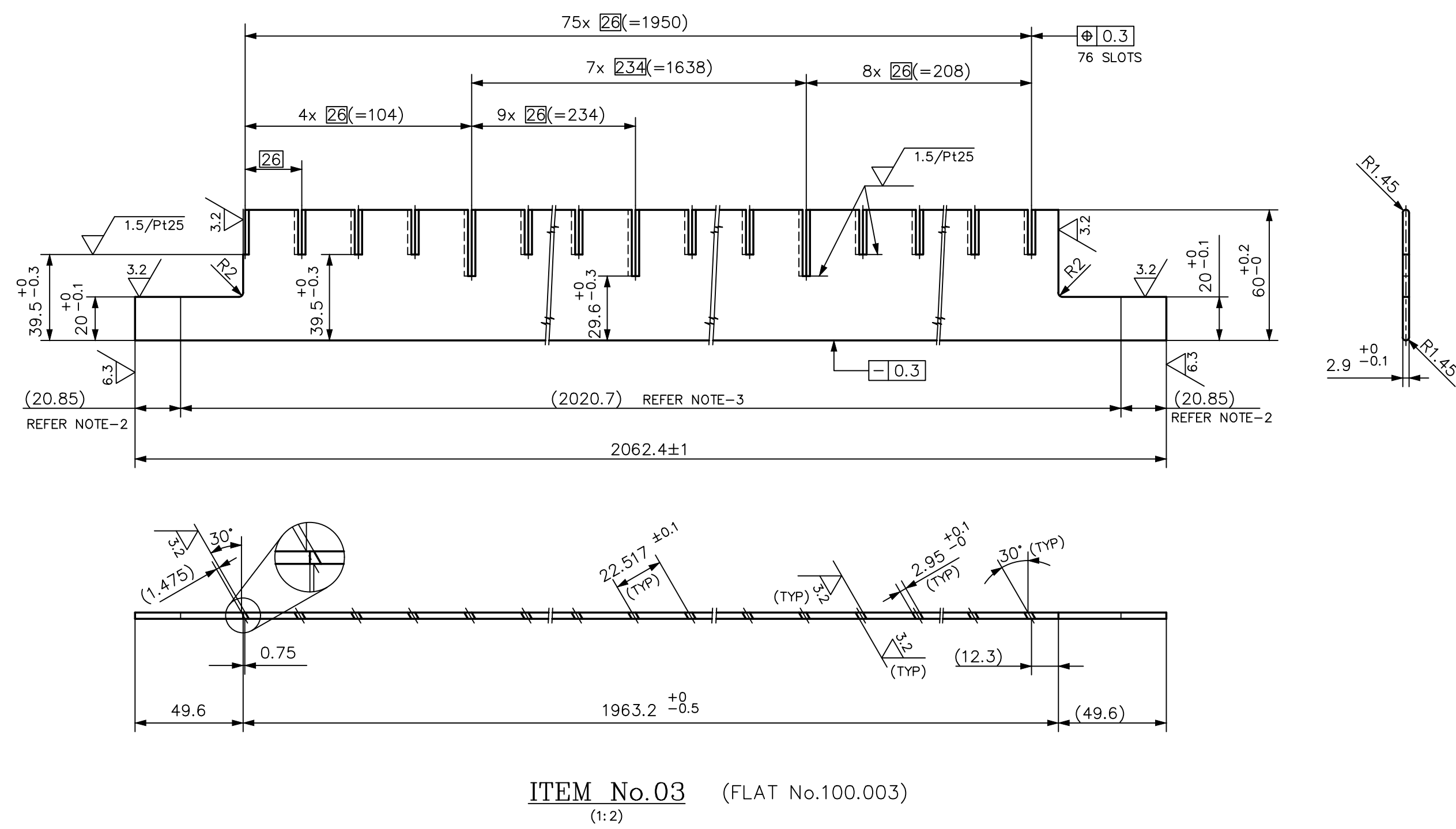
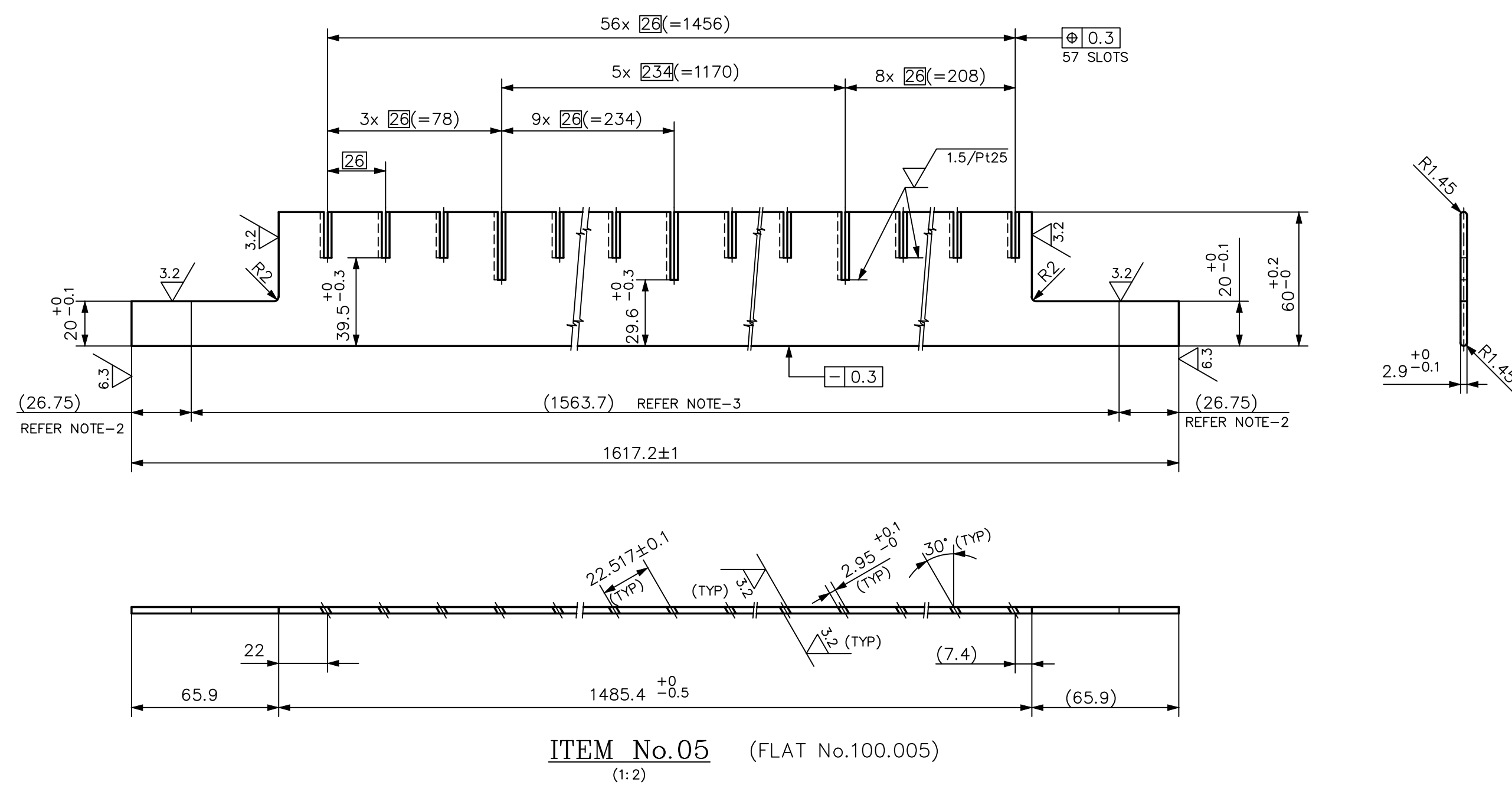
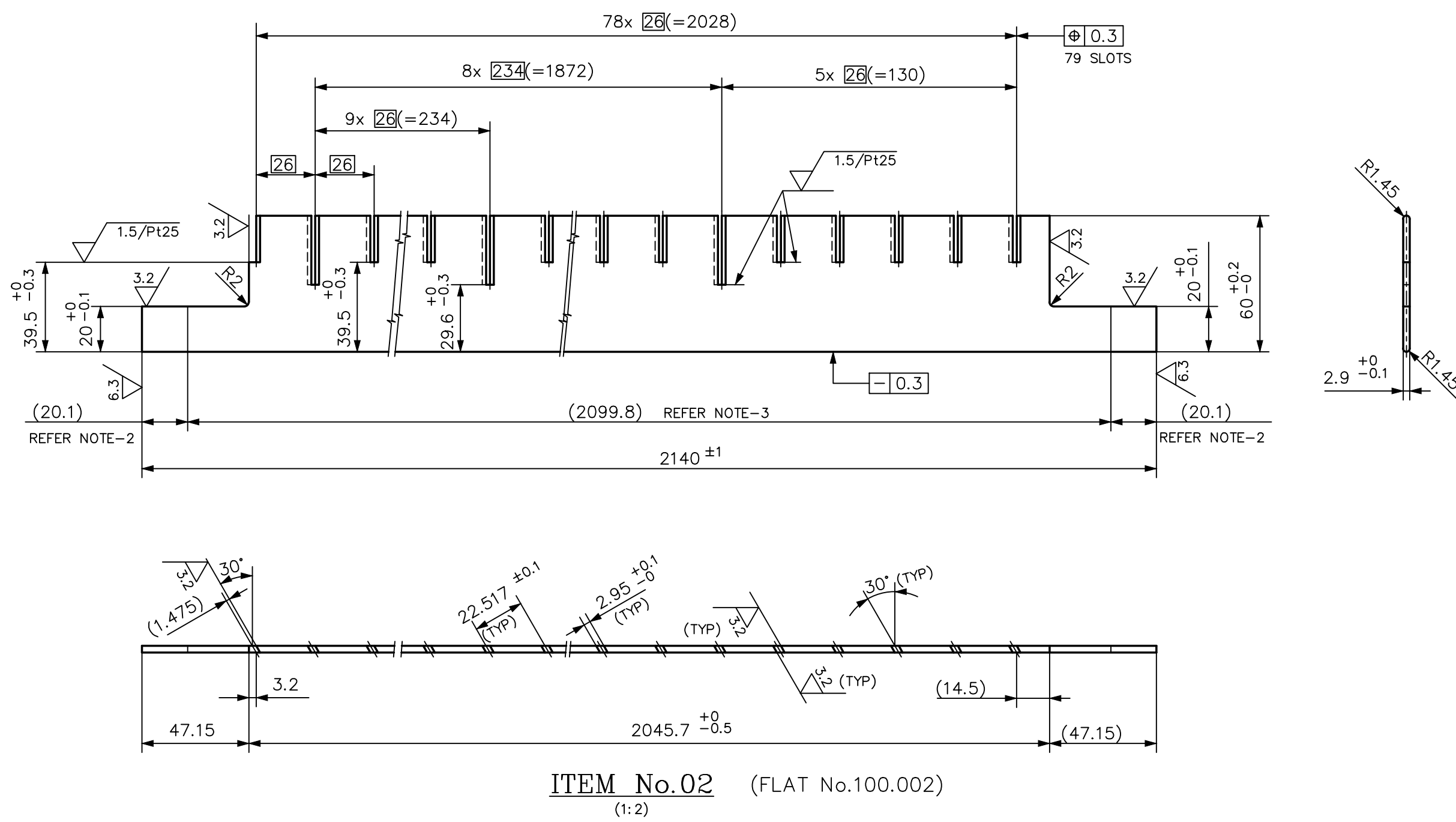
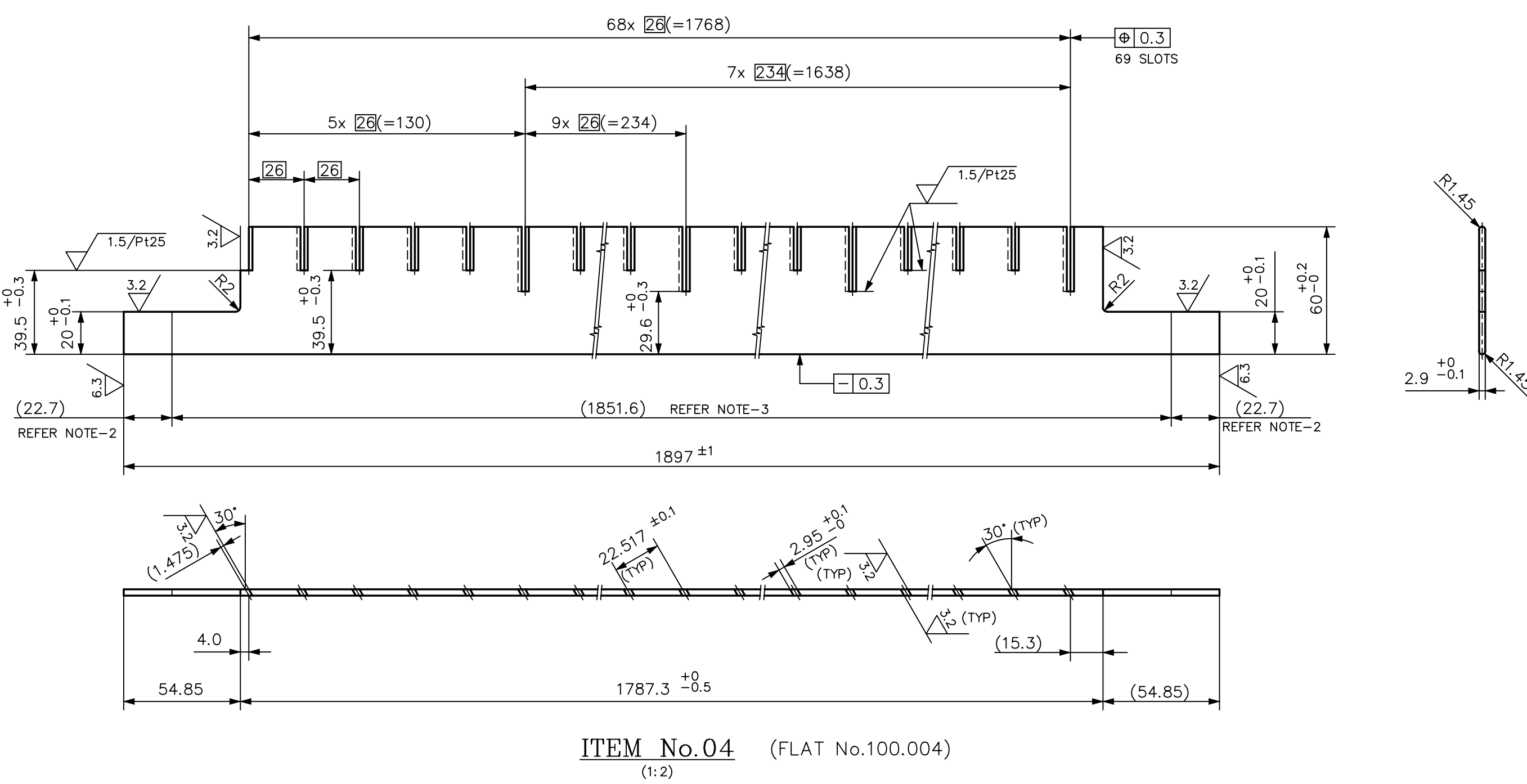
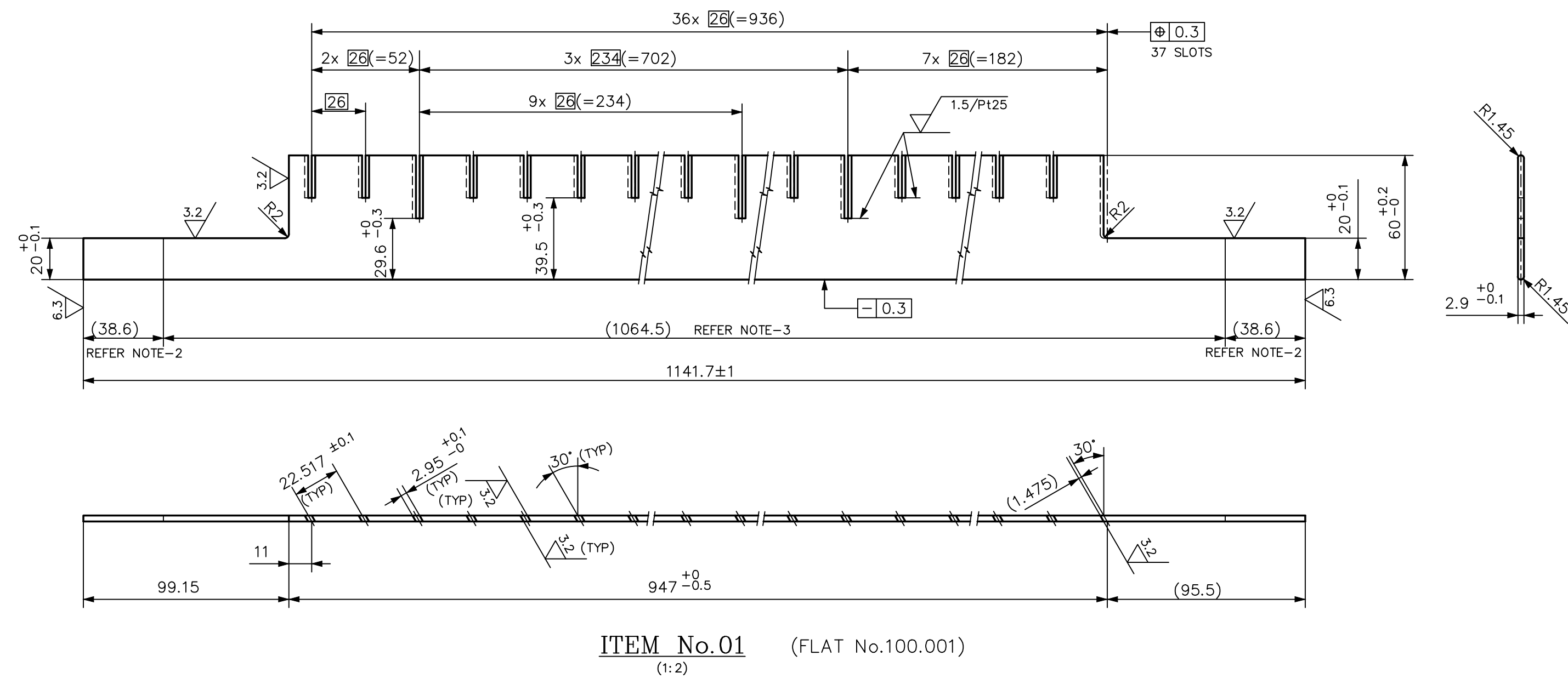
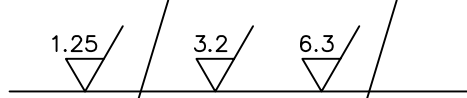




NOTE

1. FOR TOLERANCES, REFER TECHNICAL SPECIFICATION PC-M-963
2. MACHINING ALLOWANCE OF 20mm (ie AT R=1074.65) PROVIDED.
3. LENGTH OF GRID FLAT IN BRACKET INDICATED FOR REFERENCE ONLY, AND IS AFTER MACHINING.
4. CONTACT WITH FERRITIC MATERIAL SHALL BE AVOIDED AT ALL STAGES OF MANUFACTURE.
5. ENSURE TOLERANCES AS PER SPECIFICATION PC-M-963 BEFORE AND AFTER SLOT MAKING.
6. IDENTIFY THE GRID FLATS WITH IDENTIFICATION NO. (100.XXX) AFTER MACHINING.
7. MACHINE THE ENDS TO THE REQUIRED SHAPE ONLY AFTER SLOTTING.
8. ALL SHARP CORNERS SHALL BE CAREFULLY DEBURRED.
9. FOR ALUMINOUS BLASTING, REFER GRID FLATS ASSEMBLY DRG. NO. 0-93-172-05345
10. EXTRA LENGTH OF GRID FLAT SHALL BE EQUAL ON EITHER SIDE BEFORE SLOTTING. THIS EXTRA LENGTH SHALL BE REMOVED ON ASSY. DURING FINAL CIRCUMFERENTIAL MACHINING.
11. MANUFACTURING OF MAIN GRID FLATS FROM DIN 17440-1.4550 MATERIAL SPECIFICATION IS ALSO PERMISSIBLE.

ALL DIMENSIONS ARE IN MILLIMETERS



CAUTION: PITCH DIMENSIONS 26 & 22.517 ARE INDICATED
WITH RESPECT TO C.L OF SLOT

05	MAIN GRID FLAT-5 FL 2.9x60...1618LG				DN EN0028-7:1.4550	A	2.108	4
04	MAIN GRID FLAT-4 FL 2.9x60...1897LG				DN EN0028-7:1.4550	A	2.442	4
03	MAIN GRID FLAT-3 FL 2.9x60...2063LG				DN EN0028-7:1.4550	A	2.674	4
02	MAIN GRID FLAT-2 FL 2.9x60...2140LG				DN EN0028-7:1.4550	A	2.779	4
01	MAIN GRID FLAT-1 FL 2.9x60...1142LG				DN EN0028-7:1.4550	A	1.358	4
VARIANT NUMBER	DESCRIPTION	STD	DRAWING NUMBER/SIZE	ITEM NO	MATERIAL CODE	UNIT	UNIT WEIGHT	QTY
				VAR NO	MATERIAL SPECN	D1	QUANTITY	05

GENERAL TOLERANCES:	
FOR FABRICATION :	± 1.5
FOR ANGLES :	$\pm 1^\circ$
FOR MACHINING :	IS 2102-m
FOR WELDING :	EN ISO 13920-BF

TOLERANCE IF NOT SPECIFIED SHALL BE AS BELOW (REFER IS 2102-m)					
LINEAR				ANGULAR	
0.5 TO 3	±0.1	400 TO 1000	±0.8	0 TO 10	± 1'
3 TO 6	±0.1	1000 TO 2000	±1.2	10 TO 50	± 30'
6 TO 30	±0.2	2000 TO 4000	±2.0	50 TO 120	± 20"
30 TO 120	±0.3	—	—	120 TO 400	± 10'
120 TO 400	±0.5	—	—	OVER 400	± 5'

[illegible]

CAUTION: The information document is the property of HEAVY ELECTRICALS LTD. It is to be used directly or indirectly for the purpose for which it was issued and in no way detrimental to the interests of the company.

MAIN GRID FLATS

DRAWING NO. : _____

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