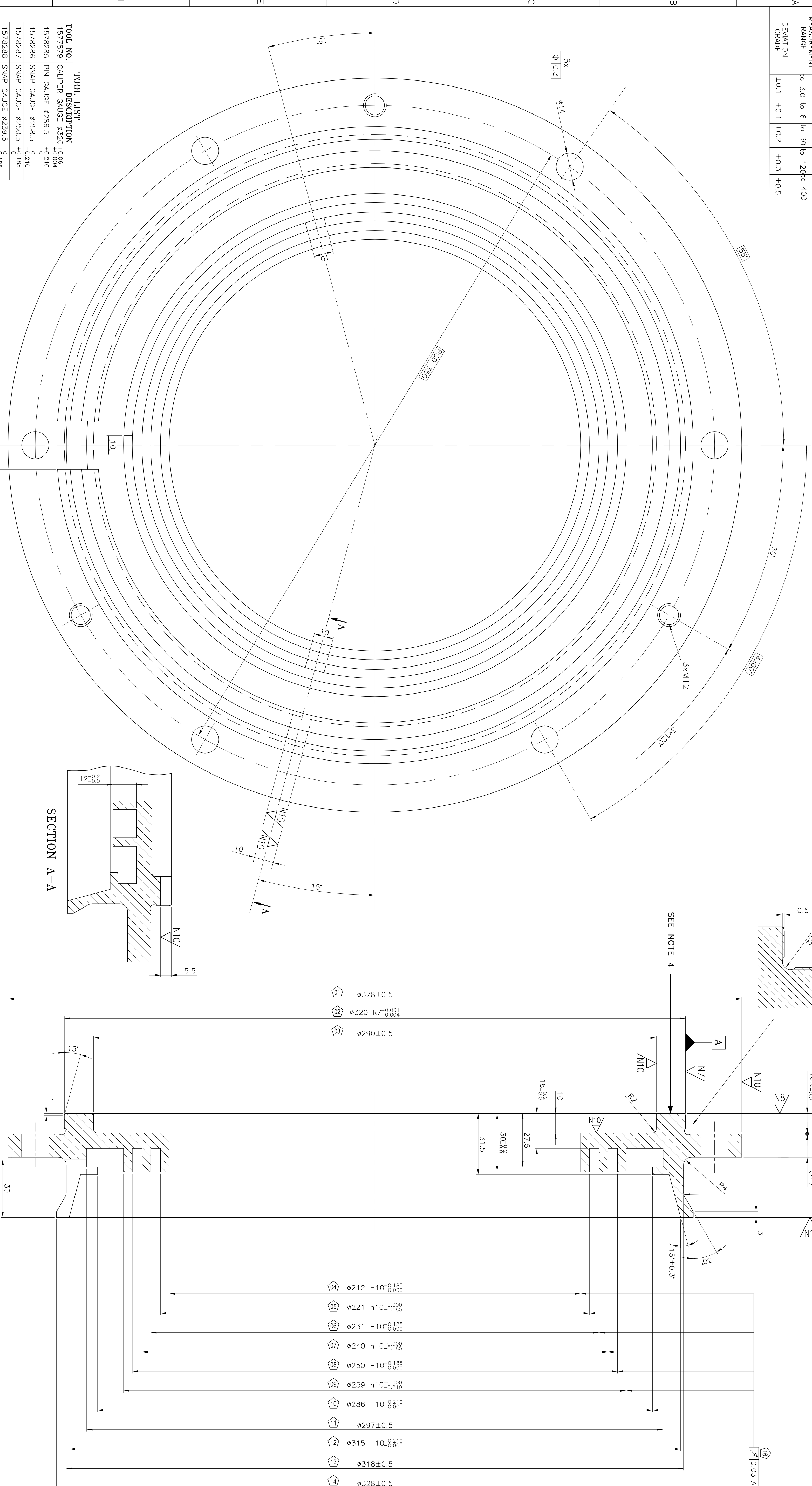


GENERAL TOLERANCE FOR LINEAR AND ANGULAR MEASUREMENTS FOR MACHINING ACCORDING TO ISO 2768				
RATED MEASUREMENT RANGE	> 0.5 to 3.0	> 3 to 6	> 6 to 30	> 30 to 120
DEVIATION GRADE	±0.1	±0.1	±0.2	±0.3

SURFACE ROUGHNESS VALUE TO ISO 3073		GRADE NUMBER	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12
Rz μm		0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50	100
SYMBOL		√	√	√	√	√	√	√	√	√	√	√	√	√



NOTES:-

- REMOVE ALL SHARP EDGES.
- MATERIAL: SPHEROIDAL GRAPHITE CAST IRON (SGG) TO DIN-1693 PART-1, GR-66G/40-GR-400/18 OF IS-1865-1991 (LATEST VERSION) TO SPECN-NO. 4TH-096-068.
- ALL 16 NOS. "O" MARKED DIMENSION ARE CRITICAL TO QUALITY (CTQ) & SL. NO. OF CTQ DIMENSION ARE INSCRIBED IN "O" & 9 "O".
- SUPPLIER'S INITIAL/TRADE MARK, MANUFACTURERS SERIAL NO., BHEL PO NO., BATCH NO. & DATE OF MFG. IN MM-YY FORMAT TO BE ETCHED AT THE SHOWN LOCATION.
- MACHINING ALLOWANCE ON EACH TOOL POINT TO BE 5-7 MM IN CASE CASTING IS SUPPLIED OR 3-5 MM IN CASE ROUGH MACHINED CASTING IS SUPPLIED.
- FOR QUALITY REQUIREMENT OF COMPONENT SPECIFICATION TM12545 TO BE REFERRED.
8. OAP FOR CASTING TO BE AS PER OTM/OAP/VENDOR/13-14/001 (LATEST REV.).
9. DIMENSIONS TO BE CHECKED ON SAMPLE BASIS- QUANTITY- OF INSPECTION SHALL BE AS GIVEN BELOW (AT LEAST ONE NUMBER):-

SL.NO.	CHECKING PARAMETER		BHEL O.C.
001	CTQ DIMS.	DIMENSIONAL TOLERANCE	20%
		GEOMETRICAL TOLERANCE	20%
002	REMAINING DIMS.		5%

REV.	DATE	ALTERED	SD8	REV.	DATE	ALTERED	SD8
13	24.07.19	CHECKED	ABHJIT	11	15.12.18	CHECKED	ABHJIT
12	13.02.19	CHECKED	AS	10	18.10.18	CHECKED	ABHJIT
11	15.12.18	CHECKED	ABHJIT	09	12.05.17	CHECKED	ABHJIT
10	18.10.18	CHECKED	ABHJIT	08	06.02.17	CHECKED	ABHJIT
09	12.05.17	CHECKED	ABHJIT	07	31.01.17	CHECKED	ABHJIT
08	06.02.17	CHECKED	ABHJIT	06	23.09.16	CHECKED	ABHJIT
07	31.01.17	CHECKED	ABHJIT	05	08.07.13	CHECKED	ABHJIT
06	23.09.16	CHECKED	ABHJIT	04	12.12.11	CHECKED	ABHJIT
05	08.07.13	CHECKED	ABHJIT	03	12.05.11	CHECKED	ABHJIT
04	12.12.11	CHECKED	ABHJIT	02	29.3.11	CHECKED	ABHJIT
03	12.05.11	CHECKED	ABHJIT	01	10.01.11	CHECKED	ABHJIT
02	29.3.11	CHECKED	ABHJIT	00	10.01.11	CHECKED	ABHJIT
01	10.01.11	CHECKED	ABHJIT	00	10.01.11	CHECKED	ABHJIT

RAW WEIGHT		OUTER BEARING CAP (DE) MACHD.		DRAWING NO.		MATERIAL		UNIT WEIGHT		ITEM NO.	
59	64 65	74 78 79 82	27 29	58	59 60	77 79	31 34	45	56 58	65 72	
07Y						IF TNO.	A 57	C	INTN	WLT	
VAR 00						32 33 46	MATL. SPECN.	54 C	68	QTY.	
ZONE											
ADDITIONAL INFORMATION											
1TMD.096.006. (ALT.4)											
STATUS OF DRAWING											
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT											
TRACTION MOTOR											
6FRA 6068											
SDB <i>6068</i>		NAME		SIGN		DATE		NO. OF		VAR.	
ASBUILT <i>6068</i>		DRA. S.O.B/MOAT		-sd-		03.09.10					
ASBUILT <i>6068</i>		CHD. D.K.		-sd-		03.09.10					
ASBUILT <i>6068</i>		APPLD. A.S.		-sd-		03.09.10					
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