

DRG. NO. 34394260063

$$178+0.35$$

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22

(156)

REMOVE ALL SHARP EDGES BY DEBURRING

Ø498

$$111.5^{+0.4}_0$$

4.258±0.025

 $4.258 \pm 0.025$ 

3

56

3.155±0.025

1

64.5

2.063±0.025	
1.931±0.025	

6

1. GENERAL TOLERANCE ON DIMENSION IS  $\pm 0.35\text{mm}$  WHERE EVER NOT SPECIFIED.
2. MANUFACTURER TO PROVIDE MARKER'S STAMP WITH INDELIBLE INK FOR IDENTIFICATION MARK AT THE SUITABLE LOCATION.
3. "SECTION THICKNESS TO BE MEASURED AT 6mm FROM THE TOP, 56mm FROM TOP AND 6mm. FROM BOTTOM.
4. i) OXYGEN CONTENT SHALL BE 400ppm.(MAX.)  
ii) AS PER JIS :C280176 SILVER CONTENT SHALL BE WITHIN THE RANGE OF 0.15 TO 0.25.
5. SAMPLING SIZE FOR PROTOTYPE INSPECTION SHALL BE ONE MOTOR SET HOWEVER  
SAMPLING PLAN FOR PROTOTYPE INSPECTION SHALL BE 10% OF ONE MOTOR SET.
6. SAMPLING SIZE FOR ROUTINE INSPECTION SHALL BE 1% OF THE OFFERED LOT.
7. RAW MATERIAL SHALL BE AS PER JIS:C280176. CLAUSE 5. CLASS -2 (CMB-2).
8. TESTING OF CHEMICAL COMPOSITION i.e TO CHECK THE REQUIRED % AGE OF CU & AG AND OXYGEN CONTENT (ONE SAMPLE FROM THE EACH LOT OFFERED) SHALL BE GOT DONE FROM ANY NABL APPROVED LAB. THE COST OF TESTING AND THAT OF MAIL. CONSUMED DURING TESTING SHALL BE BORNE BY THE SUPPLIER.
9. SURFACE OF THE COMMUNICATOR SEGMENTS SHALL BE CLEAN, BRIGHT, SMOOTH, FREE FROM TWISTS AND HARMFUL DEFECTS.
10. THE ACCEPTANCE OF ALL THE CLAUSES OF JIS C 280176 AND DRG. NO.34594260065 AND THE DEVIATIONS IF ANY SHALL BE CLEARLY BROUGHTOUT BY THE TENDERED IN THEIR OFFER
11. FIRM SHALL SUPPLY THE TC OF SOURCES FROM WHOM ELECTROLYTIC CATHODE COPPER HAS BEEN PROCURED AND ALLOYING HAS BEEN DONE.
12. TWISTED AND BENT COMMUNICATOR BARS SHOULD BE CORRECTED BY PLACING THEN ON BASE PLATE AND TAPPING THEM WITH A HAMMER THE GAP BETWEEN THE BAR AND BASE PLATE SHALL BE LESS THAN 0.1MM AFTER THE CORRECTION

ADDITIONAL INFORMATION																	
000 PRE 3 → 28						28 → 000 PRE 1											
000 PRE 3 → 28						28 → 000 PRE 2											
285 NOS						COMMUTATOR SEGMENT									Kg	0.305	
VAR 00	REMARKS	VAR NO.	ITEM NO.	STD.	DRAWING NO.	JIS C 2801-76	MATL. CODE	MATL. SPGN.	UNIT	UNIT WT.	QTY.	ZS	NS				

ADDITIONAL INFORMATION
STATUS OF DRAWING

TYPE OF PRODUCT OR  
NAME OF CUSTOMER/PROJECT

## TRACTION MOTOR

HS-15250 A

SURFACE CLASS NUMBER VALUE TO IS : 3073 67	GRADE NUMBER											
	Rep m											
	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12
SYMBOL												

REV.	DATE	ALTERED	AJHARA <del>Shiv</del>
02	28.10.17	CHECKED	SHISHUPAL <del>com</del>
		APPD.	SHISHUPAL <del>com</del>

REV.	DATE	ALTERED	CHECKED	APPD.
01	11.03.13	<del>Shoji</del>	<del>Shoji</del>	<del>Shoji</del>

DEPT. T.M.E.	GRADE OF UN.TOL. M	SCALE	WEIGHT(K.G.)	REF.TO ASSY.DRG.	ITEM NO.	NO.OF ITEM
CODE		NTS	34394260056		00	

IN NOTE-10 DRG. NO. 34394260063  
WAS 105.8139323A ALT.-10 &  
NOTE-11 MODIFIED.

	IN BOM IT. 001 WT 0.305 KG WAS 0.350 KG
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405				
TITLE			DRAWING NO.	
RAW MATERIAL OF COMMUTATOR BAR (L SHAPE)			34394260063	
SHT. NO.		01	NO. OF SHT.	01
			REV.	
			02	

A3 SIZE