FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

DRG. NO. 0 445 31 64 054

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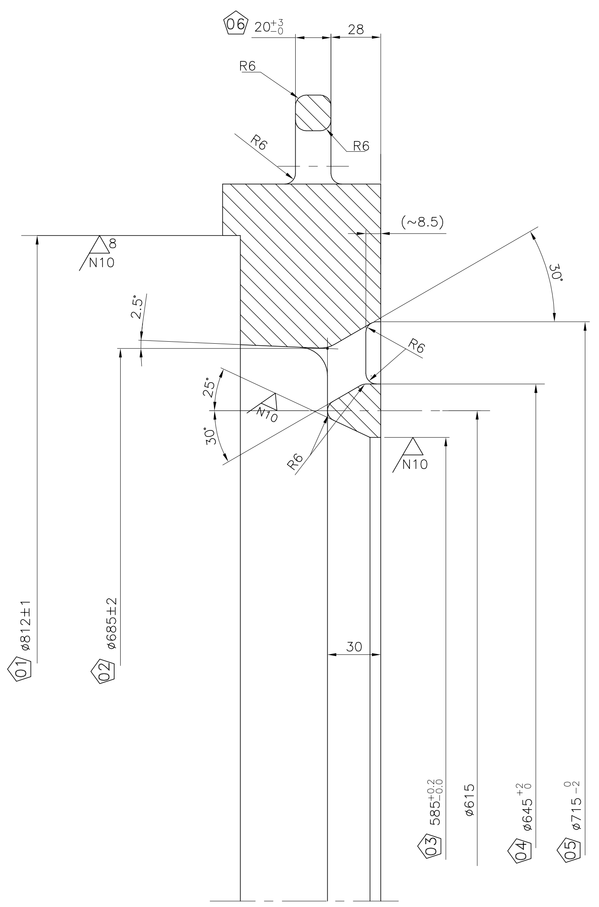
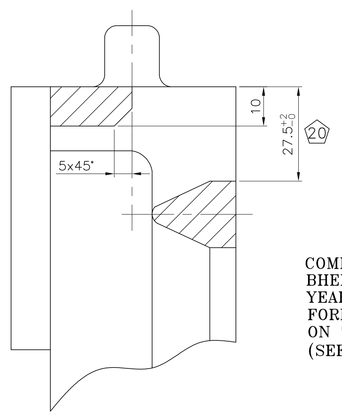
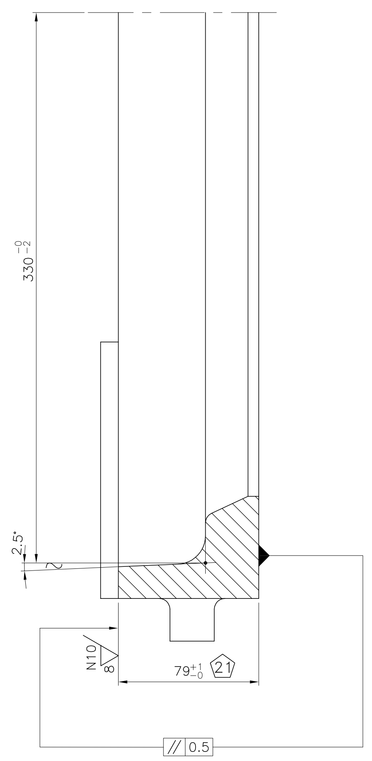
TOOL LIST		
IT.NO.	TOOL NO.	DESCRIPTION
001	1577902	MILLING FIXTURE FOR HOLDING PURPOSE
001	1577837	585 +0.2 PIN GAUGE
001	1577838	SNAP GAUGE, 89mm
001	1577839	SNAP GAUGE, 79mm



SECTION A–A



SECTION B–B



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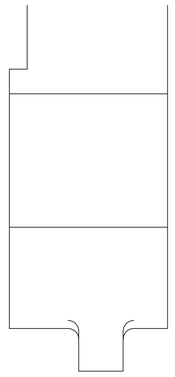
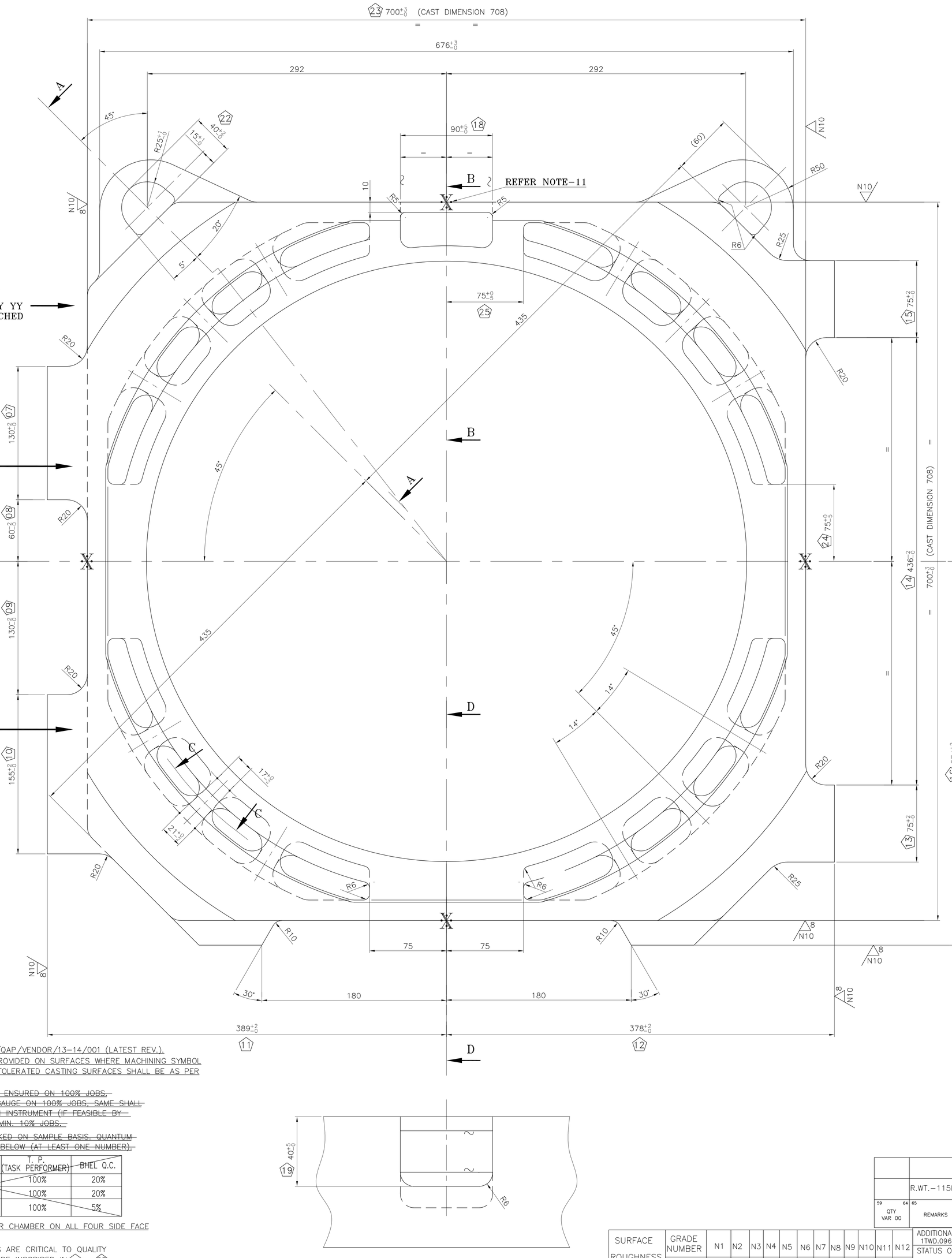
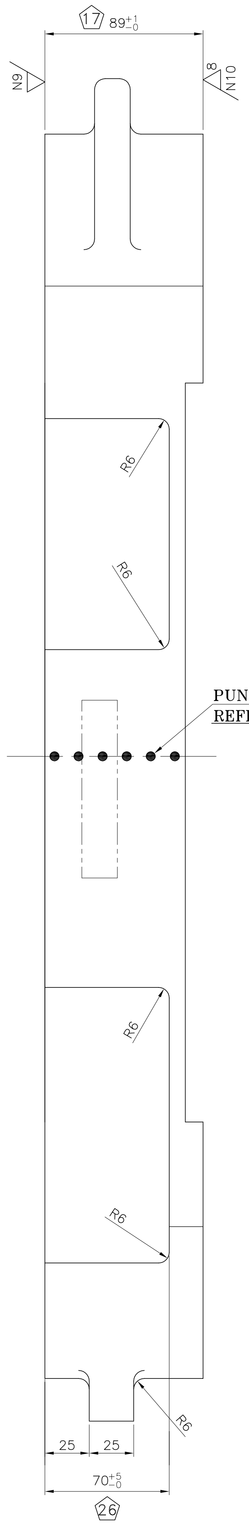


SECTION C–C





NOTES:–

1. CASTING SHALL BE CAREFULLY SCALED & CLEANED.
2. ~~MATERIAL CARBON STEEL CASTING Gr. 230 450 W TO IS–1030'89~~
3. AIR POCKETS AND TERMINAL POCKET AT SECTION–B SHALL BE PROPERLY DRESSED & REQUIRED RADIUS SHALL BE CAREFULLY MAINTAINED.
4. ~~RADIOGRAPHIC– CASTING MADE ACCORDING TO SPECN. NO. TM–11486 (LATEST REV.) SHALL BE SUBJECT TO RADIOGRAPHIC TEST & DIMENSIONAL CHECKS TO BE CARRIED OUT 100%.~~
5. ~~MATERIAL TESTS TO BE CARRIED OUT BY BHEL~~
6. FIRM SHOULD HAVE THEIR OWN FOUNDRY DULY APPROVED BY RDSO AS CLASS–A FOUNDRY FOR CASTING RAW MATERIAL OF SPECIFIED GRADE (CARBON STEEL CASTING TO IS : 1030' 89 GRADE 230–450 W) FOR ITEM STATOR CHAMBER DE & NDE OR THEY HAVE TO SUBMIT ADEQUATE DOCUMENTARY EVIDENCE REGARDING SOURCING OF RAW MATERIAL (CASTING) FROM RDSO APPROVED CLASS–A FOUNDRY ONLY.
7. EMBOSSING & PUNCHING TO BE DONE AT THE SHOWN LOCATION BY CASTING SUPPLIER. SIZE OF EMBOSSING/PUNCHING TO BE 5–20mm. EMBOSSING & PUNCHING SHOULD NOT BE MACHINED/DAMAGED DURING MACHINING AND SHALL BE RETAINED.

CONTD.

8. QAP FOR CASTING TO BE AS PER QTM/QAP/VENDOR/13–14/001 (LATEST REV.).
9. ADDITIONAL MATERIAL SHALL NOT BE PROVIDED ON SURFACES WHERE MACHINING SYMBOL IS NOT INDICATED. TOLERANCES ON UNTOLERATED CASTING SURFACES SHALL BE AS PER IS:4897, CLASS–2.
10. ~~a) CTQ DIMENSIONS TO BE CHECKED & ENSURED ON 100% JOBS. IF CTQ DIMENSION IS CHECKED BY GAUGE ON 100% JOBS, SAME SHALL BE ENSURED BY CHECKING THROUGH INSTRUMENT (IF FEASIBLE BY INSTRUMENT) ON RANDOM BASIS IN MIN. 10% JOBS.~~

~~b) REMAINING DIMENSIONS TO BE CHECKED ON SAMPLE BASIS, QUANTUM OF INSPECTION SHALL BE AS GIVEN BELOW (AT LEAST ONE NUMBER).~~

SL.NO.	CHECKING PARAMETER		T. P. (TASK PERFORMER)	BHEL Q.C.
001	CTQ DIMS.	DIMENSIONAL TOLERANCE	100%	20%
		GEOMETRICAL TOLERANCE	100%	20%
002	REMAINING DIMS.		100%	5%

11. CENTERLINE TO BE PUNCHED ON STATOR CHAMBER ON ALL FOUR SIDE FACE ALONG THE WIDTH.
12. ALL 26 NOS. "⬠" MARKED DIMENSIONS ARE CRITICAL TO QUALITY (CTQ) & SL. NO. OF CTQ DIMENSIONS ARE INSCRIBED IN ⬠ e.g.26.
13. FOR OTHER QUALITY REQUIREMENT WHICH ARE NOT CALLED IN DRAWING SPECIFICATION TM12545 TO BE REFERRED.
14. SURFACE FINISH OF UNMACHINED CASTED SURFACE TO BE AS PER IS:3073.

CONTD.

SURFACE ROUGHNESS VALUE TO IS:3073	GRADE NUMBER	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12
	Ra μ m	0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50
	SYMBOL	▽	▽	▽	▽	▽	▽	▽	▽	▽	▽	~	~

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