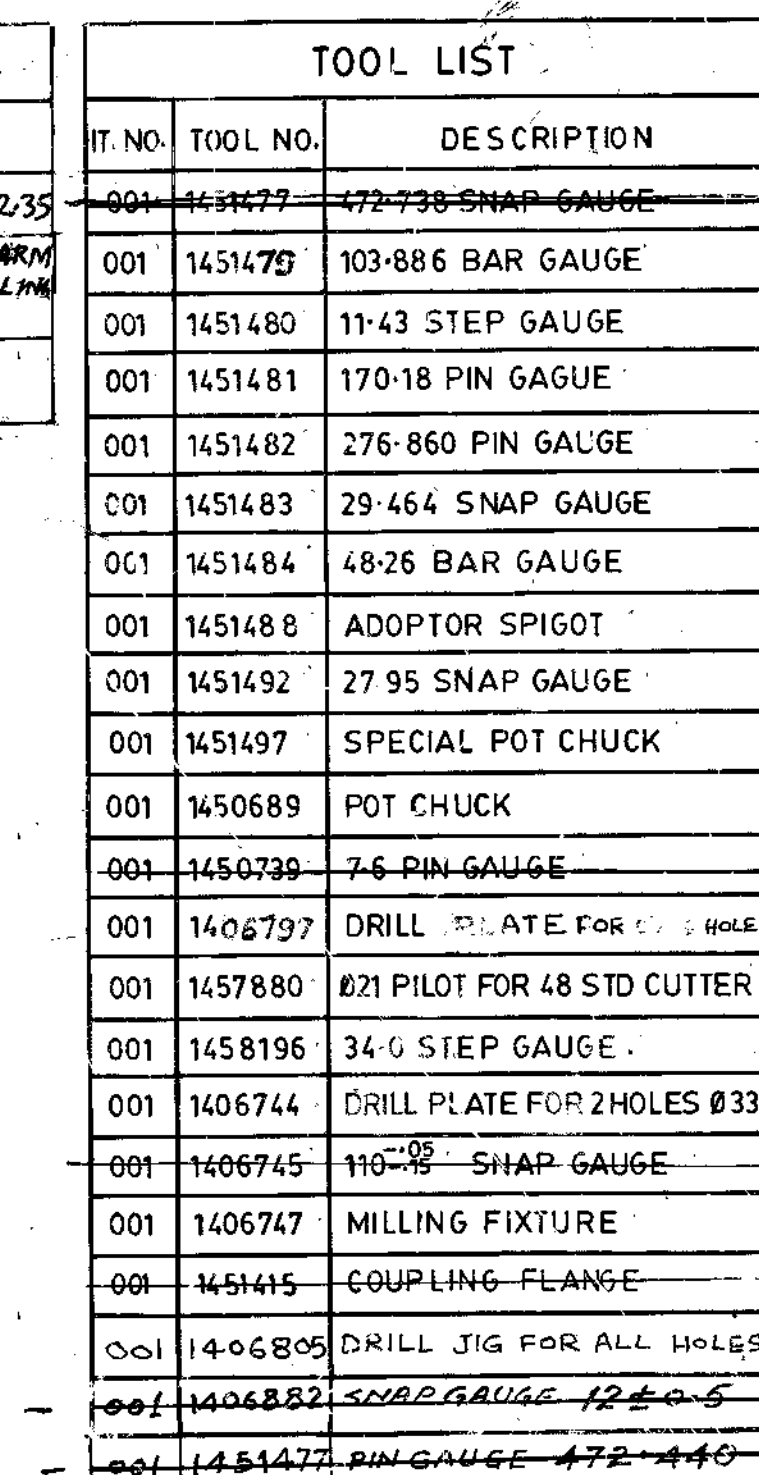


INVENTORY NO. SIGN. & DATE REF. DRG. NO.



NOTE:

1. FOR WELDING DETAIL OF SUPPORT ARM SEE DRG. NO. 3439A337001  
2. FOR ALTERNATIVE SEE CASTING END SHIELD P/W (WITH ARM) TO DRG. 1439-43-27-004  
3. WELDING OF ITEM 5 TO BE TO GRADE III OF AA 6622101 AND DP TESTED TO  
AA 0850131 & AA 0850139

~~4. AFTER WELDING OF II 005, STRESS RELIEVING TO BE CARRIED OUT TO PROCESS SPECIFICATION, BR 11640288.~~

6. ALL 9 NOS. "◇" MARKED DIMENSIONS ARE CRITICAL TO QUALITY (CTQ) & SL. NO. OF DIMENSIONS ARE INSCRIBED IN "◇" ed. (09)

[illegible]

[ADDITIONAL INFORMATION]

F 46 26 005

STATUS OF DRAWING

*[Handwritten signature]*

07 DISTRIBUTION OF PRINTS  
O/C - 1

TXM - 3

TNX 1

REV.	DATE	ALTERED
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1801	27-11-89	CHECKED	
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ZONE 1410. REF. TMA 4605 AZ

	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100	2101	2102	2103	2104	2105	2106	2107	2108	2109	2110	2111	2112	2113	2114	2115	2116	2117	2118	2119	2120	2121	2122	2123	2124	2125	2126	2127	2128	2129	2130	2131	2132	2133	2134	2135	2136	2137	2138	2139	2140	2141	2142	2143	2144	2145	2146	2147	2148	2149	2150	2151	2152	2153	2154	2155	2156	2157	2158	2159	2160	2161	2162	2163	2164	2165	2166	2167	2168	2169	2170	2171	2172	2173	2174	2175	2176	2177	2178	2179	2180	2181	2182	2183	2184	2185	2186	2187	2188	2189	2190	2191	2192	2193	2194	2195	2196	2197	2198	2199	2200	2201	2202	2203	2204	2205	2206	2207	2208	2209	2210	2211	2212	2213	2214	2215	2216	2217	2218	2219	2220	2221	2222	2223	2224	2225	2226	2227	2228	2229	2230	2231	2232	2233	2234	2235	2236	2237	2238	2239	2240	2241	2242	2243	2244	2245	2246	2247	2248	2249	2250	2251	2252	2253	2254	2255	2256	2257	2258	2259	2260	2261	2262	2263	2264	2265	2266	2267	2268	2269	2270	2271	2272	2273	2274	2275	2276	2277	2278	2279	2280	2281	2282	2283	2284	2285	2286	2287	2288	2289	2290	2291	2292	2293	2294	2295	2296	2297	2298	2299	2300	2301	2302	2303	2304	2305	2306	2307	2308	2309	2310	2311	2312	2313	2314	2315	2316	2317	2318	2319	2320	2321	2322	2323	2324	2325	2326	2327	2328	2329	2330	2331	2332	2333	2334	2335	2336	2337	2338	2339	2340	2341	2342	2343	2344	2345	2346	2347	2348	2349	2350	2351	2352	2353	2354	2355	2356	2357	2358	2359	2360	2361	2362	2363	2364	2365	2366	2367	2368	2369	2370	2371	2372	2373	2374	2375	2376	2377	2378	2379	2380	2381	2382	2383	2384	2385	2386	2387	2388	2389	2390	2391	2392	2393	2394	2395	2396	2397	2398	2399	2400	2401	2402	2403	2404	2405	2406	2407	2408	2409	2410	2411	2412	2413	2414	
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1. *Chlorophyll a* (Chl *a*)

4

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT	TM 4601 AZ/BZ/ <del>BX</del> AC EMU
---	--

 <b>BHARAT HEAVY ELECTRICALS LIMITED</b> BHARAT	DRN.	NAME	SIGN	DATE	73 N/V
	CHD.	S.G.D			

DEPT.		TIME	GRADE OF UN. TOL.		SCALE	WEIGHT (kg.)	REF. TO ASSY. DRG.	ITEM NO.	75 N IT
CODE			CHARACTER		NTS	47.00	243943-37001	00.	

405	END SHIELD P.E.	CARD CODE	DRAWING NO. 1 439 43 37 001
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(FINISH)	SHEET NO. 01	NO. OF SHEETS 01
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SIZE

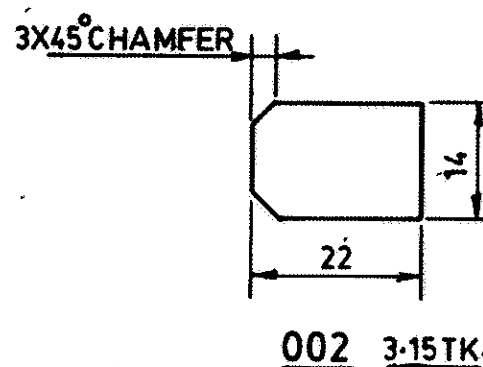
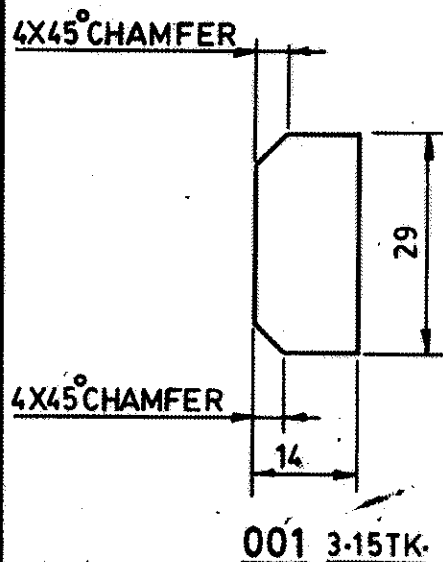
255812/2024

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IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY

REV.	DATE	ALTERED	CHECKED
01	22-2-93	OK	OK
ST. No. 9094544580 WAS NOT ON.			
REV.	DATE	ALTD.	CKD.
03	31-7-96	OK	OK
IN BOM LENGTH FOR ITS. 001 & 002 WERE 22 & 29 RESPLY.			

REV.	DATE	ALTERED	CHECKED
01	22-2-93	OK	OK
BOM UPDATED.			

ADDITIONAL INFORMATION
STATUS OF DRAWING
DISTRIBUTION O/C-1; TXM-3 OF PRINTS <i>TXN-1</i>

**NOTE:-**

1.-REMOVE ALL SHARP EDGES.

002	RIB H.R. STL. SHEET 3-15TK.X14x22	1	AA1011713136 AA 10113	NA	0.01
001	RIB H.R. STL. SHEET 3-15TK.X14x29	1	AA1011713136 AA 10113	NA	0.01
REMARKS	ITEM NO.	DESCRIPTION	MATL. CODE	UNIT	UNIT WT.
			MATL. SPECN.		QTY.

CARD TYPE-3 → 28 → CARD TYPE-1 → 28 → CARD TYPE-2

		<b>BHARAT HEAVY ELECTRICALS LIMITED</b> <b>BHOPAL</b>		DRN. <i>VRD</i> CHD. <i>SGD</i> APPD. <i>SKS</i>	NAME <i>VRD</i> SIGN <i>SGD</i> DATE <i>21-12-88</i> <i>22-12-88</i> <i>3-1-89</i>
DEPT. TME	GRADE OF UN. TOL. DIM. <i>φ/M/y</i>	SCALE 1:1	WEIGHT (Kg.) <i>NA</i>	REF. TO ASSY. DRG. 1 439 43 37 001	ITEM NO. 004
CODE 405					
TITLE <b>RIB (ENDSHIELD P.E.)</b> <i>TM-4601 A2/BZ/BX. AC EMU</i>				CARD CODE 4 439 43 37 001	DRAWING NO. 22 23 24 REV. 03
SHEET NO. 01				NO. OF SHEETS 01	

S.E.S.

SIZE A4





ORG

4 HOLES DRILL & TAP M12 NUT  
SLOT FACE 20 DIA TO ROUGH FACE  
OF CASTING AS SHOWN

## GAUGE LIST

LIMIT	NOMSIZE	SYMBOL	TOOL NO.	IT.NO.	TYPE
0.1/0.0			1458209	1&2	GROOVE
10.9/11.0			1485210	1&2	STEP
31.5/31.6			1458211	1&2	SNAP
52.80/52.50			1458212	1&2	BAR
280.00/279.90			1451170	1&2	PIN
9.32/9.37			1454120	1&2	DEPTH
166.28/166.18			1454122	1&2	SNAP
188.86/188.76			1454125	1&2	SNAP
204.85 /204.95			1454126	1&2	PIN
6.00/6.1			1457829	1&2	GROOVE
254.00/254.076			1450146	1&2	PIN
155.71/155.81			1454119	1&2	PIN
334 Øx 305 Øx30°			1454130	1&2	PROFILE
28 BAR GAUGE			1454128	1&2	BAR

## TOOL LIST

IT.NO.	TOOL NO.	DESCRIPTION
1&2	1451173	279.908.0 TURNING SPIGOT
1&2	1458147	6MM RIGHT ANGLE CRANT TOOL FOR GROOVING
1&2	1454131	D.J. FOR ALL HOLES
1&2	1454134	13 Ø PLATE FOR 20 Ø C.B.
1&2	1457392	10.2 PILOT FOR 16 Ø C.B.
1&2	1458146	6MM.R.H. RECESSING TOOL

NONES:-

1. ITEM 3 SEATING PLATE TO BE WELDED IN POSITION SHOWN WELD SHOULD BE LEAK PROOF WELD TO B GR.IV OF AA0622101.
2. CORED HOLE BMM DEEP IN POSITION SHOWN. AFTER MACHINING DRESS UP CORED HOLE & ALIGN ON DIA. 166.28/166.23 ON ONE SIDE.
- THIS BORE SHOULD BE CONCENTRIC & SQUARE WITH THE FACE WITHIN .05 TIR
4. ITEM 2 TO BE MACHINED ALL OVER EXCEPT 334 & 305 DIA. PROFILE ITEM 2 IS ALTERNATIVE TO IT. 1 & ALL DETAILS & DIMENSIONS ARE SAME AS FOR IT. 1 EXCEPT FOR DETAILS SHOWN IN VIEW AT REF.H3./1011.
5. ITEM 2 IS ALTERNATIVE TO ITEM 1
6. SYLE NO. FOR CASTING 454277  
PATTERN NO. 1245283
7. ALTERNATIVELY IT.OOI CAN BE MADE FROM ARI0108 (#340x65TX) ~~CLINT 465~~
- ~~8- BORE MARKED X TO BE CONCENTRIC WITHIN 0.04 TIR.~~
- 9- CASTING TO BE SAND/SHOT BLASTED.
- 10- SURFACE FINISH UNMACHINED CASTED SURFACE TO BE AS PER IS: 3073.

SECTION-AA

SECTION-CC

SECTION-BB

6 DIA. SLOT DRILL

[illegible]

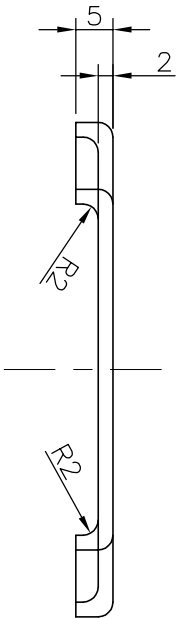
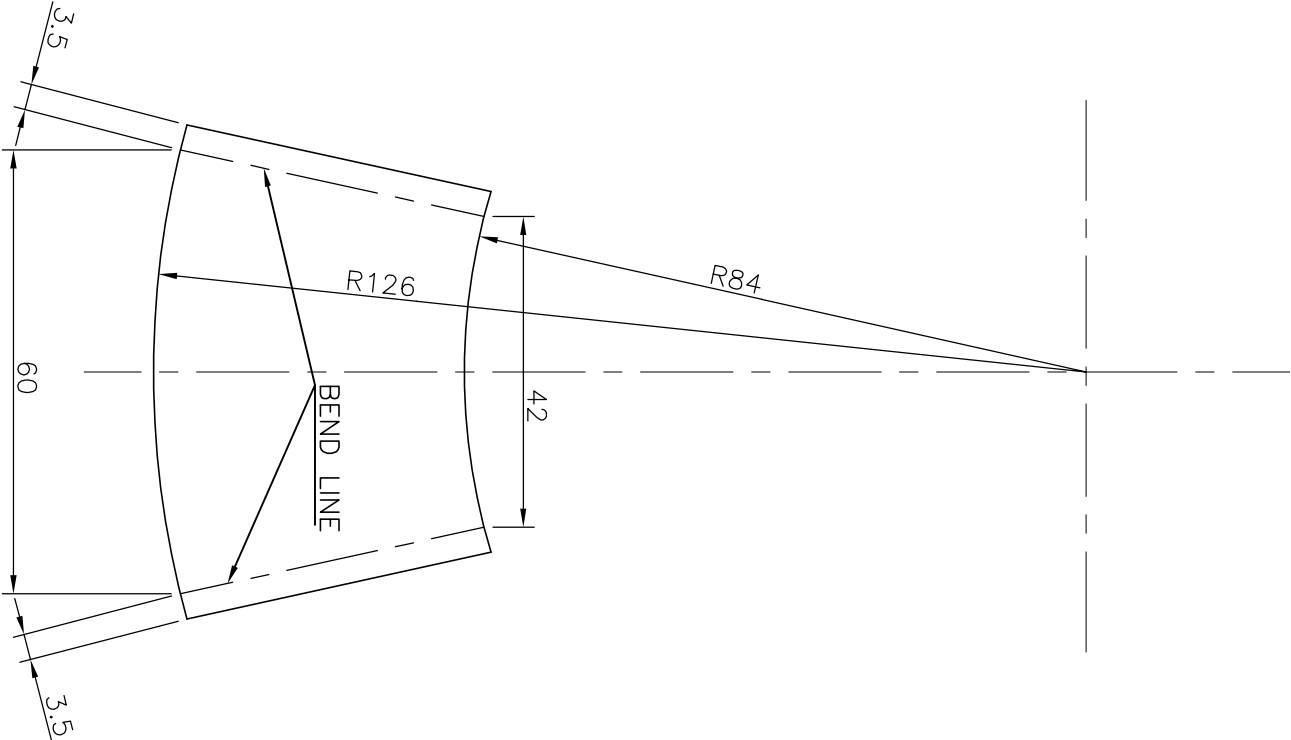
10014346343

DRG. NO.

001

TOOL LIST		
IT.NO.	TOOL NO.	DESCRIPTION
001	1458217	NIBBLING TEMPLATE

STYLE LIST		
S.NO.	DESCRIPTION	STYLE NO.
001	DRAIN COVER	BP9094760711



NOTE:—

1. TOLERANCE ON UNTOL. DIM. ±0.5

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INVENTORY NO.		SIGN. & DATE		REF. DRG. NO.	
		<div>DEVELOPED VIEW OF ITEM 001</div>			
REV		DATE		ALTERED	
04		17.02.09		F-KKK	
				CHECKED	
				APPROVED	
				-SD-	
DRG. UPDATED & DIGITIZED.		TME-1			
		TMX-3			
		TMX-1			
ADDITION INFORMATION		STATUS OF DRAWING			
DISTRIBUTION OF PRINT		TME-1			
TMX-3		TMX-1			
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		TM4601AZ/TM4603AZ/BZ			
BHARAT HEAVY ELECTRICALS LTD.		Bhopal			
GRADE OF UNTOL. DIM. & M/F		SCALE			
405		0.05			
WEIGHT (kg)		REF. TO ASSY. DRG.			
0.05		14394341003			
ITEM NO.		NO. OF ITEMS			
003		001			
DRAWING NO.		REV.			
34394341001		04			
SHEET NO. 01		NO. OF SHEET			
01		01			

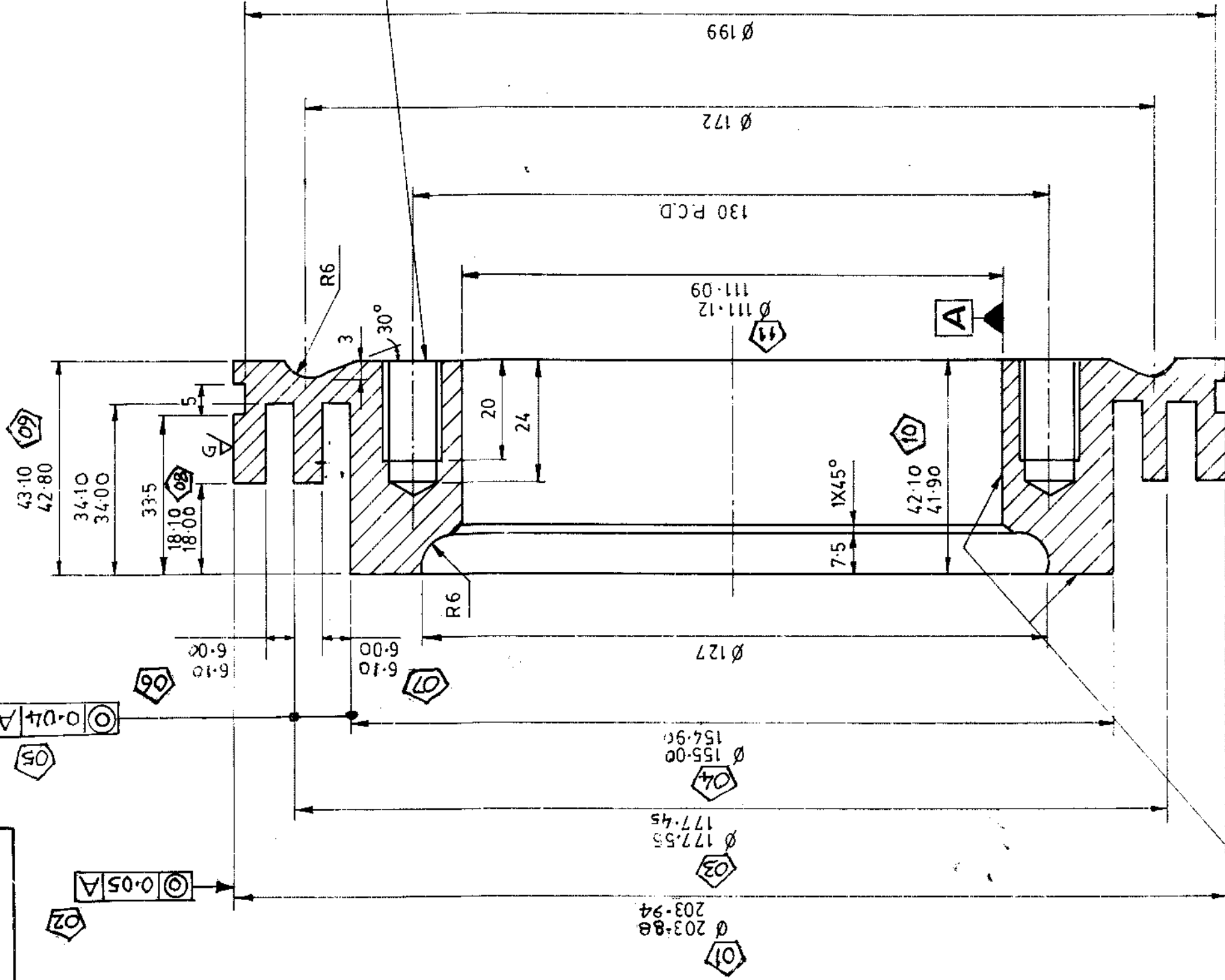




(ALL DIMENSIONS ARE IN mm.)

FIRST ANGLE PROJECTION

200 17 37 637 2 ON DRG



6 HOLES M 12 EQUALLY SPACED AS SHOWN.

GAUGE LIST

LIMIT	NOM SIZE	SYM.	GAUGE NO.	ITEM	TYPE
6-1 / 6-0	6-00	—	1457829	001	GROOVE
42-1 / 41-9	42-00	—	1458065	001	SNAP
155-0 / 154-9	—	—	1458182	001	SNAP
177-55 / 177-45	—	—	1458183	001	SNAP
111-12 / 111-09	—	—	1458180	001	PIN
18-1 / 18-0	—	—	1458213	001	STEP
25-00 / 24-80	—	—	1458236	001	SNAP

TOOL LIST

ITEM	TOOL	DESCRIPTION
001	1459040	57 RECESSING TOOL.
001	1457810	16X7-5 STEP BAR GAUGE.
001	1457811	Ø199 SNAP GAUGE.
001	1457815	Ø127 OFESET PIN GAUGE.
001	1458066	FORM TOOL FOR TURNING R 6.
001	1458181	DRILL JIG.
001	1458214	(34-0 - 18-0) X 6-05/6-00 GROOVE & DEPTH GAUGE.

SL. NO.	DESCRIPTION	ST. NO.
001	BEARING WIPER P.E.	BP9094760525

NOTES:-

- MACHINE ALL OVER.
- DIAMETERS MARKED THUS  $\varnothing$  ARE TO BE CONCENTRIC WITHIN 0.05 TIR.
- ALTERNATIVELY USE MATERIAL TO AA1933G FOR 17.00L.
- ALL DIMS. MARKED  $\varnothing$  TO BE CONCENTRIC WITHIN 0.04 TIR.
- ALL 11 NOS.  $\varnothing$  MARKED DIMENSIONS ARE CRITICAL TO QUALITY (CTR) & SLNO. OF CTR DIMENSIONS ARE INSCRIBED IN  $\varnothing$  09: 17.
- QAP FOR FORGING TO BE AS PER QTM/QAP/VENDOR/13-14/002 (LATEST REVISION)

001	R/INT 150KG	001	MED. CARBON STL BAR 2	BP 1020299037	7-58
VAR 00	REMARKS	VAR 00	DESCRIPTION	VAR 00	UNIT WT.
VAR 00	VAR 00	VAR 00	DRAWING NO	VAR 00	QTY
VAR 00	VAR 00	VAR 00	MATL SPECN.	VAR 00	ZONE

TYPE OF PRODUCT		TM 4603 AZ/BZ, TM-4601AZ/BX	
NAME OF CUSTOMER/PROJECT		BHARAT HEAVY ELECTRICALS LIMITED	
STATUS OF DRAWING		BHARAT	
DISTRIBUTION OF PRINTS		DISTRIBUTION OF PRINTS	
O/C - 1 T X M - 3		O/C - 1 T X M - 3	
MODIFIED. TCM - 335.		MODIFIED. TCM - 335.	
REV DATE		REV DATE	
01 17-2-93		01 17-2-93	
CHECKED		CHECKED	
BY		BY	
BOM UPDATED.		BOM UPDATED.	
NOT ON. NOTE-3 WAS NOT		NOT ON. NOTE-3 WAS NOT	
ON. 11-12-11. 09 WAS 11-120.		ON. 11-12-11. 09 WAS 11-120.	
11-095. MICKING SYMBOL		11-095. MICKING SYMBOL	

REV	DATE	ALT	QD	REV	DATE	ALT	QD
09	24-11-14	CHD	QD	07	7-13-11	CHD	QD
STYLE TABLE ADDED.				CRITICAL TO QUALITY DIMENSIONS ARE MARKED AND NUMBERED. NOTE 58-60. NOTE 28-4 WERE ON.			
REV	DATE	ALT	QD	REV	DATE	ALT	QD
05	15-11-14	CHD	QD	03	10-5-97	CHD	QD
NOTE WAS NOT ON.				MATERIAL SPON AA 19332 WAS BP 10299 & NOTE-3 MODIFIED.			
REV	DATE	ALT	QD	REV	DATE	ALT	QD
06	29-7-11	CHD	QD	02	9-5-94	CHD	QD
DIM 0 61 WERE 6-05				INITIAL AA0230208 GRM			
DIM 0 177-55 WERE 177-55				WAS NOT ON. NOTE-3 WAS NOT			
DIM 0 155-0 WERE 155-00				ON. 11-12-11. 09 WAS 11-120.			
154-9				11-095. MICKING SYMBOL			

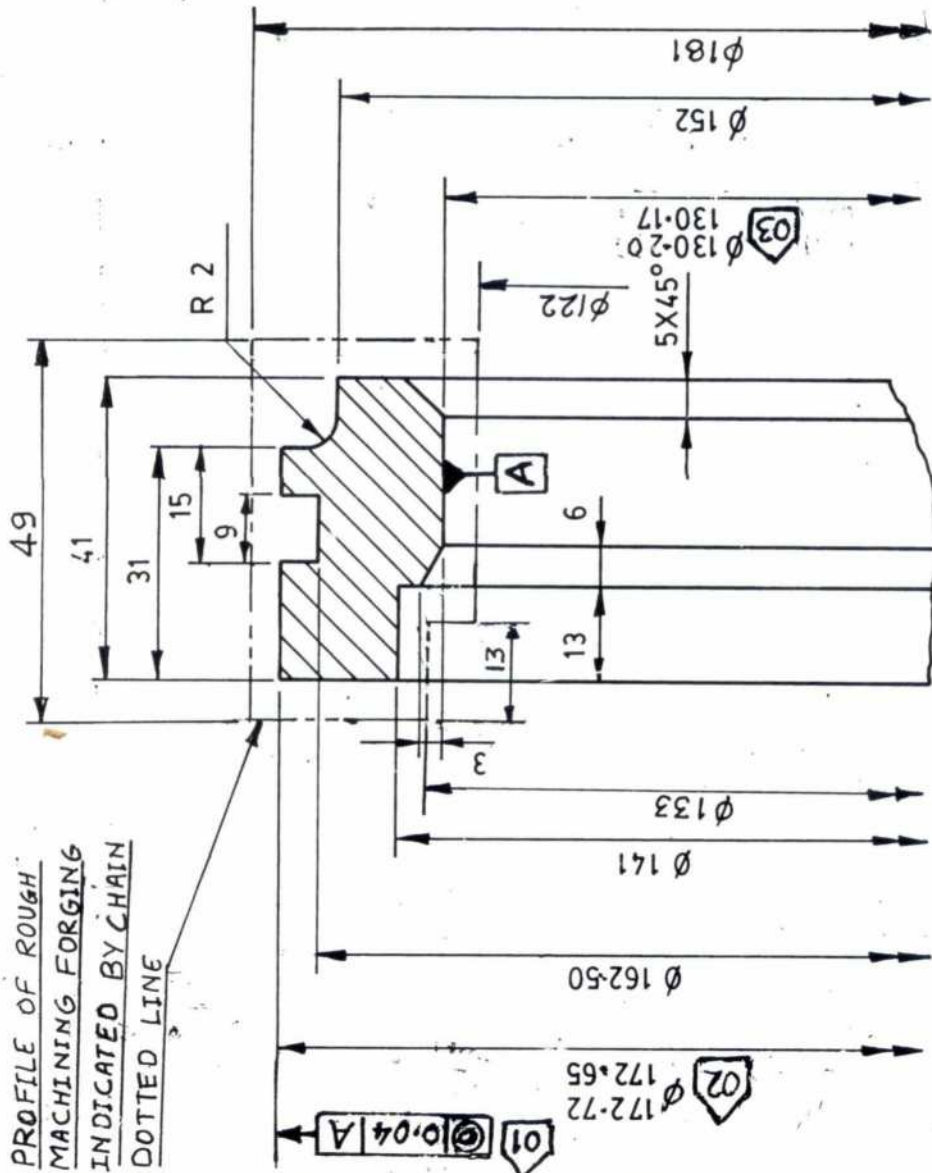
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D-4776151 REF DRG. NO. SIGN & DATE INVENTORY NO.



200 17 37 637 3 ON Dwg

PROFILE OF ROUGH  
MACHINING FORGING  
INDICATED BY CHAIN  
DOTTED LINE



REV	DATE	ALT	QTY
08	7-6-13	CKD	Rev

CRITICAL TO QUALITY  
DIMENSIONS ARE "A"  
MARKED & NUMBERED  
NOTE 3 WAS ON NOTES  
& 6 WERE NOT ON.

REV	DATE	ALT	QTY
07	16-04-13	CKD	Rev

PROFILE OF ROUGH MACHINING  
FORGING ADDED IN BOM, RAW  
MATL. SIZE WAS 180X53.  
NOTE-4 WAS NOT ON.

REV	DATE	ALT	QTY
04	9-5-94	CKD	Rev

IN TITLE AA 0230208 GR.M  
WAS NOT ON. 130.2/130.17  
WAS 130.200/130.175.

REV	DATE	ALT	QTY
02	1-3-93	CKD	Rev

BOM UPDATED.

REV	DATE	ALT	QTY
03	31-8-93	CKD	Rev

DIMN 172.72 WAS 172.65

REV	DATE	ALT	QTY
06	15-4-11	CKD	Rev

NOTE-3 WAS NOT ON.

REV	DATE	ALT	QTY
05	19-8-04	CKD	Rev

IN BOM DESCRIPTION 180X53  
& WT: 10.5 KG. WERE 172.72X41  
& WT. 2.24 KG.

NOTES :-

1. SIDES TO BE STRICTLY PARALLEL & AT RIGHT ANGLES TO BORE.
2. MACHINE ALLOWER.
3. DIMENSIONS MARKED \* TO BE CONCENTRIC WITHIN 0.04 TIR
4. ROUGH MACHINE INNER BEARING SLEEVE PE TO PROFILE SHOWN IN CHAIN DOTTED LINE.  
MACHINING TOLERANCE 10.5 MM. R/MACHINE 0.3. R/MCD WEIGHT IS 5.2 KG.
5. ALL 3 NOS. "A" MARKED DIMENSIONS ARE CRITICAL TO QUALITY (CTR) & S.L.N.O. OF  
CTR DIMENSION ARE INSCRIBED IN 0.03.
6. QAP FOR FORGING TO BE AS PER QTM/QAP/VENDOR/13-14/002 (LATEST REVISION).

GAUGE LIST

LIMIT	NOM. SIZE	SYMBOL	NO. OR TYPE	ITEM
130.2 / 130.17	—	—	1451203	001
172.72 / 172.65	172.720	—	MICRO	001

TOOL LIST

ITEM	TOOL	DESCRIPTION
001	1451202	140.95 PIN GAUGE.
001	1451205	PROFILE GAUGE FOR GROOVE.
001	1451206	2mm. SPECIAL RADIUS GAUGE.
001	1458165	CHAMFER GAUGE 5X45°

001	SEE NOTE 4	001	INNER BEARING SLEEVE	1	AA 19332	9.24
001	75.78 79.25 27.29	ITEM NO.	DESCRIPTION	58 59 60	71 72 73 74	UNIT WT. 65.72
001	64.65	VAR 00	REMARKS	51	52 53 54	QTY. 71.50

ADDITIONAL INFORMATION: CARD TYPE-1, CARD TYPE-2

STATUS OF DRAWING: TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT: TM 4601 AZ/BV, TM 4603 BZ/AZ, 25KV AC EMU

DISTRIBUTION OF PRINTS: 0C — 2; TXM — 4; TANX — 1.

REV	DATE	ALT	QTY	REV	DATE	ALT	QTY
01	27-4-92	CKD	Rev	02	1-3-93	CKD	Rev
01	27-4-92	CKD	Rev	02	1-3-93	CKD	Rev

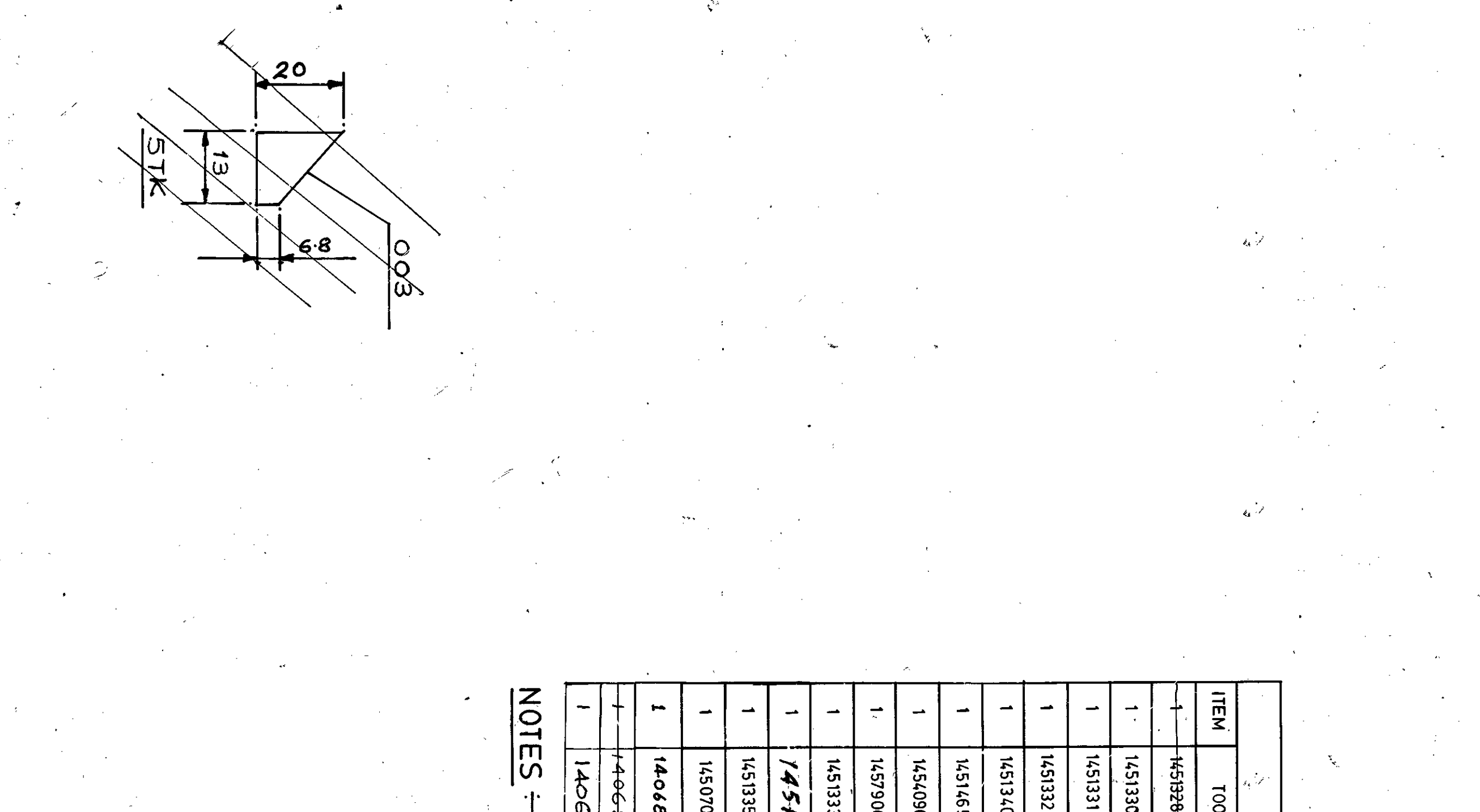
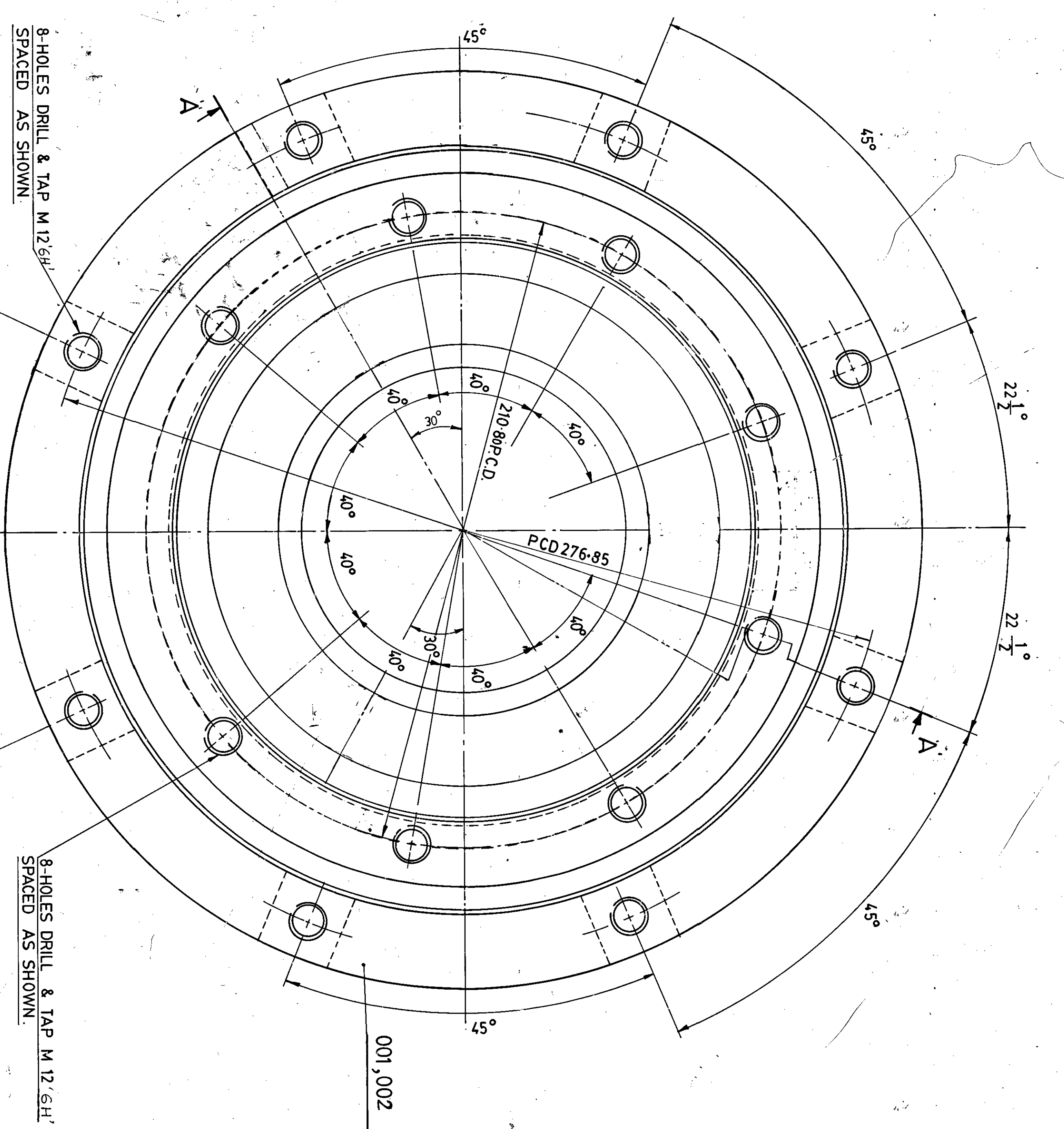
IN BOM MAT. 19332 WAS 10213.



BHARAT HEAVY ELECTRICALS LIMITED  
BHOPAL

DEPT. TME	GRADE OF UN. TOL.	SCALE	WEIGHT (Kg.)	REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEMS
CODE 405	4A0230208	1:1	2.24	2-439-43-41-001	005	001
TITLE	INNER BEARING SLEEVE PE.	CARD CODE	3 439 43 41 002	DRAWING NO.	22 23 24	REV. 03
		SHEET NO.	01	NO. OF SHEETS	01	01





GAUGE LIST					
LIMIT	NOM SIZE	STK.	NO.	ITEM	TYPE
108.93 / 108.64	108.985	H 8	145.035	1	PN
255.400/259.966	255.965	H 6	145.449	1	GAU
108.635/108.407	—	—	145.325	1	PN
37.92 / 37.84	—	—	145.327	1	STEP
42.61 / 42.53	42.672	—	145.6613	1	STEP
18.961/18.9462	—	—	145.325	1	PN
37.77 / 37.72	37.77	—	145.653	1	STEP
30.2/30.22	30.30	—	145.770	1	SNAP
18.969 / 19.000	—	—	145.770	1	PN
231.99 / 235.04	—	—	145.230	1	PN

TOOL LIST					
	ITEM	TOOL	DESCRIPTION		
	1	1451930	4572R BAR WAVE		
	1	1451930	45112 STEP GAUGE		
D&E					
	ITEM	DESCRIPTION	S.T. NO.		
	DO1	BEARING CARTRIDGE	BC-2004181029		
		MILING			
		CARTRIDGE			
		SENDING			
			BP-2004181874		

1	145132	SINGLE SLOPED PROFILE GAUGE.
1	145134	GRINDING SPINDLE
1	145165	12" STEP GAUGE.
1	145406	CALIBER GAUGE
1	145700	DRAW JIG
1	145733	39.85 SNAP GAUGE
1	<u>1451334</u>	PROFILE GAUGE.
1	1451935	M.O. TEMPLATE
1	145706	POT CHUCK
1	1450804	PROFILE CHECKING GAUGE 2 1/2" DIA. 1/16" MINIMUM 2 1/2" DIA. 1/32" MINIMUM
1	1440852	2 1/2" DIA. 1/16" MINIMUM 2 1/2" DIA. 1/32" MINIMUM
1	1406366	2 CALIBER GAUGE 2 1/2" / 1/32"

1. RIBS TO BE WELDED TO EACH OTHER.  
2. TOLERANCE ON ANGLE  $\pm 1^{\circ}$ .  
3. TOLERANCE ON ANGLE  $\pm 1^{\circ}$ .  
4. MAX. TENSILE TO BE AFTER DRG. 28394441002  
5. DIMENSIONS IN INCHES TO BE CENTER  
6. ALL 7 DIM. DIMENSIONS ARE CRITICAL TO QUALITY (CTQ) &  
SL. NO. OF CTQ DIMENSIONS ARE INCREASING IN "O" & "8".

SECTION - "A"

25°

25°

[illegible]










DRG. NO. 2 439 44 37 001





GAUGE LIST					
ITEM	LIMIT	NOM SIZE	SYMBOL	TOOL NO.	TYPE
<del>001</del>	<del>115.24 / 115.19</del>	<del>—</del>	<del>—</del>	<del>1457822</del>	<del>PIN</del>
001	122.1 / 122.0	—	—	1457828	PIN
001	6.1 / 6.00	—	—	1457829	GROOVE
001	153.94 / 153.84	—	—	1457830	SNAP
<del>001</del>	<del>144.1 / 143.942</del>	<del>—</del>	<del>—</del>	<del>1457831</del>	<del>PIN</del>
001	234.98 / 234.95	—	—	1457820	SNAP

TOOL LIST		
ITEM	TOOL NO.	DESCRIPTION
001	1457821	Ø 168 OFFSET PIN GAUGE
001	1457823	Ø 125 SPL SNAP GAUGE
001	1457824	3-2X20 COMBINED STEP GAUGE
001	1457825	TURNING SIP GGT
001	1457826	30 mm. BAR GAUGE
001	1457827	14.2 X 5 DEPTH GAUGE
001	1457832	DRILL JIG FOR ALL HOLES
001	1605509	HTYPE CALLIPER GAUGE 132.00/131.90

1. ☒ ALL OVER
2. ~~DIAS MARK \* TO BE CONCENTRIC WITHIN 0.04MM.~~
3. ALL 8 NOS. "  " MARKED DIMENSIONS ARE CRITICAL TO QUALITY (CTQ) & SL.NO. OF CTQ DIMENSIONS ARE INSCRIBED IN "  " e.g. 

001		ST. NO. 454146 RINT 228146		001		OUTER BEARING CAP 50 TKX 242 SQ		1		AA101808269 AA 10108		AA 10108		3.90									
59	64	65	75	76	79	25	27	28	58	59	60	77	78	31	34	45	55	56	57	58	65	72	
VAR 00		REMARKS		IVAR.		ITEM NO.		DESCRIPTION		STD.		DRAWING NO.		J.T. NO.		MATL. CODE		UNIT		UNIT WT.		ZONE	
VAR.		MATL. SPECN.		C		A		QTY.		CS		ZONE											
28		CARD TYPE-3		28		CARD TYPE-1		28		CARD TYPE-2													

REV. DATE 06 7/10/73	ALT: CKD: <i>Handwritten</i>	REV. DATE 07 10/12/74	ALT: CKD: <i>Handwritten</i>	REV. DATE 08 7/11/76	ALT: CKD: <i>Handwritten</i>	REV. DATE 09 7/15/76	ALT: CKD: <i>Handwritten</i>
CRITICAL TO GAUITY DIMENSIONS ARE "O" MARKED & NUMBERED. NOTE-3 ADDED. NOTE-2 WAS ON.		STYLE LIST ADDED.		TOOL LIST UPDATED  (TCM-348)		TOOL NO. 1605509 ADDED  (TCM-348)	
REV 05 7/9/71	ALT: CKD: <i>Handwritten</i>	REV 04 24.7.11	ALT: CKD: <i>Handwritten</i>	REV 03 2-12-06	ALT: CKD: <i>Handwritten</i>		
TL NO 1457830, 828 820, 822 & 829 GAUGE LIMIT MODIFIED TCM 335.		DIM# 153.94 WAS 153.940 153.84 153.882 DIM# 132.0 WAS 132.000 131.9 132.942 DIM# 122.1 WAS 122.063 122.0 122.000		DIM# 234.98 WAS 234.985 224.95 224.980 DIM# 115.24 WAS 115.243 115.19 115.189 DIM# 6.1 WAS 6.05 6.0 6.00		3-HOLES DRILL & TAP M12 WAS M10.	

ADDITIONAL INFORMATION E 4700403				TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT				TM - 4601AZ / BZ / BX 25 KV AC EMU					
STATUS OF DRAWING				 BHARAT HEAVY ELECTRICALS LIMITED BHOPAL				DRN.	NAME VRD	SIGN S. S. S.	DATE 21-12-88	73 74 NO. OF VAR.	
DISTRIBUTION OF PRINTS O/C-1, TXM-3, TXM-1,								CHD.	SGD	S. S. S.	22-12-88	00	
REV. 01				DATE 23-2-93	ALTERED CHECKED	DEPT. TIME	GRADE OF UN. TOL. DIM F/M/Y		SCALE N.T.S.	WEIGHT (Kg.) 3.90	REF. TO ASSY. DRG. 2 439 44 37 002	ITEM NO. 004	75 77 NO. OF ITEMS 001
-B ZONE BOM UPDATED.				CODE 405				TITLE C.E. OUTER BEARING CAP	CARD CODE	DRAWING NO. 2 439 44 37 001	SHEET NO. 01	NO. OF SHEETS 01	REV. 09
4				3									

SFS BPL SIZE A2