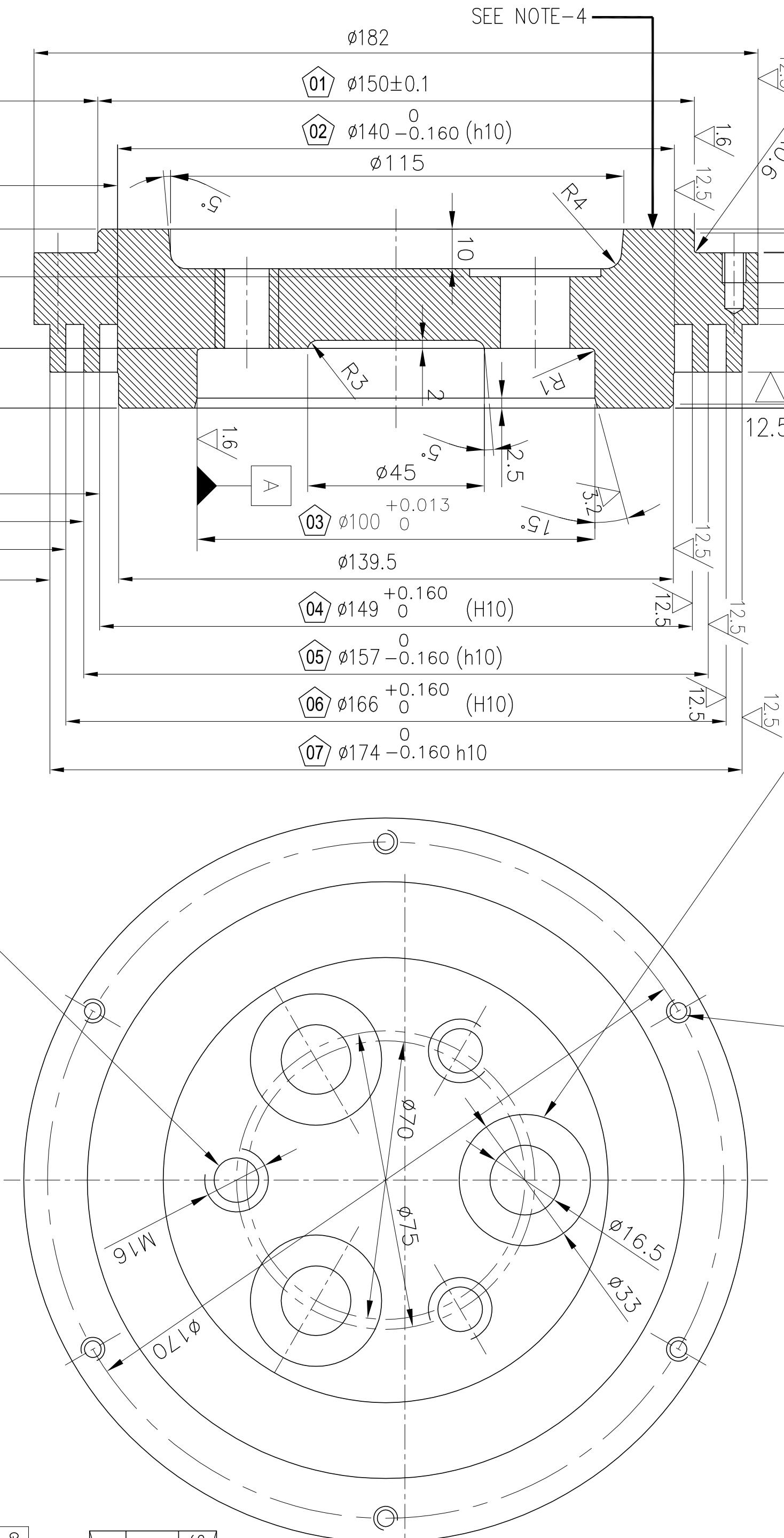


DRG. NO. 2 445 44 64 051

EQUALLY DISTRIBUTED 3 COUNTER
BORED HOLES

6 EQUALLY DISTRIBUTED M6 TAPPED HOLES

3 EQUALLY DISTRIBUTED M16 TAPPED HOLE



NOTES :-

1. REMOVE ALL SHARP EDGES.
2. MATERIAL: ~~SPHEROIDAL GRAPHITE CAST IRON (SGCI) TO~~
~~DN-1693 PART 1 GR.66G/40 OR GR 400/18 OF IS:1865-1991~~
~~(LATEST VERSION).~~
3. ALL 11 NOS. "◊" MARKED DIMENSION ARE CRITICAL TO QUALITY (CTQ) & S.L. NO. OF CTQ DIMENSION ARE INSCRIBED IN ◊ e.g. ◊
4. 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.
5. 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.
6. FOR QUALITY REQUIREMENT OF COMPONENT SPECIFICATION TM12545 TO BE REFERRED.
7. QAP FOR CASTING TO BE AS PER QTM/QAP/VENDOR/13-14/001 (LATEST REV.).
8. DIMENSIONS TO BE CHECKED ON SAMPLE BASIS. QUANTITY OF INSPECTION SHALL BE AS GIVEN BELOW (AT LEAST ONE NUMBER)

9. ALL MACHINED/ R.MACHINED SURFACES TO BE PROTECTED WITH TRP.

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

GENERAL TOLERANCE FOR LINEAR AND ANGULAR MEASUREMENTS FOR MACHINING ACCORDING TO ISO-2768					
RATED MEASUREMENT RANGE	> 0,5	> 3	> 6	> 30	>120
	to 3,0	to 6	to 30	to 120	to 400
DEVIATION GRADE	±0,1	±0,1	±0,2	±0,3	±0,5

[illegible]

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT					6FRA 6068				
भारत भारती  BHARAT HEAVY ELECTRICALS LTD. BHOPAL					DRN.	ASWINI	—sd—	03/09/10	NO. OF VAR.
					CHD.	D.K.	—sd—	03/09/10	
					APPD.	A.S.	—sd—	03/09/10	

TOOL LIST	
IT.NO.	DESCRIPTION
1605006	SNAP GAUGE $\phi 173.5 \pm 0.160$
1605007	PIN GAUGE $\phi 149.5 \pm 0.160$ (H10)
1605008	SNAP GAUGE $\phi 156.5 \pm 0.160$ (h10)
1605009	PIN GAUGE $\phi 166.5 \pm 0.160$ (H10)
1577971	PIN GAUGE $\phi 100 \pm 0.013$
1605003	SNAP GAUGE $\phi 139.5 \pm 0.160$ (H10)
1577975	SNAP GAUGE $\phi 150 \pm 0.1$
1577976	DRILL JIG FOR ALL HOLES
1577977	SPOT FACE CUTTER FOR $\phi 33$
1605010	GROOVE GAUGE 5x12.2

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
	SYMBOL	V			V			V			V		
	~												

REF. DRG. NO.										SIGN. & DATE				INVENTORY NO.					
E																			
 10																			
REV.	DATE	ALT.	SDB	REV.	DATE	ALTERED	SDB	REV.	DATE	ALTERED	SDB	REV.	DATE	ALTERED	SDB	REV.	DATE		
13	24.07.19	CHK. ABHJIT	ABHJIT	09	06.10.16	CHECKED AS	ABHJIT	10	06.12.17	CHECKED	ABHJIT	11	18.10.18	CHK. ABHJIT	ABHJIT	59	64		
ZONE				ZONE				ZONE				ZONE				59 QTY. VAR 00			
DIMS. 174, 166, 157, 149, 140 & 21 WERE 173.5, 166.5, 156.5, 149.5, 139.5 & 21.2 (CLW LETTER REF. CLW/TM/18059/ PART-1/1 DATED 12/07/19). NOTE 8 DELETED & NOTE 9 ADDED.				TOOL NOS. 1577975 & 1577977 DELETED.				DIMS. 21.2+0.2, 9+0.2 & 15+0.2 WERE 21.2, 9 & 15. NOTES-7 & 8 ADDED.				NOTE-2 DELETED. NOTE-8 MODIFIED.							
(TCM-349)				(TCM-349)				(TCM-349)				(TCM-349)				(TCM-349)			
REV.	DATE	ALT.	SDB	REV.	DATE	ALTERED	SDB	REV.	DATE	ALTERED	SDB	REV.	DATE	ALTERED	SDB	REV.	DATE		
12	15.12.18	CHK. ABHJIT	ABHJIT	08	18.12.14	CHECKED	ABHJIT	07	10.10.13	CHECKED	ABHJIT	06	08.07.13	CHECKED	ABHJIT	01	13.01.11		
ZONE				ZONE				ZONE				ZONE				ZONE			
IN TITLE BLOCK R/WT & FINISH WT. WERE 13.23 & 4.84KG.				6 HOLES MB ON 170PCD WAS M16.				POSITION OF DIMENSION 10 CORRECTED. ((-1)				CRITICAL TO QUALITY DIMENSIONS ARE "O" MARKED & NUMBERED. NOTE-3, 4, 5 & 6 ADDED.				DISTRIBUTION OF PRINTS TME-1, TXM-3, TNX-1			
F																			
REV.	DATE	ALTERED	SDB	REV.	DATE	ALTERED	SDB	REV.	DATE	ALTERED	SDB	REV.	DATE	ALTERED	SDB	REV.	DATE		
05	13.03.13	CHECKED	ABHJIT	04	22.11.12	CHECKED	ABHJIT	03	13.12.11	CHECKED	ABHJIT	02	06.05.11	CHECKED	ABHJIT	01	13.01.11		
ZONE				ZONE				ZONE				ZONE				ZONE			
IN TOOL LIST PIN GAUGE 100+0.013 WAS 100+0.035				DIM. Ø100+0.035 CHANGED TO Ø100+0.013 AS PER REQUIREMENT OF RDSO MODIFICATION SHEET NO. RDSO/2012/ELRS/MS/0415 DATED 03.10.12. DRG. DIGITIZED & UPLOADED.				RAW WT. 13.230 KG. & FINISH WT. 4.84 KG. WERE NOT ON.				TOOL LIST WAS NOT ON. TM-11491 WAS ON 4TMS.096.068.				DRG. UPDATE & DIGITIZED.			
(TCM-341)				(TCM-341)				(TCM-341)				(TCM-341)				(TCM-341)			
1																			
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