



ITEM NO.	TOOL NO.	DESCRIPTION
001	1579020	DOVE/TAIL TOOL LH & RH
001	1579120	DOVE/TAIL TOOL
001	1579118	PN GAUGE 141.08 +0.025/0
001	1579119	SNAP GAUGE 20
001	1579120	STEP GAUGE (78-1)-20
001	1579121	DRILL JIG FOR ALL HOLES
001	1579030	PN GAUGE (S/F) 140.68/140.60
001	1579036	STATIC BALANCING MANDEL
001	1579175	DYNAMIC BALANCING MANDEL

PARAMETERS	REQUIREMENTS
INTERNAL DEFECTS	ASTM E155 CLASS 1 OR BETTER
SURFACE DEFECTS	FREE FROM DEFECTS AND LINE FORMED MARKS
INSPECTION METHOD	V-RAY INSPECTION!

[illegible]

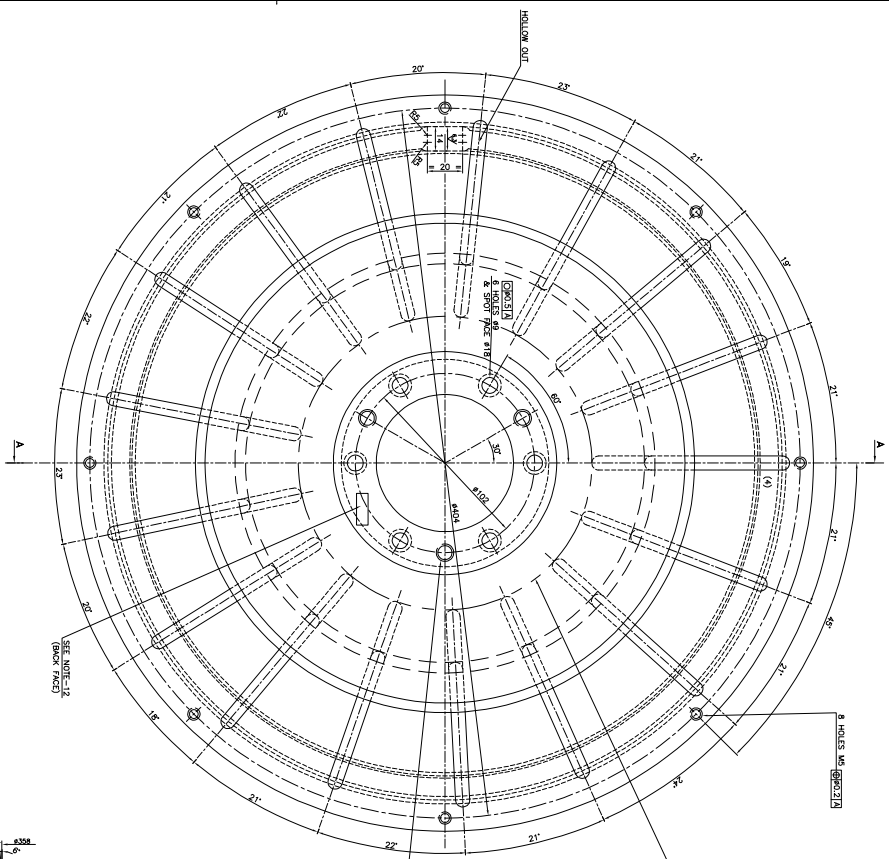
ADDITIONAL INFORMATION		TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT	
STATUS OF DRAWING		IM3601AZ	
DISTRIBUTION OF PRINTS TNE-1 TXX-3 TXX-1		BHAHAT HEAVY ELECTRICALS LTD BHOPAL	
			
NAME	SRN	DATE	NO.
DRN A.J.HARA	287	17.08.11	VAR
CRD D.K.	1808	18.08.11	
ST	1	10.08.11	

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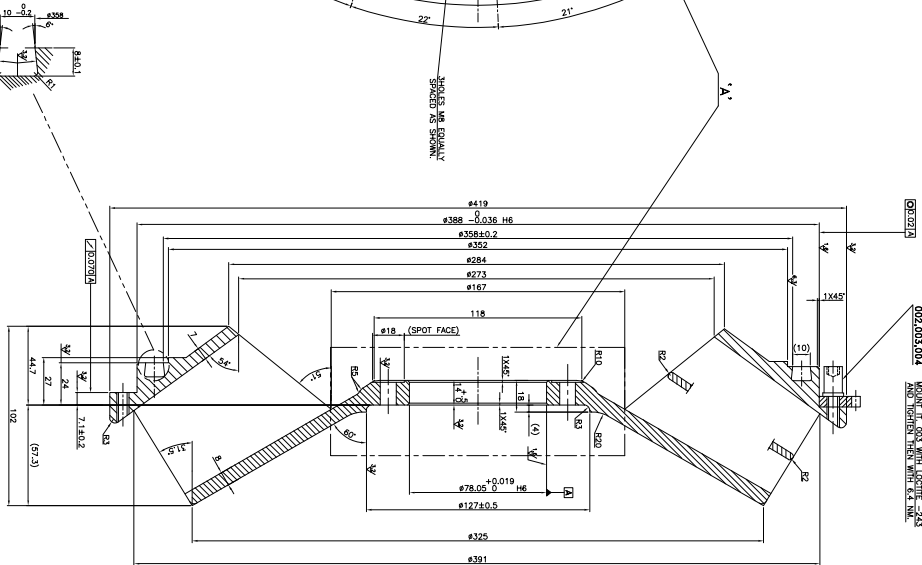
20020205471 W. 300

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN MM)



SECTION-AA



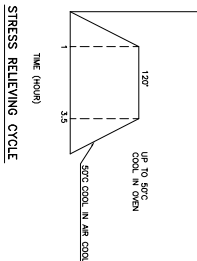
TOOL LIST		
IT. NO.	TOOL NO.	DESCRIPTION
001	1579019	DOVETAIL TOOL LH & RH
001	1579020	DOVETAIL - CHECKING GAUGE
001	1579126	STEP GAUGE 27- (71+/-0.2)
001	1579127	STEP GAUGE 27- 14-13
001	1579128	CALLIPER GAUGE 352
001	1579130	OFF-SET PIN GAUGE 127+0.5
001	1579131	SNIP GAUGE 14MM
001	1579132	DRILL JIG FOR ALL HOLES
001	1579067	STATIC BALANCING MANDREL
001	1579018	CALIPER GAUGE 388.3mm
001	1579174	DYNAMIC BALANCING MANDREL

NOTES:-

1. NON STATED RADI R=3.
2. THE VENTILATOR IS TO BE MANUFACTURED AS PER R090.
3. THE VENTILATOR IS TO BE MANUFACTURED AS PER R090.
4. MATERIAL TESTING AND SPECIFICATION: S-2000C.
5. VENTILATOR TO BE STRESS RELIEVED.
6. PAINTING: A6000000-10012798.
7. VENTILATOR TO BE GIVEN AN ACCURATE DYNAMIC BALANCE AS PER DRG.
8. CASTING TOLERANCES IS 487 CLASS-1.
9. MACHINING TOLERANCES TO BE MAINTAINED ±0.1.
10. AS PER THE FOLLOWING TABLE:

PARAMETERS		REQUIREMENTS
INTERNAL DEFECTS	AS PER CLASS 1 OR BETTER	
SURFACE DEFECTS	FREE FROM DEFECTS AND LINE FORMED MARKS	
INSPECTION METHOD	X-RAY INSPECTION	

11. GP TESTING TO BE DONE ON COMPLETE AREA OF EACH VENTILATOR (INCLUDING JOINING AREA OF BLADES WITH BODY) AS PER SPEC. A0050132.
12. SUPPLIER'S IDENTIFICATION MARKING TO BE EMBOSSED AS PER M12546 AT THE LOCATION SHOWN (B/W THE HOLES).



STRESS RELIEVING CYCLE

AS REQ.		005	BALANCE WEIGHT	34450203005	00
008		004	WASHER M/CD		A07161001020
008		003	SOCKET HD SCREW		A07161001
001		002	TOOTH RING		A07232125
001		001	VENTILATOR		34450103001
001		001	VENTILATOR		34450103001

ADDITIONAL INFORMATION

STATUS OF DRAWING
TYPE OF PRODUCT OR
NAME OF CUSTOMER/PROJECT

IM3601A2

DISTRIBUTION OF PRINTS
TXM-1 TXM-3

BY BHARAT HEAVY ELECTRICALS LTD.
BHEL

DATE 02.08.11
NO. OF SETS 00

REV. DATE

REV. DATE

REV. DATE

REV. DATE

REV. DATE

REV. DATE

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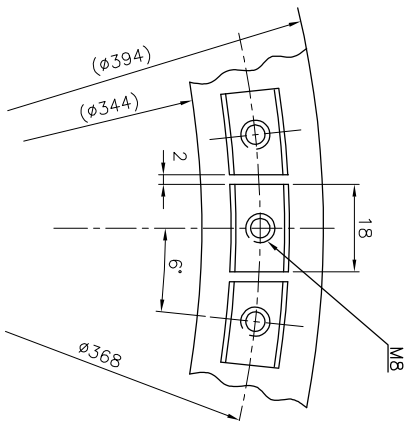
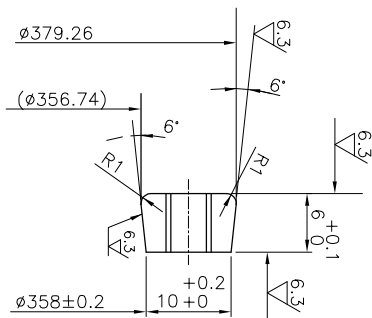
REV. DATE


REV. DATE

REV. DATE

INVENTORY NO.	SIGN. & DATE	REF. DRG. NO.	WFO
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M10012209

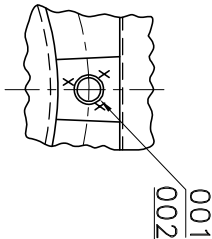
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ADDITIONAL INFORMATION		TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT	
STATUS OF DRAWING		IM3601AZ	
DISTRIBUTION OF PRINTS			
TIME-1 TMM-1 TMM-3			
REV.	DATE	ALTERED	CHECKED
01	16.01.14	APPROVED	
IN BOM IT. 002 SOC. GRUB SCREW M8 WAS M6.			
BALANCE WEIGHT FOR VENTILATOR DE&NDE			
TITLE		CODE 405	
DEPT TIME		GRADE OF UNIT. DIM	
			
SCALE		NTS	
WEIGHT (K.G.)			
REF. TO ASSY. DRG.		NO. OF	
2 445 02 03 001		002	
1 445 02 03 002		002	
DRAWING NO.		REV	
34450203005		01	
SHT. No. 01		NO. OF SHT. 01	

RAILWAY BOARD CONTRACT NO. 2010/ELECT.(DEV.)/181/8 DATED:23-11-2010

A3

DRG. NO. 34450203004



BALANCE WITH A HALF KEY

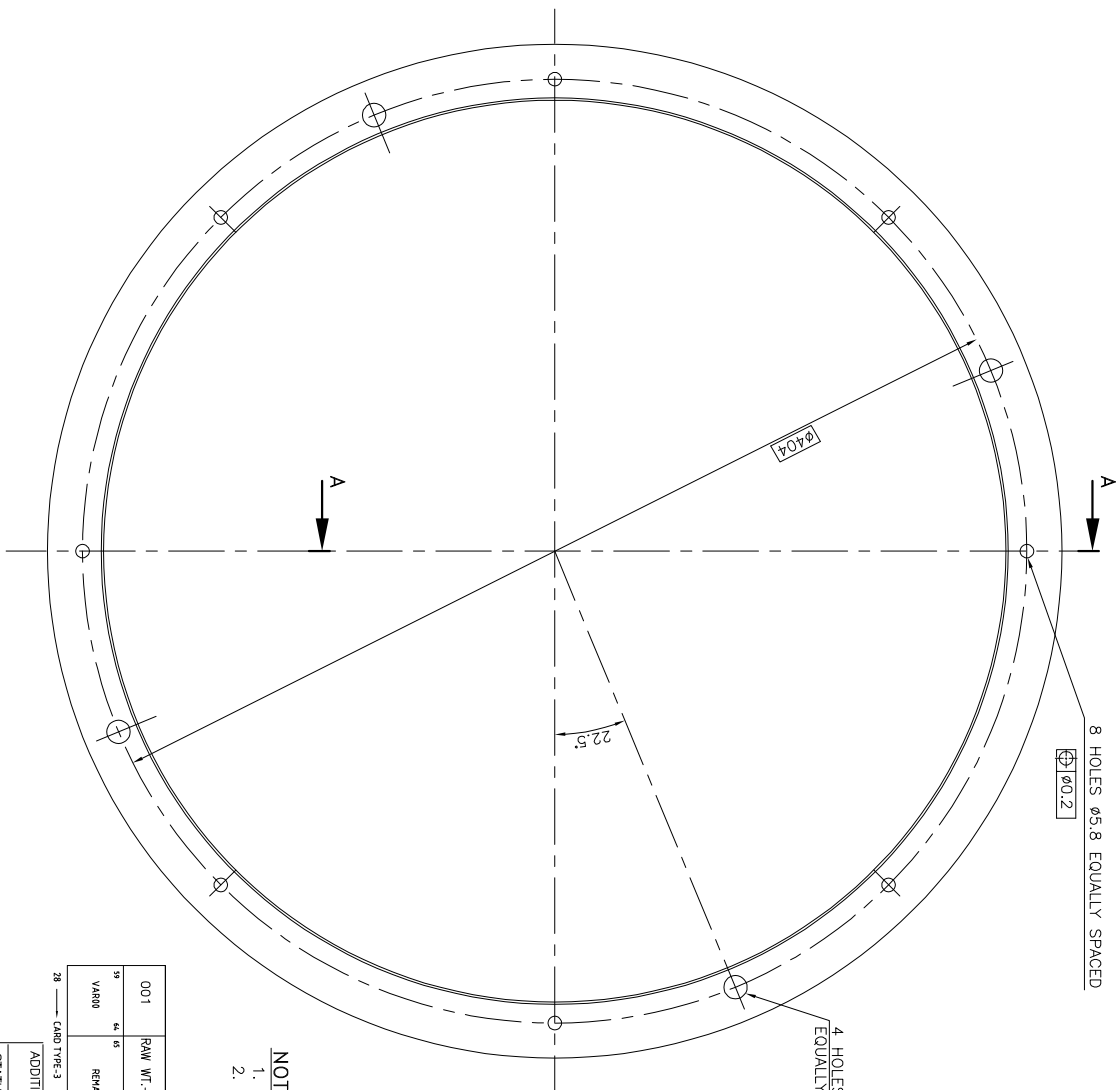
- NOTES:—
1. MOUNT VENTILATOR ON BALANCE SHAFT.
 2. CORRECTION OF THE UNBALANCE HAS TO BE DONE BY FITTING BALANCE SEGMENTS (SEE DRG. 34450203005)
LOCK GRUB SCREW WITH LOCITE 243 & CENTRE PUNCH
LOCK BALANCE SEGMENTS BY MEANS OF A CENTRE PUNCH.
 3. MAX. PERMISSIBLE RESIDUAL UNBALANCE 0.36 GRAM.

[illegible][illegible]

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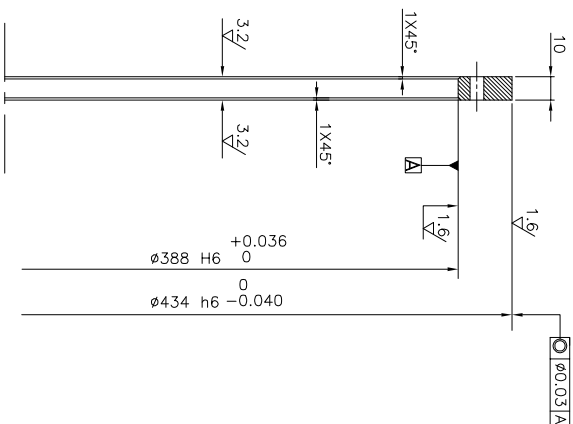
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2003010547 ON GRD



8 HOLES $\phi 5.8$ EQUALLY SPACED

4 HOLES $\phi 10$ H8
EQUALLY SPACED AS SHOWN



SECTION-AA

TOOL LIST	
IT. NO.	TOOL NO.
1579060	CALLER GAUGE 434-0.04/0
1579061	PIN GAUGE 388+0.036/0
1579062	DRILL JIG
1579063	TURNING FIXTURE WITH CLAMPING

- NOTES:-
1. ALL SHARP EDGES TO BE CHAMFERED TO 0.2-0.3 X 45°
 2. ZINC PLATED THICKNESS 20 μ m.

001	RAW WT.-24.3KG	001	RING	161K X440X440
VAR. NO.	REMARKS	VAR. ITEM NO.	DESCRIPTION	GLS
28	CABO TYPE-3	28	CABO TYPE-1	

STATUS OF DRAWING	
DISTRIBUTION OF PRINTS	
TME-1	
TNX-1	
TXM-4	

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT	
IM3601AZ	

REVISIONS	
REV.	DATE
01	09.02.13
02	02.13
03	02.13
04	02.13
05	02.13
06	02.13
07	02.13
08	02.13
09	02.13
10	02.13
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20	02.13
21	02.13
22	02.13
23	02.13
24	02.13
25	02.13
26	02.13
27	02.13
28	02.13

TITLE	
TOOTHED RING FOR TRANSDUCER 24450103002	
(ROUGH MACHINED)	