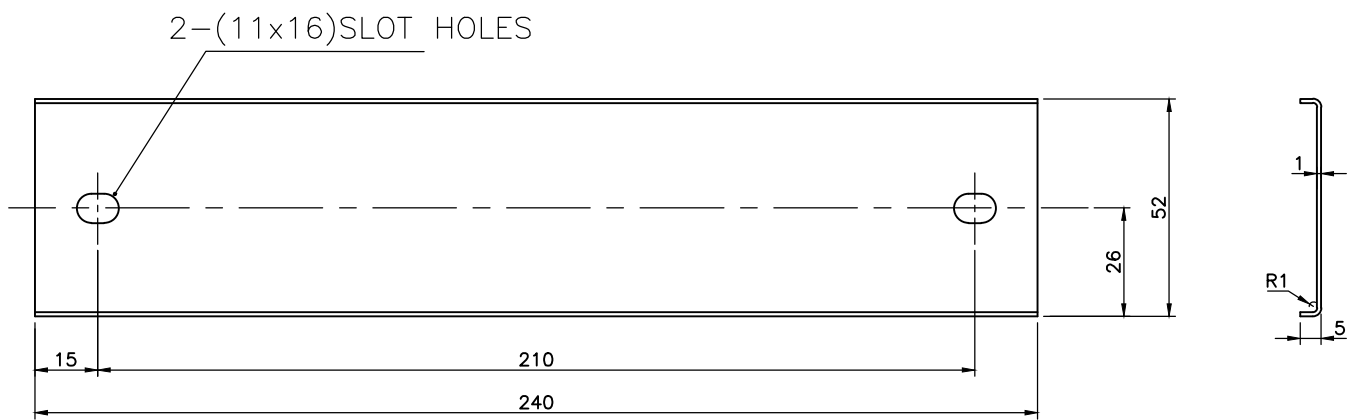
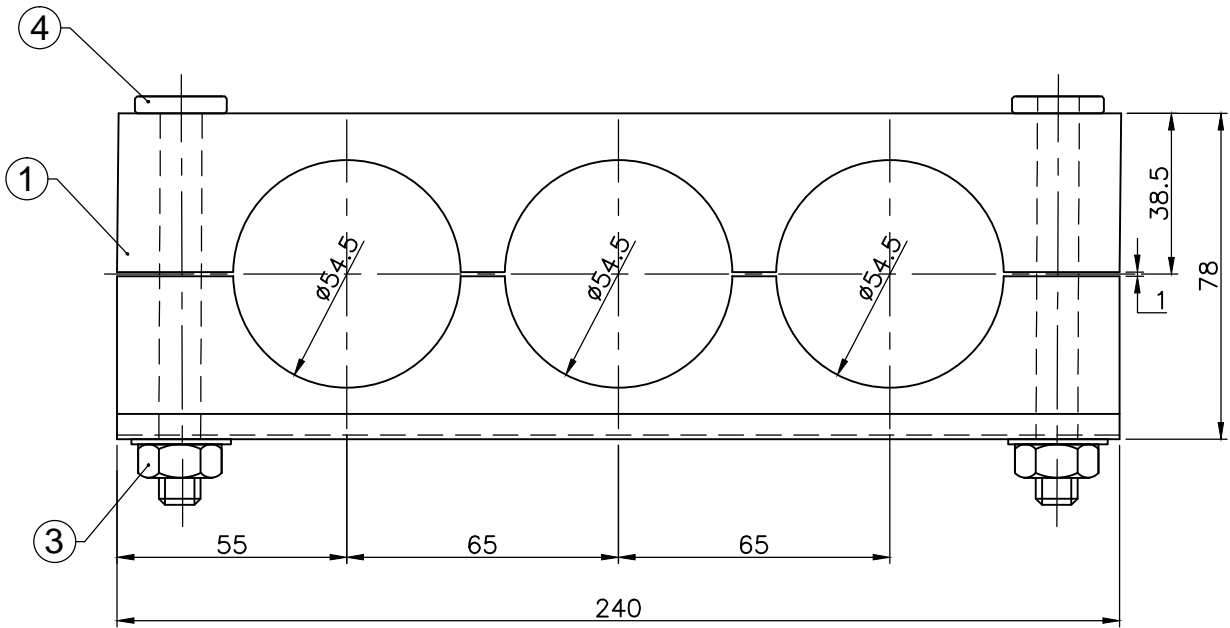
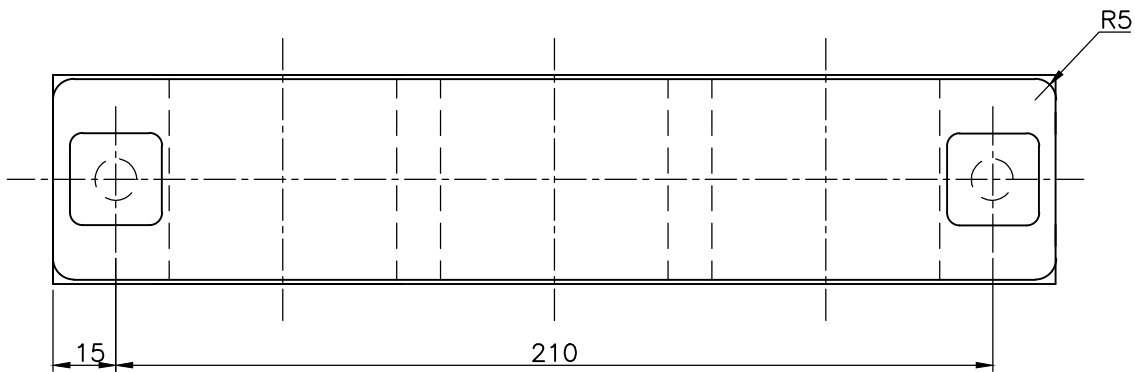


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GRADE No.	VALUE	SYMBOL	RA	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12
			0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50	
SURFACE															
ROUGHNESS															

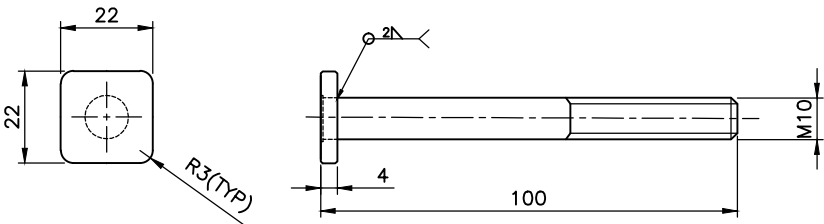
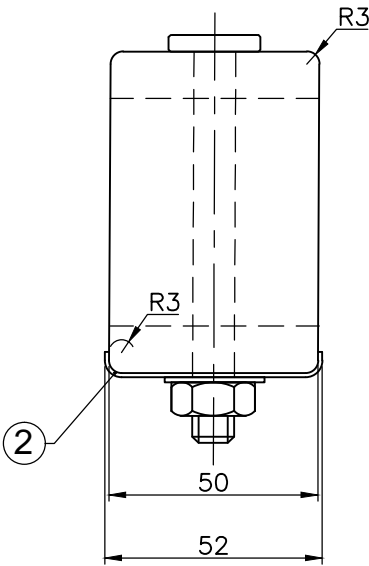


DETAIL-2

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										




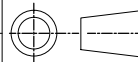



NOTE:

1. REMOVE ALL SHARP EDGES
2. FOR CLEATS Min TENSILE STRENGTH: 65 N/mm²
3. BURNING RESISTANCE : SELF EXTINGUISH.
4. FOR ITEM-4, BOLT SHALL BE AS PER ISO:4162, Matl: IS-1367(P14)-84 Gr A2-70,SS



DETAIL-4

UNCONTROLLED

4	2	926-56129-4	T BOLT ASSY				AISI 304				
3	2	RFN5541084	HEX. NUT WITH FLANGE M10 TO ISO:7044-83/ Matl: IS-1367(P14)-84 Gr A2-70, STAINLESS STEEL								
2	1	926-56129-2	PLATE				t1		AISI 304		
1	2	926-56129-1	CLEAT						NYLON6		
SL.No.	QTY	PART / STOCK No.		DESCRIPTION				SIZE		COMPANY STD./I.S	Wt. (Kg)
										MATERIAL	
					PRODUCT	BMRCL METRO CARS					
					REF DRG						
					MATERIAL						
					HEAT TREAT.		APPD	KCS			
					SURFACE TREAT.		REVD				
					TITLE		CHKD	SNH			
					CLEAT ASSY, AUTO COUPLER		DRWN	VISHNU		18.04.18	
							SCALE		SHEET	Wt.(Kg)	
								OF		0	
	REVISED & REDRAWN ECN:92610069		DATE 25.04.18	BY VISHNU	CHKD SNH	APPD KCS	DRG No.				ALT
ALT.NO.	ECN NO/CHANGES					 BEM LIMITED	926-56129				

1

REVISED & REDRAWN
ECN:92610069

DATE 25.04.18
BY VISHNU
CHKD SNH
APPD KCS

CLEAT ASSY,
AUTO COUPLER

BEML LIMITED

926-56129

1