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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	~

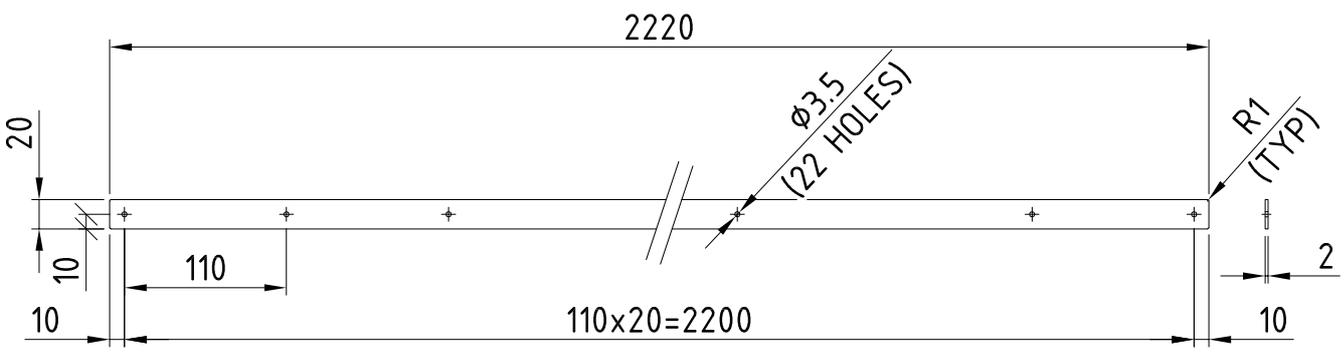
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

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:

- ALL DIMENSIONS ARE IN mm.
- 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	

						2220x20x2THK				
SL.No.	QTY	PART / STOCK No.	DESCRIPTION			SIZE	COMPANY STD./I.S	Wt. (Kg)		
							MATERIAL			
PRODUCT		MUMBAI METRO CARS L2 & L7								
REF DRG		-								
MATERIAL		AISI 304, No. 2B FINISH								
HEAT TREAT.		-		APPD		<i>[Signature]</i>		25/11/2019		
SURFACE TREAT.		-		REVD		<i>[Signature]</i>		25/11/2019		
TITLE		STIFFENER, FIVE SEATER			CHKD		<i>[Signature]</i>		25/11/2019	
					DRWN		<i>[Signature]</i>		25/11/2019	
					SCALE				SHEET	
					1:5		1 OF 1		Wt.(Kg)	
					DRG No.		525-23139		ALT	
					BEML LIMITED <small>NEW FRONTIERS. NEW DREAMS</small>					

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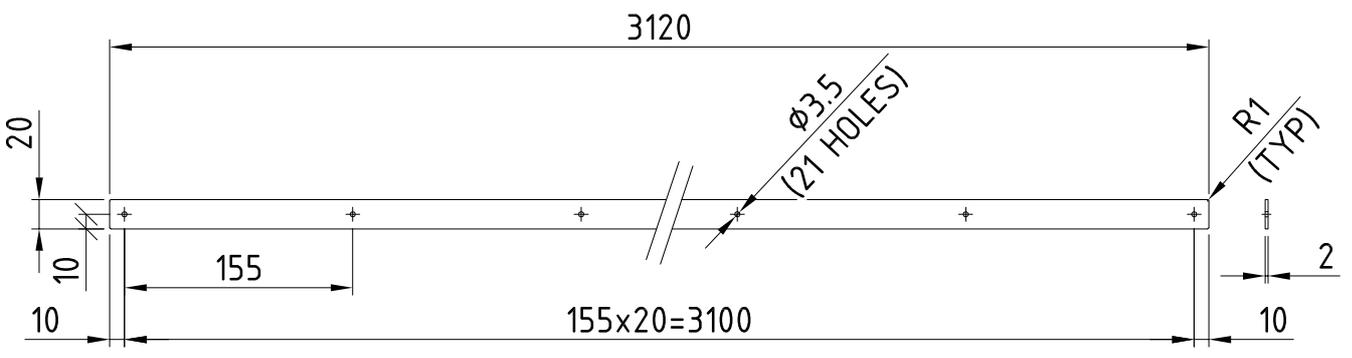
MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000	RA
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	~

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
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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
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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	

				3120x20x2THK					
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S		Wt. (Kg)		
					MATERIAL				
				PRODUCT MUMBAI METRO CARS L2 & L7					
				REF DRG -					
				MATERIAL AISI 304, No. 2B FINISH					
				HEAT TREAT. -		APPD <i>[Signature]</i>		25/11/2019	
				SURFACE TREAT. -		REVD <i>[Signature]</i>		25/11/2019	
				TITLE		CHKD <i>[Signature]</i>		25/11/2019	
				STIFFENER		DRWN <i>[Signature]</i>		25/11/2019	
				SCALE 1:5		SHEET 1 OF 1		Wt.(Kg) -	
				DRG No.		525-23140		ALT 0	
				BEML LIMITED <small>NEW FRONTIERS. NEW DREAMS</small>					

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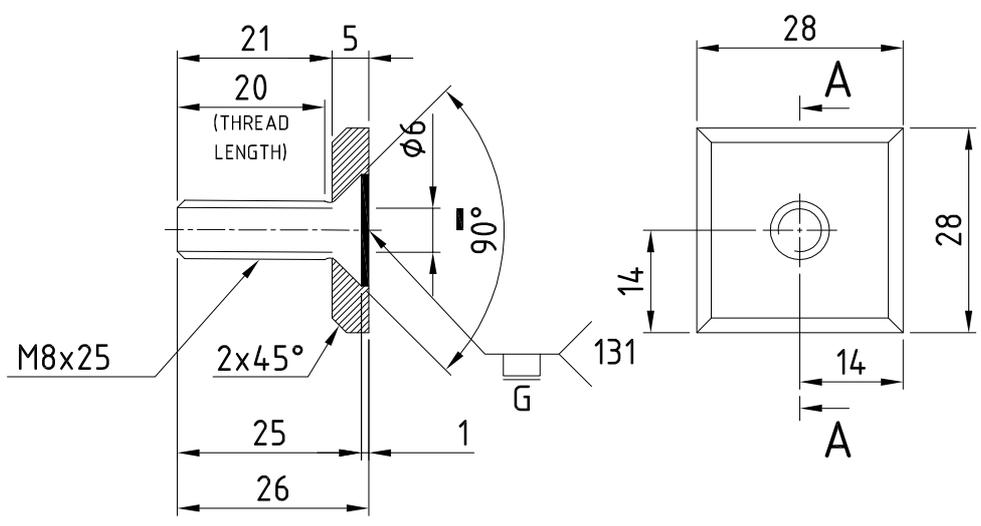
MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000	RA
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	~

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
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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
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SECTION-AA

UNCONTROLLED

NOTE:

1. ALL DIMENSIONS ARE IN mm.
2. REMOVE ALL SHARP EDGES AND BURRS.
3. WELDING SYMBOLS AS PER ISO 2553.
4. NYLOK BLUE PATCH TO BE APPLIED ON THE THREAD.
5. THE SQUARE HEAD BOLT SHALL CONFORM TO DOC. No. GR/TD/4931 (TECHNICAL DELIVERY CONDITIONS).

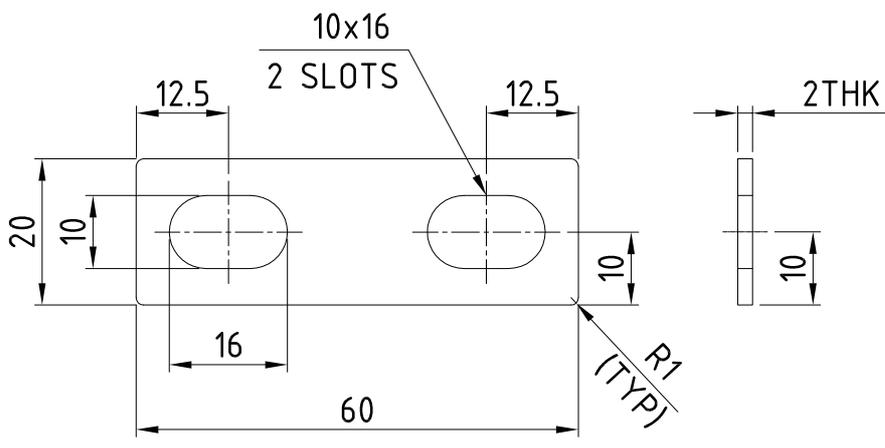
N1	0.025
N2	0.05
N3	0.1
N4	0.2
N5	0.4
N6	0.8
N7	1.6
N8	3.2
N9	6.3
N10	12.5
N11	25
N12	50

2	1	525-23156-2	CSK FLAT HEAD	M8x25	IS:7485/MATL. ISO:3506,Gr. A2-70	
1	1	525-23156-1	PLATE	28x28x5THK	AISI 304, 2B FINISH	
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	<i>[Signature]</i>	25/11/2019	
SURFACE TREAT.	-	REVD	<i>[Signature]</i>	25/11/2019	
TITLE	BOLT, SQUARE HEAD		CHKD	<i>[Signature]</i>	25/11/2019
			DRWN	<i>[Signature]</i>	25/11/2019
	SCALE	1:1	SHEET	1 OF 1	Wt.(Kg)
					-
DRG No.			525-23156		ALT
BEML LIMITED			525-23156		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.							STATUS:	PROTO/PRODUCTION		
WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96										



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		▽

						60x20x2THK				
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>Ajath</i>	25/11/2019			
N12	△		SURFACE TREAT.	-	REVD	<i>R. D. ...</i>	25/11/2019			
			TITLE	SHIM			CHKD	<i>R. D. ...</i>	25/11/2019	
					DRWN	<i>K. Mohith</i>	25/11/2019			
					SCALE	1:1	SHEET	1 OF 1		
							Wt.(Kg)	-		
					DRG No.	525-23157			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	~

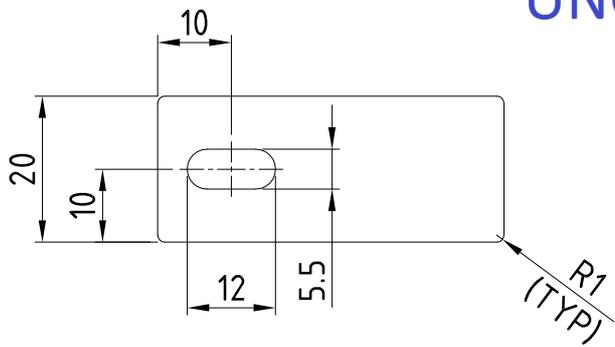
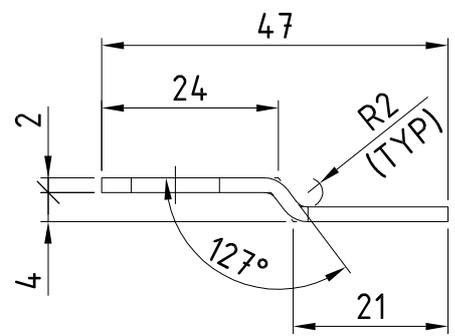
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

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**



UNCONTROLLED

NOTE:

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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		▽

					49x20x2THK		
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)	MATERIAL

					PRODUCT MUMBAI METRO CARS L2 & L7		
					REF DRG -		
					MATERIAL AISI 304, No. 2B FINISH		
					HEAT TREAT.	-	APPD <i>K. Mohith</i> 25/11/2019
					SURFACE TREAT.	-	REVD <i>R. Dwaraknathan</i> 25/11/2019
					TITLE	STOPPER	CHKD <i>R. Dwaraknathan</i> 25/11/2019
					DRWN	<i>K. Mohith</i>	25/11/2019
					SCALE	1:1	SHEET 1 OF 1
					DRG No.	525-23158	Wt.(Kg) -
					BEML LIMITED <small>NEW FRONTIERS. NEW DREAMS</small>		ALT 0