUALITY OF WELD JOINTS REF, RD 230 MEDIUM

VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS. 1012.C.

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

STATUS:

UNCONTROLLED



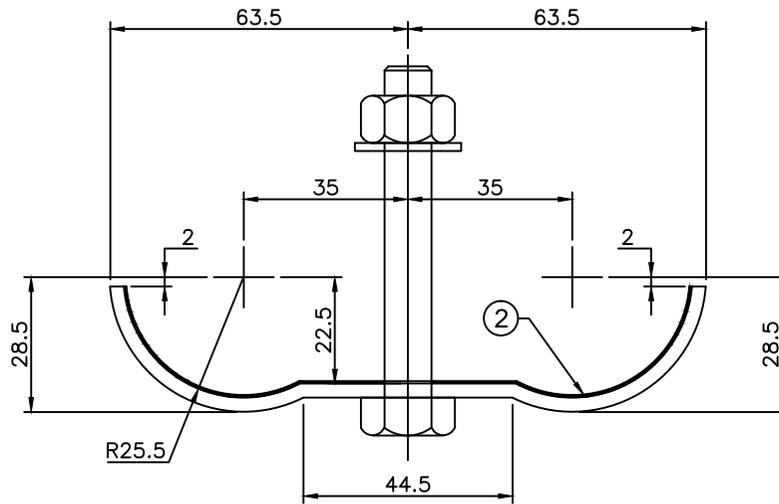
- NOTE:**
1. WELD JOINTS ARE NOT PERMITTED.
 2. CONDUIT PIPE TO BE ANODISED TO Gr.AC15 OF IS:1868
 3. WRINKLES AT BEND REGIONS ARE NOT PERMITTED
 4. PIPE THREADS SHALL MATCH TO THE RESPECTIVE END BUSHING/COUPLER/LOCK NUT THREADS

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
GRADE No. VALUE	
SYMBOL	
SURFACE ROUGHNESS	

					Ø50x3753x2.5w/t	A6063-T5	
						COMPANY STD./I.S	Wt. (Kg)
						MATERIAL	

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE		
			PRODUCT	MUMBAI METRO CARS L2&L7		
			REF DRG			
			MATERIAL			
			HEAT TREAT.	APPD	VS	14.11.19
			SURFACE TREAT.	REVD		
			TITLE	CHKD	SNH	14.11.19
			CONDUIT PIPE 51C-MC	DRWN	VISHNU	14.11.19
				SCALE		SHEET OF
				DRG No.		ALT
				BEML LIMITED		525-56209
ALT.NO.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	

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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:

UNCONTROLLED

5	1	RFW0921022	SPRING WASHER B10 TO IS:3063-1994/ Matl:IS-1367(P14) Gr.A2-70, STAINLESS STEEL			
4	1	RFB1421070	HEX HEAD BOLT M10x70 TO IS:1364(Pt-3)-2002/ Matl:IS-1367(P14) Gr.A2-70, STAINLESS STEEL WITH PRE APPLIED ADHESIVE			
3	1	RFN3861084	HEX. NUT M10 TO IS: 1364(Pt-3)-2002/ Matl:IS-1367(P14) Gr.A2-70, STAINLESS STEEL			
2	1	525-56210-1	PACKING	t0.5 EPDM		
1	1	525-56210-2	CLAMP	t3 AISI 304		
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./IS	Wt. (Kg)
					MATERIAL	
△			PRODUCT	MUMBAI METRO CARS L2&L7		
△			REF DRG			
△			MATERIAL			
△			HEAT TREAT.	APPD	VS	
△			SURFACE TREAT.	REVD		
△			TITLE	CHKD	SNH	
△			CLAMP ASSY-51C	DRWN	VISHNU	27.11.19
△			SCALE	OF	SHEET	Wt.(Kg)
			DRG No.	0	0	0
ALT No.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	ALT
						△

NOTE:

1. REMOVE ALL SHARP EDGES
2. RUBBER ITEM SHALL CONFIRM TO EN45545 HL-3
3. ITEM-2 SHALL BE BONDED TO ITEM-1 WITH ADHESIVE

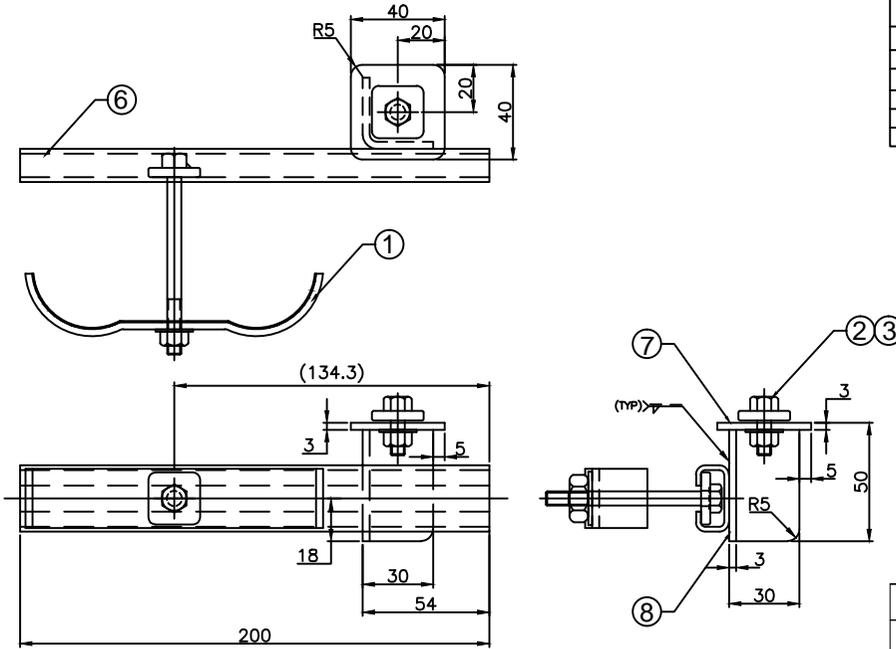
GRADE No.	VALUE	SYMBOL
N1	0.025	△
N2	0.05	△
N3	0.1	△
N4	0.2	△
N5	0.4	△
N6	0.8	△
N7	1.6	△
N8	3.2	△
N9	6.3	△
N10	12.5	△
N11	25	△
N12	50	△

ROUGHNESS

5 4 3 2 1

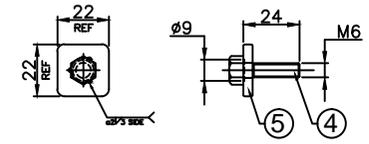
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MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000	RA
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	~
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER 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:		

UNCONTROLLED



DETAIL-3

NOTE: REMOVE ALL SHARP EDGES

8	1	525-56213-8	ANGLE	30x30x3, L=50	AISI 304
7	1	525-56213-7	PLATE	40x40x3 THK	AISI 304
6	1	926-49200-013	RAIL BRACKET		
5	1	555-56360	PAD		
4	1	RFB1420620	HEX.HD.BOLT M6x20 TO IS:1364(Pt-3)-2002/ Matl.: -IS-1367(P14)-84 Gr A2-70, STAINLESS STEEL WITH PRE APPLIED ADHESIVE		
3	1	525-56213-3	T-BOLT ASSY		
2	1	RFN5540652	HEX. NUT WITH FLANGE M6 TO ISO 7044-83/ Matl.: -IS-1367(P14)-84 Gr A2-70, STAINLESS STEEL		
1	1	525-56210	CLAMP ASSY		
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./S MATERIAL
△			PRODUCT	MUMBAI METRO CARS L2&L7	
△			REF DRG		
△			MATERIAL		
△			HEAT TREAT.	APPD	VS
△			SURFACE TREAT.	REVD	
△			TITLE	CHKD	SNH
△			CLAMP ASSY	DRWN	VISHNU 27.11.19
△			SCALE	1:1	SHEET 0 OF 0
△			DRG No.	525-56213	
ALT No.	ECN NO/CHANGES	DATE	BY	ENGD	APPD
				BEML LIMITED	
				525-56213	
				ALT	

GRADE No.	N12	50
VALUE		
SYMBOL		
SURFACE		
ROUGHNESS		

5 4 3 2 1

D

C

B

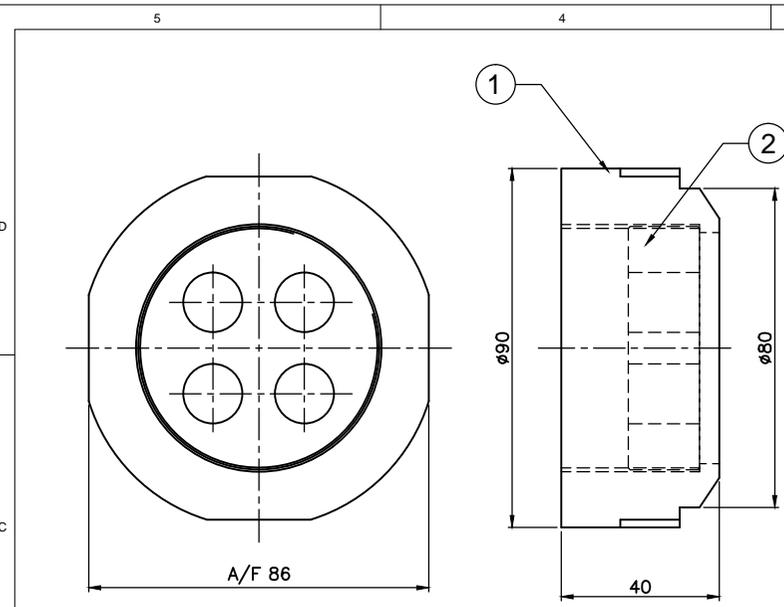
A

5 4 3 2 1

A3

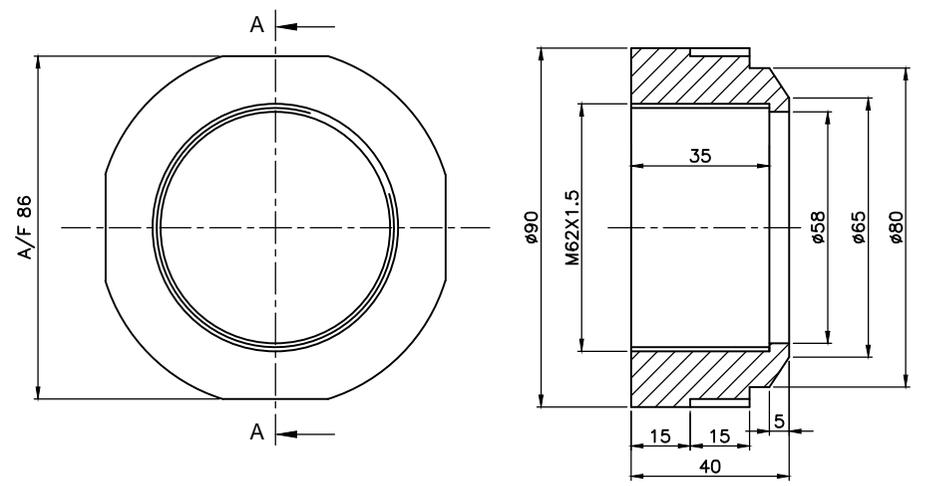
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GRADE No.	
VALUE	
SYMBOL	
SURFACE	
ROUGHNESS	



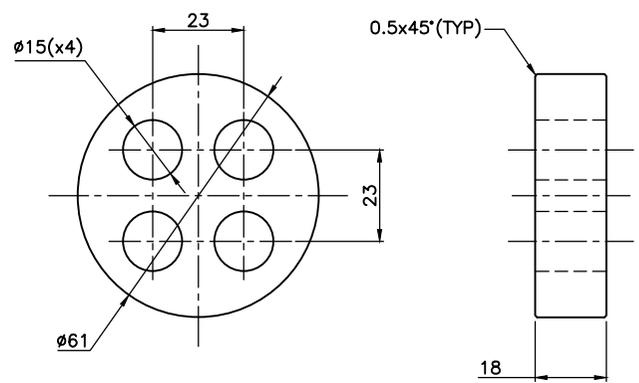
MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000	RA
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	~
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227										
UNSPECIFIED TOLERANCE FOR LINEAR 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:

UNCONTROLLED



DETAIL-1

SECTION-AA



DETAIL-2

NOTE:

- 1.REMOVE ALL SHARP EDGES & DEBURR.
2. ITEM-2 , REQUIREMENTS SHALL BE AS PER EN45545 HL-3 SPECIFICATION

2	1	525-56218-2	SPACER		EPDM
1	1	525-56218-1	BUSH		A 6061
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./IS MATERIAL
△			PRODUCT	MUMBAI METRO CARS L2&L7	
△			REF DRG		
△			MATERIAL		
△			HEAT TREAT. SURFACE TREAT. TITLE	END BUSHING 63C	
△				APPD	KCS 14.11.19
△				REVD	
△				CHKD	SNH 14.11.19
△				DRWN	VISHNU 14.11.19
△				SCALE	0
△				SHEET OF	0
ALT.No.	ECN NO/CHANGES	DATE	BY	CHKD	APPD
BEML LIMITED					525-56218



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	~

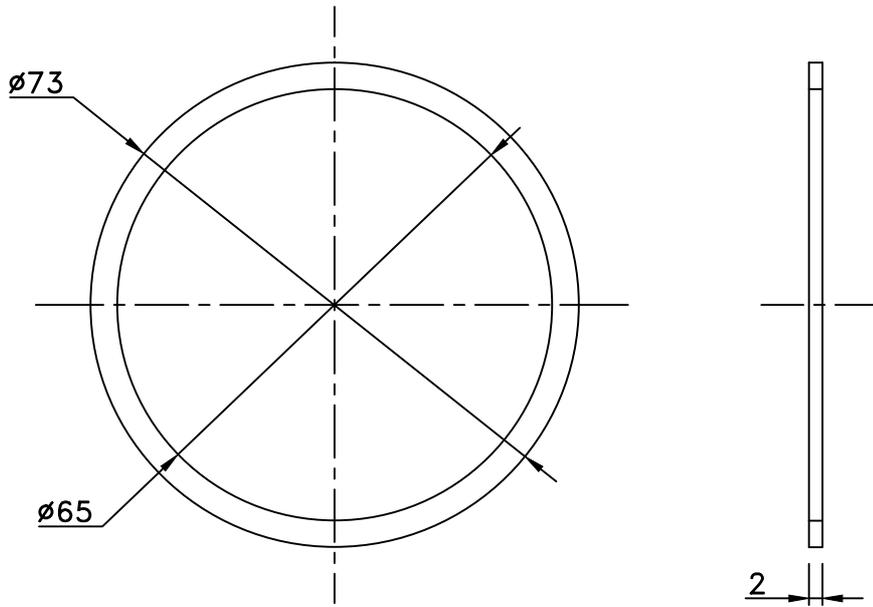
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

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:

UNCONTROLLED



NOTE: REMOVE SHARP EDGES AND BURRS

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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	▽
GRADE No.		▽
VALUE		▽
SYMBOL		▽
SURFACE ROUGHNESS		▽

				73x73x2 THK AL.SHEET		Gr.52000 condition'O' to IS:737-2008		Wt. (Kg)	
SL.No.	QTY	PART / STOCK No.		DESCRIPTION		SIZE		MATERIAL	
				MUMBAI METRO CARS L2&L7					
				PRODUCT					
				REF DRG					
				MATERIAL					
				HEAT TREAT.		APPD	VS	14.11.19	
				SURFACE TREAT.		REVD			
				TITLE		CHKD	SNH	14.11.19	
				PLAIN WASHER-63C		DRWN	VISHNU	14.11.19	
						SCALE		SHEET OF	Wt.(Kg)
								0	
						DRG No.		ALT	
						525-56219			

BEML LIMITED
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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

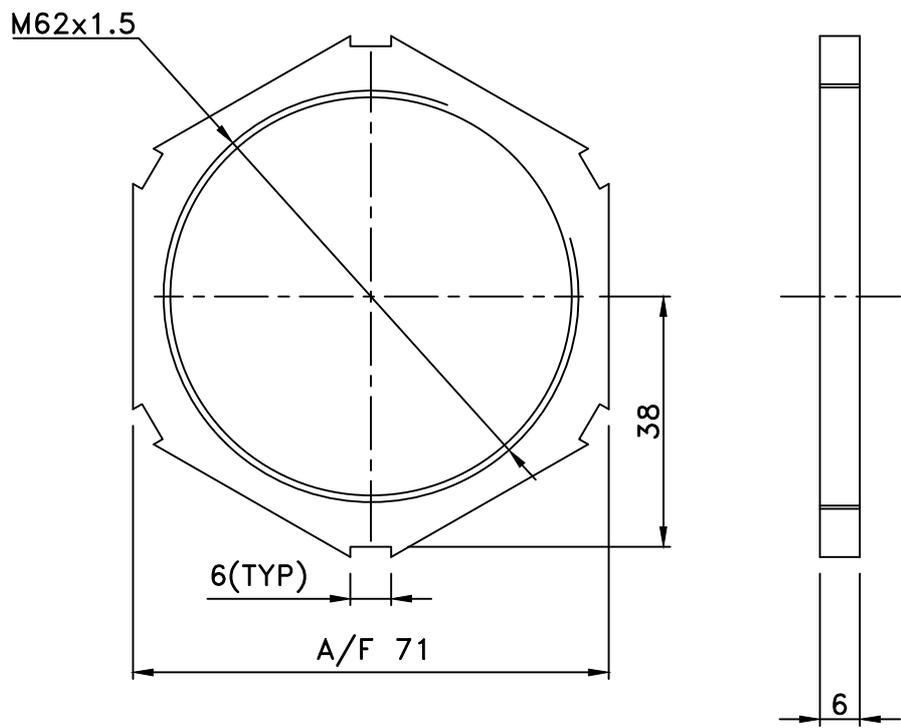
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM) QUALITY OF WELD JOINTS REF, RD 230 MEDIUM

VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS. 1012.C.

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

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UNCONTROLLED



NOTE: REMOVE SHARP EDGES AND BURRS

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	▽
GRADE No.		▽
VALUE		▽
SYMBOL		▽
SURFACE ROUGHNESS		▽

					69x59x6 THK AL. PLATE	Gr.52000 condition 'O' to IS:737-2008	
					SIZE	COMPANY STD./I.S	Wt. (Kg)
						MATERIAL	
				PRODUCT	MUMBAI METRO CARS L2&L7		
				REF DRG			
				MATERIAL			
				HEAT TREAT.	APPD	VS	14.11.19
				SURFACE TREAT.	REVD		
				TITLE	CHKD	SNH	14.11.19
				LOCK NUT-63C	DRWN	VISHNU	14.11.19
					SCALE		SHEET OF
				DRG No.	525-56220		ALT

BEML LIMITED
NEW FRONTIERS. NEW DREAMS

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

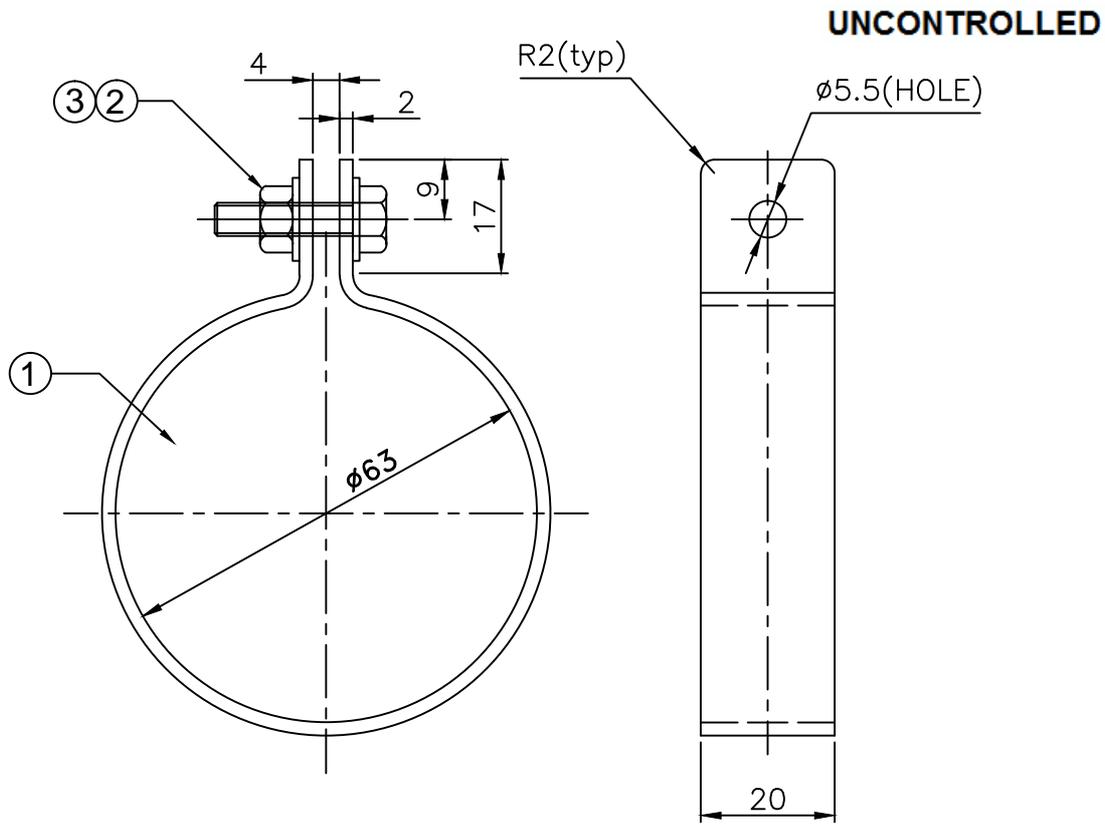
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM) QUALITY OF WELD JOINTS REF, RD 230 MEDIUM

VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS. 1012.C.

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

STATUS: _____

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NOTE: REMOVE ALL SHARP EDGES & DEBURR.

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
GRADE No.	
VALUE	
SYMBOL	
SURFACE ROUGHNESS	

3	1	RFN5850547	HEX HD NUT WITH FLANGE M5 TO ISO:4161-83 / MATL-ISO:3506,Gr-A2-70,SS
2	1	RFB3850520	HEX HEAD FLANGE BOLT FULL THREAD M5x20 TO ISO : 4162-90 / MATL : IS-1367(P-14) Gr-A2-70, SS WITH NYLOK BLUE PATCH PRE APPLIED ADHESIVE
1			CLAMP
			238x20x2 thk
			Gr.52000 condition 'O' to IS:737-2008
			COMPANY STD./I.S
			Wt. (Kg)
			MATERIAL

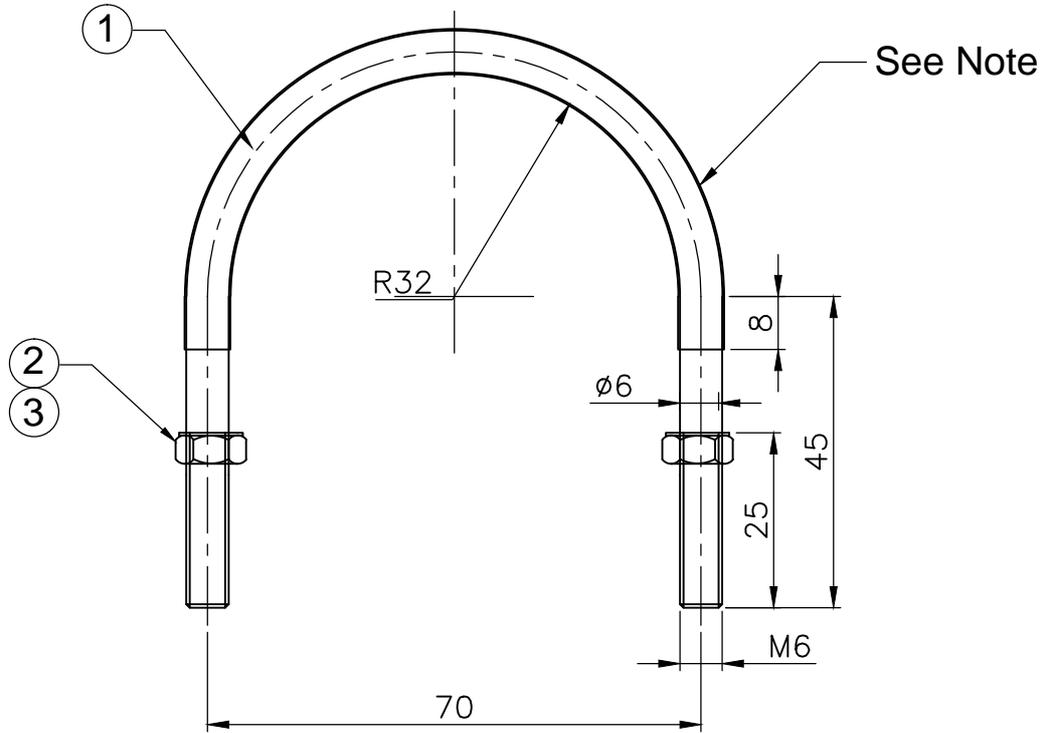
PRODUCT	MUMBAI METRO CARS L2&L7		
REF DRG			
MATERIAL			
HEAT TREAT.	APPD	VS	14.11.19
SURFACE TREAT.	REVD		
TITLE	CHKD	SNH	14.11.19
	DRWN	VISHNU	14.11.19
	SCALE		SHEET OF
			Wt.(Kg) 0
	DRG No.	525-56222	
		ALT	

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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:			

UNCONTROLLED



NOTE:

- REMOVE ALL SHARP EDGES AND BURRS
- FLAME RETARDANT HEAT SHRINK SLEEVE TO BE PROVIDED AS PER DIMENSION & TO BE HEAT SHRIKED.

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
GRADE No.	
VALUE	
SYMBOL	
SURFACE ROUGHNESS	

3	2	RFW0920616	Spring Washer-B6 to IS:3063(P-3)-2002/Matl:1367(P-14),SS
2	2	RFN3860652	Hex.head nut M6 to IS:1364(P-3)-2002 / Matl:IS-1367(P-14)Gr-A2-70,SS

1	1		U-BOLT	Ø6 x187 L	AISI 304	
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
						MATERIAL

PRODUCT		MUMBAI METRO CARS-L2&L7				
REF DRG						
MATERIAL						
HEAT TREAT.		APPD	VS		14.11.19	
SURFACE TREAT.		REVD				
TITLE		CHKD	SNH		14.11.19	
U BOLT-63C		DRWN	VISHNU		14.11.19	
		SCALE	SHEET		Wt.(Kg)	
			OF		0	
		DRG No.	525-56223		ALT	
		BEML LIMITED				