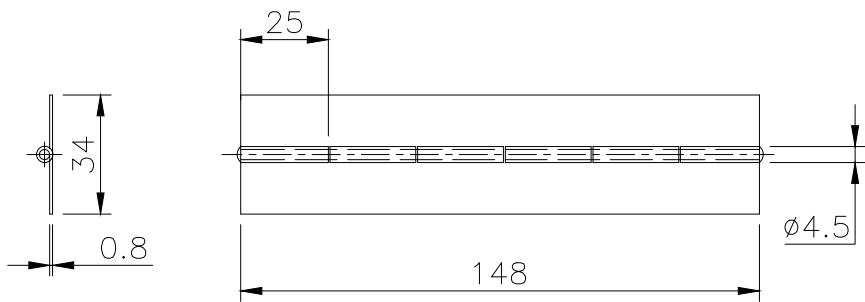
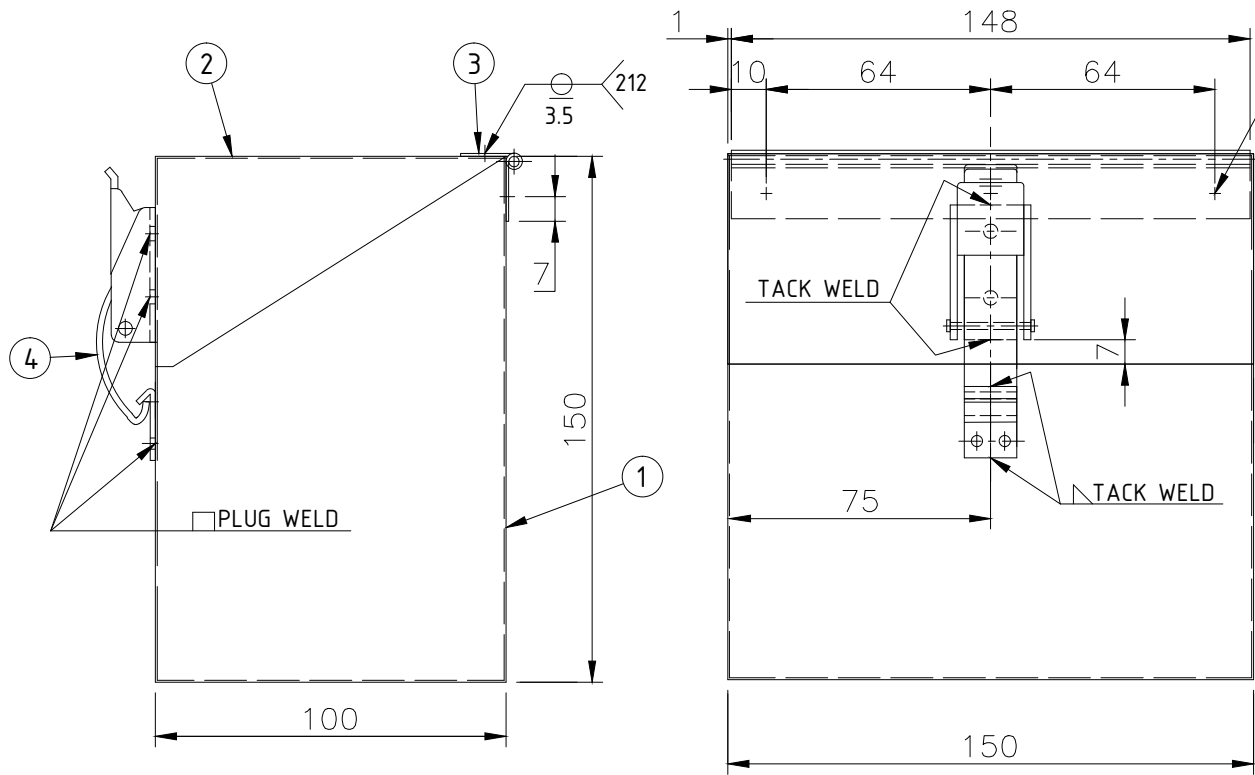


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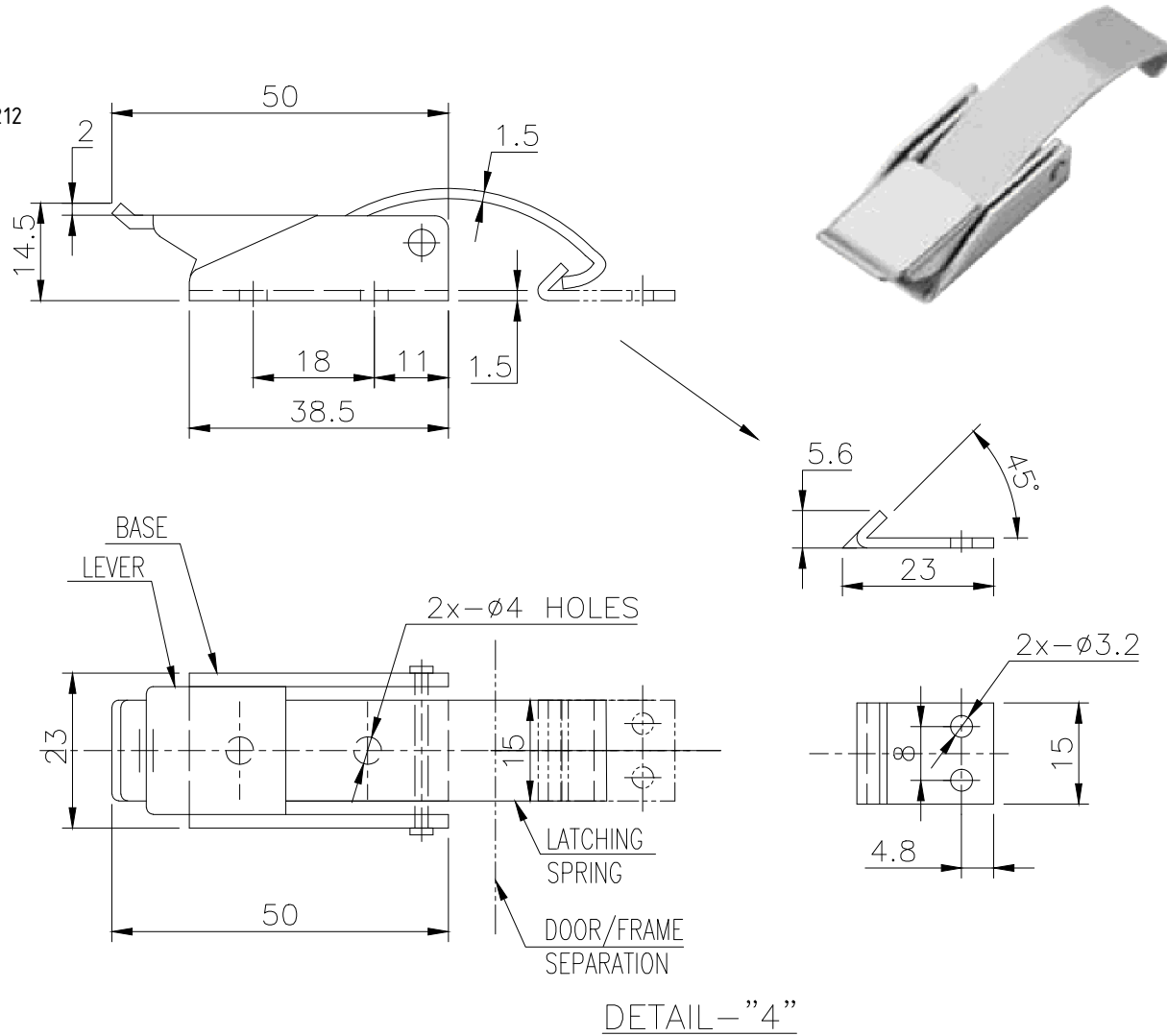
| GRADE No. | N1 | N2 | N3 | N4 | N5 | N6 | N7 | N8 | N9 | N10 | N11 | N12 | VALUE | SYMBOL |
|-------------------|-------|------|-----|-----|-----|-----|-----|-----|-----|------|-----|-----|-------|--------|
| | 0.025 | 0.05 | 0.1 | 0.2 | 0.4 | 0.8 | 1.6 | 3.2 | 6.3 | 12.5 | 25 | 50 | | |
| SURFACE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








UN CONTROLLED













PART-3 DETAIL

| 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 | | | | | | | | | | |
| | | | | | | | | | | |



| SL.No. | QTY | PART / STOCK No. | | | | DESCRIPTION | | SIZE | COMPANY STD./I.S | | Wt. (Kg) |
|---|----------------|------------------|----|------|------|--|---------------------------|-----------|---|------------|---|
| | | | | | | | | | MATERIAL | | |
|  | | | | | | PRODUCT | MUMBAI METRO CARS L2 & L7 | | | | |
| | | | | | | REF DRG | | | | | |
|  | | | | | | MATERIAL | SUS304/AISI 304 | | | | |
| | | | | | | HEAT TREAT. | | APPD | Agate PV. | 14.03.2020 | |
|  | | | | | | SURFACE TREAT. | | REVD | M. Siva Sankar | 14.03.2020 | |
| | | | | | | TITLE | FIRST AID KIT | CHKD | M. Siva Sankar | 14.03.2020 | |
| | | | | | | | | DRWN | Prathima | 14.03.2020 | |
| | | | | | | | | SCALE |  | SHEET | Wt.(Kg) |
|  | | | | | | NTS | | | 1 OF 2 | - | |
| | | | | | | DRG No. | | | | | ALT |
| ALT.NO. | ECN NO/CHANGES | DATE | BY | CHKD | APPD |  BEML LIMITED | | 525-18086 | | |  |

| 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 |  |  | |  |  | |  |  |  |  |  |  |



NOTE:

1. THIS PRODUCT SAMPLE SHALL BE APPROVED BEFORE MASS PRODUCTION.
2. ALL SHARP EDGES SHALL BE REMOVED.
3. WELDING SYMBOLS: ACCORDING TO ISO: 2553.
4. OTHER DIMENSIONS OF ITEM-4 SHALL BE MAINTAINED TO ENSURE FUNCTIONALITY & AESTHETICS. THE SURFACE SHALL BE BUFF FINISHED.
5. ALL WELDS SHALL BE PICKLED & PASSIVATED.
6. FIRST AID KIT SHALL CONFORM TO TDC DOC. NO. GR/TD/5013.
7. PAINTING:
THE ASSEMBLY SHALL BE CLEANED AND SHALL BE FREE FROM OIL/GREASE. THE ASSEMBLY SHALL BE SHOT BLASTED WITH SS GRIT TO A ROUGHNESS OF 20-25 MICRONS AND PRIMER PAINTED WITH EPOXY PRIMER TO GRADE EP1119 OF M/S KCC PAINT TO A DRY FILM THICKNESS OF 40 MICRON AND SUBSEQUENTLY FINISH PAINTED WITH POLYURETHANE PAINT TO GRADE UT 5119 OF M/S KCC PAINT TO A DRY FILM THICKNESS OF 40 MICRON. TOTAL DRY FILM THICKNESS SHALL BE 80-120 MICRON.
COLOUR OF PRIMER – WHITE
COLOUR OF FINISH PAINT – TRAFFIC WHITE TO SHADE-RAL 9003.
THINNER FOR EP1119 IS 024 & FOR UT5119 IS 037U.

| | | | | | | | | | | | | | | | | | | | | | | | |
|---------|---|----------------|------------|------------------|--|------|------------------|----------------|--|---------------------------|----------------|------|--|---|--|----------|--|------------|--|---------|--|----|--|
| 4 | 1 | - | LATCH ASSY | | | | COMMERTIAL LATCH | | | | SUS304/AISI304 | | | | | | | | | | | | |
| 3 | 1 | - | HINGE | | | | 0.8† | | | | SUS304/AISI304 | | | | | | | | | | | | |
| 2 | 1 | - | BODY-UPPER | | | | 1† | | | | SUS304/AISI304 | | | | | | | | | | | | |
| 1 | 1 | - | BODY-LOWER | | | | 1† | | | | SUS304/AISI304 | | | | | | | | | | | | |
| SL.No. | | QTY | | PART / STOCK No. | | | | DESCRIPTION | | | | SIZE | | COMPANY STD./I.S | | Wt. (Kg) | | | | | | | |
| | | | | | | | | | | | | | | MATERIAL | | | | | | | | | |
| | | | | | | | | PRODUCT | | MUMBAI METRO CARS L2 & L7 | | | | | | | | | | | | | |
| | | | | | | | | REF DRG | | | | | | | | | | | | | | | |
| | | | | | | | | MATERIAL | | SUS304/AISI304 | | | | | | | | | | | | | |
| | | | | | | | | HEAT TREAT. | | | | | | APPD | | | | 14.03.2020 | | | | | |
| | | | | | | | | SURFACE TREAT. | | | | | | REVD | | | | 14.03.2020 | | | | | |
| | | | | | | | | TITLE | | | | | | CHKD | | | | 14.03.2020 | | | | | |
| | | | | | | | | | | | | | | DRWN | | | | 14.03.2020 | | | | | |
| | | | | | | | | | | | | | | SCALE | | | | SHEET | | Wt.(Kg) | | | |
| | | | | | | | | | | | | | | NTS | | | | 2 OF 2 | | - | | | |
| | | | | | | | | | | | | | | DRG No. | | | | | | ALT | | | |
| ALT.NO. | | ECN NO/CHANGES | | | | DATE | | BY | | CHKD | | APPD | | BEML LIMITED <small>NEW FRONTIERS, NEW DREAMS</small> | | | | 525-18086 | | | | | |
| | | | | | | | | | | | | | | 4 | | | | 1 | | | | A3 | |