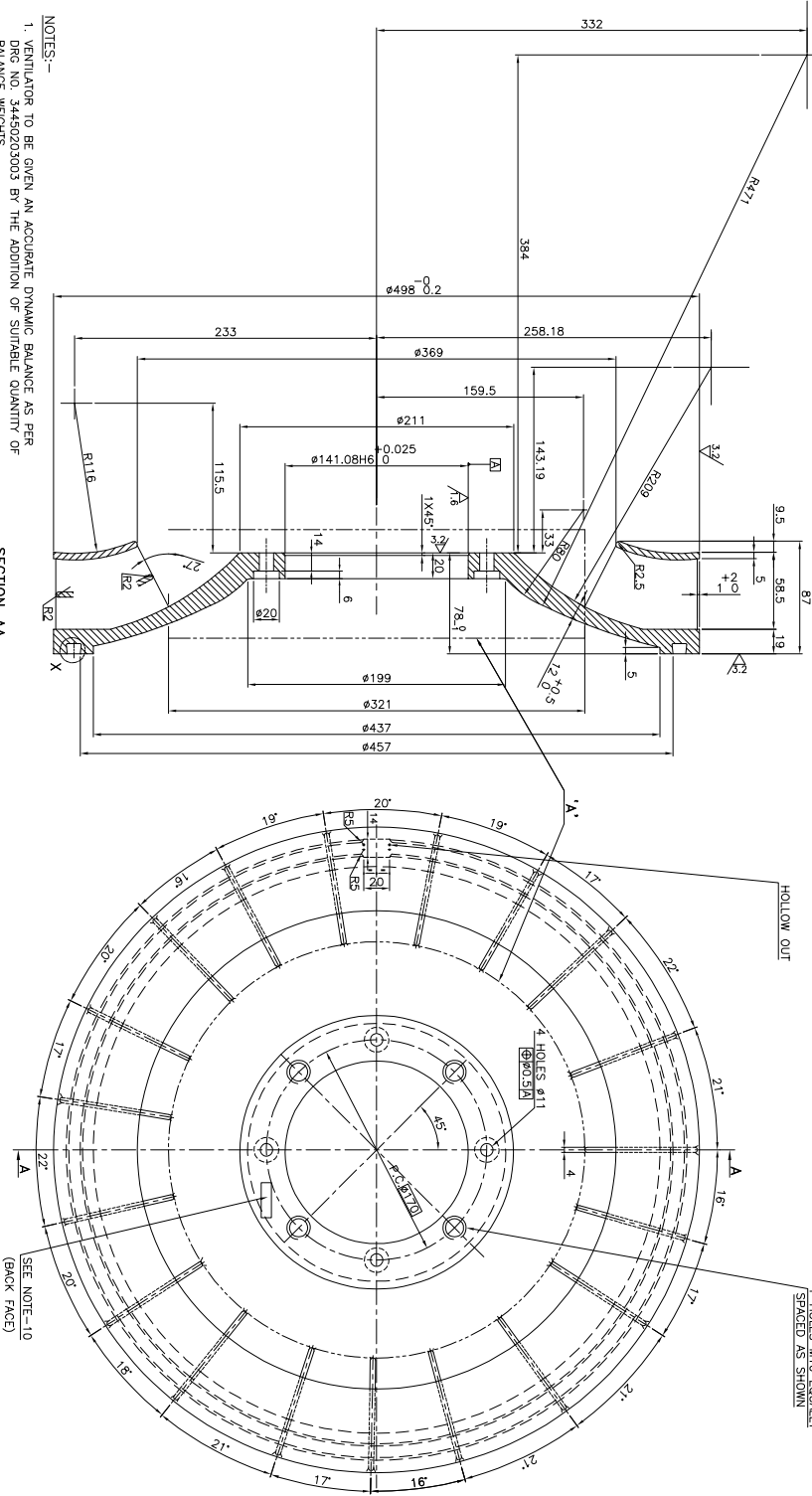
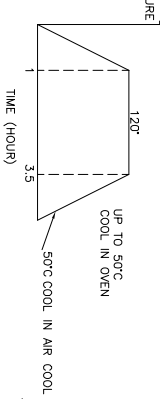
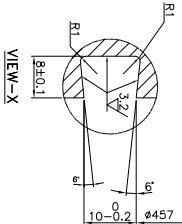


TOOL LIST	
ITEM NO.	DESCRIPTION
001	DOVETAIL TOOL LH & RH
001	DOVETAIL GAUGE
001	PIN GAUGE 141.08 +0.025/0
001	SAMP GAUGE 20
001	STEP GAUGE (78-1)-20
001	DRILL JIG FOR ALL HOLES
001	PIN GAUGE (S/F) 140.68/140.60
001	STATIC BALANCING MANDREL
001	DYNAMIC BALANCING MANDREL



- NOTES:-
1. VENTILATOR TO BE GIVEN AN ACCURATE DYNAMIC BALANCE AS PER DRG NO 34450203005 BY THE ADDITION OF SUFFICIENT QUANTITY OF LEAD WEIGHTS.
 2. CASTING TOLERANCES TO IS 4897 CL-1.
 3. MACHINING ALLOWANCES TO BE MAINTAINED 5 +2/0
 4. RADIOGRAPHY TO BE DONE ON EACH VENTILATOR AT AREA INSIDE MARKED 'A' AS PER THE FOLLOWING TABLE:

SECTION-AA

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

5. NON STATED RADI R=3
6. THE VENTILATOR IS TO BE MANUFACTURED AS PER RS90
7. MATERIAL TESTING AND SPECIFICATION 920006
8. VENTILATOR TO BE STRESS RELIEVED
9. DP TESTING TO BE DONE ON COMPLETE AREA OF EACH VENTILATOR (INCLUDING JOINING AREA OF BLADES WITH BODY) AS PER SPEC. A00850132.
10. DP TESTING TO BE DONE ON COMPLETE AREA OF EACH VENTILATOR.
11. SUPPLIER'S IDENTIFICATION MARKING TO BE EMBOSSED AS PER TM12548 AT THE LOCATION SHOWN (B/W THE HOLES).

REV	DATE	DESCRIPTION	BY	CHKD
08	22.08.22	APPRO. AS		
07	04.08.22	APPRO. AS		
06	18.09.19	APPRO. AS		
05	24.07.18	APPRO. AS		
04	21.05.16	APPRO. AS		
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01	28.04.12	APPRO. AS		

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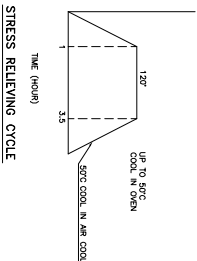
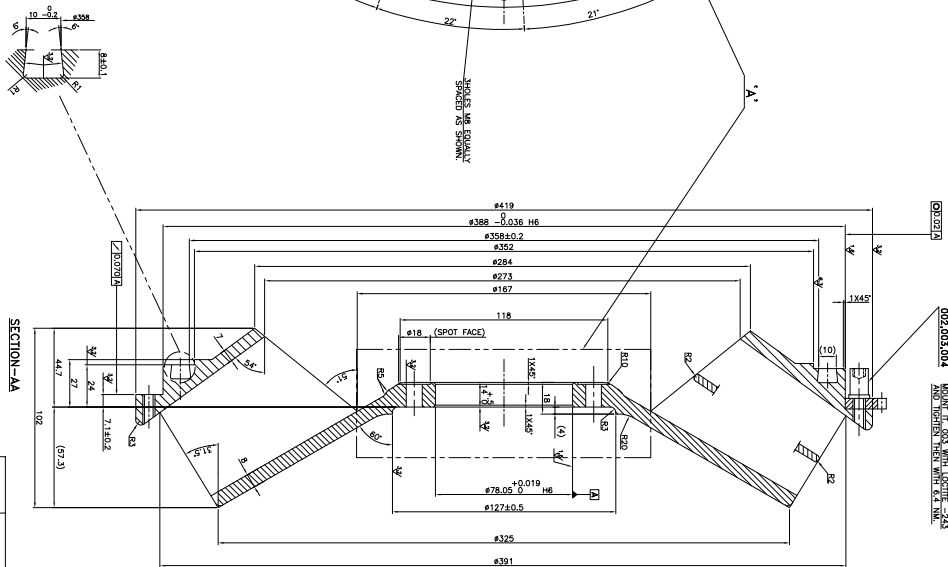
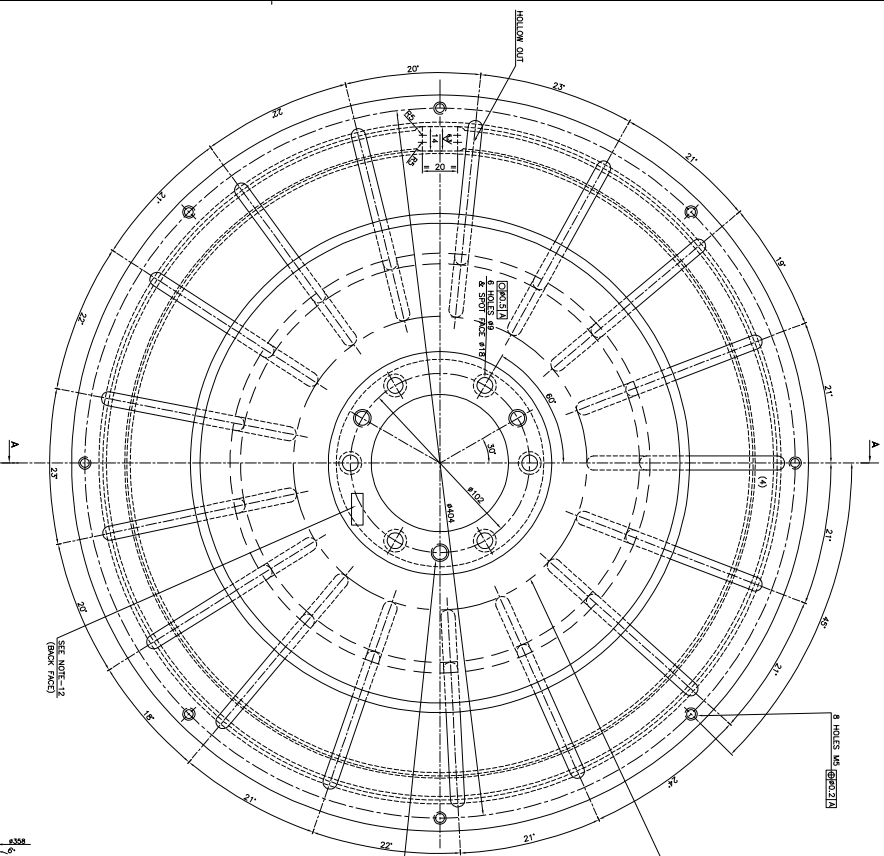
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REV	DATE	DESCRIPTION	BY	CHKD
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07	04.08.22	APPRO. AS		
06				



STRESS RELIEVING CYCLE

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	OFFSET 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 R050.
3. THE VENTILATOR IS TO BE MANUFACTURED AS PER R050.
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	ASTM E155 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).

AS REQ.		005 BALANCE WEIGHT		34450203005		00	
008		004 WASHER M/CD		004 Ø5.3		A47161001020	
008		003 SOCKET HD SCREW		003 M6X25 P8.8		A47232125	
001		002 TOOTH RING		34450103001		001	
001		001 VENTILATOR		1A185172			

ADDITIONAL INFORMATION

STATUS OF DRAWING

DISTRIBUTION OF PRINTS

TXM-1 TXM-3

REV. DATE

REV. DATE

REV. DATE

REV. DATE

REV. DATE

REV. DATE

REV. DATE

REV. DATE

OF UNIT/L		SCALE		MECHANICAL		ELECTRICAL		HYDRAULIC		PNEUMATIC		OTHER	
3/32X208		N.T.S.		6.0		0.4451003001		007		007		007	
VENTILATOR						DRAWING NO.		REV.		NO. OF SHEET		TOTAL SHEETS	
17 BLADES, NDE						1.4450203002		08		NO. OF SHEET		TOTAL SHEETS	
						SHEET NO. 01				NO. OF SHEET		TOTAL SHEETS	
										NO. OF SHEET		TOTAL SHEETS	
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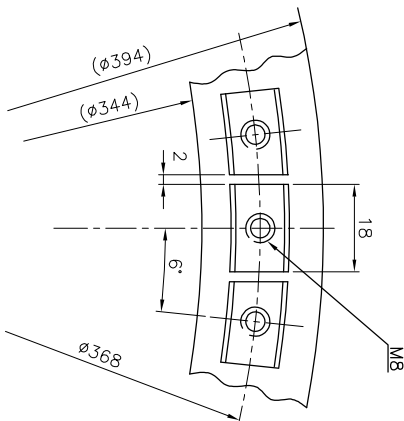
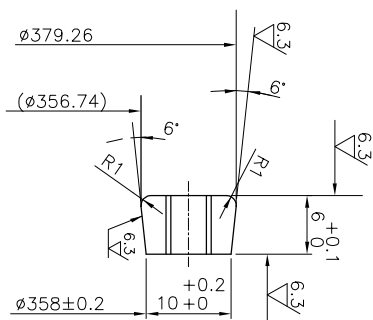
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INVENTORY NO.	SIGN. & DATE	REF. DRG. NO.
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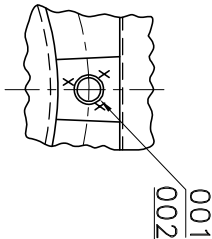
DRG. NO. 34450203005

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

[illegible][illegible]

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 LOCITTE 243 & CENTRE PUNCH
LOCK BALANCE SEGMENTS BY MEANS OF A CENTRE PUNCH.
 3. MAX. PERMISSIBLE RESIDUAL UNBALANCE 0.36 GRAM.

59	64	65	75	78	79	25	27	29	58	59	60	77	79	31	34	45	55	56	58	65	72
VAR.00		REMARKS		VAR		ITEM		DESCRIPTION		STD.	DRAWING NO.		ILL. NO.		MATL. CODE		UNIT WT.				
													32	33	46	54	57		68	71	70
													VAR.		MATL. SPON.	C	LN		QTY.		
001						001		SOCKET GRUB SCREW M8X8, 12.9			34450203005				AA7125104						
001								BALANCE SEGMENT							001						

[illegible]

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10030105744 CON DRG

FIRST ANGLE PROJECTION

8 HOLES Ø5.8 EQUALLY SPACED

SECTION-AA

NOTES:-

1. REMOVE BURRS AND ALL EDGES TO BE ROUNDED FOR SMOOTH FINISH.

2. MACHINE \sqrt{R} ALL OVER.

3. SURFACE FINISH ON UNMACHINED SURFACES TO BE AS PER IS:3073.

4. IT001 TO BE ZINC PLATED TO AA0673603 WITH PLATING THICKNESS 0.010MM TO 0.025 MM AND PASSIVATED (BRIGHT BLUE).

5. PROFILE SHOWN IN DETAIL-'X' TO BE MANUFACTURED BY HOBBING PROCESS.

6. ALL Ø2 NOS. "◇" MARKED DIMENSIONS ARE CRITICAL TO QUALITY(CTQ) & SL.NO. OF CTQ DIMENSIONS ARE INSCRIBED IN ◇ e.g. ◇

ENLARGED VIEW-X

TOOTHED RING FOR TRANSDUCER

GEAR DATA

NUMBER OF TEETH	215
MODULE	2
PRESSURE ANGLE - NORMAL	15°
NORMAL PITCH TOLERANCE (ADJACENT)	0.04
CUMULATIVE PITCH ERROR	0.06

STYLE LIST

VAR/ITNO	STYLE NO.
001 001	BP910480176

10030105744 CON DRG

FIRST ANGLE PROJECTION

8 HOLES Ø5.8 EQUALLY SPACED

SECTION-AA

NOTES:-

1. REMOVE BURRS AND ALL EDGES TO BE ROUNDED FOR SMOOTH FINISH.

2. MACHINE \sqrt{R} ALL OVER.

3. SURFACE FINISH ON UNMACHINED SURFACES TO BE AS PER IS:3073.

4. IT001 TO BE ZINC PLATED TO AA0673603 WITH PLATING THICKNESS 0.010MM TO 0.025 MM AND PASSIVATED (BRIGHT BLUE).

5. PROFILE SHOWN IN DETAIL-'X' TO BE MANUFACTURED BY HOBBING PROCESS.

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ENLARGED VIEW-X

TOOTHED RING FOR TRANSDUCER

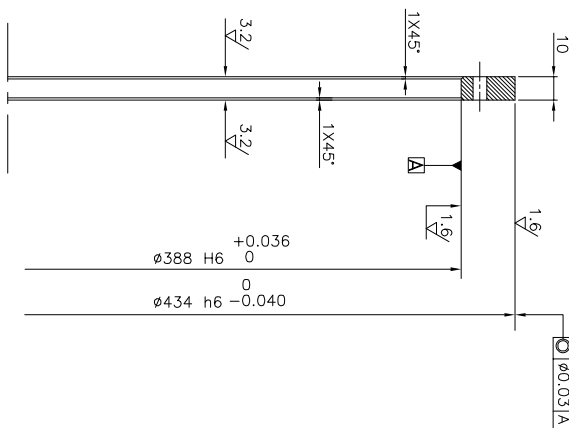
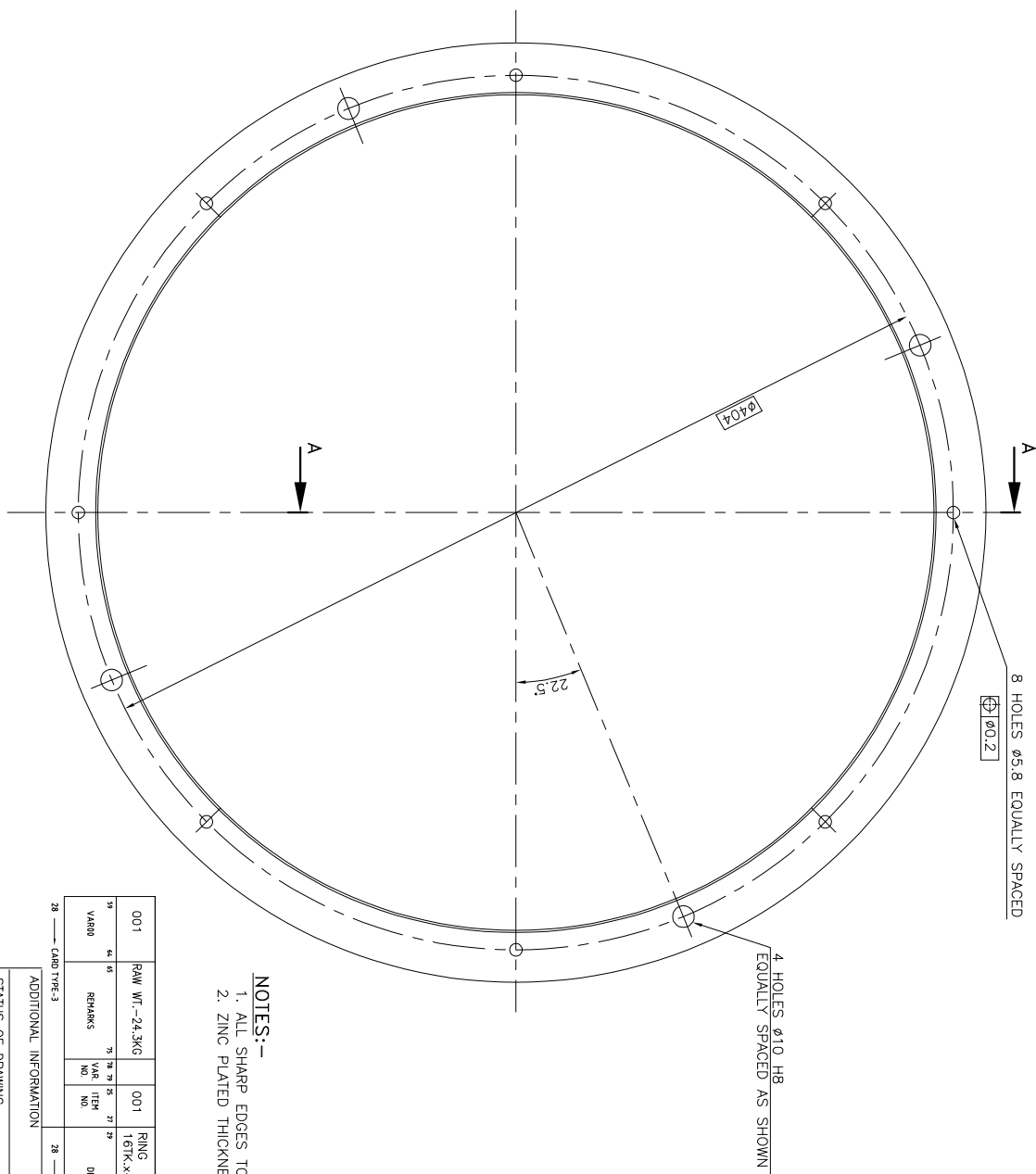
GEAR DATA

NUMBER OF TEETH	215
MODULE	2
PRESSURE ANGLE - NORMAL	15°
NORMAL PITCH TOLERANCE (ADJACENT)	0.04
CUMULATIVE PITCH ERROR	0.06

STYLE LIST

VAR/ITNO	STYLE NO.
001 001	BP910480176

2003010547 ON GRD



SECTION-AA

TOOL LIST

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

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

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ADDITIONAL INFORMATION

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT

IM3601AZ

STATUS OF DRAWING

DISTRIBUTION OF PRINTS

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TXN-1

TXM-4

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