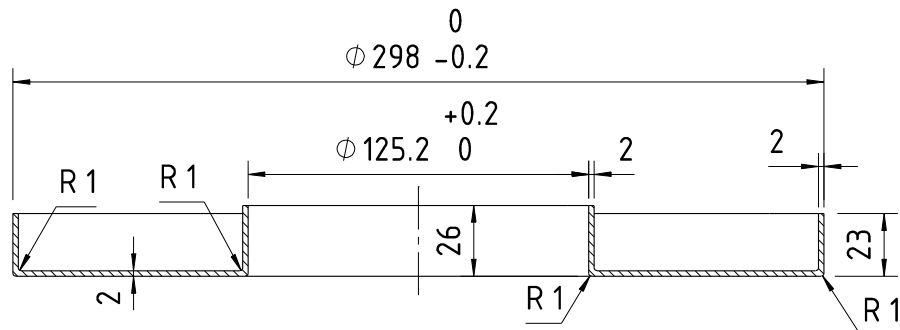


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GRADE No.	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12	VALUE	SYMBOL	SURFACE ROUGHNESS
	0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50			
	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓			

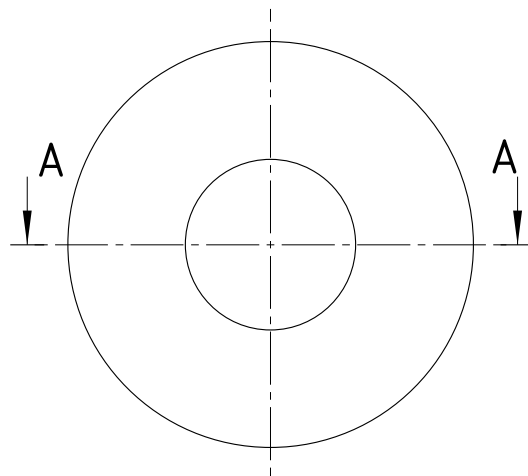
MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000	RA
	TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	~
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227										
UNSPECIFIED TOLERANCE FOR LINEAR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



SECTION A-A
SCALE 1:2.5

NOTE:

1. TENSILE STRENGTH OF MIN. 25 MPa AS PER ASTM D638 (Type 1- 50mm/min)
2. IMPACT STRENGTH OF MIN. 170 J/m AS PER ASTM D256(Method A)
3. HARDNESS OF MIN D65 SHORE AS PER ASTM D2240-05
4. FLEXURAL PROPERTY IF MIN 1125 MPa AS PER ASTM D790 (Procedure A)
5. DEFLECTION TEMPERATURE OF MIN. 85°C AS PER ASTM D648-07
6. DENSITY OF 0.9 TO 0.96 g/cm³
7. INSULATION RESISTANCE OF MIN. 1000 MΩ AS PER ASTM D257
8. THE PARAMETERS WILL BE FINALIZED IN THE DETAIL DESIGN STAGE



SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
MATERIAL						
PRODUCT MUMBAI METRO CARS L2 & L7						
REF DRG						
MATERIAL POLYESTER						
HEAT TREAT.				APPD	MS	
SURFACE TREAT.				REVD	SSB	
TITLE				CHKD	RSS	
SEAT INSULATOR				DRWN	VSE	
				SCALE	1:5	
BEML LIMITED				SHEET	1 OF 1	Wt. 0.16Kg
				DRG No.	525-81120	ALT 0
ALT.NO.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	