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- ## NOTES

1. EACH POCKET TO BE BUILT UP WITH FOUR LAMINATIONS PER LAYER.
2. ALTERNATELY AS PER ARRANGEMENT 'P' & 'O'.
3. CLAMP PLATES COE AND COE BOLT TO BE TIGHTENED 15 MINUTE BETWEEN EACH LAYER.
4. ALL WIRRES TO BE CUT AT 45°
5. ALL TEMPER SHEET TO BE CUT TO THE SHAPE OF THE ADDING TOLERANCE.
6. TOLERANCE ON LENGTH OF LAMINATIONS +10
7. LAMINATIONS TO BE FREE FROM BURS.
8. LAMINATIONS TO BE CUT WIDTH MAX DIMS. ALONG THE GRAINS.
9. FINISH THE SURFACES OF THE SHEETS OF THE T&E FOR COIL PACKING.
10. FINISH THE CORE WITH ITEM FOUR AFTER PILING CORE TO COIL PACKING POSITION.
11. IN POSITION INSTRUCTIONS SEE DEPT. STD. SHEET C600528 AND REFER NOTE 1. DRG. D627010 (METHOD-4).
12. CORE LAMINATIONS TO BE ANNEALED BUT UNWASHED.
13. THIS DRG. SHOULD BE READ IN CONNECTION WITH THE CR SHEETS.

1. SPECIFY THE QUANTITY AND DRG. NO. OF SEPARATOR ITEM 003 ON W.O.
2. SPECIFY WIDTH AND QUANTITY OF ITEM 002 CORE INSULATION ON W.O.
3. SPECIFY THE QUANTITY OF ITEM 001 CRGO STL. SHIT ON W.O.



CORE LAYING ARRANGEMENTS



ITEM NO MENTIONED IN ARRG'T 'P' & 'Q' CORRESPOND TO ITEM NO
IN COMPUTER PROGRAMME SHEETS.

STATUS OF DRAWING

NAME OF CUSTOMER/PROJECT

DISTRIBUTION OF PRINTS

0/C	PE	BAY 4.45	BAY 5
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1	2	2	2
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REV.	DATE	ALTERED Sig./
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1	9-1-77	CHECKED Sig- <i>t</i>
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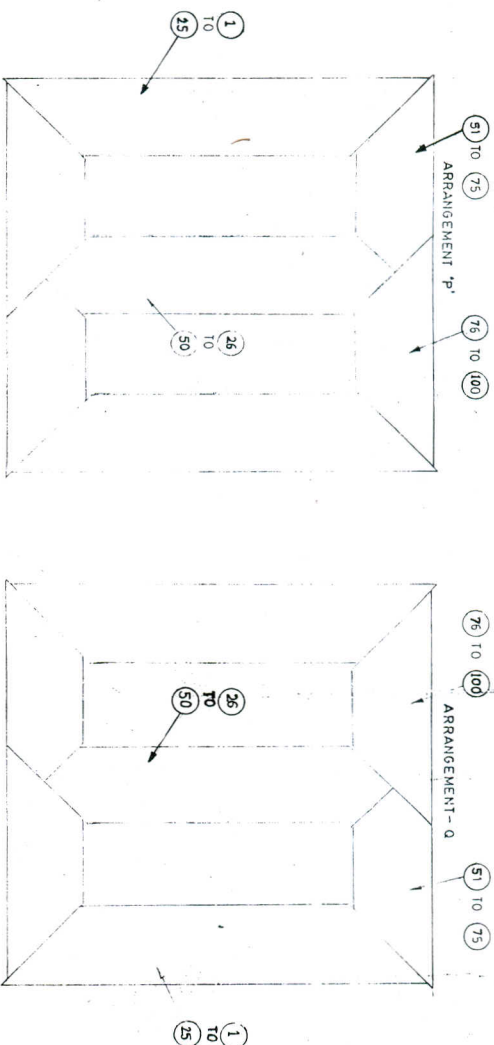
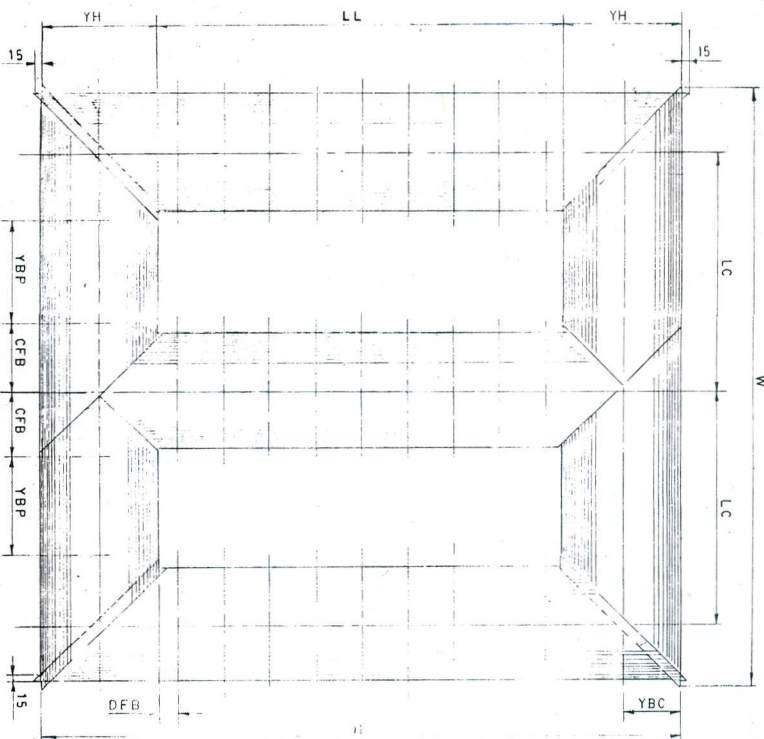
AT ZONE F-110 / ITEM N
WERE NOT SHOWN SHAPE

OF 175. 66 TO 75 AT D-2 & D-

AND A-3 WERE DIFFERENT

—

DATE	SCALE	WEIGHT (kg)	REF. TO ASBY. DIAG.	NAME	SIGN.	DATE
01/01/01	N.T.S.				-S.J.	
02/02/02					-S.J.	
03/03/03					-S.J.	
04/04/04					-S.J.	
05/05/05					-S.J.	
06/06/06					-S.J.	
07/07/07					-S.J.	
08/08/08					-S.J.	
09/09/09					-S.J.	
10/10/10					-S.J.	
11/11/11					-S.J.	
12/12/12					-S.J.	
13/13/13					-S.J.	
14/14/14					-S.J.	
15/15/15					-S.J.	
16/16/16					-S.J.	
17/17/17					-S.J.	
18/18/18					-S.J.	
19/19/19					-S.J.	
20/20/20					-S.J.	
21/21/21					-S.J.	
22/22/22					-S.J.	
23/23/23					-S.J.	
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25/25/25					-S.J.	
26/26/26					-S.J.	
27/27/27					-S.J.	
28/28/28					-S.J.	
29/29/29					-S.J.	
30/30/30					-S.J.	
31/31/31					-S.J.	
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72/72/72					-S.J.	
73/73/73					-S.J.	
74/74/74					-S.J.	
75/75/75					-S.J.	



CORE LAYING ARRANGEMENT
ITEM NO. MENTIONED IN ARRANGEMENT 'P' & Q CORRESPOND TO ITEM NO. IN COMPUTER PROGRAMME SHEET

NOTES TO SHOP

1. FOR GRADE AND HEIGHT OF CORE STEEL REFER CORE COMPUTER SHEETS/ASSIGNED Dwg No. 0.
2. LAMINATIONS TO BE CUT WITH MAX DIMENSIONS ALONG THE GRAIN.
3. FOR TOLERANCES AND BOND LEVEL ON LAMINATIONS REFER STANDARD SHEET TR 15035C.
4. ALL CORNERS TO BE BUILT UP WITH MITRE JOINT UNLESS SPECIFIED OTHERWISE AND MITRING TO BE AT 45°.
5. EACH PACKET TO BE BUILT UP WITH 2 OR 4 LAMINATIONS PER LAYER (AS CALLED ON Dwg) ALTERNATELY AS PER ARRANGEMENT 'P' AND 'Q'. PACKET DETAILS TO BE AS PER Dwg OR CORE COMPUTER SHEETS.
6. AND THE CORE WITH RESIN IMPREGATED FIBRE GLASS TAPE (TO SAJ25714) AFTER PUTTING CORE TO OIL PACKING IN POSITION. EACH BAND SHALL CONSIST OF 3 TURNS OF PLATE OR 4 TURNS OF 0.1% RESIN IMPREGATED FIBRE GLASS TAPE. FOR DETAILED INSTRUCTIONS REGARDING CORE LEG CLAMPING / TAPPING / DAMPING REFER STANDARD SHEET TR 15041C.
7. THIS DRAWING SHOULD BE READ WITH THE CORRESPONDING CORE COMPUTER SHEETS.
8. FOR ARRANGEMENT OF CERAMIC SPACERS ON CORE AND YOKE LAMINATIONS TO PROVIDE OIL DUCT, REFER Dwg NO 31997000085.
9. ASSEMBLED CORES ARE TO BE TESTED BETWEEN CORE AND YOKE STRUCTURE, CORE AND BOLTS, AND BOLTS AND CLAMPING STRUCTURE AT 2 KV TEST FOR ONE HOUR UNLESS OTHERWISE SPECIFIED.

NOTES TO DIMAN:

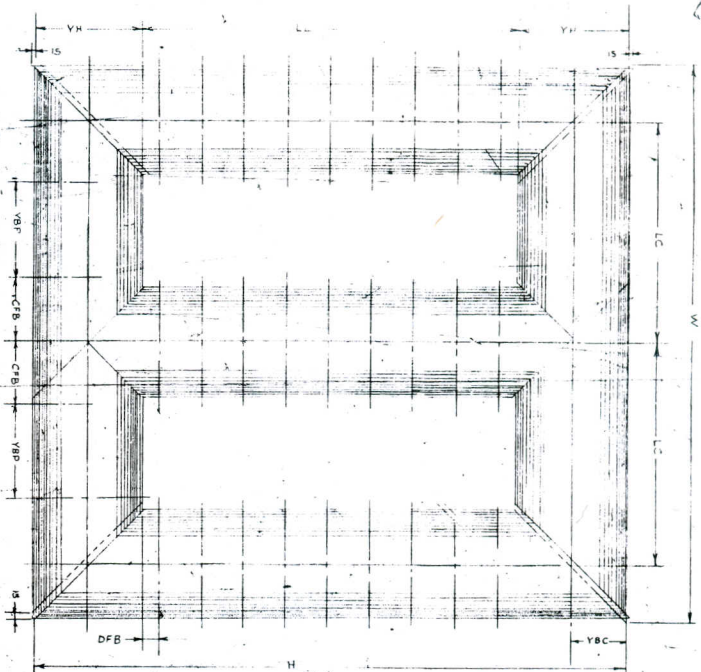
1. SPECIFY THE FOLLOWING ON ASST DRAWING/W/O:
 - (a) QUANTITY OF CERAMIC SPACER
 - (b) WEIGHT AND GRADE OF CORE STEEL
 - (c) 2 OR 4 LAMINATIONS PER LAYER
2. THIS DRAWING SUPERSEDES Dwg F 6130087.

REV	DATE	BY	CHKD	DESCRIPTION
1	15/01/2015	...	...	...
2	...	...	...	...

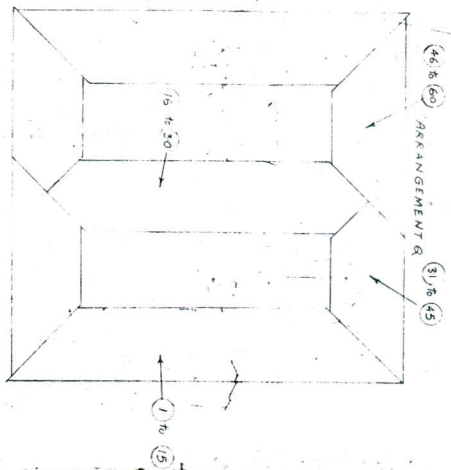
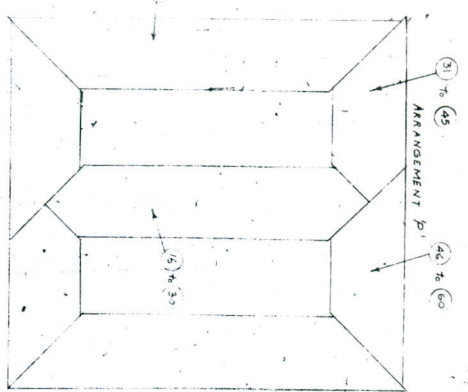
REVISIONS 1. 15/01/2015 2. ...		APPROVALS 1. ... 2. ...	
PROJECT INFORMATION PROJECT NO: ... DRAWING NO: ... SHEET NO: ...		CLIENT INFORMATION CLIENT NAME: ... PROJECT NAME: ...	
DESIGN INFORMATION DESIGNER: ... CHECKED: ... DATE: ...		MANUFACTURING INFORMATION MANUFACTURER: ... DATE: ...	

NOMENCLATURE

H : HEIGHT OF CORE
W : LENGTH OF CORE
LL : LEG LENGTH
LC : LEG CENTRE
YH : YOKE HEIGHT
YBC : YOKE BOLT CENTRE DISTANCE
YBP : YOKE BOLT PITCH
CFB : FIRST BOLT FROM CENTRE
DFB : DISTANCE OF FIRST BAND FROM BOTTOM



NO. 1001 - 147061	
H	HEIGHT OF CONE
W	WIDTH OF CONE
LL	LEAF LENGTH
LC	LEAF CIRCUMF.
W	WORM HEIGHT
WAL	WORM BOLT CIRCUMF. DISTANCE
WBL	WORM BOLT FITCH
CFS	FIRST BOLT FROM CROWN
DPS	DISTANCE OF FIRST BOLT FROM BOTTOM



CORE LAYING ARRANGEMENT.
Item No mentioned in Arg. 'P' & 'Q' correspond to item No in COMPUTER Programme sheet.

1. Each member to be built up with two laminations per layer.
2. Core to be tapered at 2 ft. intervals from outside between caps and clamp plates. Core and cap bolts.
3. All members to be cut at 45°.
4. For standard TR-50A and TR-15030C.
 - a. Laminations to be cut with maximum along the grain.
 - b. Laminations to be cut with maximum across the grain.
5. Each band shall consist of 4 turns of the tape for finishing of type.
6. Band the joints with 1/2" after applied core to seal packing in position.
7. Band the joints with 1/2" after applied TR-50A and TR-15030C.
8. Band the joints with 1/2" after applied TR-50A and TR-15030C.
9. For binding laminations to be applied TR-50A and TR-15030C.
10. Method B for cutting of above 1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, 42, 43, 44, 45, 46, 47, 48, 49, 50, 51, 52, 53, 54, 55, 56, 57, 58, 59, 60, 61, 62, 63, 64, 65, 66, 67, 68, 69, 70, 71, 72, 73, 74, 75, 76, 77, 78, 79, 80, 81, 82, 83, 84, 85, 86, 87, 88, 89, 90, 91, 92, 93, 94, 95, 96, 97, 98, 99, 100, 101, 102, 103, 104, 105, 106, 107, 108, 109, 110, 111, 112, 113, 114, 115, 116, 117, 118, 119, 120, 121, 122, 123, 124, 125, 126, 127, 128, 129, 130, 131, 132, 133, 134, 135, 136, 137, 138, 139, 140, 141, 142, 143, 144, 145, 146, 147, 148, 149, 150, 151, 152, 153, 154, 155, 156, 157, 158, 159, 160, 161, 162, 163, 164, 165, 166, 167, 168, 169, 170, 171, 172, 173, 174, 175, 176, 177, 178, 179, 180, 181, 182, 183, 184, 185, 186, 187, 188, 189, 190, 191, 192, 193, 194, 195, 196, 197, 198, 199, 200, 201, 202, 203, 204, 205, 206, 207, 208, 209, 210, 211, 212, 213, 214, 215, 216, 217, 218, 219, 220, 221, 222, 223, 224, 225, 226, 227, 228, 229, 230, 231, 232, 233, 234, 235, 236, 237, 238, 239, 240, 241, 242, 243, 244, 245, 246, 247, 248, 249, 250, 251, 252, 253, 254, 255, 256, 257, 258, 259, 260, 261, 262, 263, 264, 265, 266, 267, 268, 269, 270, 271, 272, 273, 274, 275, 276, 277, 278, 279, 280, 281, 282, 283, 284, 285, 286, 287, 288, 289, 290, 291, 292, 293, 294, 295, 296, 297, 298, 299, 300, 301, 302, 303, 304, 305, 306, 307, 308, 309, 310, 311, 312, 313, 314, 315, 316, 317, 318, 319, 320, 321, 322, 323, 324, 325, 326, 327, 328, 329, 330, 331, 332, 333, 334, 335, 336, 337, 338, 339, 340, 341, 342, 343, 344, 345, 346, 347, 348, 349, 350, 351, 352, 353, 354, 355, 356, 357, 358, 359, 360, 361, 362, 363, 364, 365, 366, 367, 368, 369, 370, 371, 372, 373, 374, 375, 376, 377, 378, 379, 380, 381, 382, 383, 384, 385, 386, 387, 388, 389, 390, 391, 392, 393, 394, 395, 396, 397, 398, 399, 400, 401, 402, 403, 404, 405, 406, 407, 408, 409, 410, 411, 412, 413, 414, 415, 416, 417, 418, 419, 420, 421, 422, 423, 424, 425, 426, 427, 428, 429, 430, 431, 432, 433, 434, 435, 436, 437, 438, 439, 440, 441, 442, 443, 444, 445, 446, 447, 448, 449, 450, 451, 452, 453, 454, 455, 456, 457, 458, 459, 460, 461, 462, 463, 464, 465, 466, 467, 468, 469, 470, 471, 472, 473, 474, 475, 476, 477, 478, 479, 480, 481, 482, 483, 484, 485, 486, 487, 488, 489, 490, 491, 492, 493, 494, 495, 496, 497, 498, 499, 500, 501, 502, 503, 504, 505, 506, 507, 508, 509, 510, 511, 512, 513, 514, 515, 516, 517, 518, 519, 520, 521, 522, 523, 524, 525, 526, 527, 528, 529, 530, 531, 532, 533, 534, 535, 536, 537, 538, 539, 540, 541, 542, 543, 544, 545, 546, 547, 548, 549, 550, 551, 552, 553, 554, 555, 556, 557, 558, 559, 560, 561, 562, 563, 564, 565, 566, 567, 568, 569, 570, 571, 572, 573, 574, 575, 576, 577, 578, 579, 580, 581, 582, 583, 584, 585, 586, 587, 588, 589, 590, 591, 592, 593, 594, 595, 596, 597, 598, 599, 600, 601, 602, 603, 604, 605, 606, 607, 608, 609, 610, 611, 612, 613, 614, 615, 616, 617, 618, 619, 620, 621, 622, 623, 624, 625, 626, 627, 628, 629, 630, 631, 632, 633, 634, 635, 636, 637, 638, 639, 640, 641, 642, 643, 644, 645, 646, 647, 648, 649, 650, 651, 652, 653, 654, 655, 656, 657, 658, 659, 660, 661, 662, 663, 664, 665, 666, 667, 668, 669, 670, 671, 672, 673, 674, 675, 676, 677, 678, 679, 680, 681, 682, 683, 684, 685, 686, 687, 688, 689, 690, 691, 692, 693, 694, 695, 696, 697, 698, 699, 700, 701, 702, 703, 704, 705, 706, 707, 708, 709, 710, 711, 712, 713, 714, 715, 716, 717, 718, 719, 720, 721, 722, 723, 724, 725, 726, 727, 728, 729, 730, 731, 732, 733, 734, 735, 736, 737, 738, 739, 740, 741, 742, 743, 744, 745, 746, 747, 748, 749, 750, 751, 752, 753, 754, 755, 756, 757, 758, 759, 760, 761, 762, 763, 764, 765, 766, 767, 768, 769, 770, 771, 772, 773, 774, 775, 776, 777, 778, 779, 780, 781, 782, 7

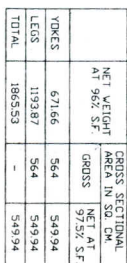
BILL OF MATERIAL			QTY	UNIT
CON. ITEM NO.	DESCRIPTION	REQ. ON ORDER	COMPOUND OR AS SUP.	ALTERN. STYLE
1	6.00, steel 2.5" x 2"	46395	1005316	1005316
2	Key-plate 2.5" x 3"	46395	1005316	1005316

	DATE	09-1-87	DATE	25-3-8
CDD	CDD	01	CDD	SCH.
APPO	APPO	19/04/87	APPO	

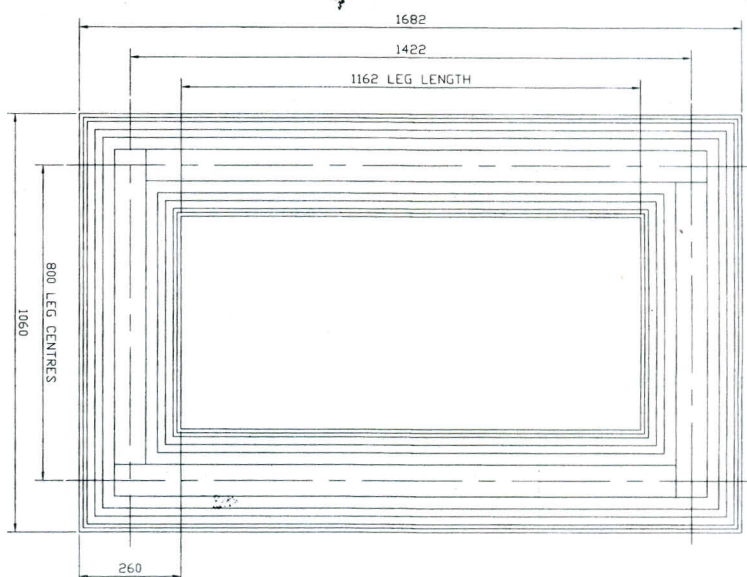
NOTE - 4 MODIFIED

AGAINST NOTE 7 & 9
SIC NO WAS C60058R

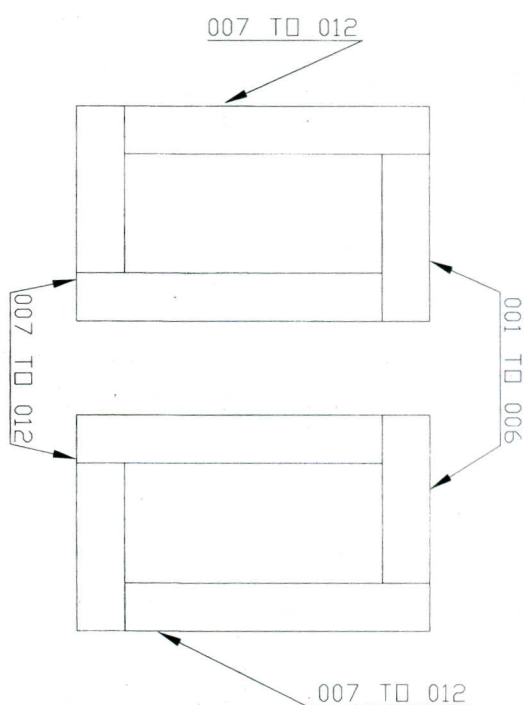
REVISIONS		DRAWING CODE			
DATE	REVISION	PROJECT CODE	ACCOUNT CODE	DRAWING CODE	
02.04.2017	1			THREE LIMB NON SHEAR	
02.04.2017	2			MITRE CORE CONFIGURATION	
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YDKE PUNCHINGS						
ITEM NO.	STACK HEIGHT AT 57.5% ΔF	A	B	WEIGHT IN KG.		
001	56.4	180	800	805	24.66	
002	54.8	192	800	140	46.06	
003	82.4	208	800	180	88.83	
004	59.2	204	800	280	76.91	
005	79.6	276	800	240	113.50	
006	237.6	722	800	240	321.68	
TOTAL WT.					671.66	



LEG PUNCHINGS					
ITEM NO.	STACK AT 73.25°	ADOF, LAM IN DEG.	A	B	WEIGHT IN KG.
007	50.4	180	1422	80	4386
008	54.8	192	1422	140	6187
009	86.4	288	1422	180	15790
010	59.2	204	1422	220	13670
011	79.6	276	1422	240	20176
012	207.6	722	1422	260	57178
TOTAL V.I.					119347



ARRANGEMENT 'Q'

1. ALL PUNCHES TO BE CUT KEEPING LONGER DIMENSION ALONG GRAINS.
2. TOLERANCE ON LENGTH OF LAMINATIONS IS ± 0.1 .
3. TOLERANCE ON WIDTH OF LAMINATIONS PER LAYER ARRANGED TO BE BUILT UP TO 1/8" IS ± 0.005 .
4. INDIVIDUAL TIE WEIGHTS & NO. OF LAMINATIONS ARE BASED ON 92.5% S.F. AND 7.65 SPEC. DENSITY.
5. TOLERANCE ON SPACING OF LAMINATIONS OF BOTH LEGS AND BOTTOM TIE WEIGHTS ARE BASED ON EPI-LUX-VANISH TYP. TIE ELDE TO BE VERIFIED AFTER COIL ASSY.
6. REFER TR-10303 FOR TOLERANCES.
7. MAX. PERMISSIBLE BURR LEVEL IS 50 MICRONS.

TOTAL CRGD STL. REQD. = 1920 Kg.
(THIS INCLUDES 3% EXTRA OVER NET WEIGHT AT 97.5% S.F.)

[illegible]

ADDITIONAL INFORMATION			
W.D. 0497A03001			
STATUS OF DRAWING			
DISTRIBUTION OF PRINTS			
TRE	TRP	BAY	BAY
		3,4&5	9
1	1	2	4
REV	DATE	ALTERED	BY
01	9/11/99	CHECKED	DATE

TYPE OF PRODUCT		6531 KVA FRI. LOCO. TRFR.	
DR			
NAME OF CUSTOMER/PROJECT		M/S : CLW	
ADDRESS		SHARATI HEAVY ELECTRICALS LIMITED	
CITY		JHANSI	
SERIAL NO. DATE OF ORDER ORDER NO. INVOICE NO.	SCALE 1:1 & N.T.S.	WEIGHT (KG) REF TO ASSY DRG.	NAME RAJESH K KUMAR DESIGNED BY DATE 20/06/98 10:35 AM
TITLE CORE & YOKE DETAILS		TRAILING NO 14664450014 NO. OF SHEETS 01	

