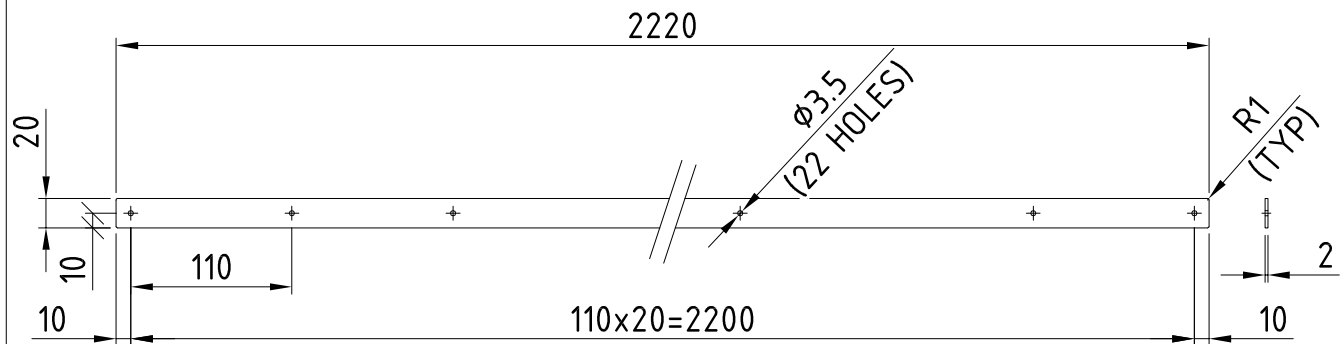


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DRAWING RELEASED FROM PLM, PHYSICAL SIGNATURE NOT REQUIRED

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										






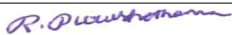








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NOTE:

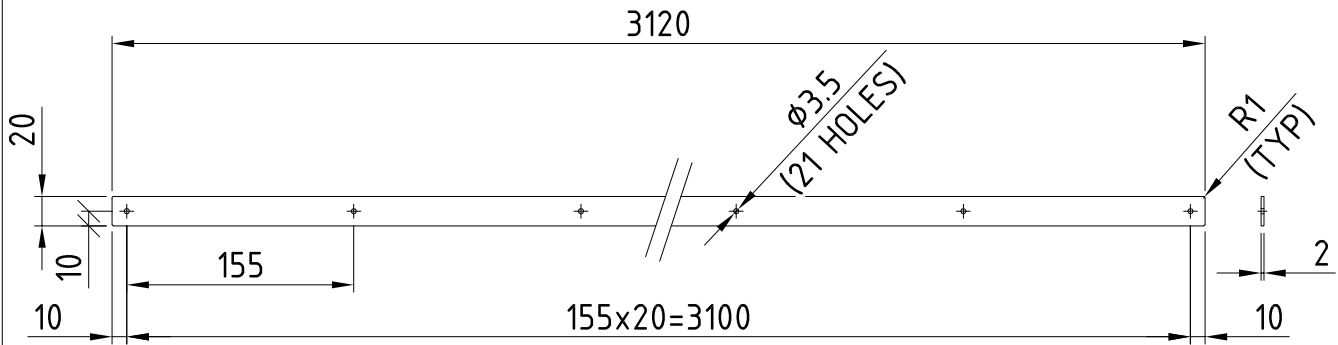
1. ALL DIMENSIONS ARE IN mm.
2. REMOVE ALL SHARP EDGES AND BURRS.

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		

							2220x20x2THK				
SL.No.	QTY	PART / STOCK No.				DESCRIPTION	SIZE	COMPANY STD./I.S		Wt. (Kg)	
								MATERIAL			
						PRODUCT	MUMBAI METRO CARS L2 & L7				
						REF DRG	-				
						MATERIAL	AISI 304, No. 2B FINISH				
						HEAT TREAT.	-	APPD		25/11/2019	
						SURFACE TREAT.	-	REVD		25/11/2019	
						TITLE	STIFFENER,FIVE SEATER		CHKD		25/11/2019
						SCALE					SHEET
						1:5			1 OF 1	-	
ALT.No.	ECN NO/CHANGES	DATE	BY	CHKD	APPD	DRG No.				525-23139	
							BEM LIMITED				

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DRAWING RELEASED FROM PLM, PHYSICAL SIGNATURE NOT REQUIRED

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										



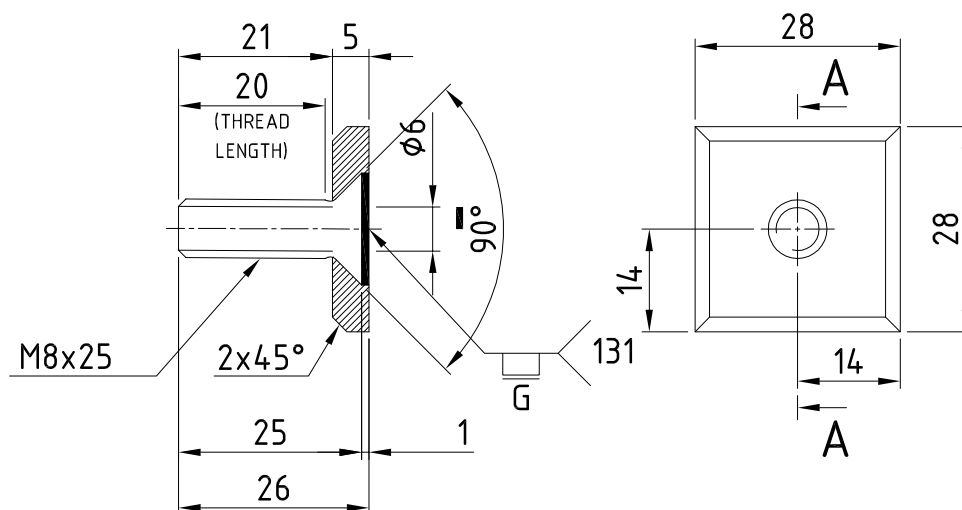
UNCONTROLLED

NOTE:

1. ALL DIMENSIONS ARE IN mm.
2. REMOVE ALL SHARP EDGES AND BURRS.

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	
												3120x20x2THK															
SL.No.		QTY		PART / STOCK No.		DESCRIPTION		SIZE		COMPANY STD./I.S		Wt. (Kg)		MATERIAL													
						PRODUCT		MUMBAI METRO CARS L2 & L7																			
						REF DRG		-																			
						MATERIAL		AISI 304, No. 2B FINISH																			
						HEAT TREAT.		-		APPD		25/11/2019															
						SURFACE TREAT.		-		REVD		25/11/2019															
						TITLE		STIFFENER		CHKD		25/11/2019															
										DRWN		25/11/2019															
										SCALE		1:5		SHEET		1 OF 1		Wt.(Kg)		-							
										DRG No.		525-23140		ALT		0											
SURFACE ROUGHNESS		ALT.NO.		ECN NO/CHANGES		DATE		BY		CHKD		APPD		BEML LIMITED													

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										














SECTION-AA

UNCONTROLLED

NOTE:

1. ALL DIMENSIONS ARE IN mm.
2. REMOVE ALL SHARP EDGES AND BURRS.
3. WELDING SYMBOLS AS PER ISO 2553.
4. NYLOK BLUE PATCH TO BE APPLIED ON THE THREAD.
5. THE SQUARE HEAD BOLT SHALL CONFORM TO DOC. No. GR/TD/4931 (TECHNICAL DELIVERY CONDITIONS).

2	1	525-23156-2	CSK FLAT HEAD				M8x25		IS:7485/MATL. ISO:3506,Gr. A2-70				
1	1	525-23156-1	PLATE				28x28x5THK		AISI 304, 2B FINISH				
SL.No.	QTY	PART / STOCK No.			DESCRIPTION				SIZE		COMPANY STD./IS	Wt. (Kg)	
											MATERIAL		
						PRODUCT	MUMBAI METRO CARS L2 & L7						
						REF DRG	-						
						MATERIAL	-						
						HEAT TREAT.	-	APPD			25/11/2019		
						SURFACE TREAT.	-	REVD			25/11/2019		
						TITLE	CHKD				25/11/2019		
						BOLT,SQUARE HEAD		DRWN			25/11/2019		
								SCALE			SHEET	Wt.(Kg)	
								1:1			1 OF 1	-	
								DRG No.			ALT		
								525-23156					
ALT.NO.						ECN NO/CHANGES						DATE	
												BY	
												CHKD	
												APPD	
						 BEM LIMITED <small>NEW FRONTIERS. NEW DREAMS</small>							

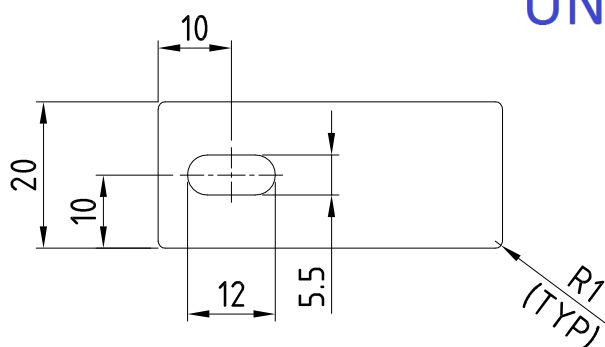
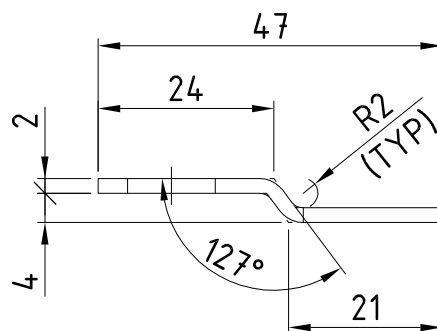


1. ALL DIMENSIONS ARE IN mm.
2. REMOVE ALL SHARP EDGES AND BURRS.



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	
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		



UNCONTROLLED

1. ALL DIMENSIONS ARE IN mm.
2. 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	