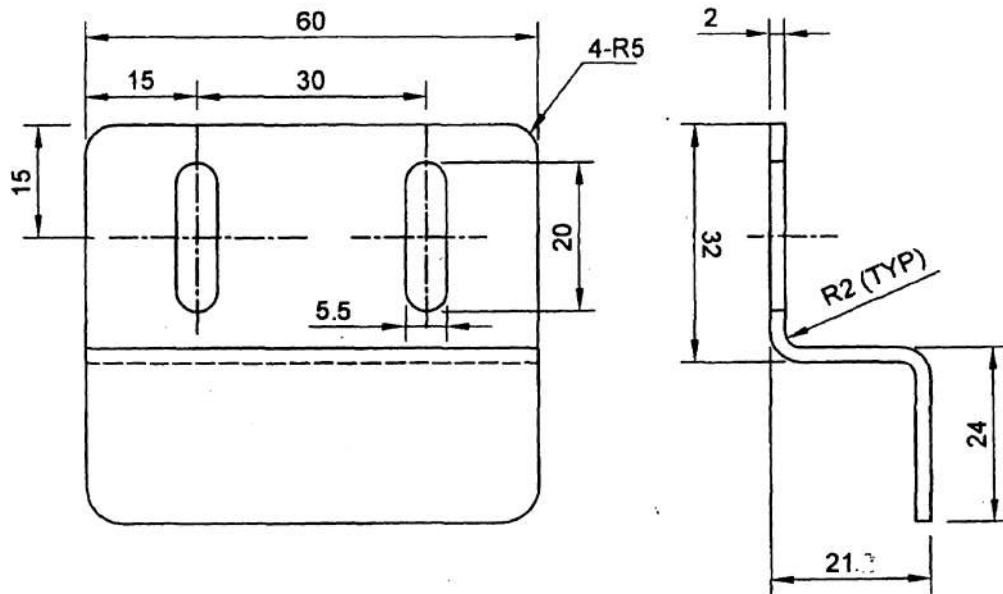


MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0-6	6-30	30-120	120-315	315-1000	1000-2000	2000-4000	ABOVE 4000
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227									
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR 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			
PAINTING SHALL BE DONE AS PER RD - 38						-PROTO/PILOT/PRODUCTION			
WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96									



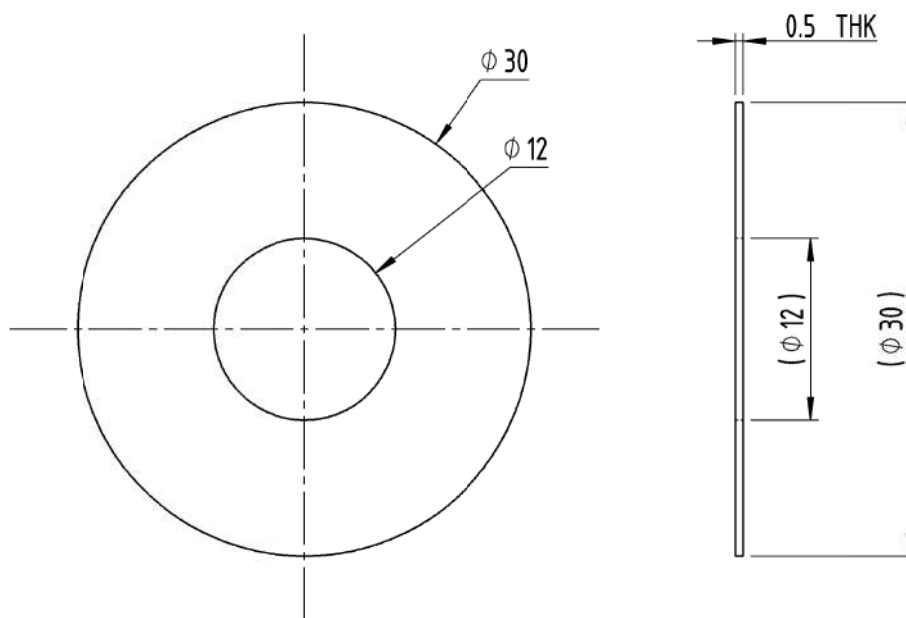
UN CONTROLLED

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	

				71x60x2THK.		SUS304	
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		Wt.(Kg)
					1:1		
					QTY	NEXT ASSY	MODEL
					REF DRG		
					APPROVED <i>J. Subudh</i> 24/2		
					CHECKED <i>K. S. R.</i> 24/2/12		
					DRAWN SUNIL 22.02.12		
					DRG No.		
					909-19587		
					ALT		
BEML LIMITED		R&D, BANGALORE COMPLEX					
BANGALORE 560 075							
ALT	CHANGES	DATE	BY	CKD	APP		

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<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td colspan="2"></td> <td colspan="2"></td> <td colspan="2"></td> <td colspan="2"></td> <td colspan="2">218x20x2THK</td> <td colspan="2"></td> </tr> <tr> <td>SL.No.</td> <td>QTY</td> <td colspan="2">PART / STOCK No.</td> <td colspan="4">DESCRIPTION</td> <td>SIZE</td> <td colspan="2">COMPANY STD./I.S</td> <td>Wt. (Kg)</td> </tr> <tr> <td colspan="10"></td> <td colspan="2" style="text-align: center;">MATERIAL</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <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></td> <td></td> <td></td> <td></td> <td>REF DRG</td> <td colspan="5"></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td>MATERIAL</td> <td colspan="5">AISI304/SUS304-2B FINISHED ▲</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td>HEAT TREAT.</td> <td>APPD</td> <td>PVG</td> <td colspan="2">18.12.2015</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td>SURFACE TREAT.</td> <td>REVD</td> <td colspan="3"></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td>TITLE</td> <td>CHKD</td> <td>KP</td> <td colspan="2">18.12.2015</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td rowspan="3" style="text-align: center; vertical-align: middle;"> WIRE SUPPORT </td> <td>DRWN</td> <td>SUNIL</td> <td colspan="2">18.12.2015</td> </tr> <tr> <td>GRADE No.</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td>SCALE</td> <td>1:2</td> <td>SHEET</td> <td>1 OF 1</td> <td>Wt.(Kg)</td> </tr> <tr> <td>VALUE</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td>DRG No.</td> <td colspan="3">909-19638</td> <td>ALT</td> </tr> <tr> <td>SURFACE ROUGHNESS</td> <td>ALT.NO.</td> <td colspan="2">ECN NO/CHANGES</td> <td>DATE</td> <td>BY</td> <td>CHKD</td> <td>APPD</td> <td colspan="4" style="text-align: center;"> BEML LIMITED <small>NEW FRONTIERS. NEW DREAMS</small> </td> <td style="text-align: center;"> </td> </tr> </table>																					218x20x2THK				SL.No.	QTY	PART / STOCK No.		DESCRIPTION				SIZE	COMPANY STD./I.S		Wt. (Kg)											MATERIAL									PRODUCT	DMRC BG METRO CARS												REF DRG													MATERIAL	AISI304/SUS304-2B FINISHED ▲												HEAT TREAT.	APPD	PVG	18.12.2015									SURFACE TREAT.	REVD											TITLE	CHKD	KP	18.12.2015									WIRE SUPPORT	DRWN	SUNIL	18.12.2015		GRADE No.							SCALE	1:2	SHEET	1 OF 1	Wt.(Kg)	VALUE							DRG No.	909-19638			ALT	SURFACE ROUGHNESS	ALT.NO.	ECN NO/CHANGES		DATE	BY	CHKD	APPD	BEML LIMITED <small>NEW FRONTIERS. NEW DREAMS</small>				
								218x20x2THK																																																																																																																																																																				
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MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000	RA
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	~
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227										
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM)							QUALITY OF WELD JOINTS REF, RD 230 MEDIUM			
VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS. 1012.C.							STATUS:	PROTO / PRODUCTION		
WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96										

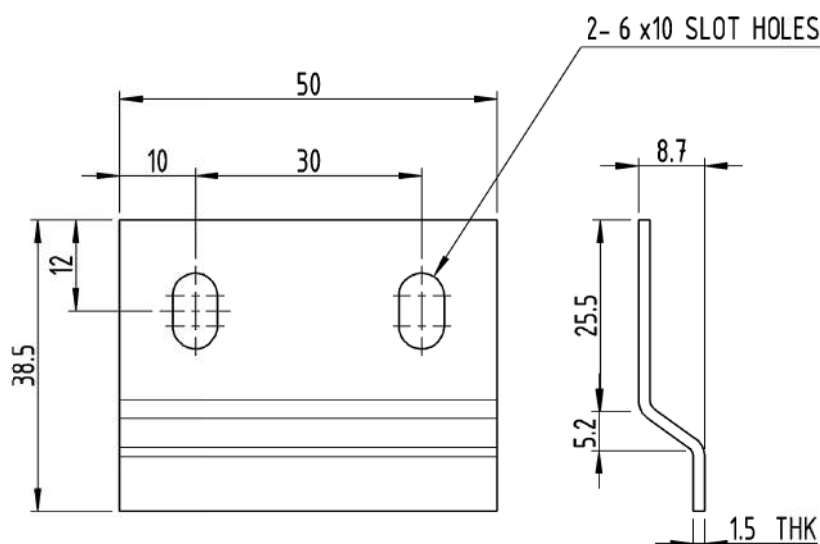


UN CONTROLLED

NOTE: REMOVE ALL SHARP EDGES AND BURRS.

[illegible]

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										



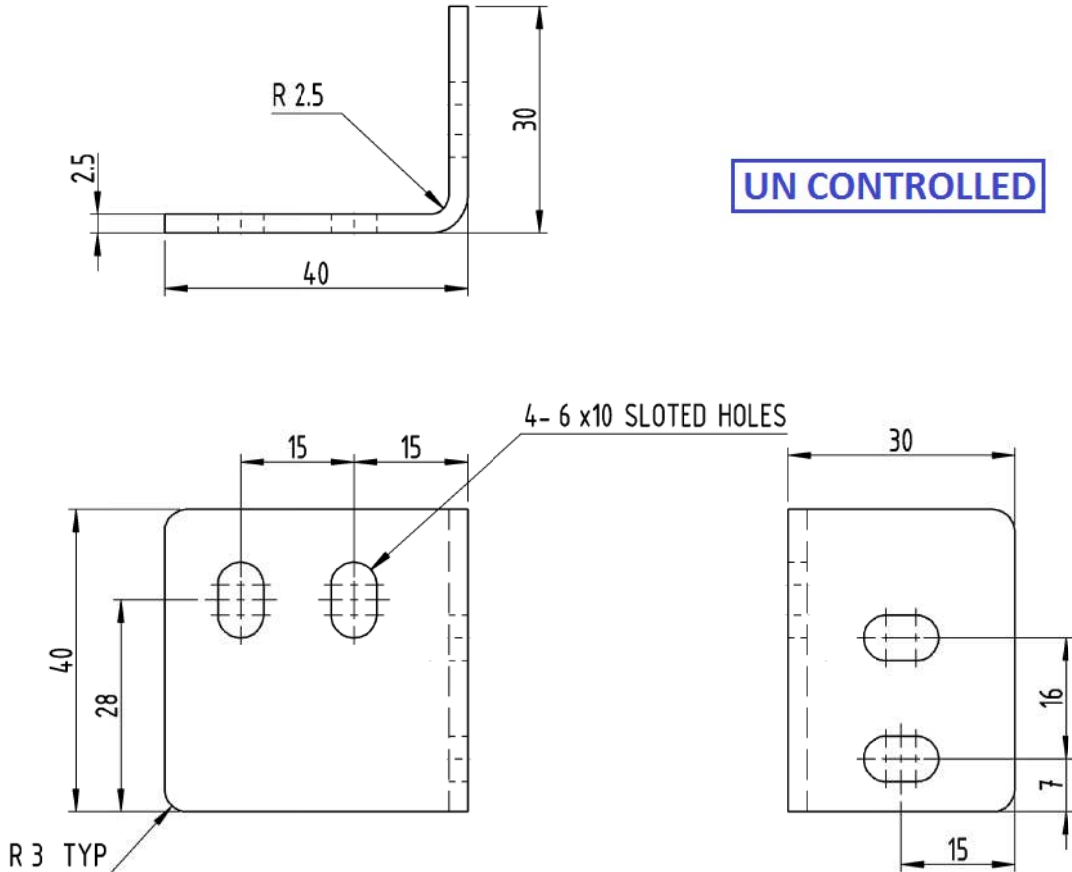
UN CONTROLLED

NOTE: REMOVE ALL SHARP EDGES AND BURRS.





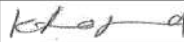
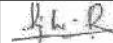
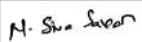

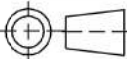


[illegible]

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	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										



NOTE: REMOVE ALL SHARP EDGES AND BURRS.

						65x40x2.5 THK						
SL.No.	QTY	PART / STOCK No.				DESCRIPTION				SIZE	COMPANY STD./I.S	Wt. (Kg)
											MATERIAL	
					PRODUCT	DMRC BG METRO CARS						
					REF DRG							
					MATERIAL	SUS304, 2B FINISH						
					HEAT TREAT.		APPD			10.04.2018		
					SURFACE TREAT.		REVD			10.04.2018		
					TITLE	BRACKET 3	CHKD			10.04.2018		
					DRWN				10.04.2018			
					SCALE			SHEET		Wt.		
					1:1			1 OF 1		-		
ALT.NO.	ECN NO/CHANGES				DATE	BY	CHKO	APPD	DRG No.		ALT	
									909-19647			
					 BEM <small>NEW FRONTIERS. NEW DREAMS</small>				BEM LIMITED			



BEML LIMITED

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

UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM)	QUALITY OF WELD JOINTS REF. RD 230 MEDIUM
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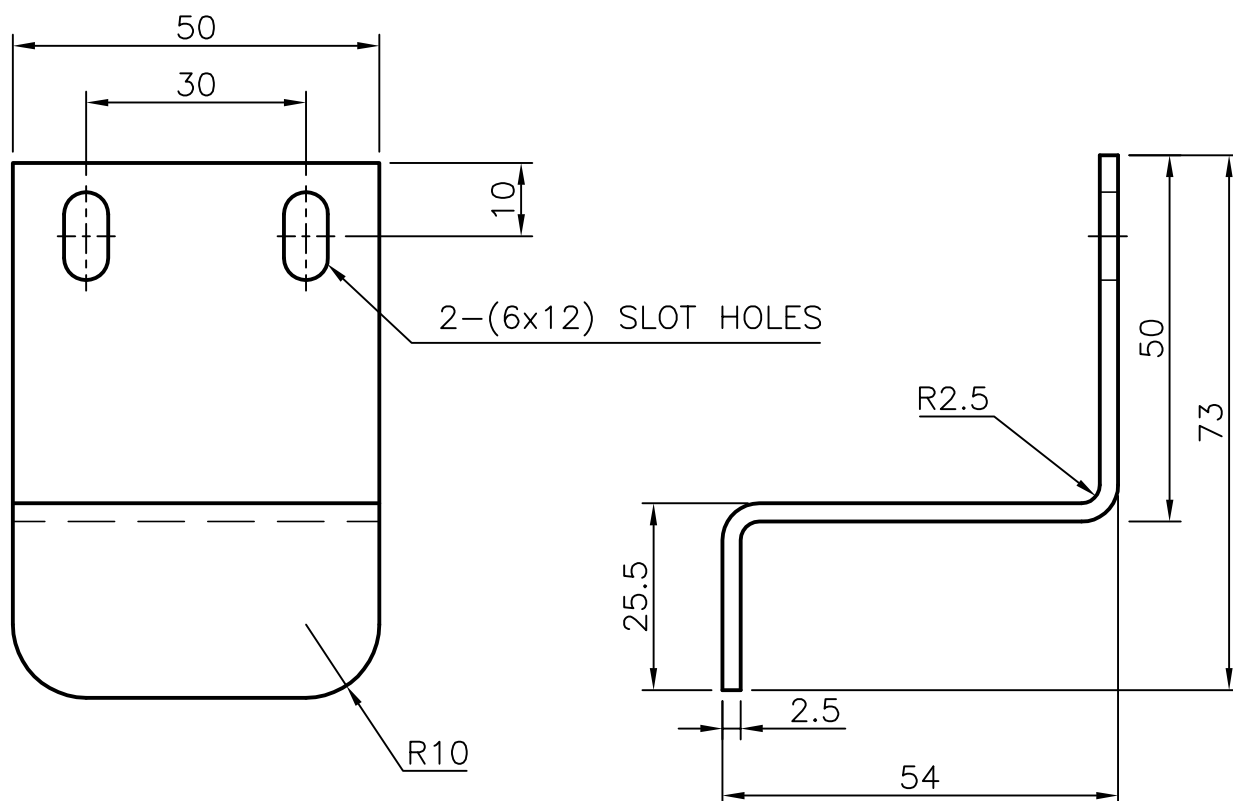
VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS: 1012.C

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

STATUS:










PRODUCTION

UNCONTROLLED



NOTE

REMOVE ALL SHARP EDGES AND BURRS

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												

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3		2										1				
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	±3	~						
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227																
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 202 (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 9555-56																