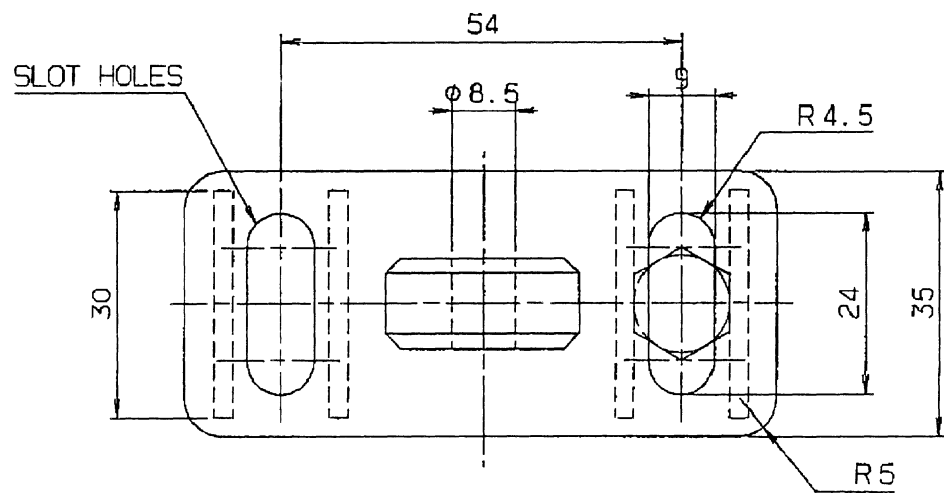
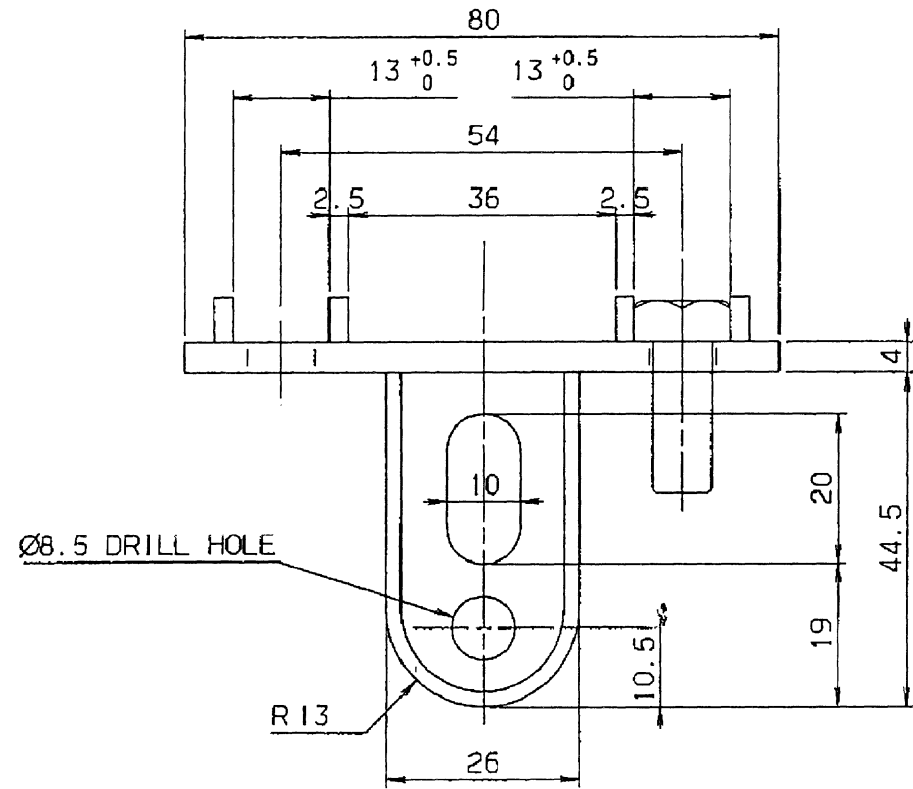


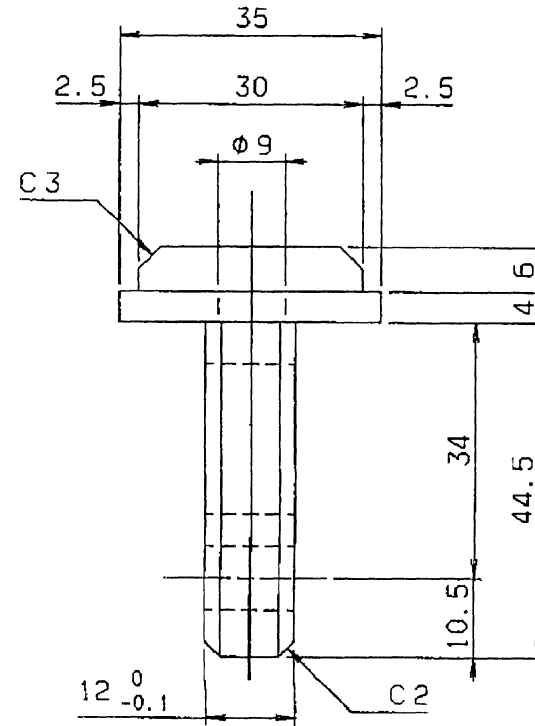
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GRADE No.	VALUE	SYMBOL
N1	0.025	
N2	0.05	
N3	0.1	
N4	0.2	
N5	0.4	
N6	0.8	
N7	1.6	
N8	3.2	
N9	6.3	
N10	12.5	
N11	25	
N12	50	
ROUGHNESS		



NOTE:
1. REMOVE ALL BURRS AND SHARP EDGES.

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	±12	±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 IS 1012 C							STATUS	PRODUCTION		
WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96										



UNCONTROLLED

SL.No.	QTY	PART / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./I.S	Wt. (Kg)
					MATERIAL	
			PRODUCT	DMRC BG METRO CARS		
			REF DRG			
			MATERIAL	SUS 304		
			HEAT TREAT.	-	APPD	24/10/15
			SURFACE TREAT.	-	REVD	
			TITLE	BRACKET, POLE, CEILING		
			CHKD	20.10.15		
			DRWN	PURUSHOTHAMAN 04/09/2015		
			SCALE		SHEET	Wt.(Kg)
			NTS		1 OF 1	-
			DRG No.	ALT		
			ALT.No	ECN NO/CHANGES		
			DATE	BY	CHKD	APPD
			BEML BEML LIMITED			909-29004