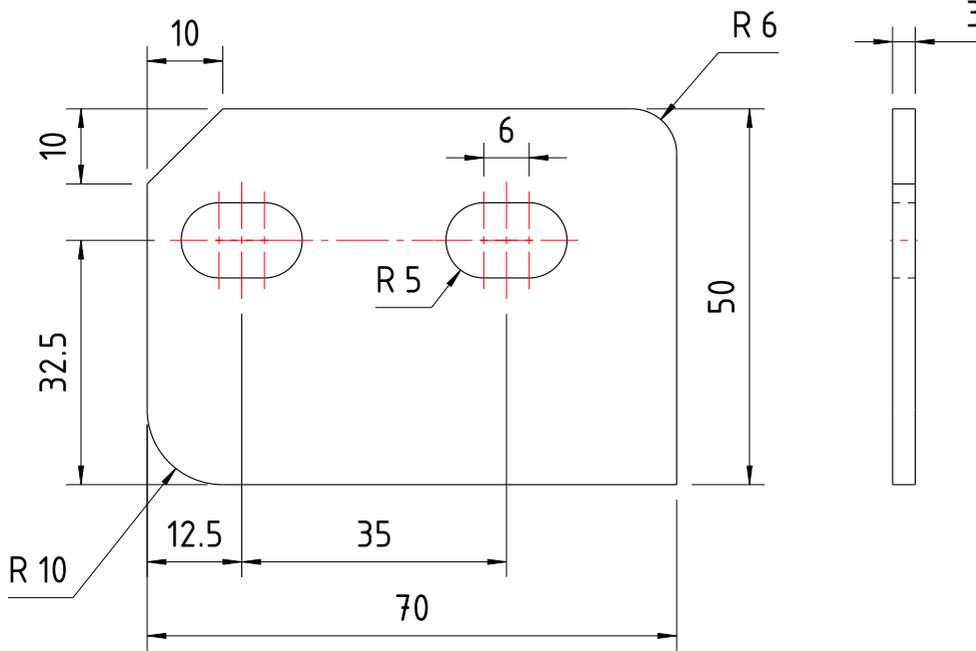


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MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000	RA
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	~
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER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



NOTE:

1. ALL DIMENSIONS ARE IN mm.
2. REMOVE ALL SHARP EDGES AND BURRS.

UNCONTROLLED

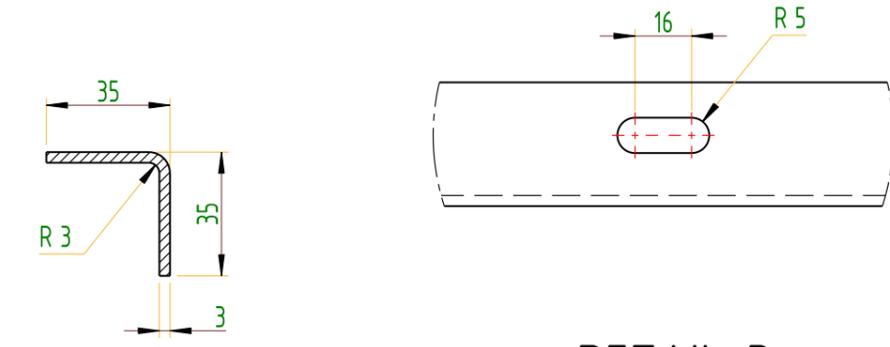
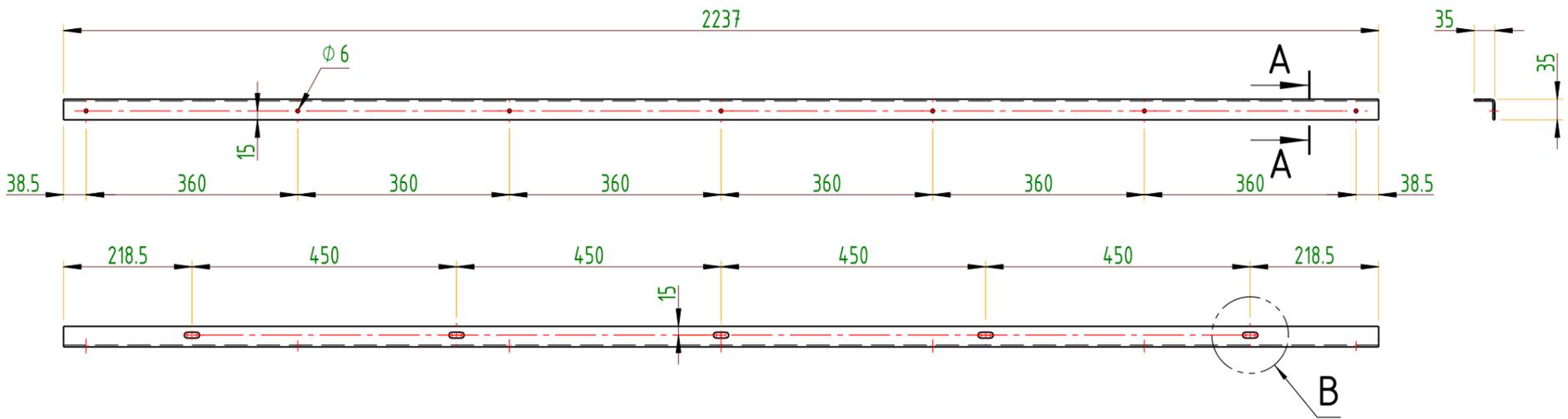
N1	0.025	▽
N2	0.05	▽
N3	0.1	▽
N4	0.2	▽
N5	0.4	▽
N6	0.8	▽
N7	1.6	▽
N8	3.2	▽
N9	6.3	▽
N10	12.5	▽
N11	25	▽
N12	50	▽
GRADE No.		▽
VALUE		▽
SYMBOL		▽
SURFACE ROUGHNESS		▽

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)	
					MATERIAL		
			PRODUCT	MUMBAI METRO CARS L2&L7			
			REF DRG	-			
			MATERIAL	SUS 304 / AISI 304, No. 2B FINISH			
			HEAT TREAT.	-	APPD	30/11/2019	
			SURFACE TREAT.	-	REVD	30/11/2019	
			TITLE	CHKD	30/11/2019		
			SUPPORT	DRWN	30/11/2019		
				SCALE	1:1	SHEET	1 OF 1
				DRG No.	525-23123		ALT
			BEML LIMITED		0		

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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		

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



SECTION A-A
SCALE 1:2

DETAIL B
SCALE 1:2
(TYP)

UNCONTROLLED

NOTE:
 1. ALL DIMENSIONS ARE IN mm.
 2. REMOVE ALL SHARP EDGES AND BURRS.

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
			PRODUCT	MUMBAI METRO CARS L2 & L7		
			REF DRG	-		
			MATERIAL	SUS 304 / AISI 304, No. 2B FINISH		
			HEAT TREAT.	APPD	<i>[Signature]</i>	30/11/2019
			SURFACE TREAT.	REVD	<i>[Signature]</i>	30/11/2019
			TITLE	CHKD	<i>[Signature]</i>	30/11/2019
				DRWN	<i>[Signature]</i>	30/11/2019
				SCALE	1:10	SHEET 1 OF 1
						Wt. 3.4 Kg
				DRG No.	525-23125	
ALT.No.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	ALT 0



525-23125

ALT 0

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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

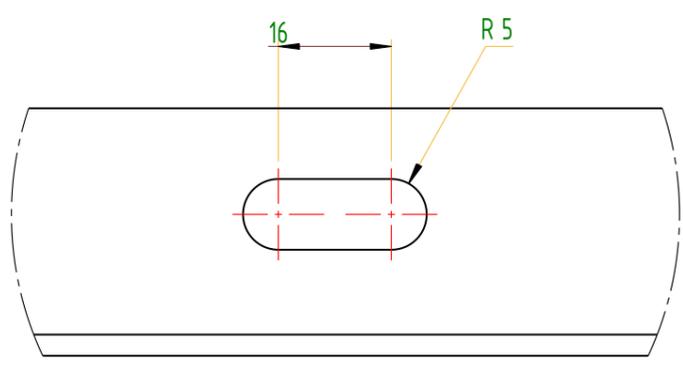
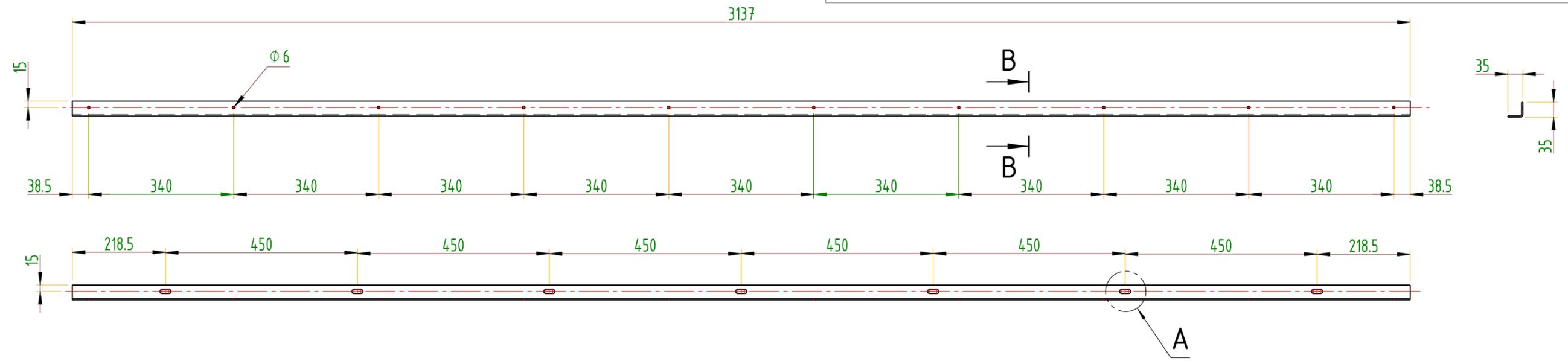
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

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

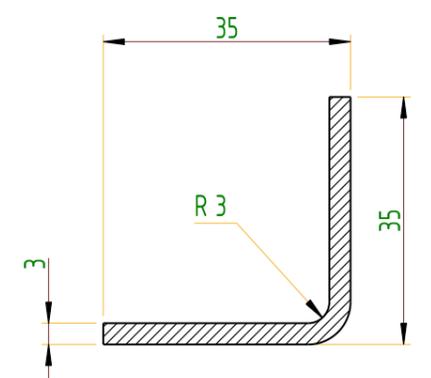
VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS. 1012.C.

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

STATUS: **PROTO/PRODUCTION**



DETAIL A
SCALE 1:1



SECTION B-B
SCALE 1:1

NOTE:

- ALL DIMENSIONS ARE IN mm.
- REMOVE ALL SHARP EDGES AND BURRS.

UNCONTROLLED

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
			PRODUCT	MUMBAI METRO CARS L2 & L7		
			REF DRG	-		
			MATERIAL	SUS 304 / AISI 304, No. 2B FINISH		
			HEAT TREAT.	APPD	<i>K. Mohith</i>	30/11/2019
			SURFACE TREAT.	REVD	<i>R. P. Deshpande</i>	30/11/2019
			TITLE	CHKD	<i>R. P. Deshpande</i>	30/11/2019
				DRWN	<i>K. Mohith</i>	30/11/2019
				SCALE	1:10	SHEET 1 OF 1
						Wt. 4.80 Kg
				DRG No.	525-23126	
ALT.No.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	ALT 0

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NEW FRONTIERS. NEW DREAMS

525-23126

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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	~

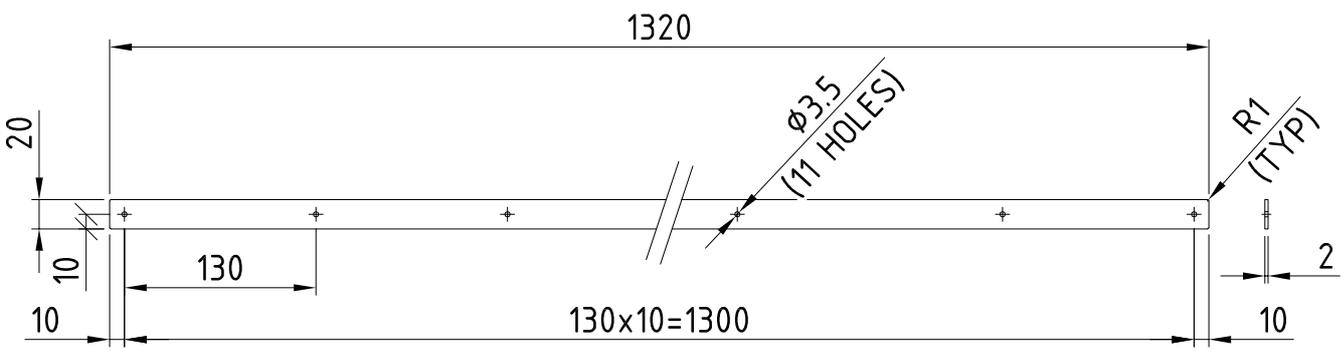
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

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/PRODUCTION**



UNCONTROLLED

NOTE:

1. ALL DIMENSIONS ARE IN mm.
2. REMOVE ALL 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	

						1320x20x2THK				
SL.No.	QTY	PART / STOCK No.	DESCRIPTION			SIZE	COMPANY STD./I.S	Wt. (Kg)		
							MATERIAL			
N8			PRODUCT	MUMBAI METRO CARS L2 & L7						
N9			REF DRG	-						
N10			MATERIAL	AISI 304, No. 2B FINISH						
N11			HEAT TREAT.	-	APPD	<i>[Signature]</i>	25/11/2019			
N12			SURFACE TREAT.	-	REVD	<i>[Signature]</i>	25/11/2019			
			TITLE	STIFFENER, THREE SEATER			CHKD	<i>[Signature]</i>	25/11/2019	
							DRWN	<i>[Signature]</i>	25/11/2019	
							SCALE		SHEET	Wt.(Kg)
							1:5		1 OF 1	-
							DRG No.	525-23138		ALT

BEML LIMITED
NEW FRONTIERS. NEW DREAMS