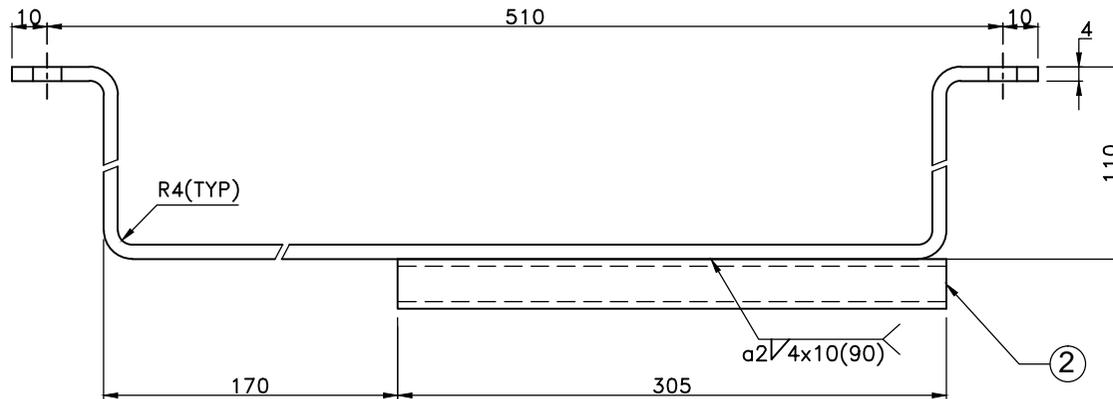


MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227									
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM)									
VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS. 1012.C.									
QUALITY OF WELD JOINTS REF. RD-230 MEDIUM								PROTO / PILOT / PRODUCTION	

UNCONTROLLED



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

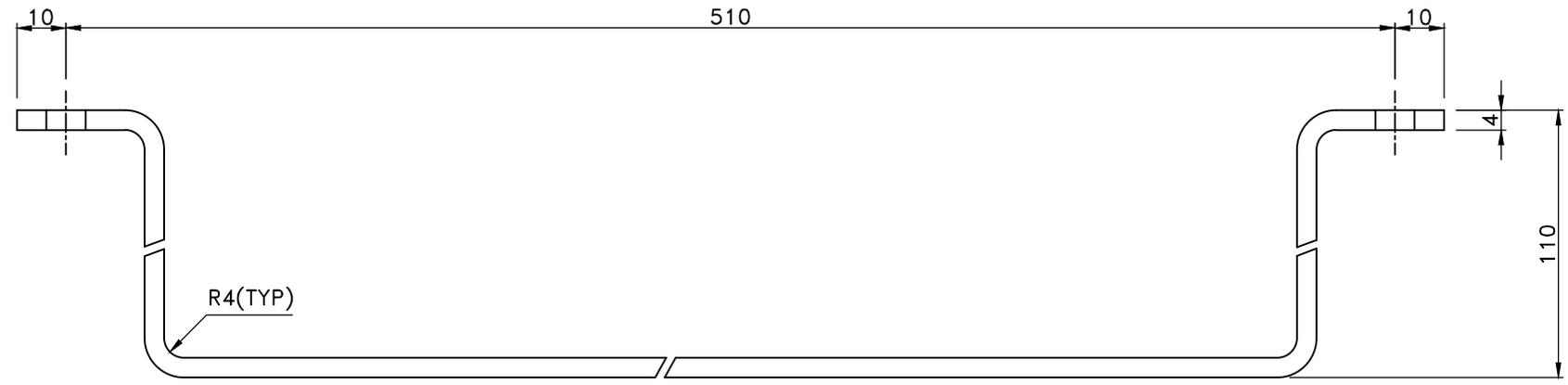
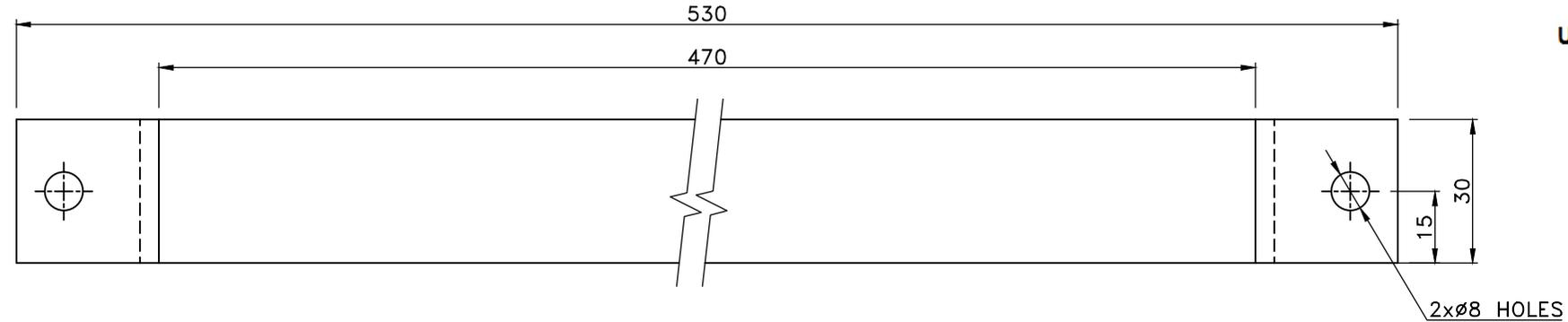
SURFACE ROUGHNESS

2	1	RTR0114325	RAIL BR'T. MOUNTING L.G.S		
1	1	909-56406	WIRE SUPPORT		AISI 304
SI No.	QTY	DRG. / STOCK No.	DESCRIPTION	SIZE	COMPANY STD/IS STD Wt(Kg)
			DETAIL PARTS		MATERIAL
			PRODUCT	DMRC BG METRO CARS	
				SURFACE TREATMENT	
				SCALE	SHEET OF
	2	909-56101	M-CAR		Wt(Kg)
	QTY	NEXT ASSY	MODEL	REF DRG	
	TITLE			APPROVED	12.01.09
	WIRE,SUPPORT			CHECKED	12.01.09
				DRAWN	10.01.09
				DRG No.	ALT
				909-56051	
ALT	CHANGE/ECN No.	DATE	BY	CKD	APP



MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000
	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)									
VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD. DS. 1012.C.									
QUALITY OF WELD JOINTS REF, RD-230 MEDIUM								PROTO / PILOT / PRODUCTION	

UNCONTROLLED



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

732x30x4 THK S.S.SHEET	AISI 304
COMPANY.STD./IS.STD	Wt(Kg)

Sl No.	QTY	DRG. / STOCK No.	DESCRIPTION	SIZE	COMPANY.STD./IS.STD	Wt(Kg)
			DETAIL PARTS	MATERIAL		
PRODUCT DMRC BG METRO CARS						
SURFACE TREATMENT						
01	909-56051	M-CAR	SCALE		SHEET OF	Wt(Kg)
QTY	NEXT ASSY	MODEL	REF DRG			
TITLE WIRE SUPPORT			APPROVED	KCS	12.01.09	
			CHECKED	KRKR	12.01.09	
			DRAWN	SNH	10.01.09	
			DRG No.	909-56406		
ALT	CHANGE/ECN No.	DATE	BY	CKD	APP	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

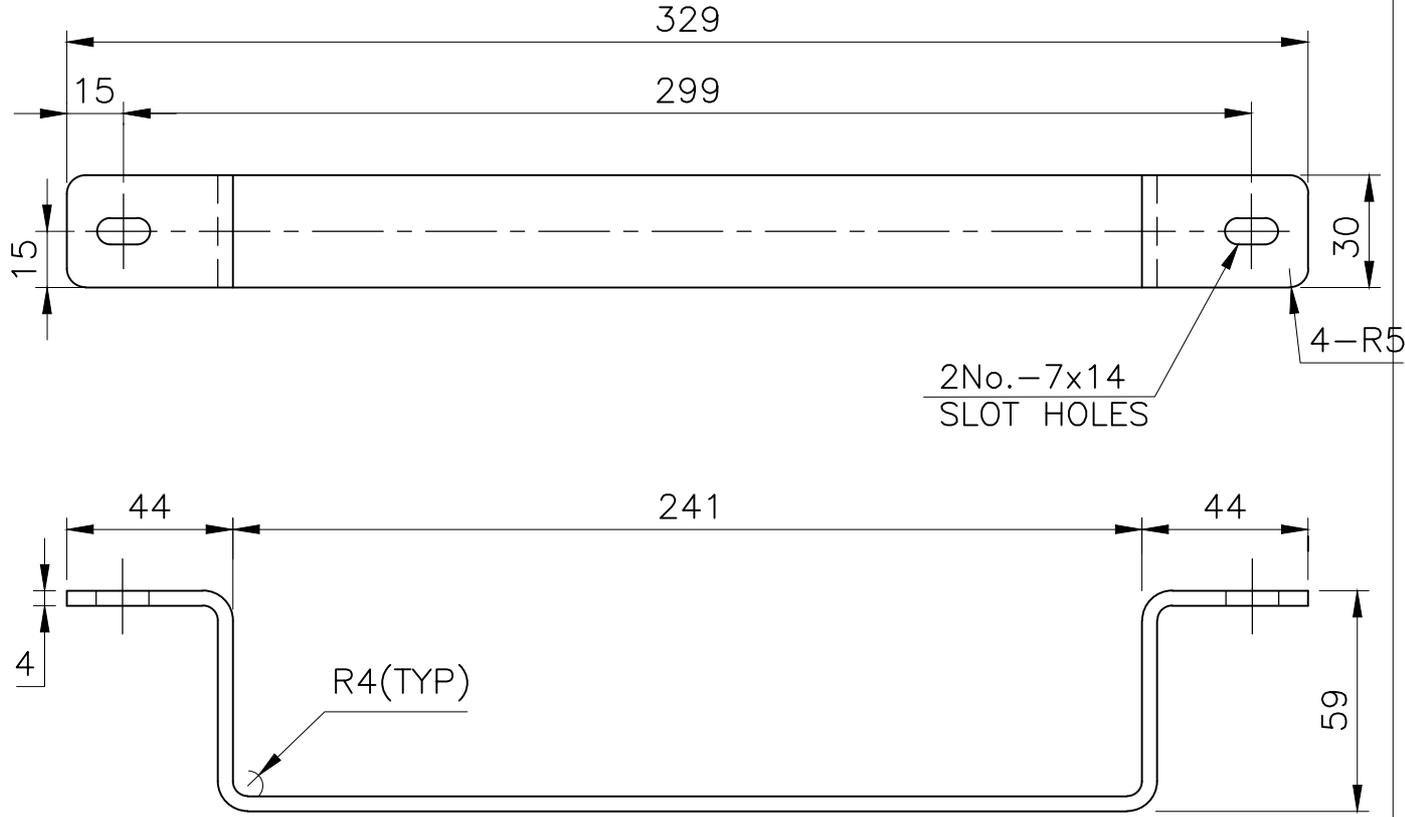
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM) QUALITY OF WELD JOINTS REF, RD 230 MEDIUM

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



2No.-7x14
SLOT HOLES

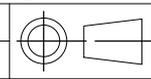
NOTE: REMOVE ALL SHARP EDGES & DEBURR.

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	

				429x30x4 THK		AISI 304	
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)	
				MATERIAL			
				PRODUCT			
				DMRC BG METRO CARS			
				REF DRG			
				909-56607			
				MATERIAL			
				HEAT TREAT.			
				APPD			
				KCS			
				22.4.15			
				SURFACE TREAT.			
				REVD			
				CHKD			
				SNH			
				22.4.15			
				DRWN			
				Jagadish			
				21.4.15			
				SCALE			
				SHEET			
				OF			
				0			
				DRG No.			
				909-56608			
				ALT			
				A4			

SUPPORT

BEML LIMITED
NEW FRONTIERS. NEW DREAMS



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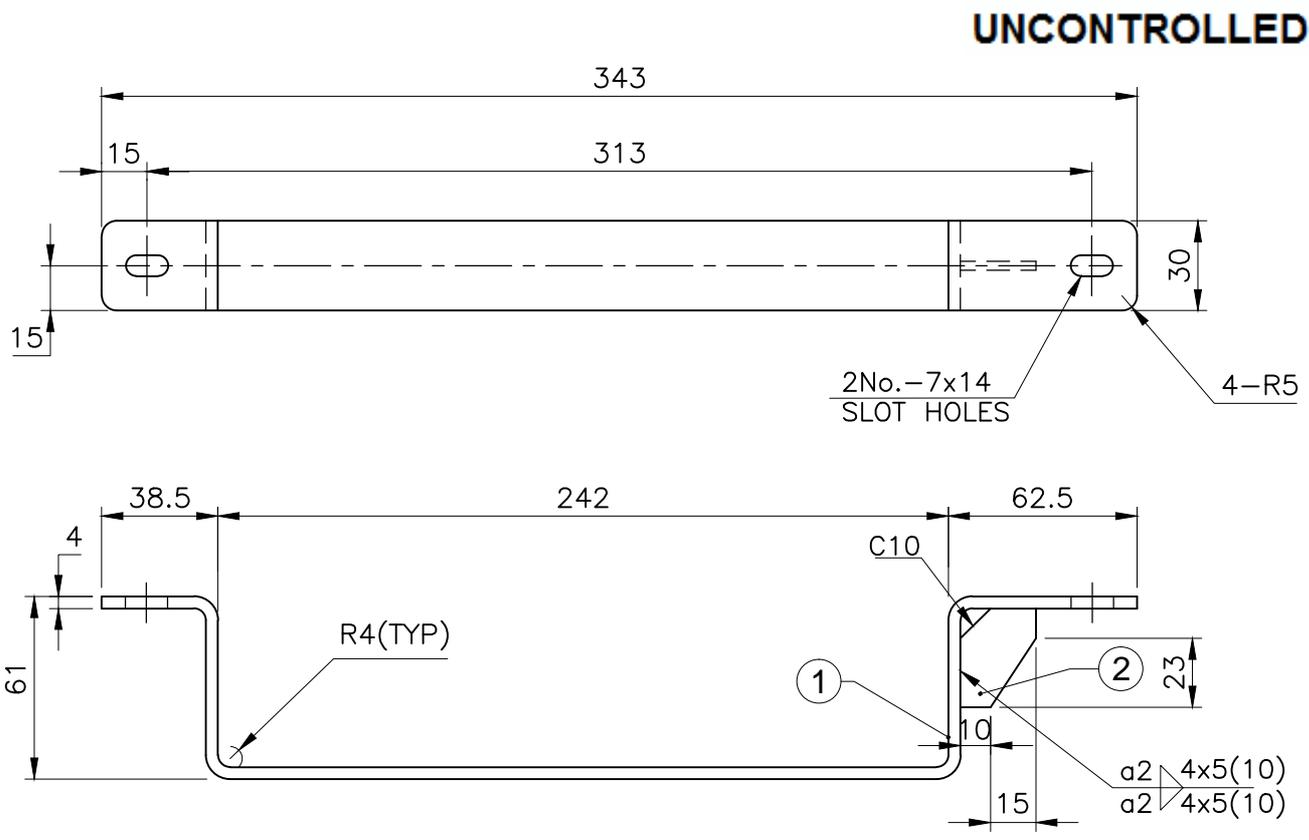
MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000	RA
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	~

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:



NOTE: REMOVE ALL SHARP EDGES & DEBURR.

2	1	909-56611-2	PLATE	33x25x3 THK	AISI 304		
1	1	909-56611-1	BRACKET	473x30x4 THK	AISI 304		
N7	SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
						MATERIAL	

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

PRODUCT: **DMRC BG METRO CARS**

REF DRG: **909-56608**

MATERIAL: **SUPPORT**

HEAT TREAT. APPD: **KCS** 22.4.15

SURFACE TREAT. REVD:

TITLE: **SUPPORT** CHKD: **SNH** 22.4.15

DRWN: **Jagadish** 21.4.15

SCALE: SHEET: **0** Wt.(Kg)

DRG No. **909-56611** 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	~

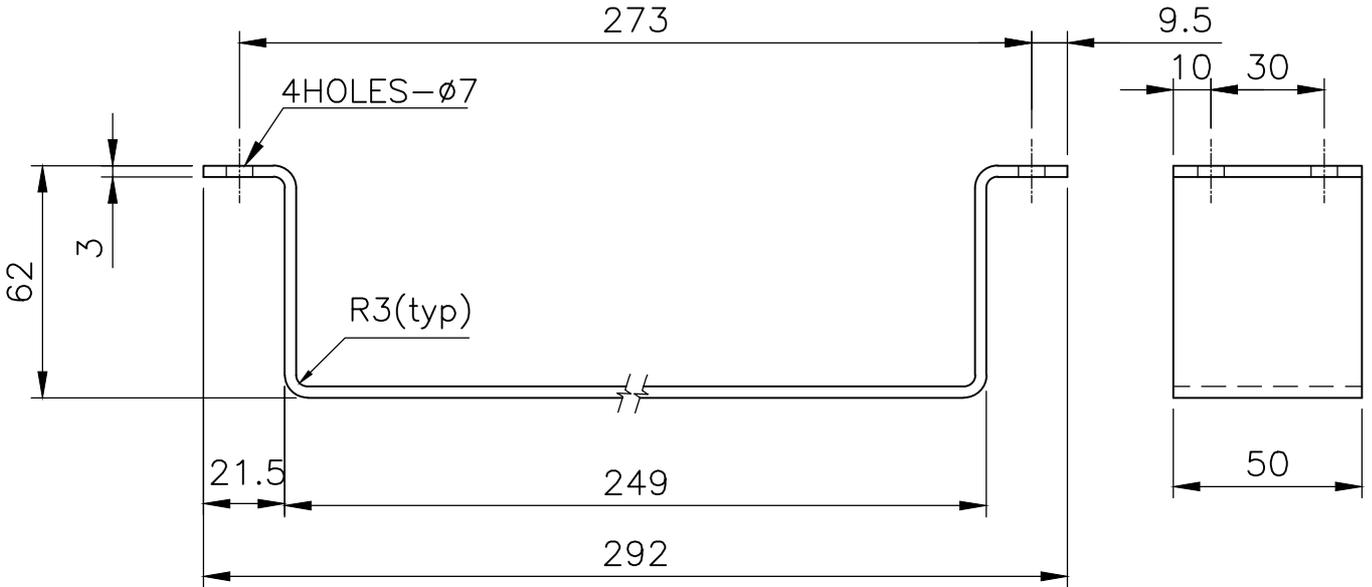
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

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

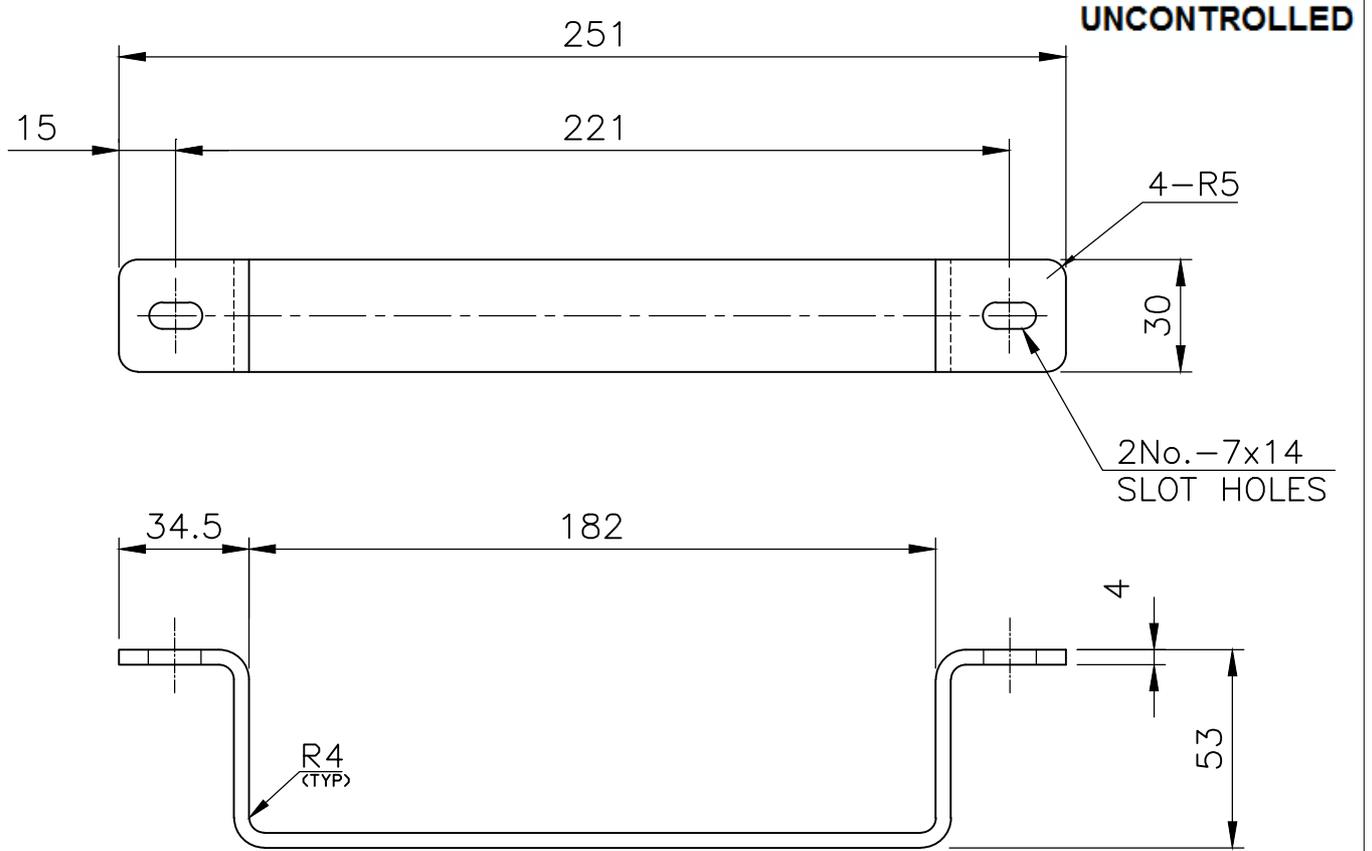


NOTE: REMOVE ALL SHARP EDGES & DEBURR.

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
<p>SL.No. QTY PART / STOCK No. DESCRIPTION SIZE 402x50x3 THK AISI 304 COMPANY STD./I.S Wt. (Kg)</p> <p>MATERIAL</p> <p>PRODUCT DMRC BG METRO CARS</p> <p>REF DRG 909-56008</p> <p>MATERIAL</p> <p>HEAT TREAT. APPD KCS 15.4.15</p> <p>SURFACE TREAT. REVD</p> <p>TITLE SUPPORT CHKD SNH 15.4.15</p> <p>DRWN Jagadish 13.4.15</p> <p>SCALE 1:2 SHEET OF Wt.(Kg) 0</p> <p>DRG No. 909-56747 ALT</p> <p>BEML LIMITED 909-56747 </p> <p>NEW FRONTIERS. NEW DREAMS</p> <p>ALT.NO. ECN NO/CHANGES DATE BY CHKO APPD</p>																							

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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:			



NOTE: REMOVE ALL SHARP EDGES & DEBURR.

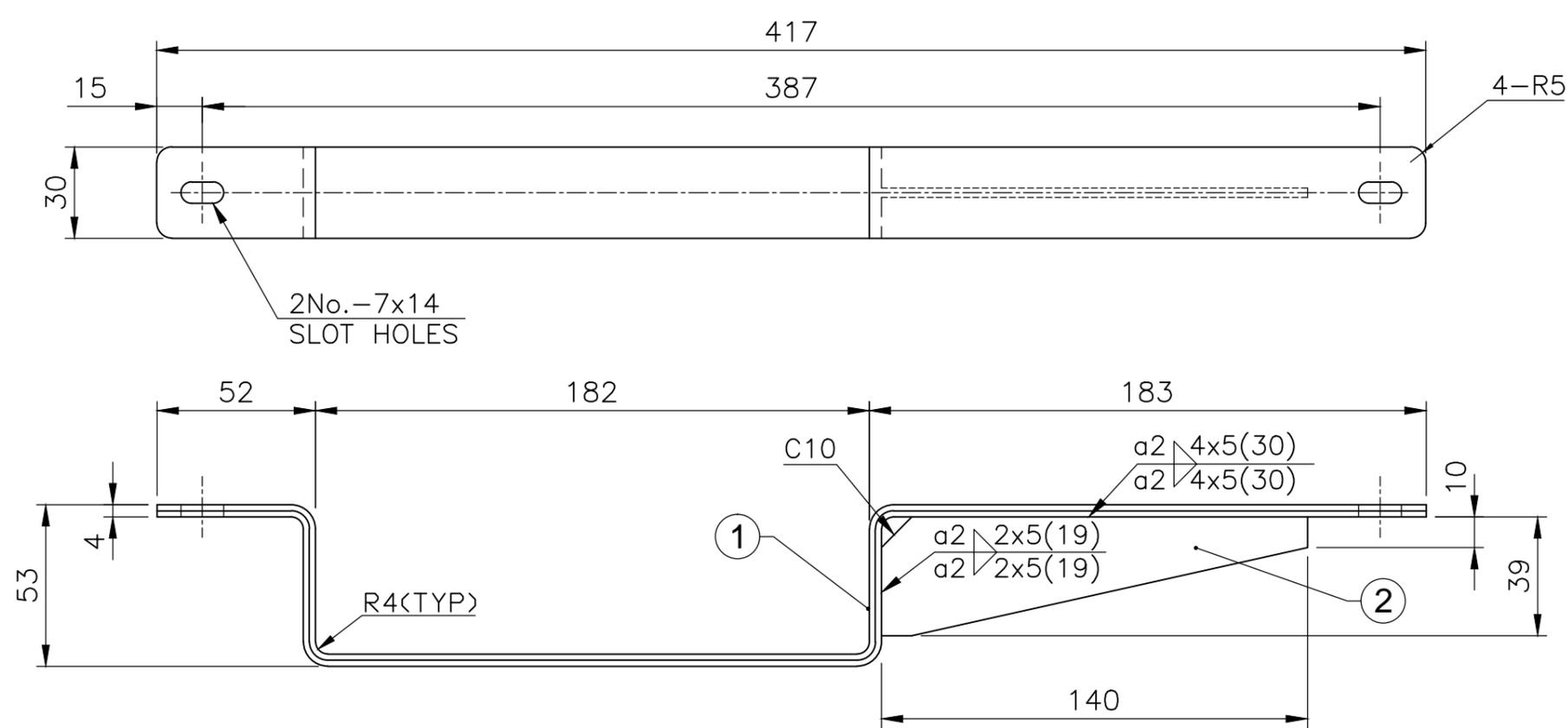
N1	0.025	N2	0.05	N3	0.1	N4	0.2	N5	0.4	N6	0.8	N7	1.6	N8	3.2	N9	6.3	N10	12.5	N11	25	N12	50																																																																																																																									
<table border="1"> <tr> <td>SL.No.</td> <td>QTY</td> <td>PART / STOCK No.</td> <td>DESCRIPTION</td> <td>SIZE</td> <td>339x30x4 THK</td> <td>AISI 304</td> <td>COMPANY STD./I.S</td> <td>Wt. (Kg)</td> </tr> <tr> <td colspan="5"></td> <td colspan="4">MATERIAL</td> </tr> <tr> <td colspan="3"></td> <td>PRODUCT</td> <td colspan="5">DMRC BG METRO CARS</td> </tr> <tr> <td colspan="3"></td> <td>REF DRG</td> <td colspan="5">909-56021</td> </tr> <tr> <td colspan="3"></td> <td>MATERIAL</td> <td colspan="5"></td> </tr> <tr> <td colspan="3"></td> <td>HEAT TREAT.</td> <td>APPD</td> <td colspan="3">KCS</td> <td>15.4.15</td> </tr> <tr> <td colspan="3"></td> <td>SURFACE TREAT.</td> <td>REVD</td> <td colspan="3"></td> <td></td> </tr> <tr> <td colspan="3"></td> <td>TITLE</td> <td>CHKD</td> <td colspan="3">SNH</td> <td>15.4.15</td> </tr> <tr> <td colspan="3"></td> <td rowspan="3">SUPPORT</td> <td>DRWN</td> <td colspan="3">Jagadish</td> <td>13.4.15</td> </tr> <tr> <td>GRADE No.</td> <td>VALUE</td> <td>SYMBOL</td> <td>SCALE</td> <td colspan="2">SHEET</td> <td>Wt.(Kg)</td> </tr> <tr> <td colspan="2"></td> <td></td> <td>1:2</td> <td colspan="2">OF</td> <td>0</td> </tr> <tr> <td colspan="3">SURFACE ROUGHNESS</td> <td>ALT.NO.</td> <td>ECN NO/CHANGES</td> <td>DATE</td> <td>BY</td> <td>CHKD</td> <td>APPD</td> <td>DRG No.</td> <td colspan="2">909-56748</td> <td>ALT</td> </tr> <tr> <td colspan="9"> BEML LIMITED <small>NEW FRONTIERS. NEW DREAMS</small> </td> <td colspan="3"></td> <td></td> </tr> </table>																								SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	339x30x4 THK	AISI 304	COMPANY STD./I.S	Wt. (Kg)						MATERIAL							PRODUCT	DMRC BG METRO CARS								REF DRG	909-56021								MATERIAL									HEAT TREAT.	APPD	KCS			15.4.15				SURFACE TREAT.	REVD								TITLE	CHKD	SNH			15.4.15				SUPPORT	DRWN	Jagadish			13.4.15	GRADE No.	VALUE	SYMBOL	SCALE	SHEET		Wt.(Kg)				1:2	OF		0	SURFACE ROUGHNESS			ALT.NO.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	DRG No.	909-56748		ALT	BEML LIMITED <small>NEW FRONTIERS. NEW DREAMS</small>												
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	339x30x4 THK	AISI 304	COMPANY STD./I.S	Wt. (Kg)																																																																																																																																								
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SURFACE ROUGHNESS			ALT.NO.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	DRG No.	909-56748		ALT																																																																																																																																				
BEML LIMITED <small>NEW FRONTIERS. NEW DREAMS</small>																																																																																																																																																

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GRADE No.	N1	0.025
VALUE	N2	0.05
SYMBOL	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		

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 & DEBURR.

2	1	909-56749-2	PLATE	140x39x3THK.	AISI 304	
1	1	909-56749-1	BRACKET	505x30x4THK.	AISI 304	
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
			PRODUCT	DMRC BG METRO CARS		
			REF DRG	909-56022		
			MATERIAL			
			HEAT TREAT.	APPD	KCS	20.4.15
			SURFACE TREAT.	REVD		
			TITLE	CHKD	SNH	20.4.15
			SUPPORT	DRWN	Jagadisha M	19.4.15
				SCALE	1:2	SHEET OF
			DRG No.	909-56749		
ALT.No.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	ALT
				BEML LIMITED <small>NEW FRONTIERS - NEW DREAMS</small>		

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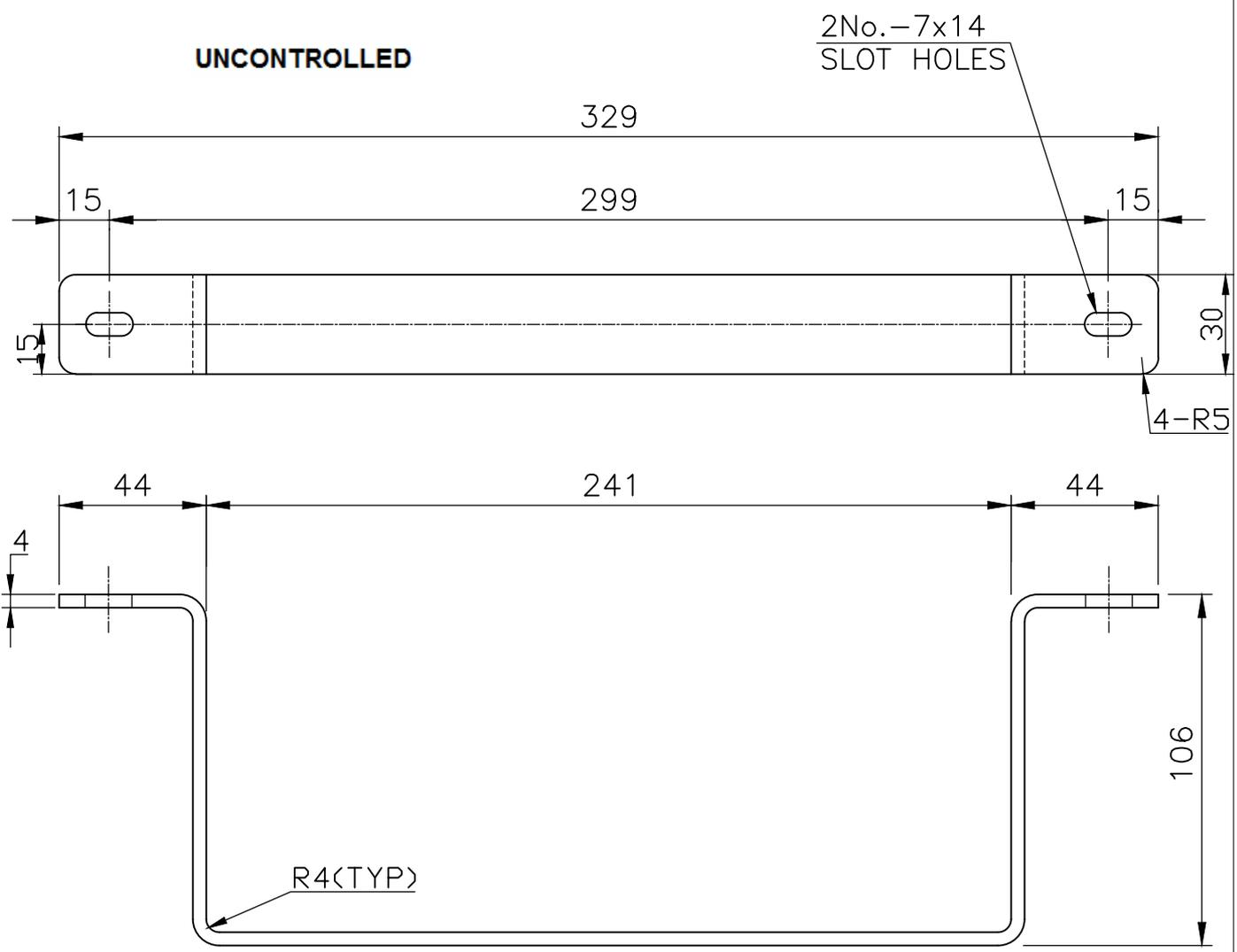
MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000	RA
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	~

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:



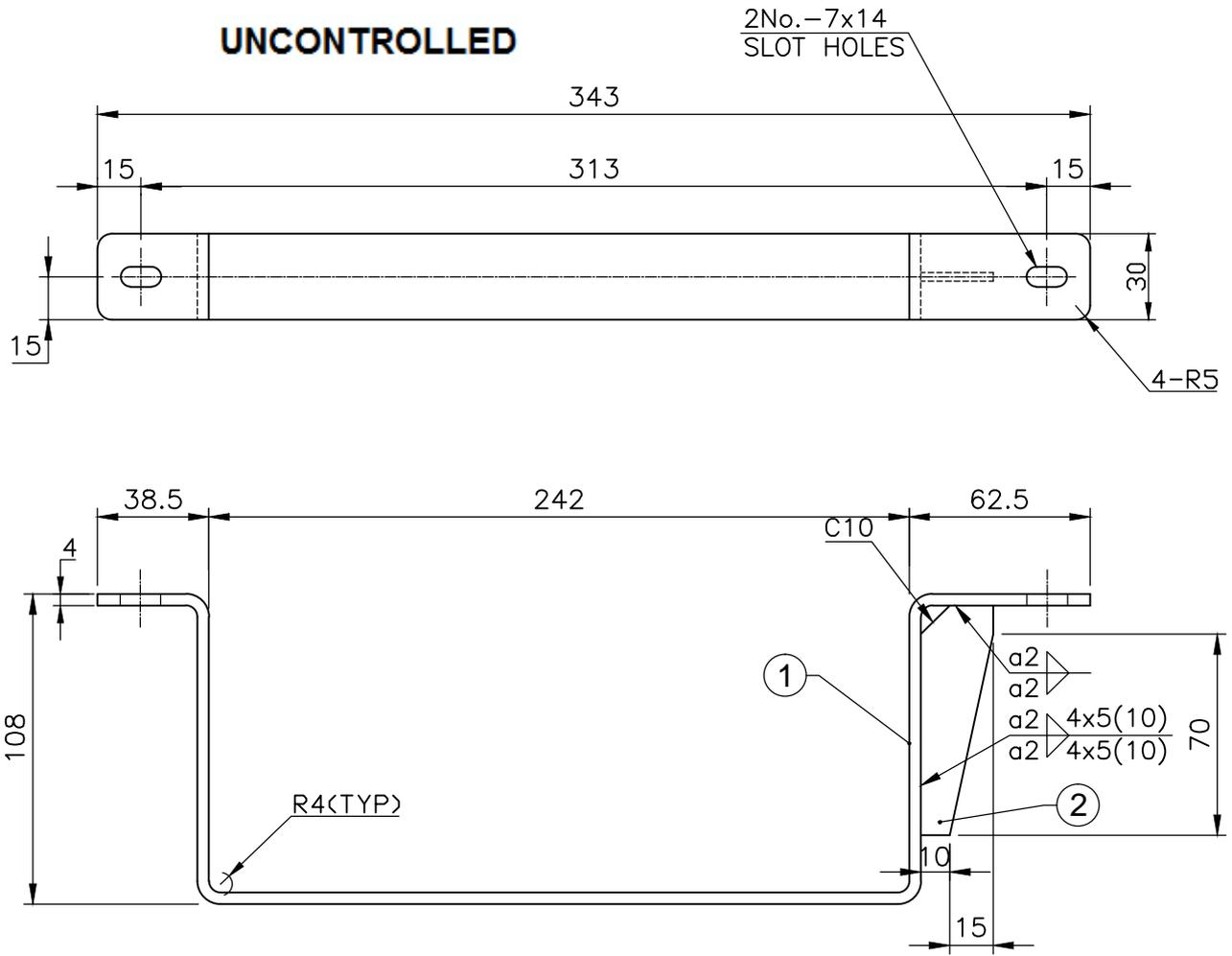
NOTE: REMOVE ALL SHARP EDGES & DEBURR.

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		

				523x30x4 THK		AISI 304		
SL.No.	QTY	PART / STOCK No.	DESCRIPTION			SIZE	COMPANY STD./I.S	Wt. (Kg)
						MATERIAL		
			PRODUCT	DMRC BG METRO CARS				
			REF DRG	909-56027				
			MATERIAL					
			HEAT TREAT.	APPD	KCS			22.4.15
			SURFACE TREAT.	REVD				
			TITLE	CHKD	SNH			22.4.15
			SUPPORT	DRWN	Jagadish			21.4.15
				SCALE	1:2		SHEET OF	0
				DRG No.	909-56753			ALT
ALT.NO.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	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:			



NOTE: REMOVE ALL SHARP EDGES & DEBURR.

2	1	909-56754-2	PLATE	80x25x3 THK	AISI 304		
1	1	909-56754-1	BRACKET	527x30x4 THK	AISI 304		
N7	SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
						MATERIAL	

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

PRODUCT	DMRC BG METRO CARS		
REF DRG	909-56027		
MATERIAL			
HEAT TREAT.	APPD	KCS	22.4.15
SURFACE TREAT.	REVD		
TITLE	CHKD	SNH	22.4.15
SUPPORT	DRWN	Jagadish	21.4.15
	SCALE	1:2	SHEET OF
	SCALE	1:2	SHEET OF
DRG No.			ALT
BEML LIMITED			909-56754

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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)

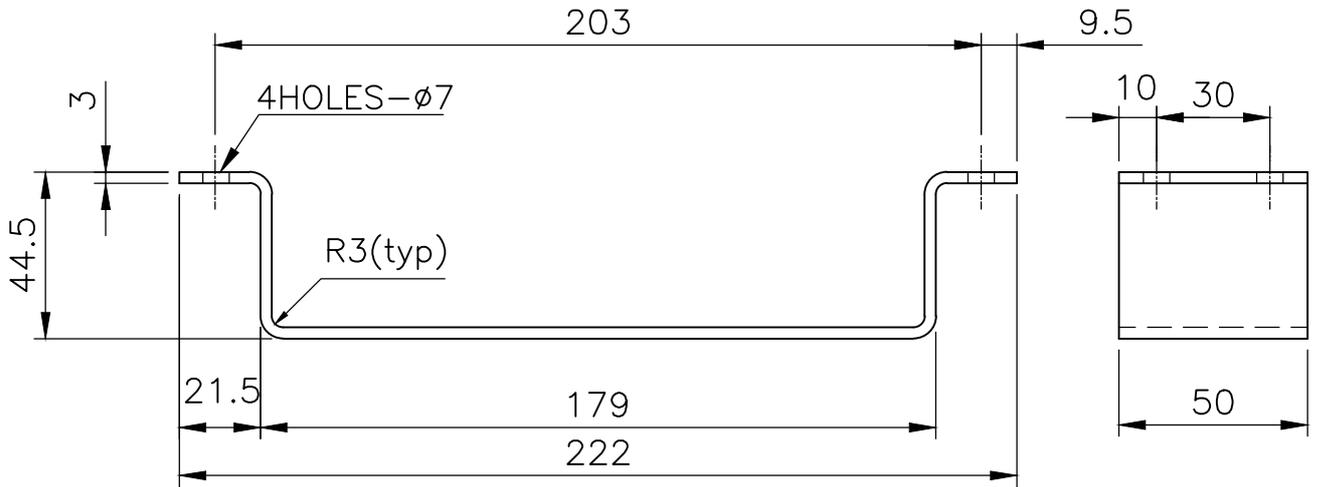
QUALITY OF WELD JOINTS REF, RD 230 MEDIUM

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	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 colspan="6"></td> <td colspan="2">297x50x3 THK</td> <td colspan="2">AISI 304</td> <td colspan="2"></td> <td colspan="2"></td> </tr> <tr> <td>SL.No.</td> <td>QTY</td> <td>PART / STOCK No.</td> <td colspan="3">DESCRIPTION</td> <td colspan="2">SIZE</td> <td colspan="2">COMPANY STD./I.S</td> <td colspan="2">Wt. (Kg)</td> <td colspan="2">MATERIAL</td> </tr> <tr> <td></td> <td></td> <td></td> <td colspan="3">PRODUCT</td> <td colspan="2">DMRC BG METRO CARS</td> <td colspan="2"></td> <td colspan="2"></td> <td colspan="2"></td> </tr> <tr> <td></td> <td></td> <td></td> <td colspan="3">REF DRG</td> <td colspan="2">909-56043</td> <td colspan="2"></td> <td colspan="2"></td> <td colspan="2"></td> </tr> <tr> <td></td> <td></td> <td></td> <td colspan="3">MATERIAL</td> <td colspan="2"></td> <td colspan="2"></td> <td colspan="2"></td> <td colspan="2"></td> </tr> <tr> <td></td> <td></td> <td></td> <td colspan="3">HEAT TREAT.</td> <td colspan="2"></td> <td>APPD</td> <td colspan="2">KCS</td> <td colspan="2"></td> <td>24.4.15</td> </tr> <tr> <td></td> <td></td> <td></td> <td colspan="3">SURFACE TREAT.</td> <td colspan="2"></td> <td>REVD</td> <td colspan="2"></td> <td colspan="2"></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td colspan="3">TITLE</td> <td colspan="2">SUPPORT</td> <td>CHKD</td> <td colspan="2">SNH</td> <td colspan="2"></td> <td>24.4.15</td> </tr> <tr> <td></td> <td></td> <td></td> <td colspan="3"></td> <td colspan="2"></td> <td>DRWN</td> <td colspan="2">Jagadish</td> <td colspan="2"></td> <td>23.4.15</td> </tr> <tr> <td></td> <td></td> <td></td> <td colspan="3"></td> <td colspan="2"></td> <td>SCALE</td> <td colspan="2">1:2</td> <td>SHEET</td> <td colspan="2">OF</td> <td>0</td> </tr> <tr> <td></td> <td></td> <td></td> <td colspan="3"></td> <td colspan="2"></td> <td>DRG No.</td> <td colspan="2">909-56758</td> <td colspan="2"></td> <td>ALT</td> </tr> <tr> <td></td> <td></td> <td></td> <td colspan="3"></td> <td colspan="2"></td> <td colspan="2"> BEML LIMITED <small>NEW FRONTIERS. NEW DREAMS</small> </td> <td colspan="2"></td> <td></td> </tr> </table>																				297x50x3 THK		AISI 304						SL.No.	QTY	PART / STOCK No.	DESCRIPTION			SIZE		COMPANY STD./I.S		Wt. (Kg)		MATERIAL					PRODUCT			DMRC BG METRO CARS											REF DRG			909-56043											MATERIAL														HEAT TREAT.					APPD	KCS				24.4.15				SURFACE TREAT.					REVD									TITLE			SUPPORT		CHKD	SNH				24.4.15									DRWN	Jagadish				23.4.15									SCALE	1:2		SHEET	OF		0									DRG No.	909-56758				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	~

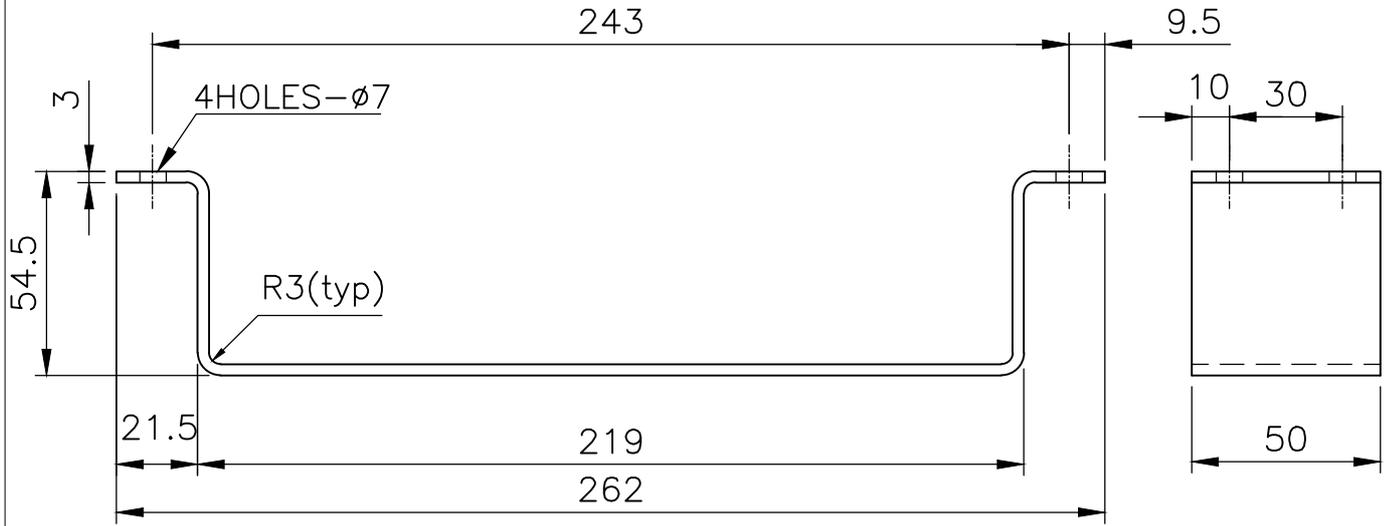
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

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.

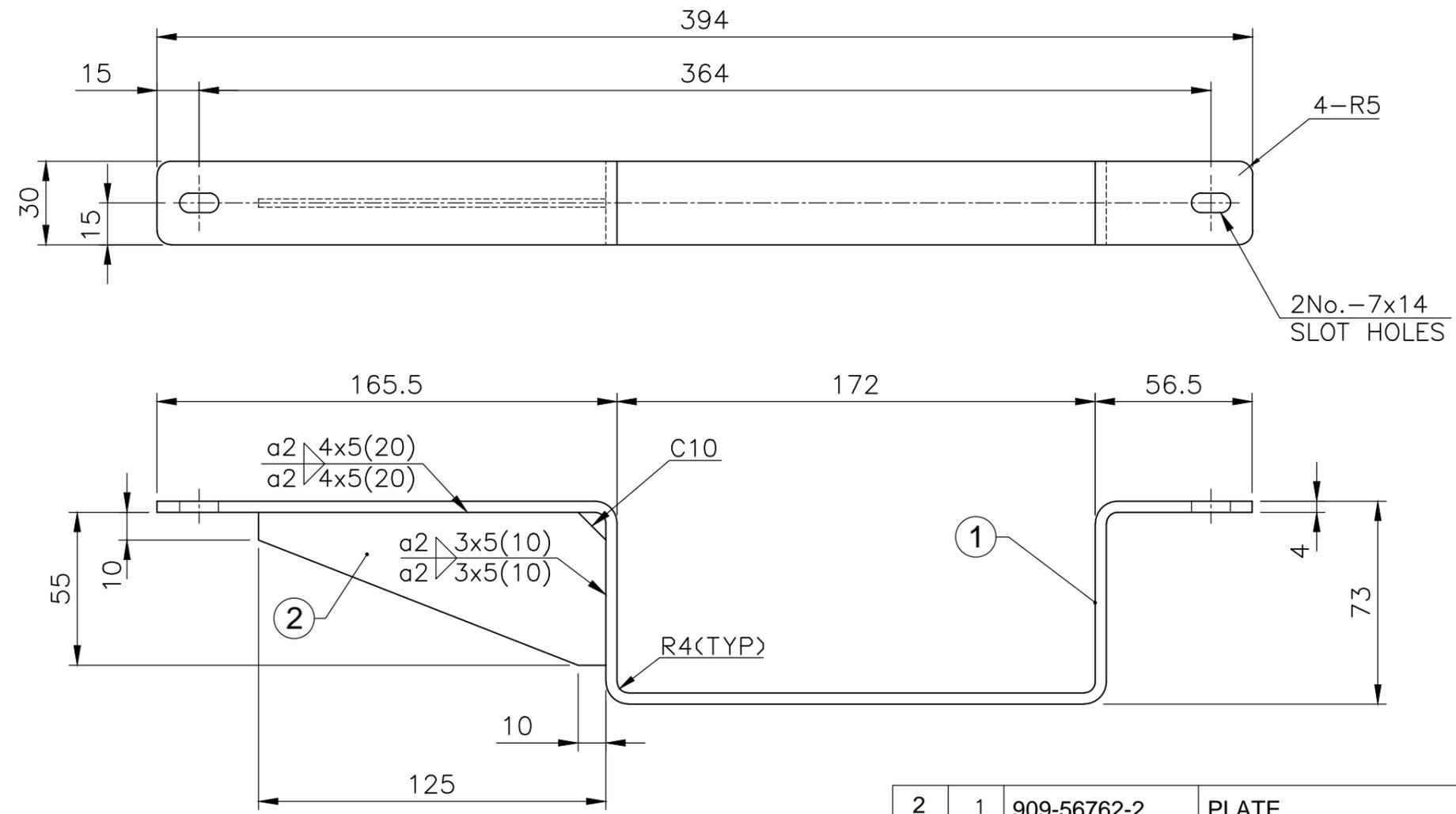
N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12	GRADE No. VALUE	SYMBOL	SURFACE ROUGHNESS																																																																																																														
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<table border="1"> <tr> <td>SL.No.</td> <td>QTY</td> <td>PART / STOCK No.</td> <td>DESCRIPTION</td> <td>SIZE</td> <td>357x50x3 THK</td> <td>AISI 304</td> <td>COMPANY STD./I.S</td> <td>Wt. (Kg)</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td>MATERIAL</td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td>PRODUCT</td> <td colspan="5">DMRC BG METRO CARS</td> </tr> <tr> <td></td> <td></td> <td></td> <td>REF DRG</td> <td colspan="5">909-56044</td> </tr> <tr> <td></td> <td></td> <td></td> <td>MATERIAL</td> <td colspan="5"></td> </tr> <tr> <td></td> <td></td> <td></td> <td>HEAT TREAT.</td> <td>APPD</td> <td colspan="3">KCS</td> <td>24.4.15</td> </tr> <tr> <td></td> <td></td> <td></td> <td>SURFACE TREAT.</td> <td>REVD</td> <td colspan="3"></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td>TITLE</td> <td>CHKD</td> <td colspan="3">SNH</td> <td>24.4.15</td> </tr> <tr> <td></td> <td></td> <td></td> <td rowspan="3">SUPPORT</td> <td>DRWN</td> <td colspan="3">Jagadish</td> <td>23.4.15</td> </tr> <tr> <td></td> <td></td> <td></td> <td>SCALE</td> <td>1:2</td> <td>SHEET</td> <td>OF</td> <td>0</td> </tr> <tr> <td></td> <td></td> <td></td> <td>DRG No.</td> <td colspan="3">909-56759</td> <td>ALT</td> </tr> <tr> <td></td> <td></td> <td></td> <td>ALT.NO.</td> <td>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></td> <td></td> <td></td> </tr> </table>														SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	357x50x3 THK	AISI 304	COMPANY STD./I.S	Wt. (Kg)								MATERIAL					PRODUCT	DMRC BG METRO CARS								REF DRG	909-56044								MATERIAL									HEAT TREAT.	APPD	KCS			24.4.15				SURFACE TREAT.	REVD								TITLE	CHKD	SNH			24.4.15				SUPPORT	DRWN	Jagadish			23.4.15				SCALE	1:2	SHEET	OF	0				DRG No.	909-56759			ALT				ALT.NO.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	BEML LIMITED <small>NEW FRONTIERS. NEW DREAMS</small>				
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	357x50x3 THK	AISI 304	COMPANY STD./I.S	Wt. (Kg)																																																																																																																				
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			MATERIAL																																																																																																																									
			HEAT TREAT.	APPD	KCS			24.4.15																																																																																																																				
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			TITLE	CHKD	SNH			24.4.15																																																																																																																				
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				SCALE	1:2	SHEET	OF	0																																																																																																																				
				DRG No.	909-56759			ALT																																																																																																																				
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GRADE No.	N1	0.025
VALUE	N2	0.05
SYMBOL	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		

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 & DEBURR.

2	1	909-56762-2	PLATE	125x55x3THK.	AISI 304	
1	1	909-56762-1	BRACKET	522x30x4THK.	AISI 304	
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
					MATERIAL	
			PRODUCT	DMRC BG METRO CARS		
			REF DRG	909-56047		
			MATERIAL			
			HEAT TREAT.	APPD	KCS	28.4.15
			SURFACE TREAT.	REVD		
			TITLE	CHKD	SNH	28.4.15
				DRWN	Jagadisha M	27.4.15
				SCALE	1:2	
				SHEET	OF	0
				DRG No.	909-56762	
ALT.No.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	ALT



909-56762

A3

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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)

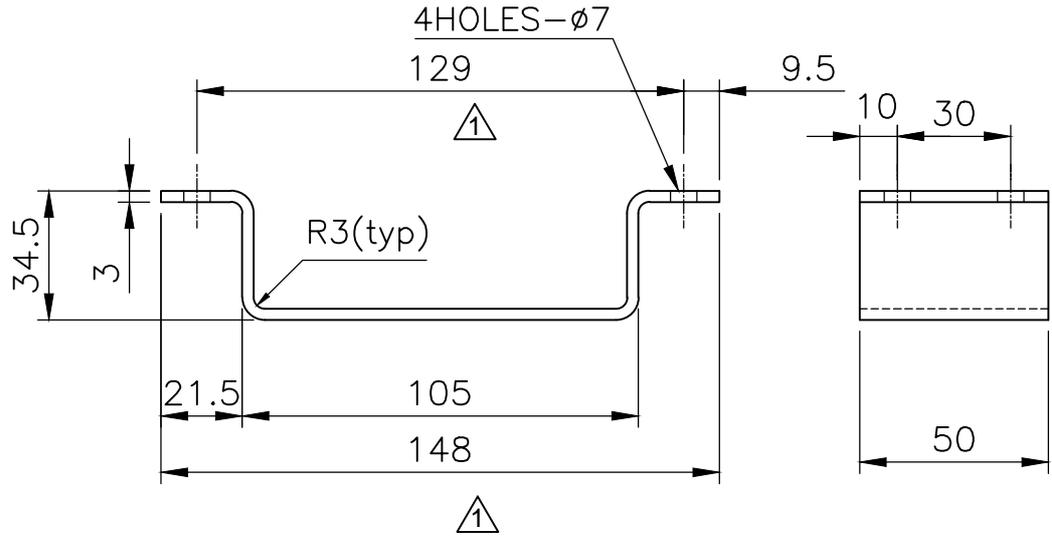
QUALITY OF WELD JOINTS REF, RD 230 MEDIUM

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
1		▽
SURFACE ROUGHNESS	ALT.NO.	ECN NO/CHANGES
DATE	BY	CHKD
09.05.18	Vishnu	SNH
APPD		KCS

						205x50x3 THK		AISI 304	
SL.No.	QTY	PART / STOCK No.		DESCRIPTION		SIZE		COMPANY STD./I.S	Wt. (Kg)
								MATERIAL	
				PRODUCT	DMRC BG METRO CARS				
				REF DRG	909-56730				
				MATERIAL					
				HEAT TREAT.			APPD	KCS	
				SURFACE TREAT.			REVD		
				TITLE			CHKD	SNH	
							DRWN	Jagadish	
							SCALE	SHEET	
							1:2	OF	
							DRG No.	ALT	
							909-56763	1	
				BEML LIMITED <small>NEW FRONTIERS. NEW DREAMS</small>					

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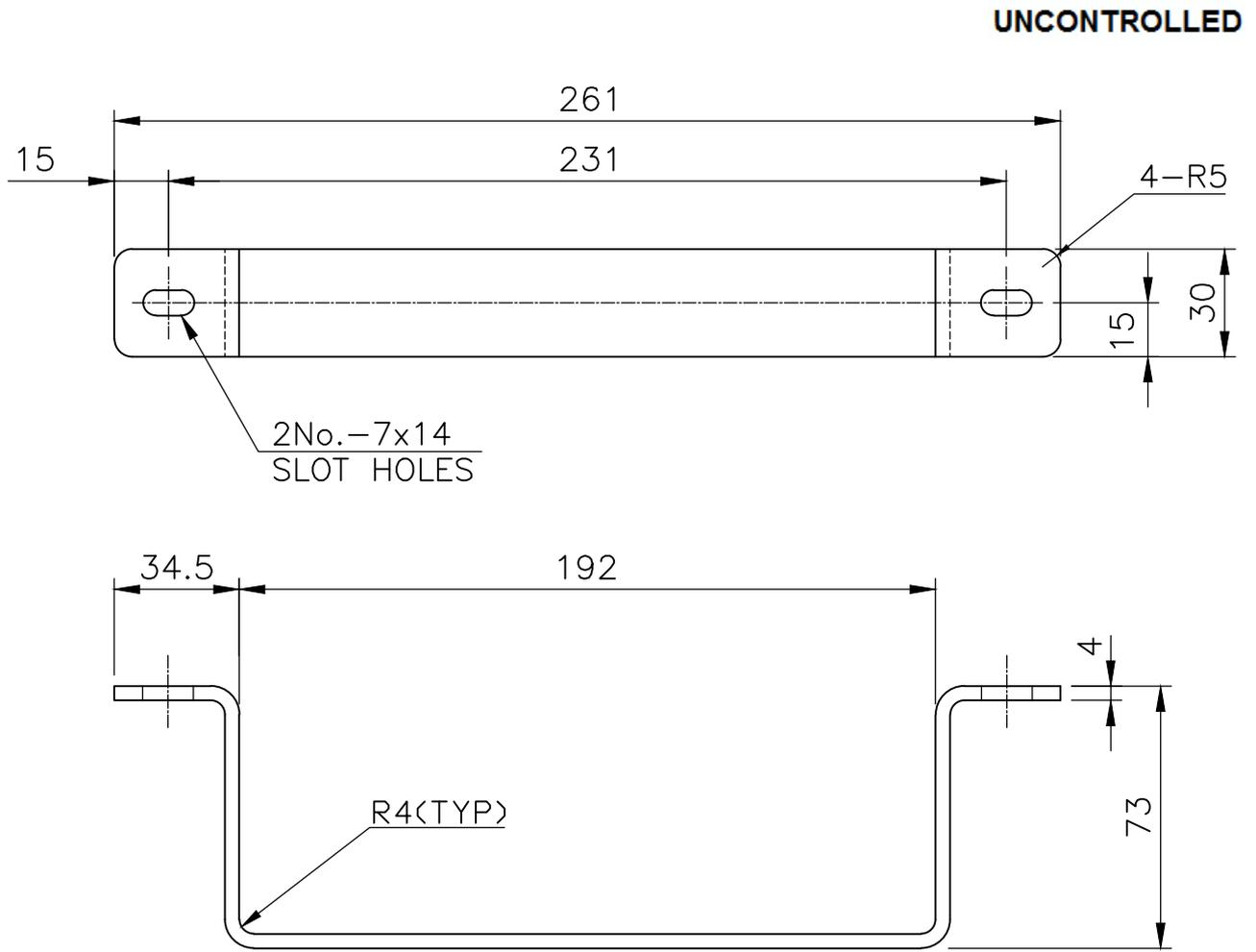
MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000	RA
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	~

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:



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	

					389x30x4 THK	AISI 304	
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S		Wt. (Kg)
					MATERIAL		

PRODUCT	DMRC BG METRO CARS						
REF DRG	909-56048						
MATERIAL							
HEAT TREAT.					APPD	KCS	15.4.15
SURFACE TREAT.					REVD		
TITLE	SUPPORT				CHKD	SNH	15.4.15
					DRWN	Jagadish	13.4.15
					SCALE	1:2	SHEET
				DRG No.	909-56764		ALT
AL.T.NO.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	BEML LIMITED NEW FRONTIERS. NEW DREAMS	

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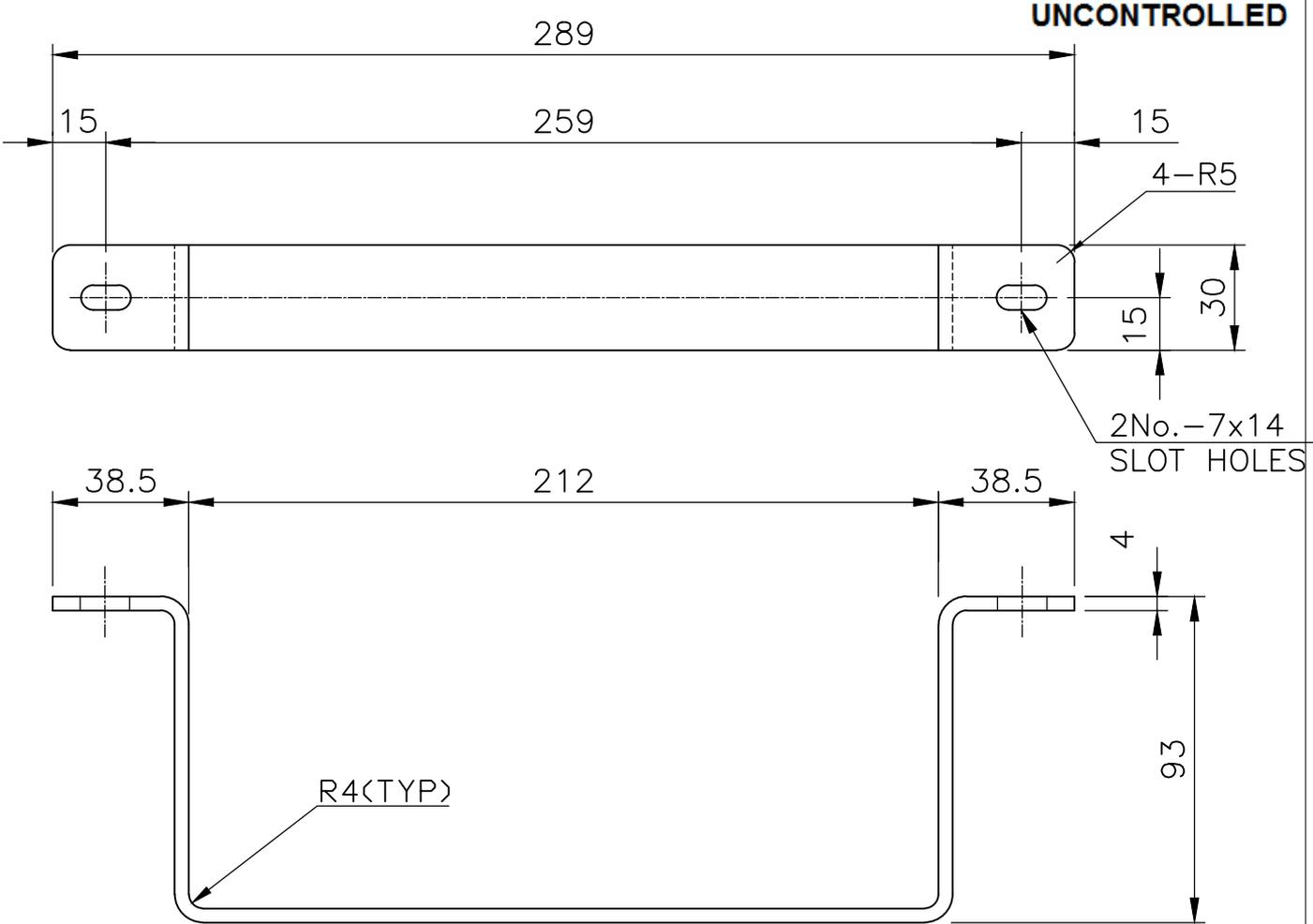
MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000	RA
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	~

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:



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	ALT.NO.	ECN NO/CHANGES
	DATE	BY
	CHKD	APPD

						457x30x4 THK		AISI 304	
SL.No.	QTY	PART / STOCK No.		DESCRIPTION		SIZE		COMPANY STD./I.S	Wt. (Kg)
								MATERIAL	
				PRODUCT	DMRC BG METRO CARS				
				REF DRG	909-56049				
				MATERIAL					
				HEAT TREAT.		APPD	K.C.S		15.4.15
				SURFACE TREAT.		REVD			
				TITLE	SUPPORT		CHKD	S.N.H	
						DRWN	Jagadish		13.4.15
						SCALE	1:2	SHEET	0
								OF	
						DRG No.	909-56765		ALT
									△

BEML LIMITED
NEW FRONTIERS. NEW DREAMS

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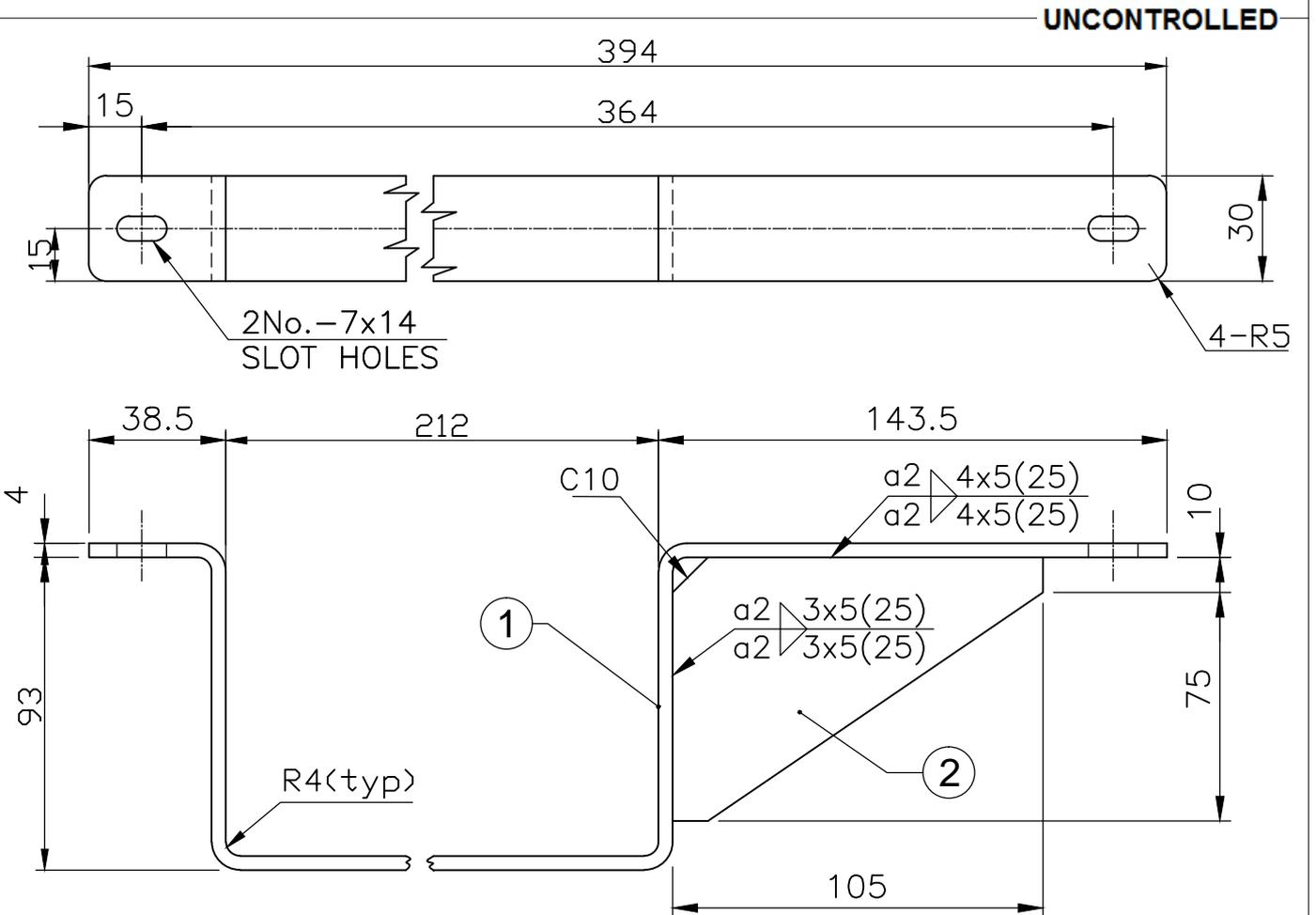
MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000	RA
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	~

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:



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
----	-------	----	------	----	-----	----	-----	----	-----	----	-----	----	-----	----	-----	----	-----	-----	------	-----	----	-----	----

NOTE: REMOVE ALL SHARP EDGES & DEBURR.

2	1	909-56766-2	PLATE	105x85x3 THK	AISI 304	
1	1	909-56766-1	BRACKET	562x30x4 THK	AISI 304	
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
					MATERIAL	

PRODUCT	DMRC BG METRO CARS					
REF DRG	909-56050					
MATERIAL						
HEAT TREAT.	APPD	KCS	30.4.15			
SURFACE TREAT.	REVD					
TITLE	CHKD	SNH	30.4.15			
SUPPORT	DRWN	Jagadish	29.4.15			
	SCALE	1:2	SHEET	Wt.(Kg)		
			OF	0		
DRG No.					ALT	
BEML LIMITED <small>NEW FRONTIERS. NEW DREAMS</small>					909-56766	
SURFACE ROUGHNESS	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	~

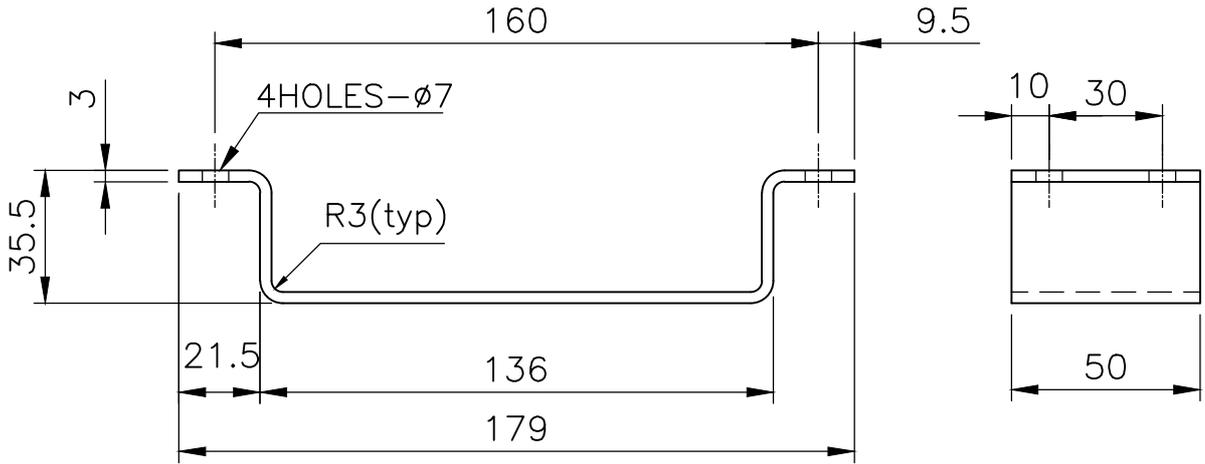
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

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



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																																																																																																																																														
<table border="1"> <tr> <td>SL.No.</td> <td>QTY</td> <td>PART / STOCK No.</td> <td>DESCRIPTION</td> <td>SIZE</td> <td>236x50x3 THK</td> <td>AISI 304</td> <td>COMPANY STD./I.S</td> <td>Wt. (Kg)</td> </tr> <tr> <td colspan="5"></td> <td colspan="4">MATERIAL</td> </tr> <tr> <td colspan="3"></td> <td>PRODUCT</td> <td colspan="5">DMRC BG METRO CARS</td> </tr> <tr> <td colspan="3"></td> <td>REF DRG</td> <td colspan="5">909-56060</td> </tr> <tr> <td colspan="3"></td> <td>MATERIAL</td> <td colspan="5"></td> </tr> <tr> <td colspan="3"></td> <td>HEAT TREAT.</td> <td>APPD</td> <td colspan="3">KCS</td> <td>2.5.15</td> </tr> <tr> <td colspan="3"></td> <td>SURFACE TREAT.</td> <td>REVD</td> <td colspan="3"></td> <td></td> </tr> <tr> <td colspan="3"></td> <td>TITLE</td> <td>CHKD</td> <td colspan="3">SNH</td> <td>2.5.15</td> </tr> <tr> <td colspan="3"></td> <td rowspan="2">SUPPORT</td> <td>DRWN</td> <td colspan="3">Jagadish</td> <td>1.5.15</td> </tr> <tr> <td>GRADE No.</td> <td>VALUE</td> <td>SYMBOL</td> <td>SCALE</td> <td colspan="2"> </td> <td>SHEET</td> <td>Wt.(Kg)</td> </tr> <tr> <td colspan="3"></td> <td>1:2</td> <td colspan="2"></td> <td>OF</td> <td>0</td> </tr> <tr> <td colspan="3"></td> <td>DRG No.</td> <td colspan="4">909-56768</td> <td>ALT</td> </tr> <tr> <td colspan="3"></td> <td colspan="4"> </td> <td colspan="2"> </td> </tr> <tr> <td colspan="3"></td> <td colspan="4">BEML LIMITED</td> <td colspan="2"></td> </tr> <tr> <td colspan="3"></td> <td>DATE</td> <td>BY</td> <td>CHKD</td> <td>APPD</td> <td colspan="2"></td> </tr> <tr> <td colspan="3"></td> <td>ALT.NO.</td> <td colspan="3">ECN NO/CHANGES</td> <td colspan="2"></td> </tr> </table>																								SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	236x50x3 THK	AISI 304	COMPANY STD./I.S	Wt. (Kg)						MATERIAL							PRODUCT	DMRC BG METRO CARS								REF DRG	909-56060								MATERIAL									HEAT TREAT.	APPD	KCS			2.5.15				SURFACE TREAT.	REVD								TITLE	CHKD	SNH			2.5.15				SUPPORT	DRWN	Jagadish			1.5.15	GRADE No.	VALUE	SYMBOL	SCALE			SHEET	Wt.(Kg)				1:2			OF	0				DRG No.	909-56768				ALT													BEML LIMITED									DATE	BY	CHKD	APPD						ALT.NO.	ECN NO/CHANGES				
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	236x50x3 THK	AISI 304	COMPANY STD./I.S	Wt. (Kg)																																																																																																																																																													
					MATERIAL																																																																																																																																																																
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			HEAT TREAT.	APPD	KCS			2.5.15																																																																																																																																																													
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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)

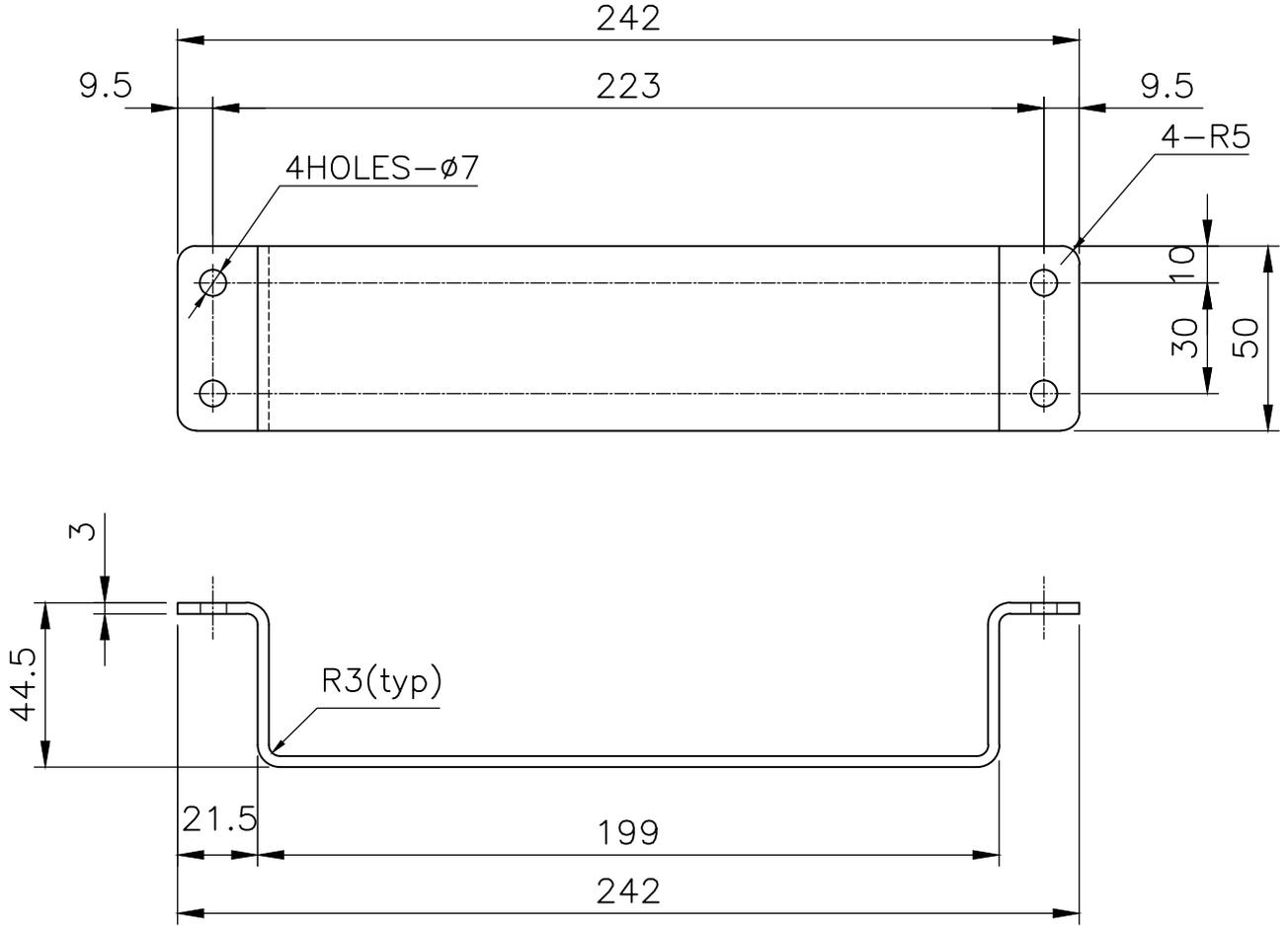
QUALITY OF WELD JOINTS REF, RD 230 MEDIUM

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.

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
	DATE	BY
	CHKD	APPD

					317x50x3 THK	AISI 304	
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S		Wt. (Kg)
					MATERIAL		

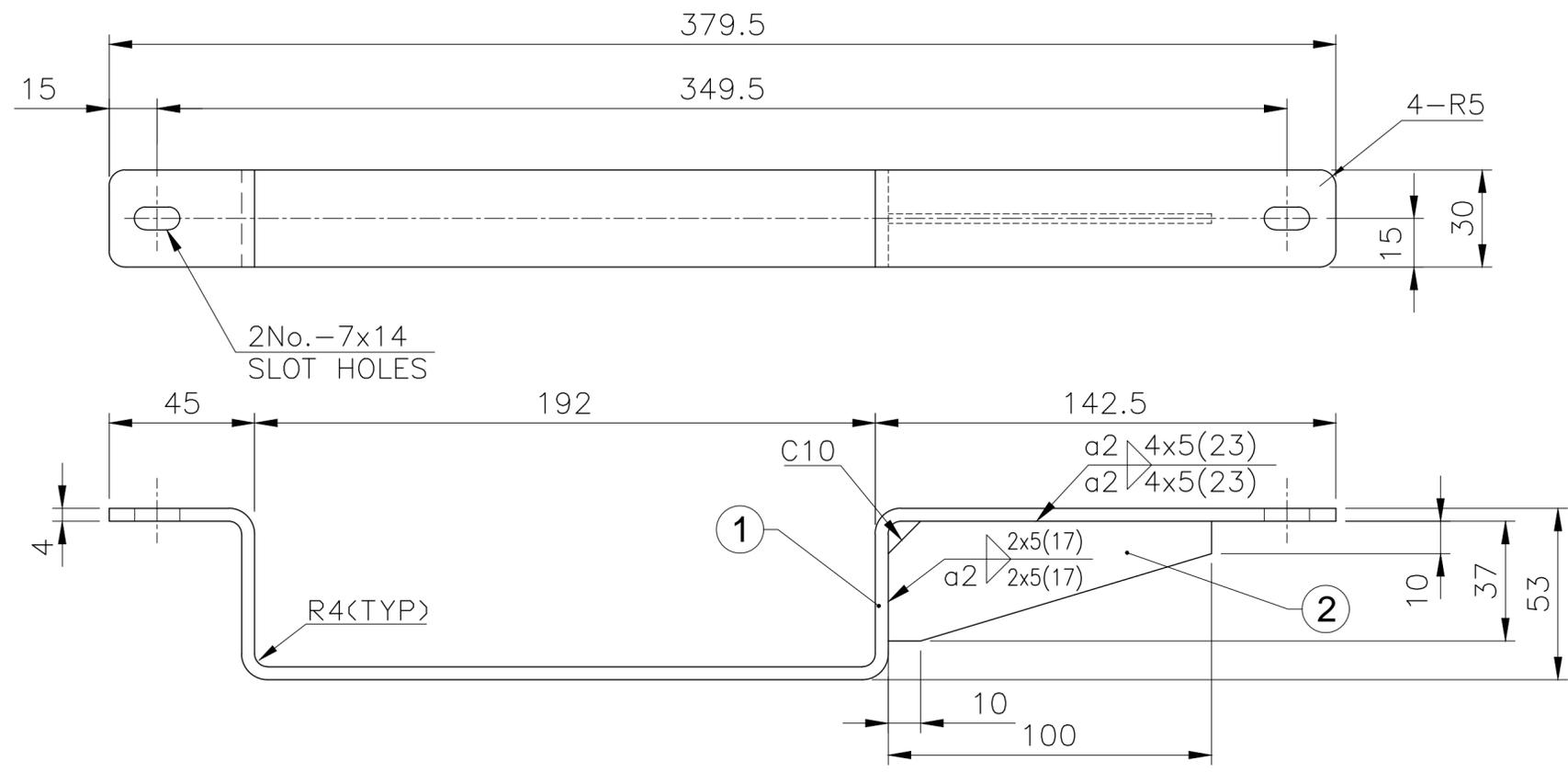
PRODUCT	DMRC BG METRO CARS						
REF DRG	909-56061						
MATERIAL							
HEAT TREAT.					APPD	KCS	28.4.15
SURFACE TREAT.					REVD		
TITLE	SUPPORT				CHKD	SNH	28.4.15
					DRWN	Jagadish	27.4.15
					SCALE	1:2	SHEET
				DRG No.	909-56769		ALT
				BEML LIMITED <small>NEW FRONTIERS. NEW DREAMS</small>			

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GRADE No.	N1	0.025
VALUE	N2	0.05
SYMBOL	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		

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 & DEBURR.

2	1	909-56770-2	PLATE	100x37x3THK.	AISI 304	
1	1	909-56770-1	BRACKET	467x30x4THK.	AISI 304	
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
					MATERIAL	
			PRODUCT	DMRC BG METRO CARS		
			REF DRG	909-56281		
			MATERIAL			
			HEAT TREAT.	APPD	KCS	20.4.15
			SURFACE TREAT.	REVD		
			TITLE	CHKD	SNH	20.4.15
				DRWN	Jagadisha M	19.4.15
				SCALE	1:2	Wt.(Kg)
					SHEET	0
					OF	
				DRG No.	ALT	
					909-56770	
ALT.No.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	



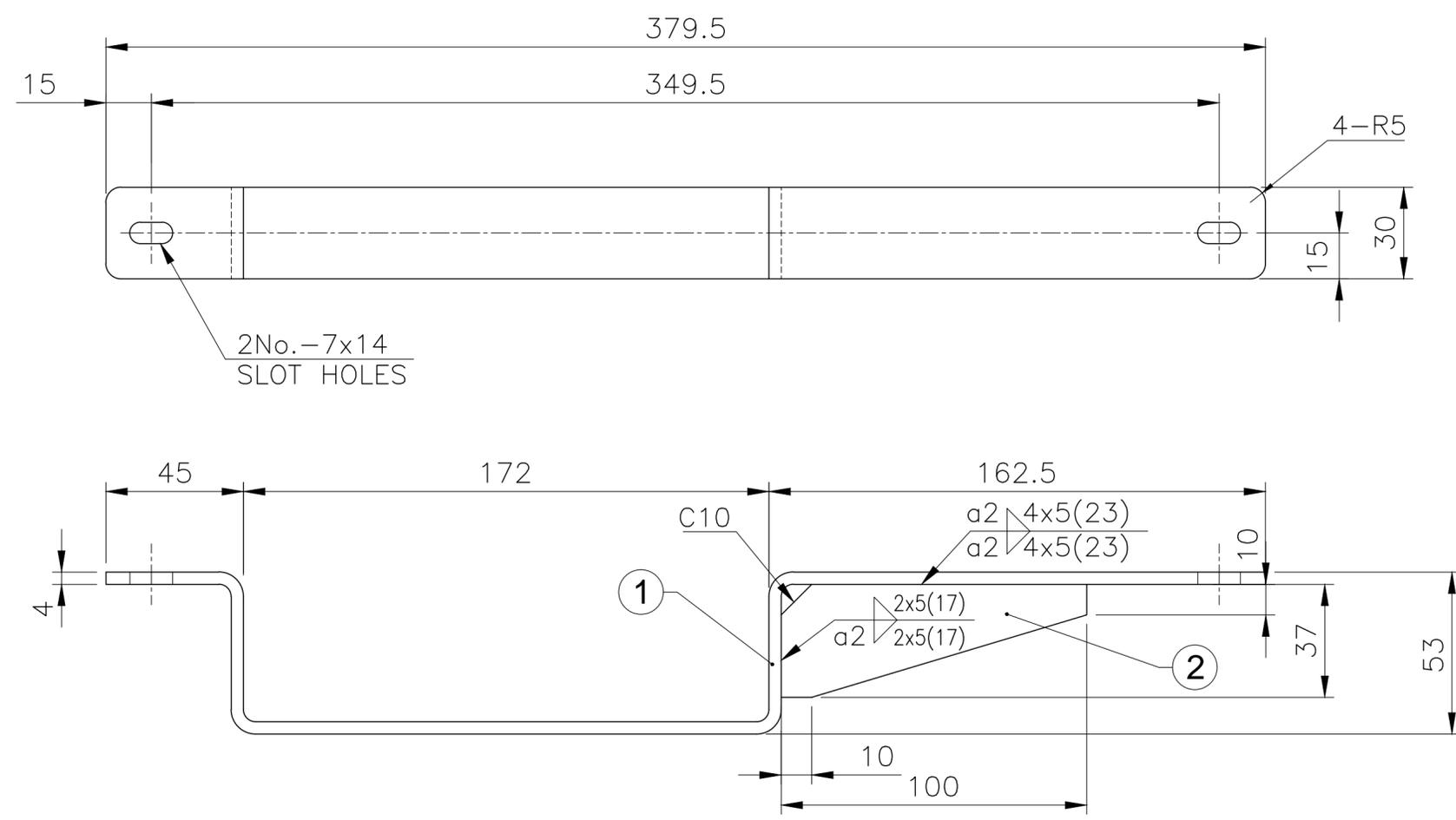
909-56770

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GRADE No.	N1	0.025
VALUE	N2	0.05
SYMBOL	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		

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 & DEBURR.

2	1	909-56772-2	PLATE	100x37x3THK.	AISI 304	
1	1	909-56772-1	BRACKET	467x30x4THK.	AISI 304	
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
					MATERIAL	
			PRODUCT	DMRC BG METRO CARS		
			REF DRG	909-56282		
			MATERIAL			
			HEAT TREAT.	APPD	K.C.S	20.4.15
			SURFACE TREAT.	REVD		
			TITLE	CHKD	S.N.H	20.4.15
				DRWN	Jagadisha M	19.4.15
				SCALE	1:2	
				SHEET	OF	0
				DRG No.	909-56772	
ALT.No.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	ALT

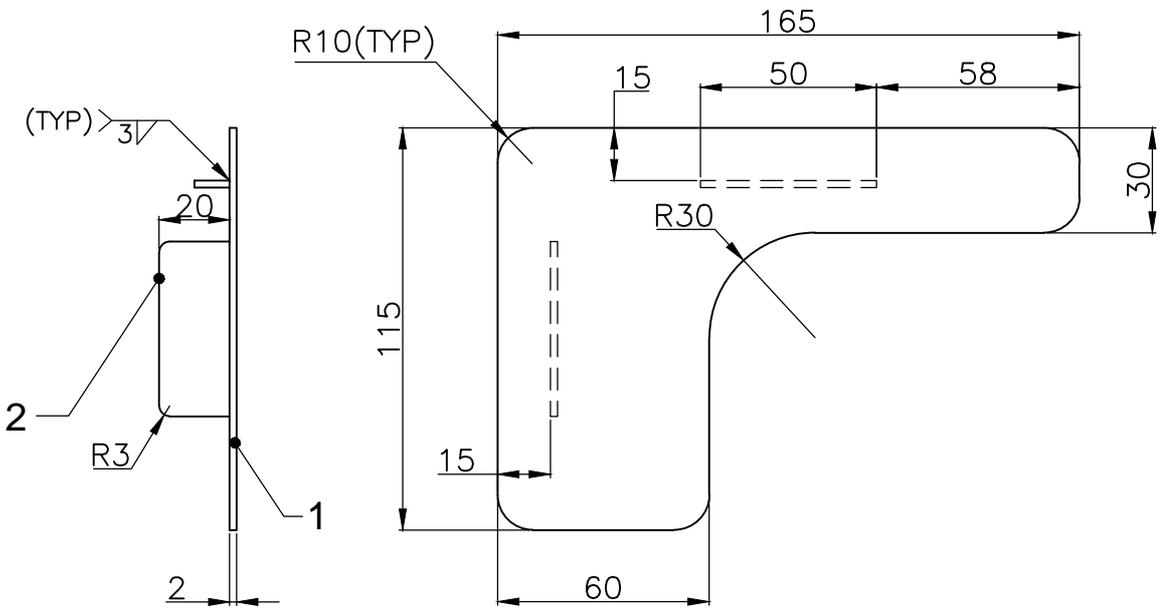


SUPPORT

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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:

1. REMOVE ALL SHARP EDGES & DEBURR.
2. PROTECTIVE RUBBER TO PART No.909-56580 TO BE BONDED ALL OVER THE PLATE & STRIP EDGE TO AVOID SHARP EDGES USING LOCTITE-401 ADHESIVE

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.	1	REVISED & REDRAWN	DATE 13.02.17	BY SNH	CHKD CRN	APPD KCS	DMRC BG METRO CARS			
SURFACE ROUGHNESS	ALT.NO.	ECN NO/CHANGES					COVER PLATE			
							BEML LIMITED			
							909-56807			
							ALT 1			