

STYLE LIST

[illegible]

1. MACHINE TOLERANCES TO IS 3469 CLOSE GRADE.
2. COMMUTATOR VEE RING FORGING / CASTING TO BE ULTRASONICALLY TESTED TO AA0850118 CATEGORY 2 ON LOCATIONS A,B,C SHOWN.
3. TEST SAMPLE DIA 25 X 600 LONG TO CL.11.2 OF AA 19333 TO BE SUPPLIED FOR TESTING.
4. ITEM 001 TO BE TO AA19333 EXCEPT FOR THE MECH. PROPERTIES WHICH WILL CONFORM TO IS 2004 CLASS-4 TABLE -2 .
5. FOR ALTERNATIVE CLASS-3 STEEL COMM.:-
VEE RING REFER 3439-4200007 (FORGED)
6. PROFILE OF FORGED STL VEE RING SHOWN IN CHAIN DOTTED LINES.
7. MACHINE ALL OVER $\sqrt{6.3}$ MACHINING TOLERANCE ± 0.5 MM.
8. ALTERNATIVELY IT. 001 CAN BE MADE BY CASTING TO TM10583. FOR ROUGH MACHINED CASTING BORE DIA SHOULD BE 180 MM WITH OUT ANY TAPER.
9. QAP FOR FORGING TO BE AS PER QTM/QAP/VENDOR/13-14/002 (LATEST REVISION).
10. QAP FOR CASTING TO BE AS PER QTM/QAP/VENDOR/13-14/001 (LATEST REVISION).
11. ALL THE MACHINED SURFACE SHALL BE PROTECTED WITH TEMPORARY RUST PREVENTIVE (TRP).

A3 SIZE