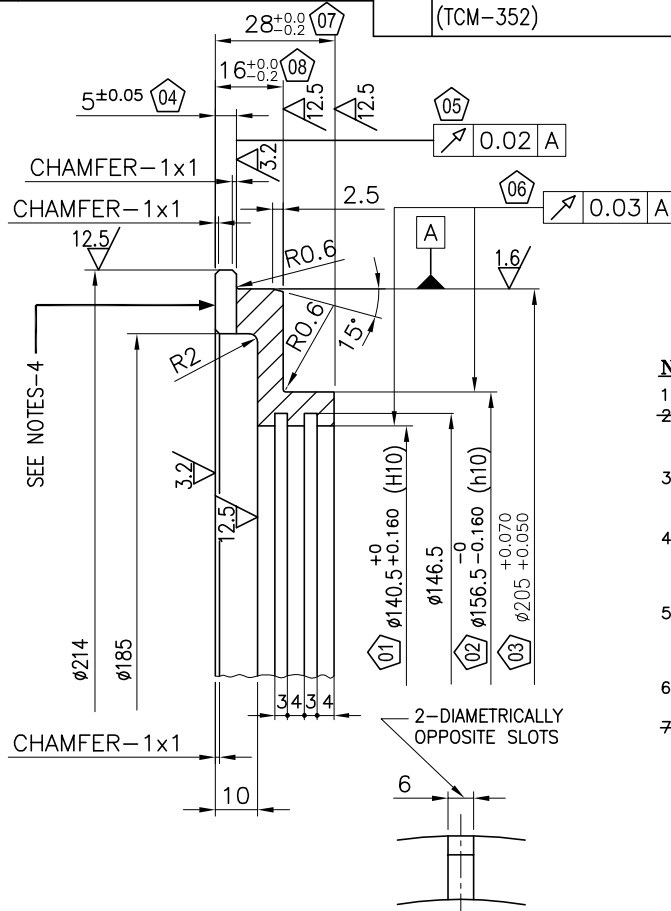


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WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

REV.	DATE	ALTERED	SDB	REV.	DATE	ALT.	SDB	ADDITIONAL INFORMATION
05	08.07.13	CHECKED	ABHIJIT	11	24.07.19	CHK.	ABHIJIT	4TWD.096.031
		APPROVED	ABHIJIT			APPD.	ABHIJIT	
ZONE	CRITICAL TO QUALITY DIMENSIONS ARE "CTQ" MARKED & NUMBERED. NOTE-3, 4, 5 & 6 ADDED.			ZONE	DIMS. $\phi 140.5$ & $\phi 156.5$ WERE $\phi 141$ & $\phi 156$. (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	SDB	REV.	DATE	ALTERED	SDB	DISTRIBUTION OF PRINTS
06	22.08.17	CHECKED	AS	07	01.12.17	CHECKED	AS	TME-1, TXM-4
		APPROVED	AS			APPROVED	AS	TNX-1
ZONE	IN TOOL LIST, TOOL NO. 1605070 ADDED. (TCM-350)			ZONE	TOL. IN DIMN. 16 & 28 ADDED. NOTE 7 ADDED.			
REV.	DATE	ALT.	SDB	REV.	DATE	ALT.	SDB	
09	18.10.18	CHK.	ABHIJIT	08	09.01.18	CHK.	AS	
		APPD.	ABHIJIT			APPD.	AS	
ZONE	NOTE-2 DELETED. NOTE-7 MODIFIED.			ZONE	TOOL NOS. 1605080 & 1605081 ADDED. (TCM-352)			



NOTES:-

1. REMOVE ALL SHARP EDGES.
2. MATERIAL: SPHEROIDAL GRAPHITE CAST IRON (SGGI) TO DIN 1693 PART 1 GR.GGG/40 OR GR 400/18 OF IS:1865-1991 (LATEST VERSION).
3. ALL 8 NOS. "CTQ" MARKED DIMENSION ARE CRITICAL TO QUALITY (CTQ) & SL. NO. OF CTQ DIMENSION ARE INSCRIBED IN (e.g. 08).
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. 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 6.0 KG.		001	INNER LABYRINTH NDE						KG	2.0			
							TM11491							
59	64	65	75	25	27	29	58	59	34	45	55	56	58	65
VAR00		REMARKS		ITEM NO.		DESCRIPTION		STD	MATL. CODE		A	UNIT	UNIT WT.	
									46	MATL. SPCN.			68	71
													QTY.	



BHARAT HEAVY ELECTRICALS LTD.
BHOPAL

DEPT.	TME	UNTOL. DIMS. GR.	SCALE	WEIGHT (K.G.)	REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEM
CODE	405		N.T.S.	2.0	0 445 10 64 051		001
TITLE					DRAWING NO.	REV.	
INNER LABYRINTH (NDE) (CNC MACHINED) 6FRA 6068					4 445 44 64 052	11	
					SHT. NO.	NO. OF SHT.	
					01	01	

SIZE A4