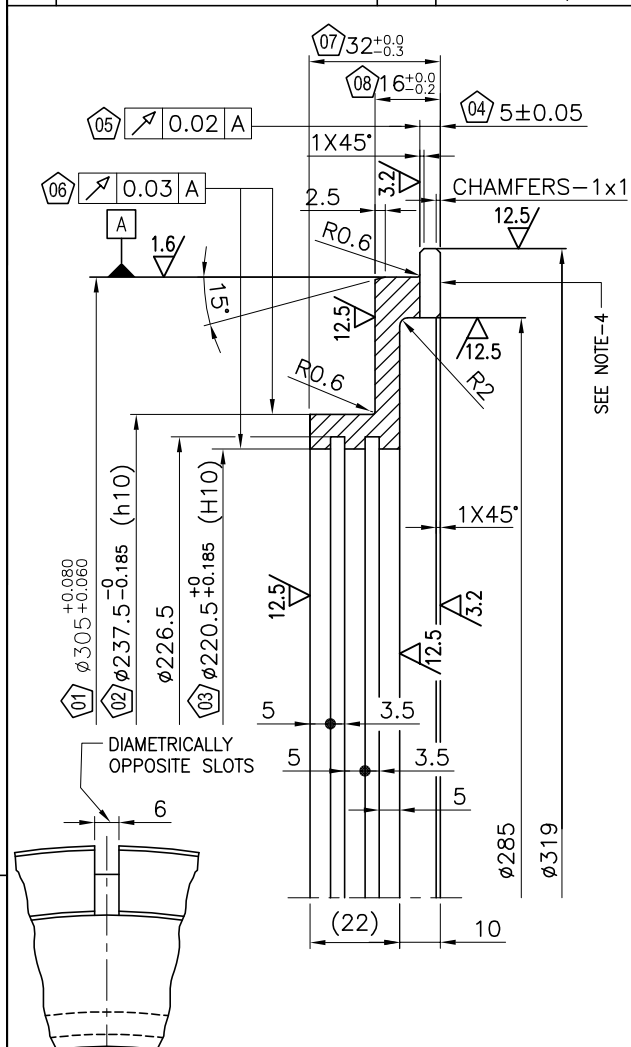


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FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

REV.	DATE	ALTERED	REV.	DATE	ALTERED	ADDITIONAL INFORMATION
05	06.07.13	CHECKED APPROVED	15	24.7.19	SDB CHECKED ABHIJIT APPROVED ABHIJIT	4TWD.096.028
ZONE	CRITICAL TO QUALITY DIMENSIONS ARE 'C' MARKED & NUMBERED. NOTE-4,5 & 6 ADDED.		ZONE	DIMS. Ø237.5 & Ø220.5 WERE Ø237 & Ø221. (CLW LETTER REF. CLW/TM/18059/ PART-I/1 DATED 12/07/19). NOTE 7 DELETED & NOTE 8 ADDED.		STATUS OF DRAWING
REV.	DATE	ALTERED	REV.	DATE	ALT.	DISTRIBUTION
06	06.10.16	CHECKED APPROVED	07	01.07.17	CHK. APPD.	TME-1, TXM-4
ZONE	TOOL NOS. 1577946 TO 1577948 & 1577950 DELETED AND 1605057 TO 1605059 ADDED. (TCM-349)		ZONE	TOOL NO. 1605069 ADDED (TCM-350).		OF PRINTS
REV.	DATE	ALT.	REV.	DATE	ALT.	TXN-1
08	01.12.17	CHK. APPD.	09	09.01.18	CHK. APPD.	
ZONE	TOL. ON DIMN. 32 & 16 ADDED.		ZONE	TOOL NOS. 1605076 & 1605077 ADDED. TOOL NO. 1577954 DELETED. (TCM-352)		



REV.	DATE	ALT.	A.J.	TOOL LIST
10	16.05.18	CHK. APPD.	AS	IT.NO. TOOL NO. DESCRIPTION
ZONE	TOOL NO.1577953 DELETED. (TCM-352)			001 1577949 GROOVE GAUGE
REV.	DATE	ALT.	VK	001 1577951 STEP GAUGE FOR 11MM
11	13.08.18	CHK. APPD.	AS	001 1577953 SNAP GAUGE FOR 32MM
ZONE	TOOL NO.1577949 DELETED. (TCM-352)			001 1577954 SNAP GAUGE FOR 22MM
REV.	DATE	ALT.	SDB	001 1577955 MILLING FIXTURE
12	18.10.18	CHK. APPD.	ABHIJIT	001 1605069 HOLDING SPIGOT FOR TURNING AND GRINDING
ZONE	NOTE-2 DELETED. NOTE-7 MODIFIED.			001 1605076 SNAP GAUGE 32-0.3/0
REV.	DATE	ALT.	SDB	GAUGE LIST
13	15.12.18	CHK. APPD.	ABHIJIT	LIMIT NOM. SIZE TOOL NO. IT.NO. SYM.
ZONE	IN TITLE BLOCK R/WT & FINISH WT. WERE 17.87 & 2.90KG.			303.50/303.55 1577946 001 CAL.
REV.	DATE	ALT.	SDB	237.5+0.185/-0 1577947 001 SNAP
14	12.02.19	CHK. APPD.	AS	221+0.185/-0 1577948 001 PIN
ZONE	IN TOOL LIST, TOOL NO. 1577949 ADDED. (TCM-353)			305+0.080/-0.080 1577950 001 CAL.
				5+0.05 1577952 001 SNAP
				237-0.185 1605057 001 SNAP
				221+0.185/-0 1605058 001 PIN
				305+0.080/-0.080 1605059 001 CAL.

NOTES:-

- REMOVE ALL SHARP EDGES.
- MATERIAL: SPHEROIDAL GRAPHITE CAST IRON (SGCI) TO DIN 1693 PART-1 GR.000/40 OR GR-400/18 OF IS:1865-1991 (LATEST VERSION).
- ALL 8 NOS. 'C' MARKED DIMENSION ARE CRITICAL TO QUALITY (CTQ) & SL. NO. OF CTQ DIMENSION ARE INSCRIBED IN 'C' e.g. 001.
- 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.	DIMENSIONAL TOLERANCE 20%
		GEOMETRICAL TOLERANCE 20%
002	REMAINING DIMS.	5%

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

RAW WEIGHT 11.0 KG.	001	INNER LABYRINTH DE	TM11491	KG	3.30
59 64 65	75 25 27 29	58 59 34	45 55 56	58	65
VAR00	REMARKS	ITEM NO.	DESCRIPTION	STD	MATL. CODE
				46	MATL. SPCN.
					UNIT WT.
					QTY.

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.)
CODE	405			N.T.S.	3.30
TITLE		INNER LABYRINTH (DE) (CNC MACHINED) 6FRA 6068			REF. TO ASSY. DRG.
					ITEM NO.
					NO. OF ITEM
					REV.
					15
					SHT. NO.
					01
					NO. OF SHT.
					01

SIZE A4