

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

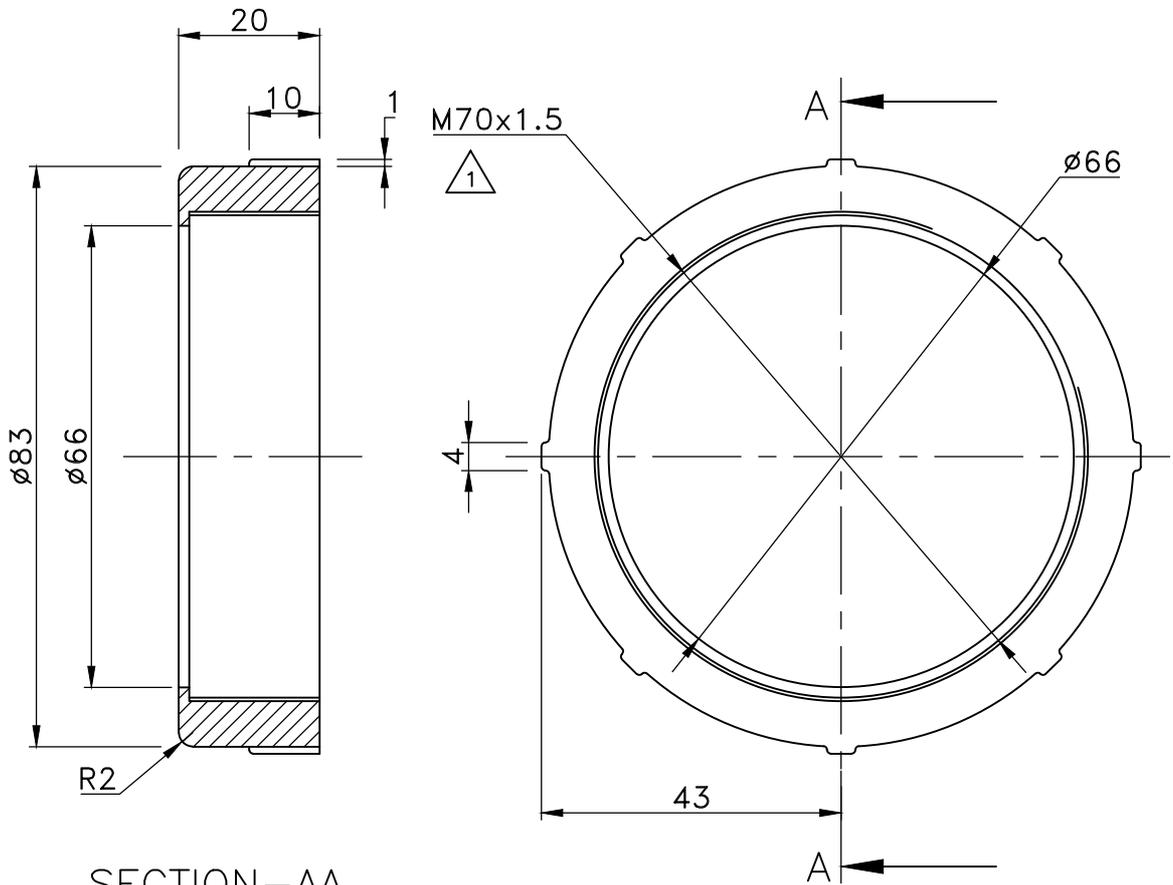
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM)

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

PROTO/PILOT/PRODUCTION

QUALITY OF WELD JOINTS REF, RD-230 MEDIUM

UNCONTROLLED



SECTION-AA

NOTE: REMOVE SHARP EDGES & BURRS

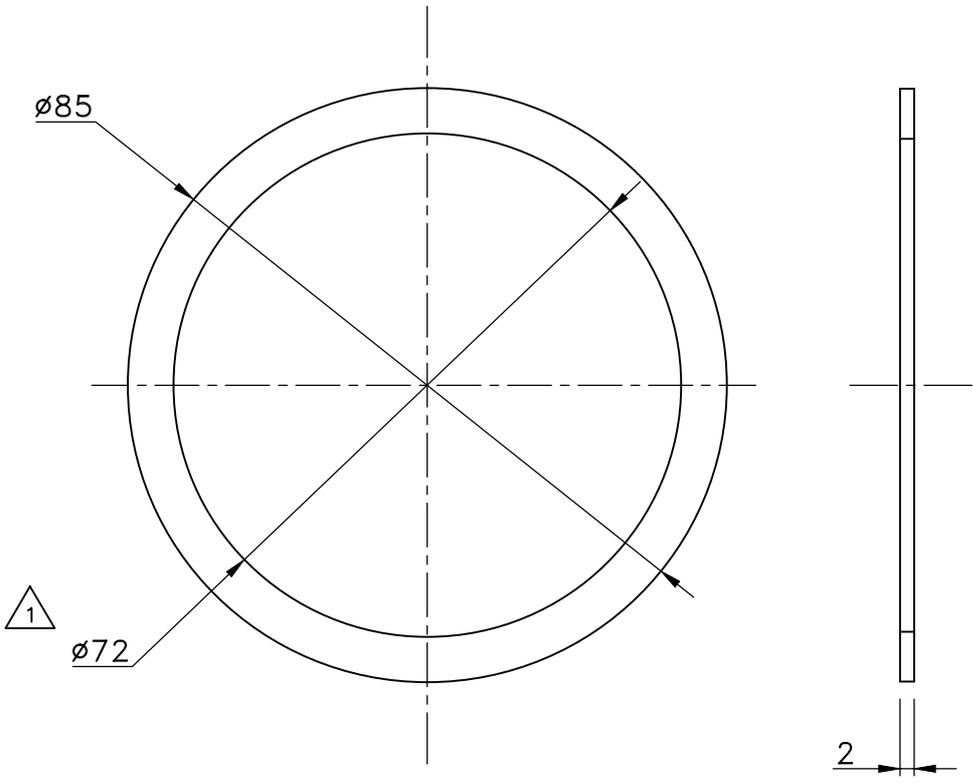
MATERIAL:-AISI 304

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												

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
	3	909-56201	T-CAR			Wt(Kg)
	QTY	NEXT ASSY	MODEL	REF DRG		
TITLE					APPROVED	Wt(Kg)
END BUSHING					KCS	12.01.09
					CHECKED	12.01.09
					KRKR	
					DRAWN	10.01.09
					SNH	
					DRG No.	ALT
1	Dim M70 was M75 ECN:90900186	29.05.12				
ALT	CHANGE/ECN No.	DATE	BY	CKD	APP	
					BEM LIMITED	
				R&D, BANGALORE COMPLEX BANGALORE 560 075		
					909-56104	

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. PROTO/PILOT/PRODUCTION
 QUALITY OF WELD JOINTS REF, RD-230 MEDIUM

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												

85x85x2 THK SS.SHEET 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	909-56201	T-CAR
				QTY	NEXT ASSY	MODEL
				REF DRG		Wt(Kg)
				APPROVED	KCS	12.01.09
				CHECKED	KRKR	12.01.09
				DRAWN	SNH	10.01.09
				DRG No.		ALT
				909-56106		
2	Material SS was Aluminium ECN:90900580	17.2.16	VSHNU SNH KCS	TITLE		
1	Dimn 72 was 77 ECN:90900189	29.05.12	SNH CRN KCS	BEML LIMITED R&D, BANGALORE COMPLEX BANGALORE 560 075		
ALT	CHANGE/ECN No.	DATE	BY	CKD	APP	



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

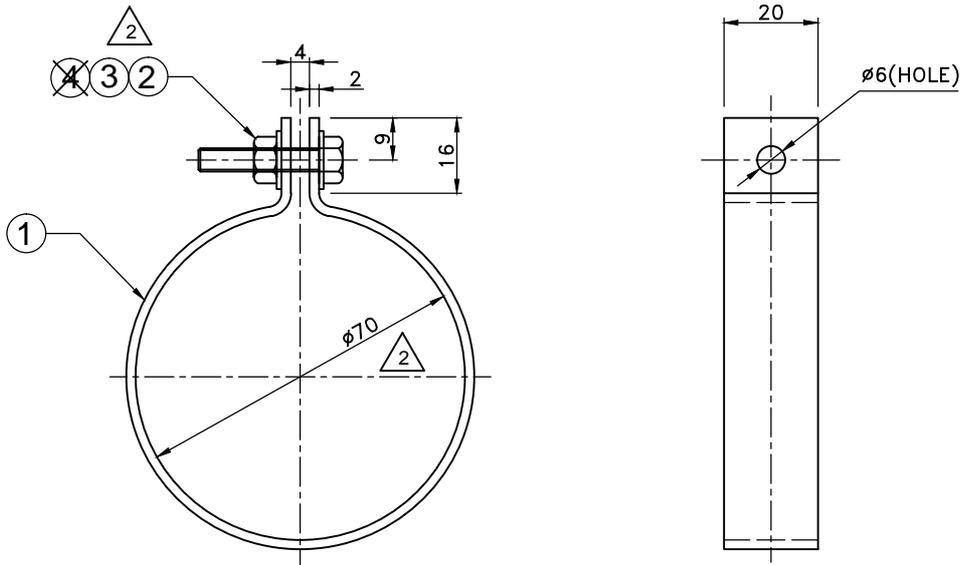
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM)

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

PROTO/PILOT/PRODUCTION

QUALITY OF WELD JOINTS REF, RD-230 MEDIUM

UNCONTROLLED



4	1	RFW0920512	SPRING WASHER B5 TO IS:3063(TAB 1) 1994/MATL:AISI 304,STAINLESS STEEL			
3	1	RFN5850547	HEX HD NUT WITH FLANGE M5 TO ISO:4161-83 / MATL-ISO:3506,Gr-A2-70,SS			
2	1	RFB3850525	HEX HEAD FLANGE BOLT FULL THREAD M5x25 TO ISO:4162-90 / MATL:IS-1367(P-14) Gr-A2-70,SS WITH NYLOK BLUE PATCH PRE APPLIED ADHESIVE			
1	1		CLAMP. PIPE 265x20x2 SS.SHEET AISI 304			
SI No.	QTY	DRG. / STOCK No.	DESCRIPTION	SIZE	COMPANY.STD/IS.STD	Wt(Kg)
		DETAIL PARTS			MATERIAL	

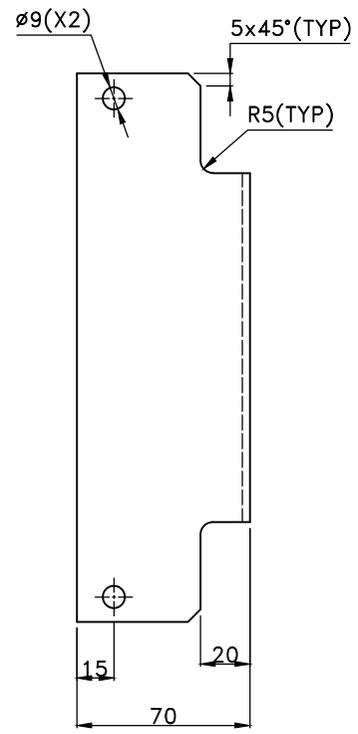
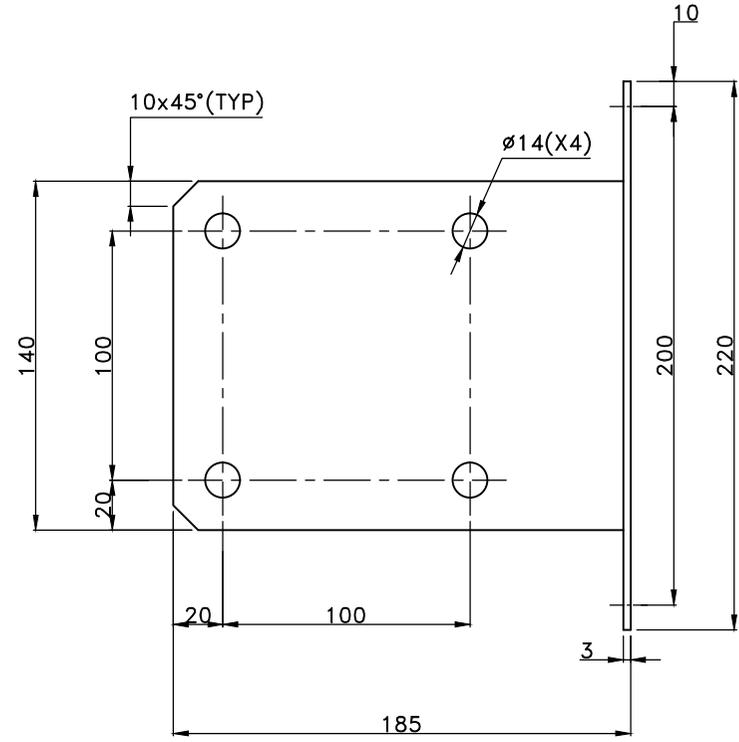
PRODUCT							DMRC BG METRO CARS									
SURFACE TREATMENT																
SCALE								SHEET OF		Wt(Kg)						
3							909-56201	T-CAR								
QTY							NEXT ASSY	MODEL		REF DRG						
TITLE							APPROVED		KCS	12.01.09						
2							DIM 70 WAS 72 ITEM-4 DELETED ITEM-2&3 ALTERED		04.06.13	SNH	CRN	KCS	CHECKED	KRKR	12.01.09	
1							DIM 72 WAS 77 ECN:90900186		29.05.12	SNH	CRN	KCS	DRAWN	SNH	10.01.09	
ALT							CHANGE/ECN No.		DATE	BY	CKD	APP	DRG No.		909-56304	ALT
SURFACE ROUGHNESS							ALT		DATE		BY		CKD		APP	

BEML LIMITED
R&D, BANGALORE COMPLEX
BANGALORE 560 075

2

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



NOTE: ALL SHARP EDGES & BURRS TO BE REMOVED

289x220x3THK
SS.SHEET
AISI 304

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

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	Wt(Kg)
	1	909-56033	T-CAR			
			QTY	NEXT ASSY	MODEL	REF DRG
3		Dim 70 was 97 Dim 185 was 198 ECN:90900596	19.4.16	VSK	SNH	KCS
2		Revised & redrawn ECN:90900580	19.2.16	VSK	SNH	KCS
1		Revised & redrawn ECN:90900224	7.4.12	SNH	CRN	KCS
ALT	CHANGE/ECN No.	DATE	BY	CKD	APP	
					BEM LIMITED R&D, BANGALORE COMPLEX BANGALORE 560 075	
					DRG No.	ALT
					909-56306	3
						12.01.09
						12.01.09
						10.01.09

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

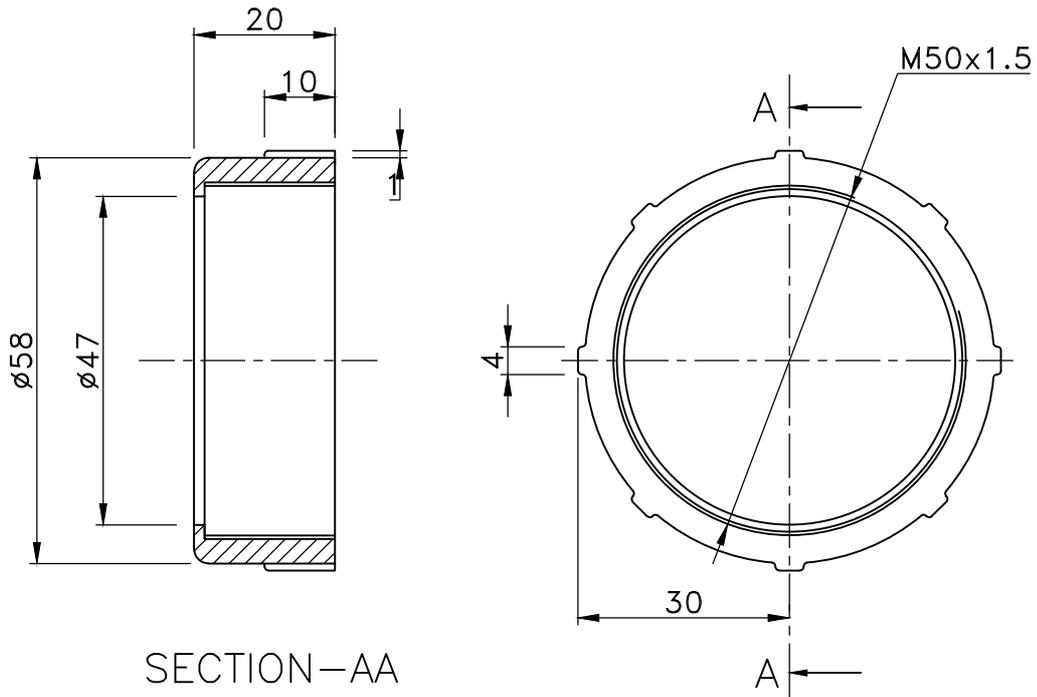
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM)

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

PROTO/PILOT/PRODUCTION

QUALITY OF WELD JOINTS REF, RD-230 MEDIUM

UNCONTROLLED



SECTION-AA

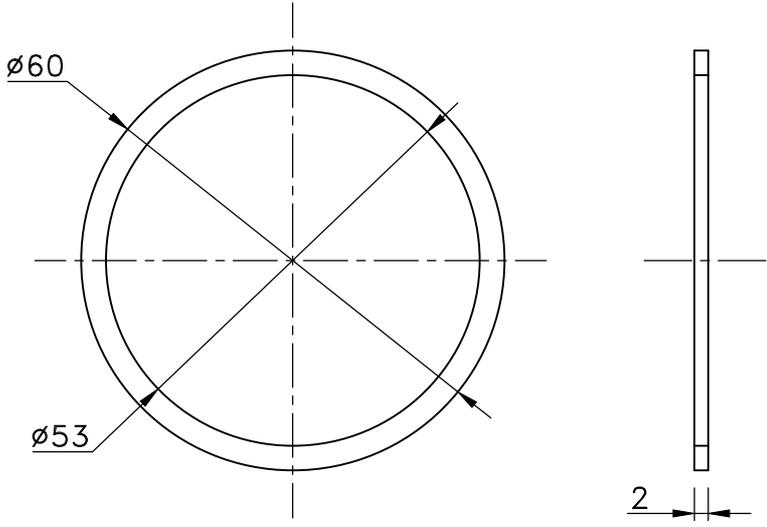
MATERIAL:-Zinc die casting to alloy Zn Al4 cu1 IS:742-1981

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												

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 END BUSHING (51C)						
APPROVED KCS						12.01.09
CHECKED KRKR						12.01.09
DRAWN SNH						10.01.09
DRG No.						ALT
1	Dim M50 was M51 ECN:90900186	29.05.12	SNH	CKN	KCS	
ALT	CHANGE/ECN No.	DATE	BY	CKD	APP	
BEM LIMITED R&D, BANGALORE COMPLEX BANGALORE 560 075						909-56319

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. PROTO/PILOT/PRODUCTION
 QUALITY OF WELD JOINTS REF, RD-230 MEDIUM

UNCONTROLLED



NOTE: REMOVE SHARP EDGES AND BURRS

60x60x2 THK
AL.SHEET
Gr.52000 condition'O' to
IS:737-2008

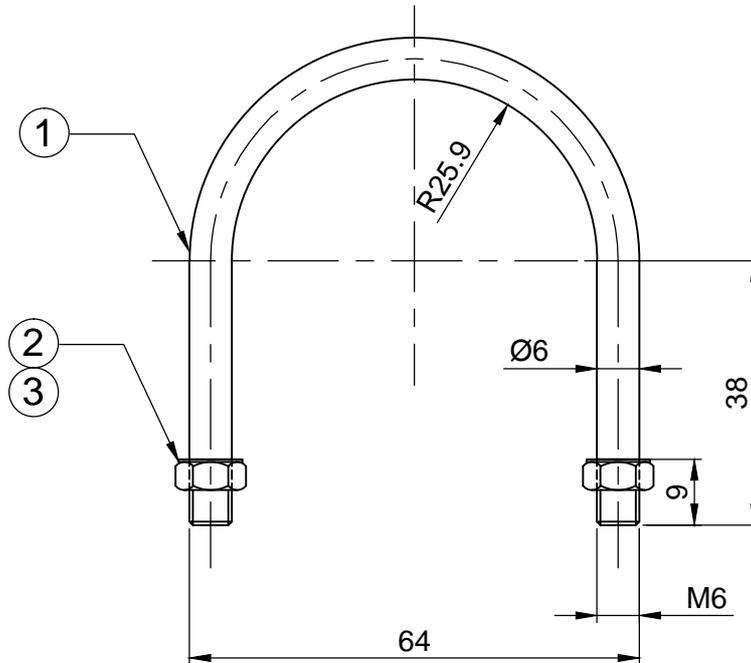
GRADE No.	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12
VALUE	0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50
SYMBOL												
SURFACE ROUGHNESS												

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
	WASHER (51C)				CHECKED	12.01.09
					DRAWN	10.01.09
					DRG No.	ALT
					909-56321	

BEML LIMITED
 R&D, BANGALORE COMPLEX
 BANGALORE 560 075

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.						PROTO/PILOT/PRODUCTION			
QUALITY OF WELD JOINTS REF, RD-230 MEDIUM									

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	

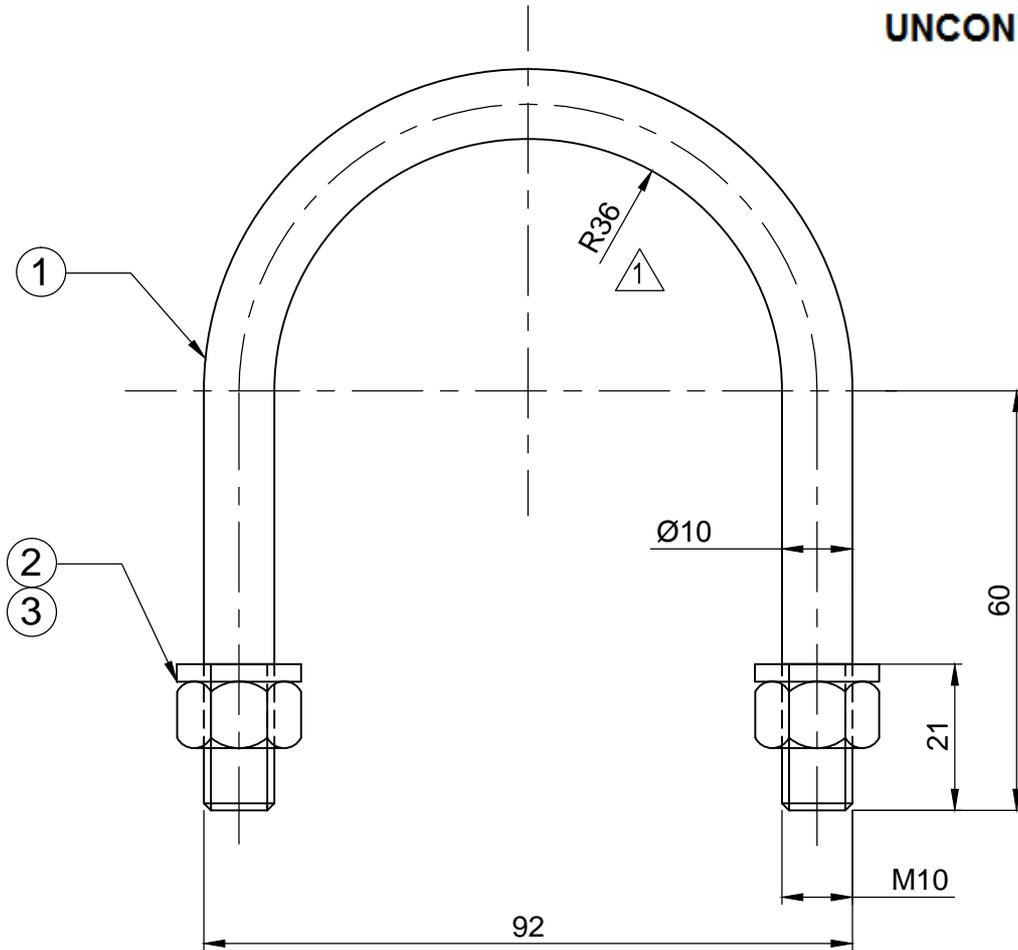
3	2	RFW0921022	Spring Washer-B6 to IS:3063(P-3)-2002/Matl:1367(P-14),SS			
2	2	RFN3861084	Hex.head nut M6 to IS:1364(P-3)-2002/Matl:IS-1367(P-14)Gr-A2-70,SS			
1	1		U-BOLT			
			Ø6 x165 L			
			AISI 304			
SL.No.	QTY	DRG. / STOCK No.	DESCRIPTION	SIZE	COMPANY,STD/IS.STD	Wt.Kg.
			DETAIL PARTS	MATERIAL		

PRODUCT				DMRC BG METRO CARS		
				SURFACE TREATMENT		
2	909-56101	M-CAR	SCALE	NTS		Wt.(Kg)
QTY	NEXT ASSY	MODEL	REF DRG			
TITLE			APPROVED	KCS	12.01.09	
U-BOLT (51C)			CHECKED	KRKR	12.01.09	
			DRAWN	SNH	10.01.09	
				DRG No.	ALT	
				909-56616		

BEML LIMITED
R&D, BANGALORE COMPLEX
BANGALORE 560 075

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.						PROTO/PILOT/PRODUCTION			
QUALITY OF WELD JOINTS REF, RD-230 MEDIUM									

UNCONTROLLED



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

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			
			Ø10 x248 L			
			AISI 304			
SL.No.	QTY	DRG. / STOCK No.	DESCRIPTION	SIZE	COMPANY,STD/IS.STD	Wt.Kg.
			DETAIL PARTS	MATERIAL		

PRODUCT				DMRC BG METRO CARS			
				SURFACE TREATMENT			
				SCALE	NTS		Wt.(Kg)
				5	909-56201		0.16
				QTY	NEXT ASSY	MODEL	REF DRG
				TITLE			APPROVED
				U-BOLT			KCS
							12.01.09
							CHECKED
							KRKR
							12.01.09
							DRAWN
							SNH
							10.01.09
				DRG No.			ALT
				909-56617			1

1	Dim R36 was R38 ECN:90900186	29.05.12	SNH	CRN	KCS
ALT	CHANGES	DATE	BY	CKD	APP

BEML LIMITED
R&D, BANGALORE COMPLEX
BANGALORE 560 075

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

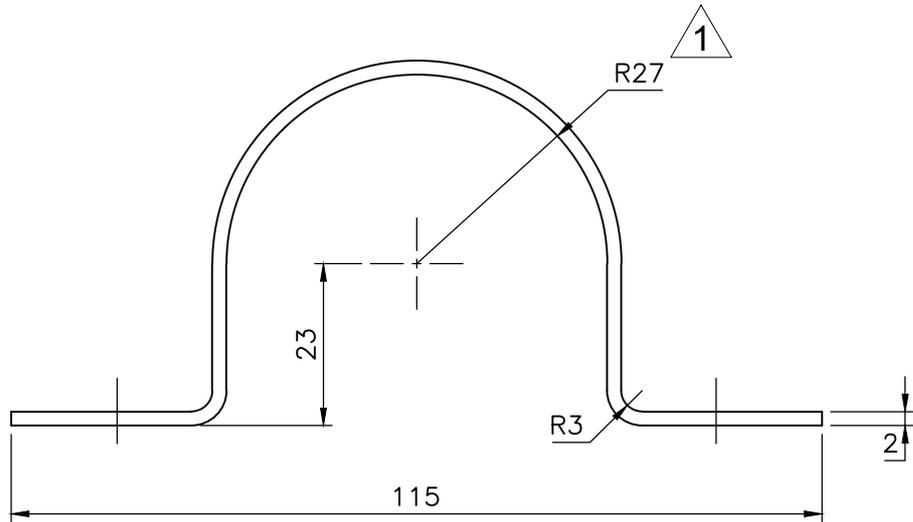
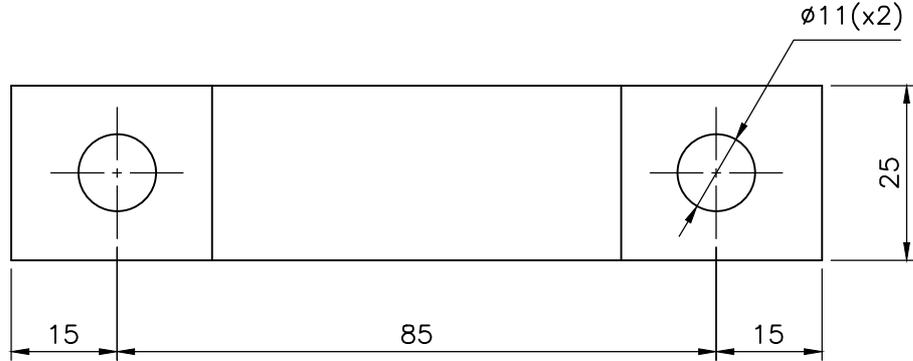
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM)

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

PROTO/PILOT/PRODUCTION

QUALITY OF WELD JOINTS REF, RD-230 MEDIUM

UNCONTROLLED



182x25x2THK
SS SHEET

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	Wt(Kg)	
						SHEET OF	
			1	909-56033	T-CAR		
			QTY	NEXT ASSY	MODEL	REF DRG	
			TITLE			APPROVED	Wt(Kg)
			CLAMP			KCS	12.01.09
						CHECKED	12.01.09
						DRAWN	10.01.09
						DRG No.	ALT
						909-56620	

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												

1	DIM R27 WAS R21 ECN:90900256	29.05.12	SNH	CPN	KCS
ALT	CHANGE/ECN No.	DATE	BY	CKD	APP

BEML LIMITED
R&D, BANGALORE COMPLEX
BANGALORE 560 075

NEW FRONTIERS. NEW DREAMS

APPROVED **KCS** 12.01.09
CHECKED **KRKR** 12.01.09
DRAWN **SNH** 10.01.09
DRG No. **909-56620**
ALT

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

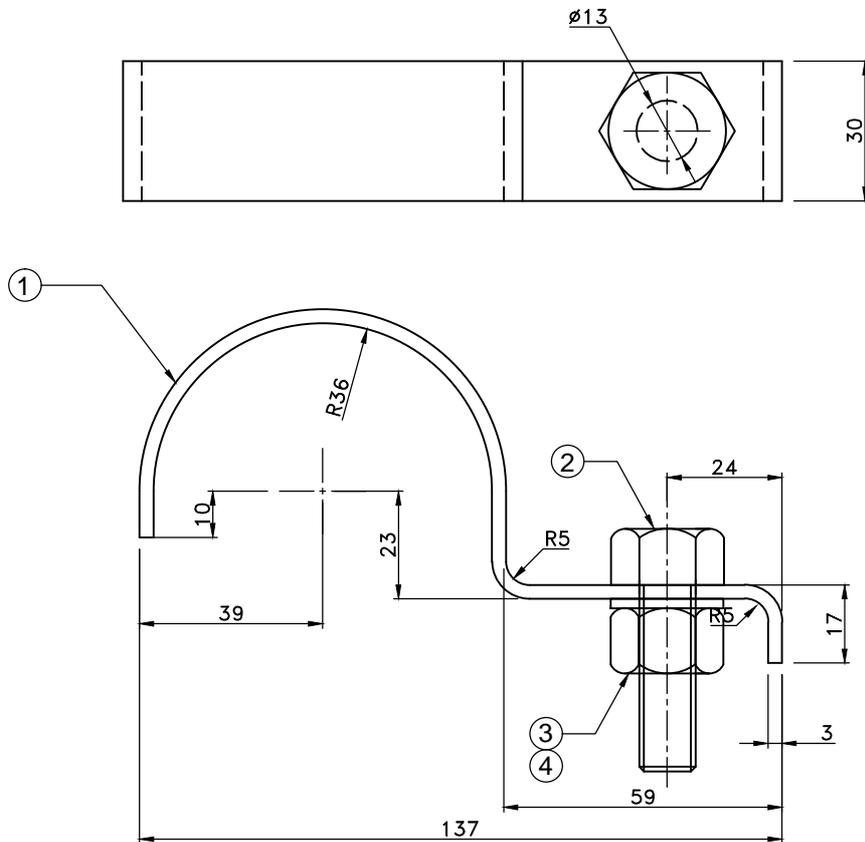
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM)

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

PROTO/PILOT/PRODUCTION

QUALITY OF WELD JOINTS REF, RD-230 MEDIUM

UNCONTROLLED



4	1	RFW0921225	SPRING WASHER B12 TO IS:3063-1994/MATL-AISI-304,SS
3	1	RFN3861211	HEX HD NUT M12 TO IS:1364-(PT-2)2002 / MATL-IS:1367(P-14),Gr-A2-70,SS
2	1	RFB1461240	HEX HD BOLT M12x40 TO IS:1364-(PT-1)2002 / MATL-IS:1367(P-14),Gr-A2-70,SS

1	1		BRACKET	222x30x3THK SS SHEET	AISI 304
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SI No.	QTY	DRG. / STOCK No.	DESCRIPTION	SIZE	COMPANY.STD/IS.STD	Wt(Kg)
			DETAIL PARTS	MATERIAL		

PRODUCT							DMRC BG METRO CARS		
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SURFACE TREATMENT						
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				SCALE		SHEET OF	Wt(Kg)
--	--	--	--	-------	--	----------	--------

3	909-50501	T-CAR				
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QTY	NEXT ASSY	MODEL	REF DRG
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TITLE			APPROVED	KCS	12.01.09
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CLAMP ASSY			CHECKED	KRKR	12.01.09
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			DRAWN	SNH	10.01.09
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			DRG No.	909-56621	ALT
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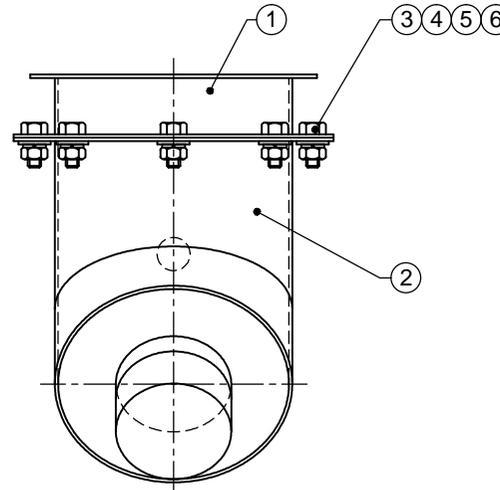
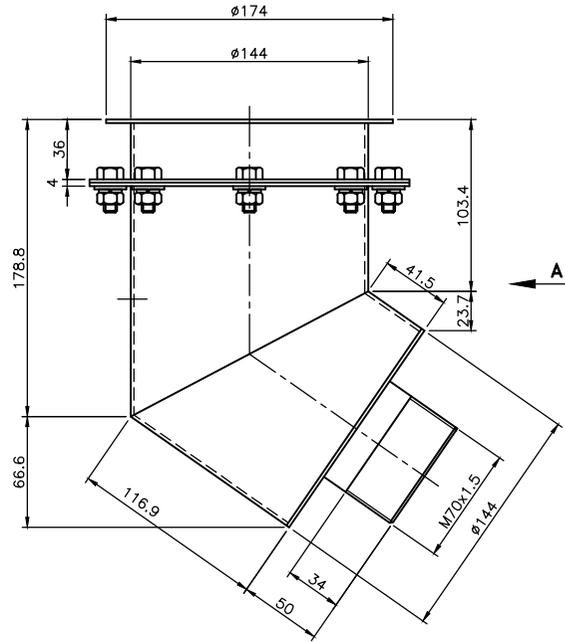
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VALUE	0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50
SYMBOL												

ALT	CHANGE/ECN No.	DATE	BY	CKD	APP
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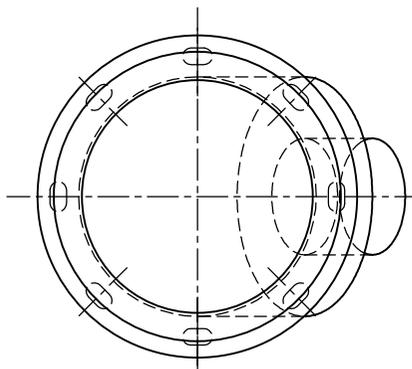
BEML LIMITED
R&D, BANGALORE COMPLEX
BANGALORE 560 075

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, ISO 5817								PROTO / PILOT / PRODUCTION	

UNCONTROLLED



VIEW-A



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												

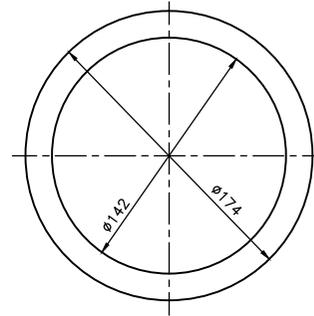
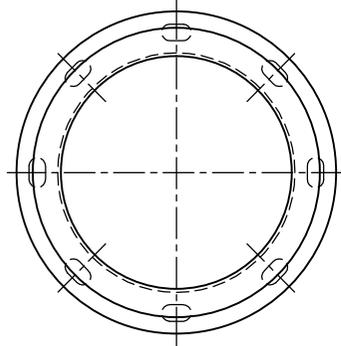
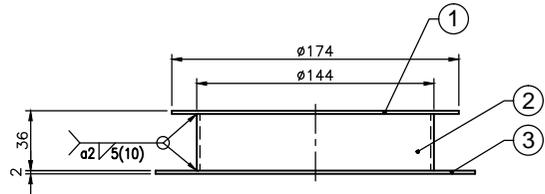
6	8	RFW0920820	SPRING WASHER M8 TO IS:3063-1994, MATL- AISI-304,STAINLESS STEEL
5	16	RFW1730816	PUNCHED WASHER A9 TO IS:2016(T2)-1967, MATL- AISI-304,STAINLESS STEEL
4	8	RFN3860868	HEX. HEAD NUT M8 TO IS:1364(P3)-2002,MATL- IS:1367(P14) Gr.A2-70,STAINLESS STEEL
3	8	RFB1060820	HEX. HEAD BOLT M8x20 TO IS:1364(P1)-2002,MATL- IS:1367(P14) Gr.A2-70,STAINLESS STEEL
2	1	909-56632	BRACKET
1	1	909-56631	BRACKET

SL.No.	QTY	DRG. / STOCK No.	DESCRIPTION	SIZE	COMPANY.STD/IS.STD	Wt.Kg.
			DETAIL PARTS	MATERIAL		
PRODUCT DMRC BG METRO CARS						
SURFACE TREATMENT						
			SCALE	NTS		Wt.(Kg)
1	909-50501	T CAR				
QTY	NEXT ASSY	MODEL	REF DRG			
TITLE BRACKET ASSY				APPROVED	AMIT BANERJEE	04.05.11
				CHECKED	SUDARSHAN	03.05.11
				DRAWN	SOMASHEKAR	02.05.11
				DRG No.	909-56630	
				BEML LIMITED		ALT
				R&D, BANGALORE COMPLEX		
				BANGALORE 560 075		
ALT	CHANGES	DATE	BY	CKD	APP	

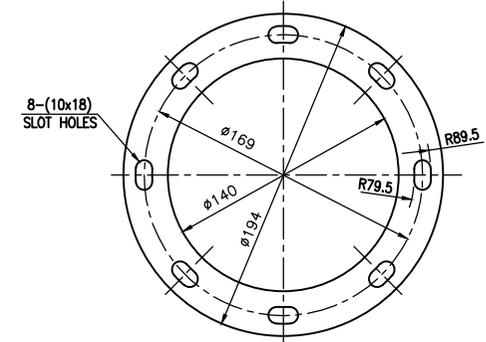
MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227									
UNSPECIFIED TOLERANCE FOR LINEAR AND 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, ISO 5817									

PROTO / PILOT / PRODUCTION

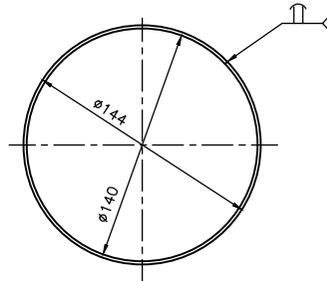
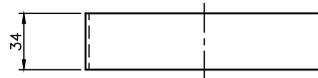
UNCONTROLLED



DETAIL-P1



DETAIL-P3



DETAIL-P2

NOTE:

1. WELDING SYMBOLS AS PER IS:813-1986.
2. REMOVE ALL SHARP CORNERS & DEBURR.

GRADE No.	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12
VALUE	0.025	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50	100
SYMBOL												
SURFACE ROUGHNESS												

3	1		MOUNTING PLATE	195x195x2 THK	AISI 304	
2	1		SHEET	442x34x2 THK	AISI 304	
1	1		SHEET	175x175x2 THK	AISI 304	
SL.No.	QTY	DRG. / STOCK No.	DESCRIPTION	SIZE	COMPANY.STD/IS.STD	Wt.Kg.
			DETAIL PARTS	MATERIAL		
PRODUCT						DMRC BG METRO CARS
SURFACE TREATMENT						
				SCALE	NTS	Wt.(Kg)
1	909-56630	T CAR				
QTY	NEXT ASSY	MODEL	REF DRG			
TITLE				APPROVED	AMIT BANERJEE	04.05.11
				CHECKED	SUDARSHAN	03.05.11
				DRAWN	SOMASHEKAR	02.05.11
				DRG No.	909-56631	ALT
ALT	CHANGES	DATE	BY	CKD	APP	
BEML LIMITED				R&D, BANGALORE COMPLEX BANGALORE 560 075		

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

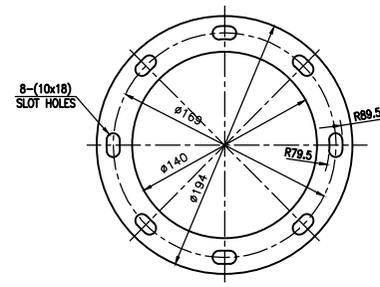
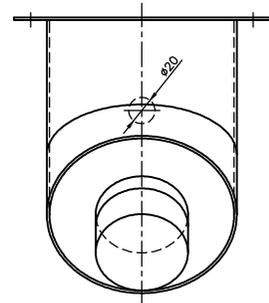
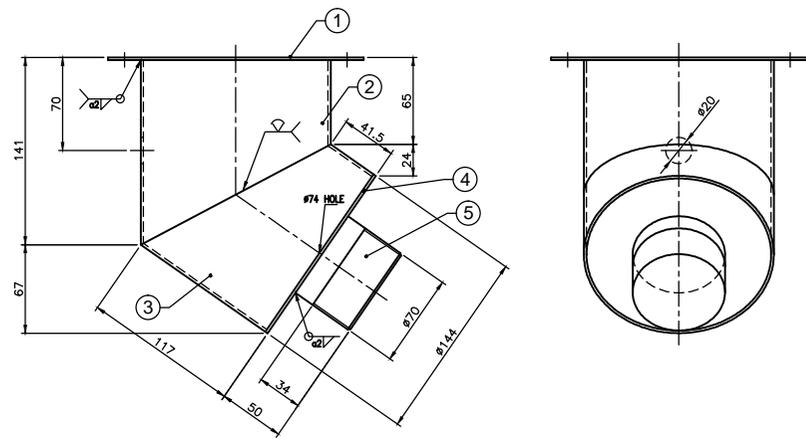
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227

UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM)

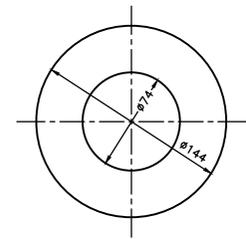
VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS. 1012.C.

QUALITY OF WELD JOINTS REF, ISO 5817

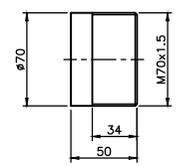
PROTO / PILOT / PRODUCTION



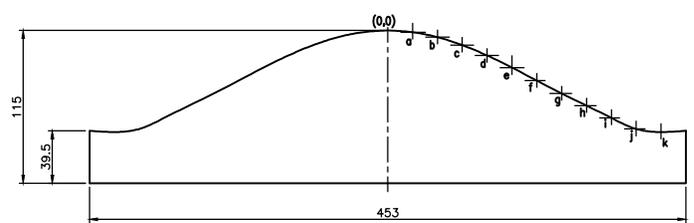
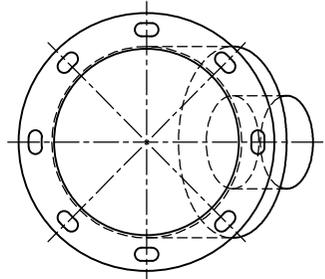
DETAIL-P1



DETAIL-P4

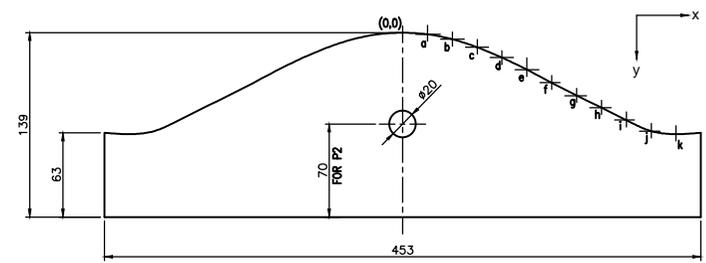


DETAIL-P5



DEVELOPED VIEW P3

x	y
a	19
b	30
c	87
d	79
e	84
f	113
g	132
h	151
i	170
j	189
k	207
l	226



DEVELOPED VIEW P2

SL.No.	QTY	DRG. / STOCK No.	DESCRIPTION	SIZE	COMPANY.STD./IS.STD	Wt.Kg.
5	1		PIPE	#70 SS PIPE	IS:6913 TABLE-2,WELDED TUBE	
4	1		SHEET	145x145x2 THK	AISI 304	
3	1		SHEET	453x115x2 THK	AISI 304	
2	1		SHEET	453x139x2 THK	AISI 304	
1	1		MOUNTING PLATE	195x195x2 THK	AISI 304	

SL.No.	QTY	DRG. / STOCK No.	DESCRIPTION	SIZE	COMPANY.STD./IS.STD	Wt.Kg.																																																																													
<table border="1"> <tr> <td colspan="3">PRODUCT</td> <td colspan="4">DMRC BG METRO CARS</td> </tr> <tr> <td colspan="3">SURFACE TREATMENT</td> <td colspan="4"></td> </tr> <tr> <td colspan="3">SCALE</td> <td colspan="2">T CAR</td> <td colspan="2">Wt.(Kg)</td> </tr> <tr> <td colspan="3">1</td> <td colspan="2">909-56630</td> <td colspan="2">NTS</td> </tr> <tr> <td colspan="3">QTY</td> <td colspan="2">NEXT ASSY</td> <td colspan="2">MODEL</td> </tr> <tr> <td colspan="3">TITLE</td> <td colspan="4">BRACKET</td> </tr> <tr> <td colspan="3">APPROVED</td> <td colspan="2">AMIT BANERJEE</td> <td colspan="2">04.05.11</td> </tr> <tr> <td colspan="3">CHECKED</td> <td colspan="2">SUDARSHAN</td> <td colspan="2">03.05.11</td> </tr> <tr> <td colspan="3">DRAWN</td> <td colspan="2">SOMASHEKAR</td> <td colspan="2">02.05.11</td> </tr> <tr> <td colspan="3">DRG No.</td> <td colspan="4">909-56632</td> </tr> <tr> <td colspan="3">ALT</td> <td colspan="4">ALT</td> </tr> </table>							PRODUCT			DMRC BG METRO CARS				SURFACE TREATMENT							SCALE			T CAR		Wt.(Kg)		1			909-56630		NTS		QTY			NEXT ASSY		MODEL		TITLE			BRACKET				APPROVED			AMIT BANERJEE		04.05.11		CHECKED			SUDARSHAN		03.05.11		DRAWN			SOMASHEKAR		02.05.11		DRG No.			909-56632				ALT			ALT			
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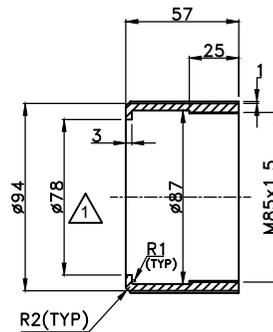
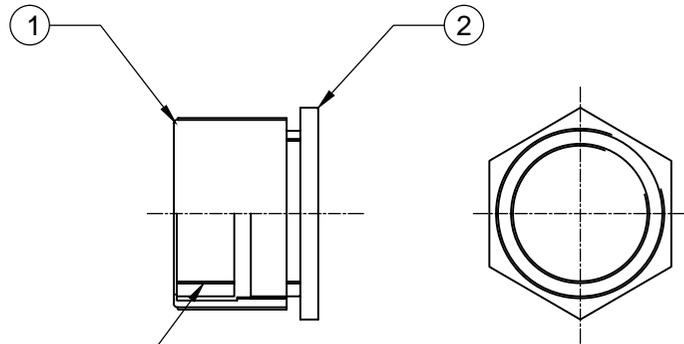
GRADE No.	VALUE	SYMBOL
N1	0.025	▽
N2	0.05	▽
N3	0.1	▽
N4	0.2	▽
N5	0.4	▽
N6	0.8	▽
N7	1.6	▽
N8	3.2	▽
N9	6.3	▽
N10	12.5	▽
N11	25	▽
N12	50	▽

SURFACE ROUGHNESS

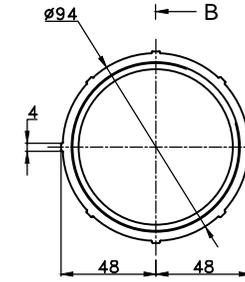
MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227									
UNSPECIFIED TOLERANCE FOR LINEAR AND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

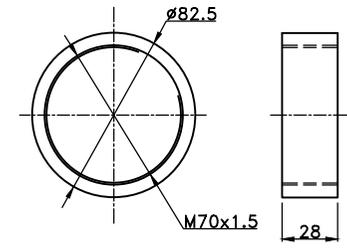
6.3 / (50)



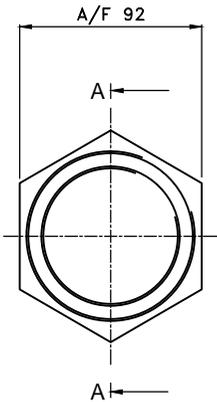
SECTION-BB



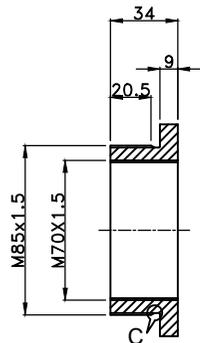
DETAIL-1



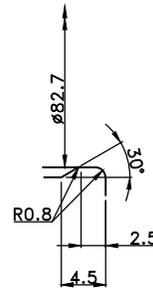
DETAIL-3



DETAIL-2



SECTION-AA



VIEW-C
(ENLARGED VIEW)

NOTE:

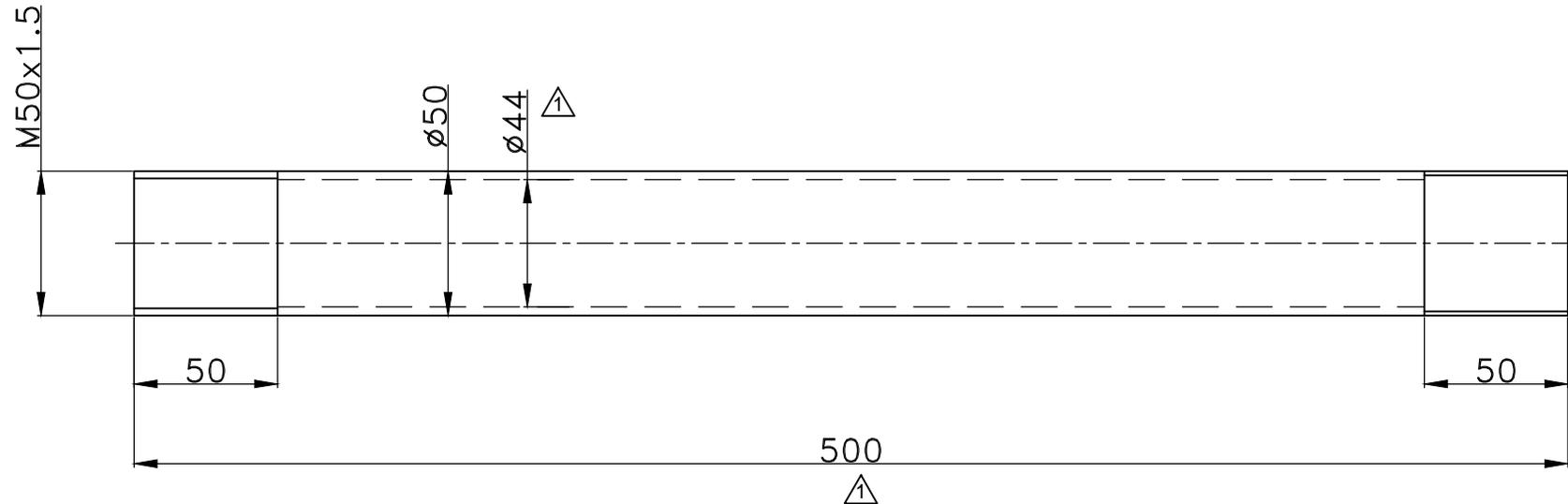
1. ITEM TO BE SUPPLIED IN ASSEMBLED CONDITION.
2. BREAK ALL SHARP EDGES
3. ITEM TO BE SUPPLIED WITH BRIGHT FINISH

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

3	1		RING		AISI 304
2	1		NUT		AISI 304
1	1		NIPPLE		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					
2	909-50501	T-CAR	SCALE	SHEET OF	Wt(Kg)
2	909-56201	T-CAR			
QTY	NEXT ASSY	MODEL	REF DRG		
TITLE UNION COUPLING			APPROVED	KCS	21.11.12
			CHECKED	JP	20.11.12
			DRAWN	SNH	20.11.12
1	78 was 80 ECN:90900365	5.2.13	DRG No. 909-56643		
ALT	CHANGE/ECN No.	DATE	BY	CKD	APP
BEML LIMITED R&D, BANGALORE COMPLEX BANGALORE 560 075			ALT		

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



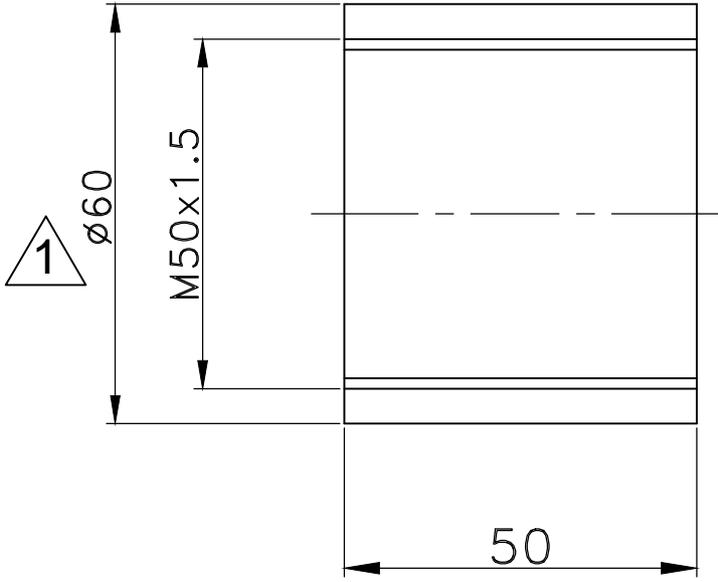
GRADE No.	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12
VALUE	0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50
SYMBOL												
SURFACE ROUGHNESS												

Ø50x325x3 W/T Aluminium tube A6063TE-T6 or IS:1285 Gr.63400, condition-W

Sl No.	QTY	DRG. / STOCK No.	DESCRIPTION	SIZE	MATERIAL	Wt(Kg)																																																																																																		
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PRODUCT			DMRC BG METRO CARS																																																																																																					
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 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. PROTO/PILOT/PRODUCTION
 QUALITY OF WELD JOINTS REF, RD-230 MEDIUM

UNCONTROLLED



ø56x50x3 THK AL. TUBE A6063TE-T6 or IS:1285 Gr.63400, condition-W

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	Wt(Kg)
1	909-56101 M-CAR	

QTY	NEXT ASSY	MODEL	REF DRG

TITLE	APPROVED	KCS	28.10.16
COUPLER	CHECKED	SNH	27.10.16
	DRAWN	VISHNU	27.10.16

1	DIA 60 WAS DIA56 ECN:90900641	04.11.16	VISHNU	SNH	KCS	DRG No.	ALT
ALT	CHANGE/ECN No.	DATE	BY	CKD	APP	909-56646	

BEML LIMITED
 R&D, BANGALORE COMPLEX
 BANGALORE 560 075

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												

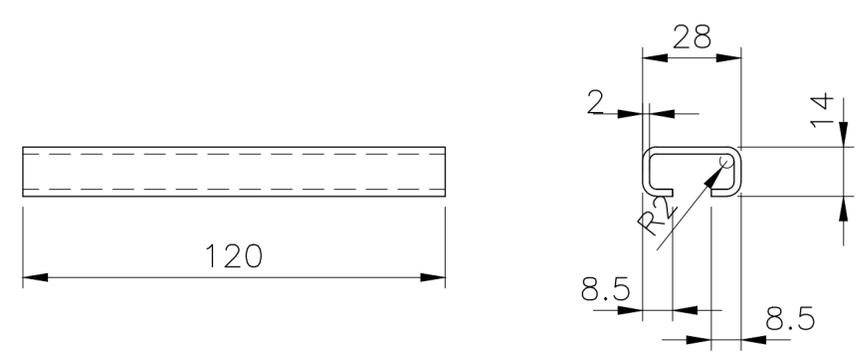
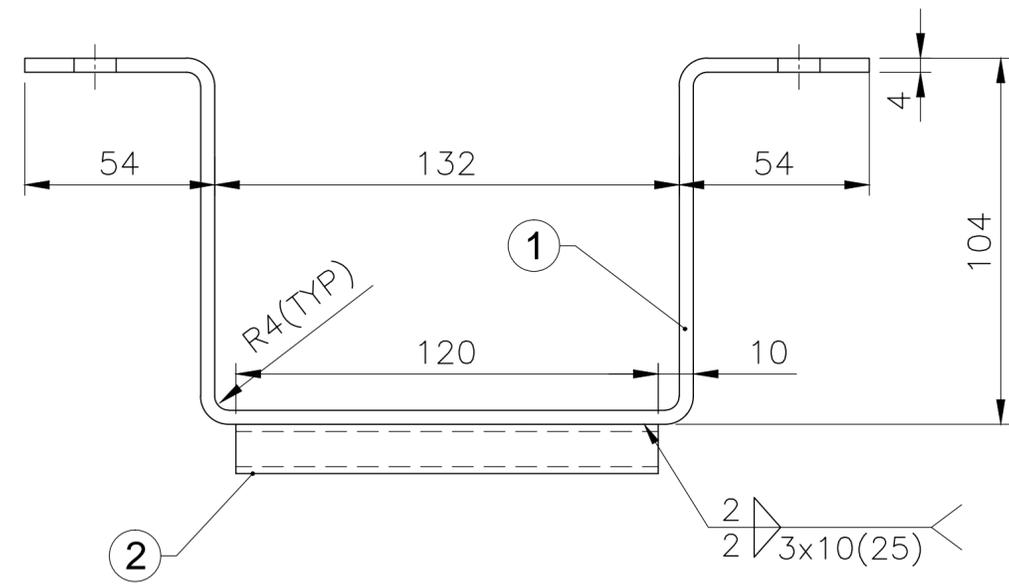
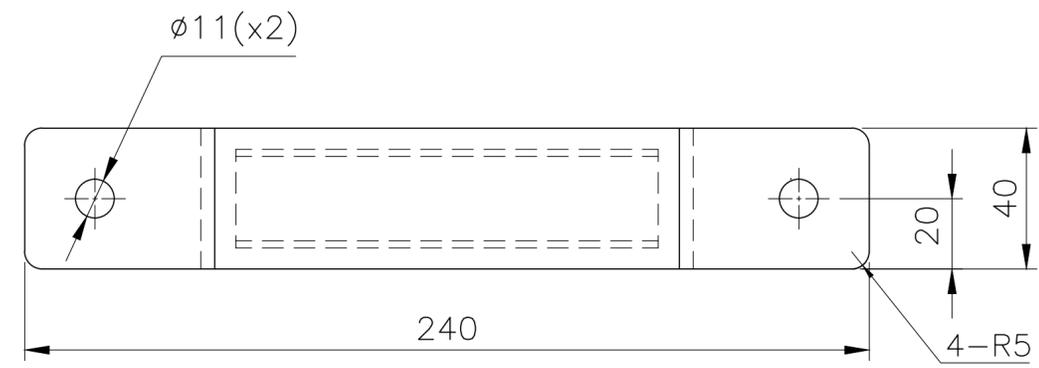
ROUGHNESS

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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		

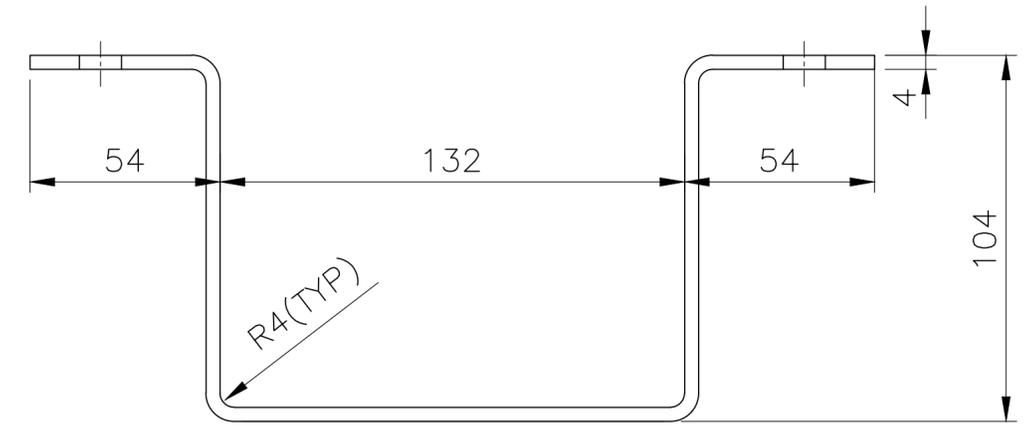
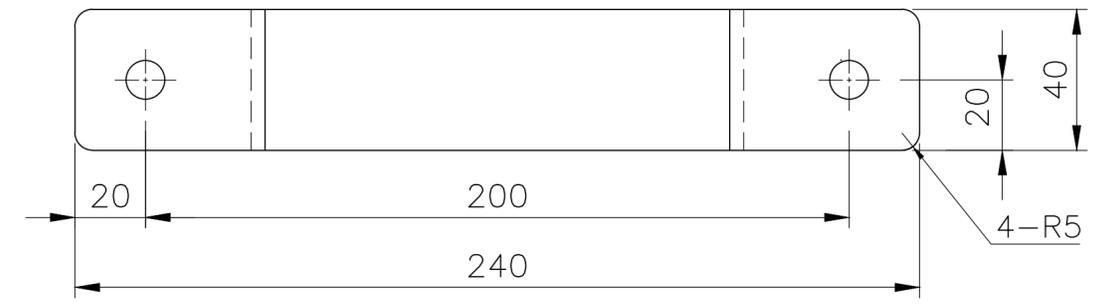
UNCONTROLLED

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										



DETAIL-2

NOTE: REMOVE ALL SHARP EDGES & DEBURR.



DETAIL-1

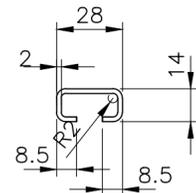
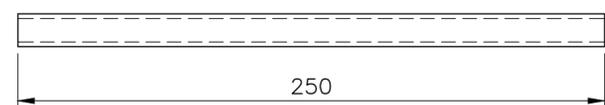
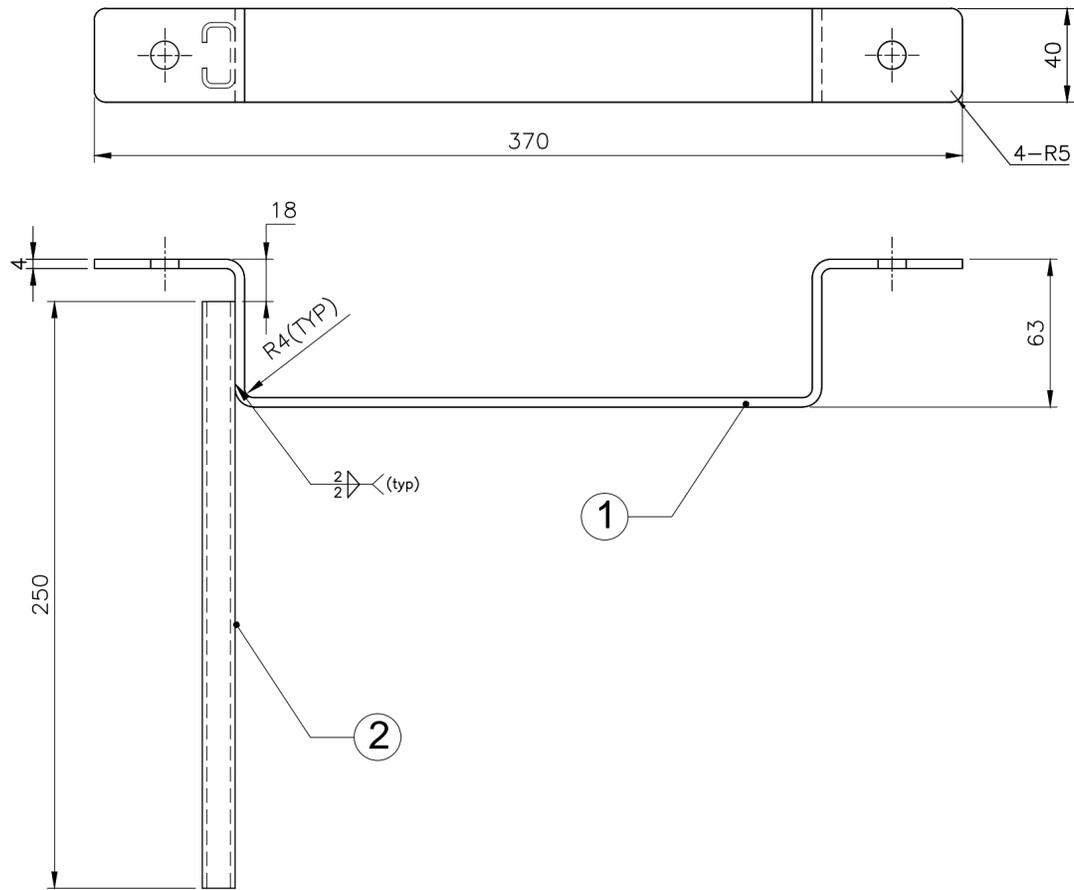
2	1	RTR01-07	RAIL BRACKET							
1	1	909-56797-1	CLAMP	432x40x4THK.	AISI 304					
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./IS	Wt. (Kg)				
							MATERIAL			
			PRODUCT	DMRC BG METRO CARS						
			REF DRG							
			MATERIAL							
			HEAT TREAT.	APPD	KCS	10.8.16				
			SURFACE TREAT.	REVD						
			TITLE	CHKD	SNH	10.8.16				
				DRWN	VSK	9.8.16				
				SCALE		SHEET	Wt.(Kg)			
						OF	0			
				DRG No.	909-56797			ALT	1	
1		REVISED & REDRAWN ECN:90900626	DATE	31.08.16	BY	VSK	CHKD	SNH	APPD	KCS
ALT.No.		ECN NO/CHANGES	DATE		BY		CHKD		APPD	



909-56797

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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												

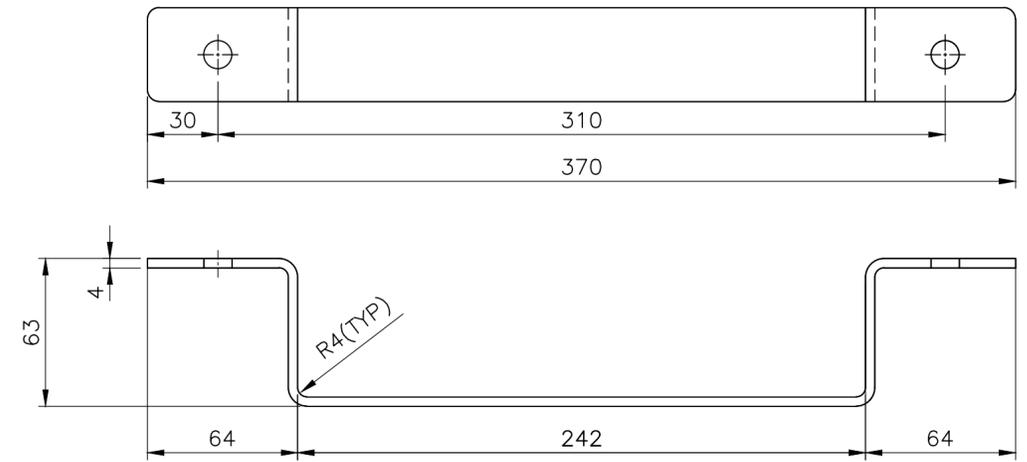


DETAIL-2

NOTE: REMOVE ALL SHARP EDGES & DEBURR.

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



DETAIL-1

2	1	RTR01-24	RAIL BRACKET						
1	1	909-56799-1	CLAMP	480x40x4THK.	AISI 304				
SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)			
					MATERIAL				
			PRODUCT	DMRC BG METRO CARS					
			REF DRG						
			MATERIAL						
			HEAT TREAT.	APPD	KCS	10.8.16			
			SURFACE TREAT.	REVD					
			TITLE	CHKD	SNH	10.8.16			
				DRWN	VSK	9.8.16			
				SCALE	1:2		SHEET	OF	0
				DRG No.	909-56799		ALT		
ALT.No.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	BEML LIMITED			



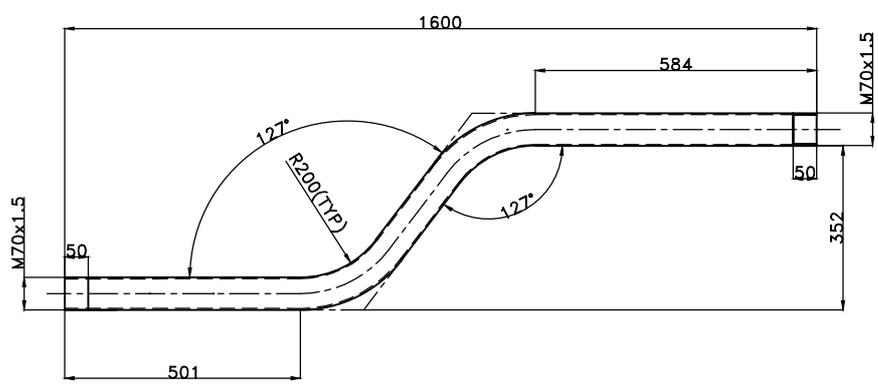
CLAMP ASSY

909-56799

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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. 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 SAMPLE MATING COUPLER THREADS

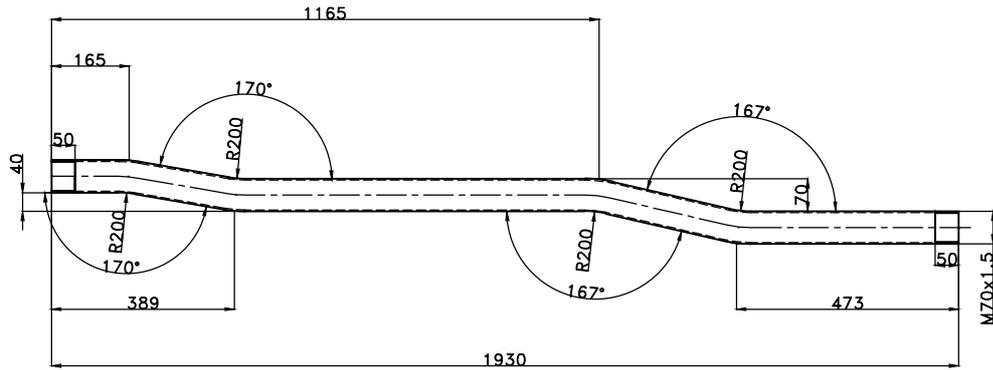
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N2	0.05	▽
N3	0.1	▽
N4	0.2	▽
N5	0.4	▽
N6	0.8	▽
N7	1.6	▽
N8	3.2	▽
N9	6.3	▽
N10	12.5	▽
N11	25	▽
N12	50	▽
GRADE No.		
VALUE		
SYMBOL		
SURFACE ROUGHNESS	ALT.NO.	ECN NO/CHANGES

						Ø70x1742x2.5w/t		AISI 304-ERW TUBE	
N7	SL.No.	QTY	PART / STOCK No.	DESCRIPTION			SIZE	COMPANY STD./I.S	Wt. (Kg)
N8				DMRC BG METRO CARS					
N9				MATERIAL					
N10				HEAT TREAT.					
N11				SURFACE TREAT.					
N12				TITLE					
				APPD		KCS		14.03.17	
				REVD					
				CHKD		SNH		14.03.17	
				DRWN		VISHNU		14.03.17	
				SCALE		SHEET		Wt.(Kg)	
						OF		0	
				DRG No.		909-56810		ALT	
				BEML LIMITED				2	

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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. 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 SAMPLE MATING COUPLER THREADS

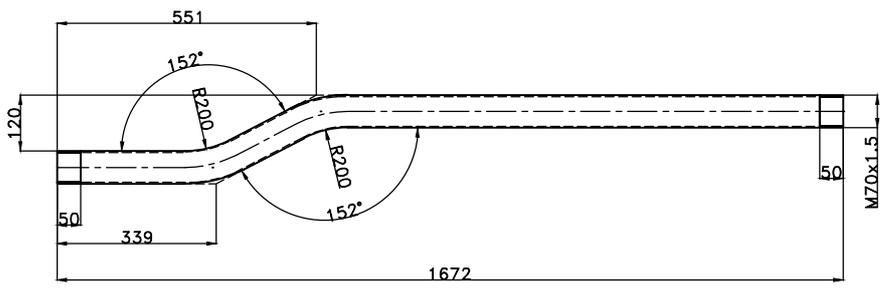
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N3	0.1	▽
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N5	0.4	▽
N6	0.8	▽
N7	1.6	▽
N8	3.2	▽
N9	6.3	▽
N10	12.5	▽
N11	25	▽
N12	50	▽
GRADE No.		▽
VALUE		▽
SYMBOL		▽
SURFACE ROUGHNESS	ALT.NO.	

						Ø70x1940x2.5w/t		AISI 304-ERW TUBE		
SL.No.	QTY	PART / STOCK No.	DESCRIPTION			SIZE	COMPANY STD./I.S	Wt. (Kg)		
							MATERIAL			
			PRODUCT	DMRC BG METRO CARS						
			REF DRG							
			MATERIAL							
			HEAT TREAT.	APPD	KCS		14.03.17			
			SURFACE TREAT.	REVD						
			TITLE	CHKD	SNH		14.03.17			
			CONDUIT PIPE	DRWN	VISHNU		14.03.17			
				SCALE			SHEET	Wt.(Kg)		
							OF	0		
			DRG No.						ALT	
			BEML LIMITED <small>NEW FRONTIERS. NEW DREAMS</small>						909-56811	

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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. 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 SAMPLE MATING COUPLER 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	ALT.NO.	ECN NO/CHANGES

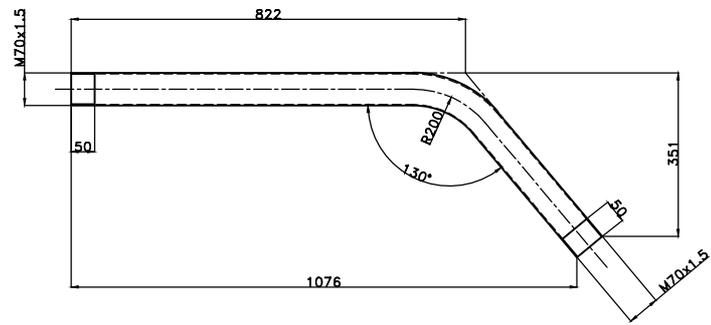
						Ø70x1697x2.5w/t		AISI 304-ERW TUBE	
SL.No.	QTY	PART / STOCK No.		DESCRIPTION		SIZE		COMPANY STD./I.S	Wt. (Kg)
								MATERIAL	
				PRODUCT		DMRC BG METRO CARS			
				REF DRG					
				MATERIAL					
				HEAT TREAT.		APPD	KCS		14.03.17
				SURFACE TREAT.		REVD			
				TITLE		CHKD	SNH		14.03.17
				CONDUIT PIPE		DRWN	VISHNU		14.03.17
						SCALE		SHEET	Wt.(Kg)
						OF	0		
						DRG No.	909-56812		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.							STATUS:			
WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96										

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 SAMPLE MATING COUPLER THREADS

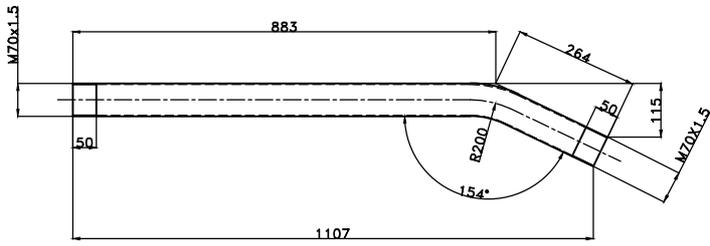
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N5	0.4	▽
N6	0.8	▽
N7	1.6	▽
N8	3.2	▽
N9	6.3	▽
N10	12.5	▽
N11	25	▽
N12	50	▽
GRADE No.		▽
VALUE		▽
SYMBOL		▽
SURFACE ROUGHNESS		▽

						Ø70x1243x2.5w/t		AISI 304-ERW TUBE		
SL.No.	QTY	PART / STOCK No.	DESCRIPTION			SIZE	COMPANY STD./I.S			
							Wt. (Kg)			
							MATERIAL			
			PRODUCT	DMRC BG METRO CARS						
			REF DRG							
			MATERIAL							
			HEAT TREAT.	APPD	KCS		14.03.17			
			SURFACE TREAT.	REVD						
			TITLE	CHKD	SNH		14.03.17			
			CONDUIT PIPE	DRWN	VISHNU		14.03.17			
				SCALE			SHEET	Wt.(Kg)		
							OF	0		
				DRG No.	909-56813				ALT	
									1	
					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.						STATUS:				
WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96										

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 SAMPLE MATING COUPLER THREADS

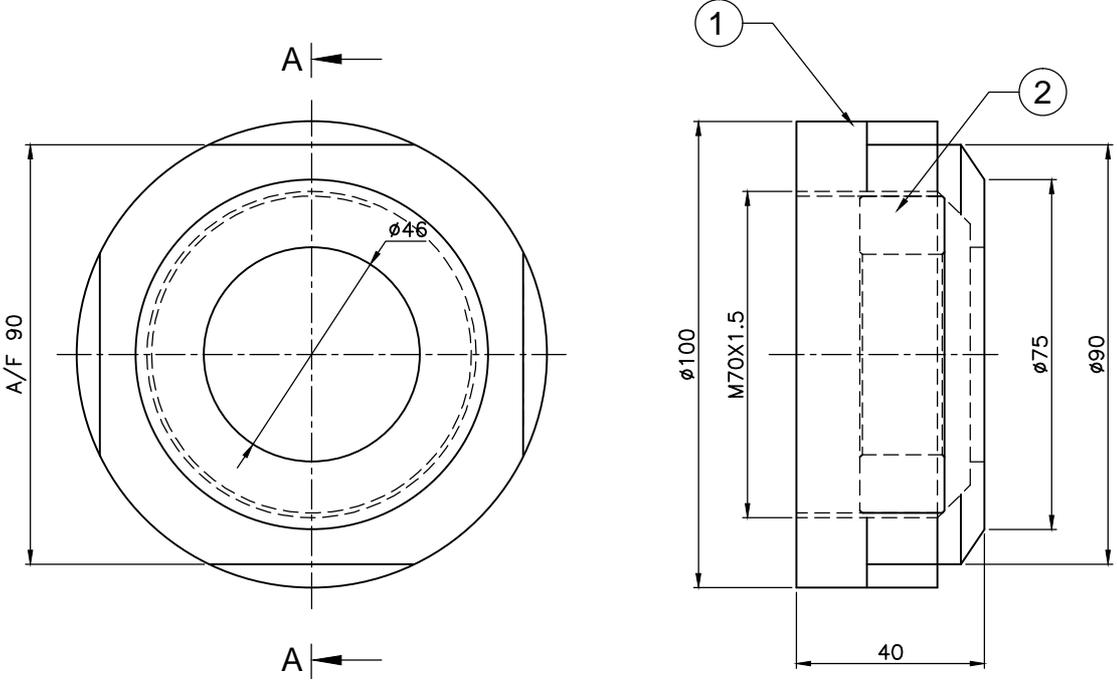
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N2	0.05	▽
N3	0.1	▽
N4	0.2	▽
N5	0.4	▽
N6	0.8	▽
N7	1.6	▽
N8	3.2	▽
N9	6.3	▽
N10	12.5	▽
N11	25	▽
N12	50	▽
GRADE No.		
VALUE		
SYMBOL		
SURFACE ROUGHNESS	ALT.No.	ECN NO/CHANGES

						Ø70x1146x2.5w/t		AISI 304-ERW TUBE	
SL.No.	QTY	PART / STOCK No.		DESCRIPTION		SIZE		COMPANY STD./I.S	Wt. (Kg)
								MATERIAL	
				PRODUCT	DMRC BG METRO CARS				
				REF DRG					
				MATERIAL					
				HEAT TREAT.	APPD	KCS		14.03.17	
				SURFACE TREAT.	REVD				
				TITLE	CHKD	SNH		14.03.17	
				CONDUIT PIPE	DRWN	VISHNU		14.03.17	
					SCALE			SHEET OF	Wt.(Kg)
								0	
						DRG No.		ALT	
						909-56814		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:			

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	ALT.NO.	ECN NO/CHANGES

2	1	909-56817	SPACER				
1	1	909-56816	BUSH				
N7	SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
N8	MATERIAL						

N8	PRODUCT	DMRC BG METRO CARS					
N9	REF DRG						
N10	MATERIAL						
N11	HEAT TREAT.	APPD	KCS			17.4.17	
N12	SURFACE TREAT.	REVD					
GRADE No.	TITLE	CHKD	SNH			17.4.17	
VALUE	BUSH ASSY	DRWN	VISHNU			17.4.17	
SYMBOL		SCALE			SHEET	Wt.(Kg)	
SURFACE ROUGHNESS			OF		0		
		DRG No.	909-56815			ALT	
		BEML LIMITED					