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FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

REV.	DATE	ALTERED	SDB	REV.	DATE	ALTERED	SDB	ADDITIONAL INFORMATION
05	27.08.16	CHED	AS	09	24.07.19	CHECKED	ABHIJIT	4TWD.096.029
		APPD	AS			APPROVED	ABHIJIT	
ZONE	TOOL LIST ADDED.			ZONE	DIMS. $\phi 285.5, \phi 259.5, \phi 249.5, \phi 240.5, \phi 230.5, \phi 221.5, \phi 211.5$ & 18.5 WERE $\phi 285, \phi 260, \phi 249, \phi 241, \phi 230, \phi 222, \phi 211$ & 18.3 . (CLW LETTER REF. CLW/TM/18059/ PART-I/1 DATED 12/07/19). NOTE 7 DELETED & NOTE 8 ADDED.			STATUS OF DRAWING
	(TCM-348)							DISTRIBUTION TME-1, TXM-4 OF PRINTS TNX-1

REV.	DATE	ALTERED	SDB
06	07.09.16	CHED	AS
		APPD	AS
ZONE	IN TOOL LIST, TOOL NO. 1605040 DELETED AND 1577916 ADDED. (TCM-348)		
REV.	DATE	ALTERED	SDB
07	18.10.18	CHED	ABHIJIT
		APPD	ABHIJIT
ZONE	NOTE-2 DELETED. NOTE-7 ADDED.		

TOOL LIST	
TOOL NO.	DESCRIPTION
1577916	DRILL JIG FOR 2 HOLES
1605041	CALIPER GAUGE $\phi 211_{-0.185}^0$
1605042	CALIPER GAUGE $\phi 230_{-0.185}^0$
1605043	CALIPER GAUGE $\phi 249_{-0.185}^0$
1605044	CALIPER GAUGE $\phi 285_{-0.210}^0$
1605045	PIN GAUGE $\phi 222^{+0.185}_0$
1605046	PIN GAUGE $\phi 241^{+0.185}_0$
1605047	PIN GAUGE $\phi 260^{+0.210}_0$

NOTES:-

- REMOVE ALL SHARP EDGES.
- MATERIAL: SPHEROIDAL GRAPHITE CAST IRON (SGCI) TO DIN-1693 PART-1 GR.GGG/40 OR GR-400/18 OF IS:1865-1991 (LATEST VERSION).
- ALL 13 NOS. "◇" MARKED DIMENSION ARE CRITICAL TO QUALITY (CTQ) & SL. NO. OF CTQ DIMENSION ARE INSCRIBED IN ◇ e.g. (13).
- 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.
- DIMENSIONS TO BE CHECKED ON SAMPLE BASIS QUANTUM OF INSPECTION SHALL BE AS GIVEN BELOW (AT LEAST ONE NUMBER).

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

REV.	DATE	ALTERED	SDB
08	15.12.18	CHED	ABHIJIT
		APPD	ABHIJIT
ZONE	IN TITLE BLOCK R/WT & FINISH WT. WERE 29.57 & 7.95KG.		

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

RAW WEIGHT 20.3 KG.		001	OUTER LABYRINTH DE	TM11491		KG	9.0
59	64	65	75	25	27	29	58
VAR00	REMARKS		ITEM NO.	DESCRIPTION		STD	34
							45
							55
							56
							58
							65
							68
							71
28 → CARD TYPE-3			28 → CARD TYPE-1			28 → CARD TYPE-2	



BHARAT HEAVY ELECTRICALS LTD.
BHOPAL

	NAME	SIGN	DATE	NO. OF VAR.
DRN.	BHAGAT	-sd-	03.09.10	
CHD.	D.K.	-sd-	03.09.10	
APPD.	A.S.	-sd-	03.09.10	

DEPT.	TME	UNTOL. DIMS. GR.	SCALE	WEIGHT (K.G.)	REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEM
CODE	405		N.T.S.	9.0	0 445 10 64 051		001
TITLE					DRAWING NO.	REV.	
OUTER LABYRINTH (DE)					4 445 43 64 051	09	
(CNC MACHINED)					SHT. NO.	NO. OF SHT.	
6FRA 6068					01	01	

SIZE A4