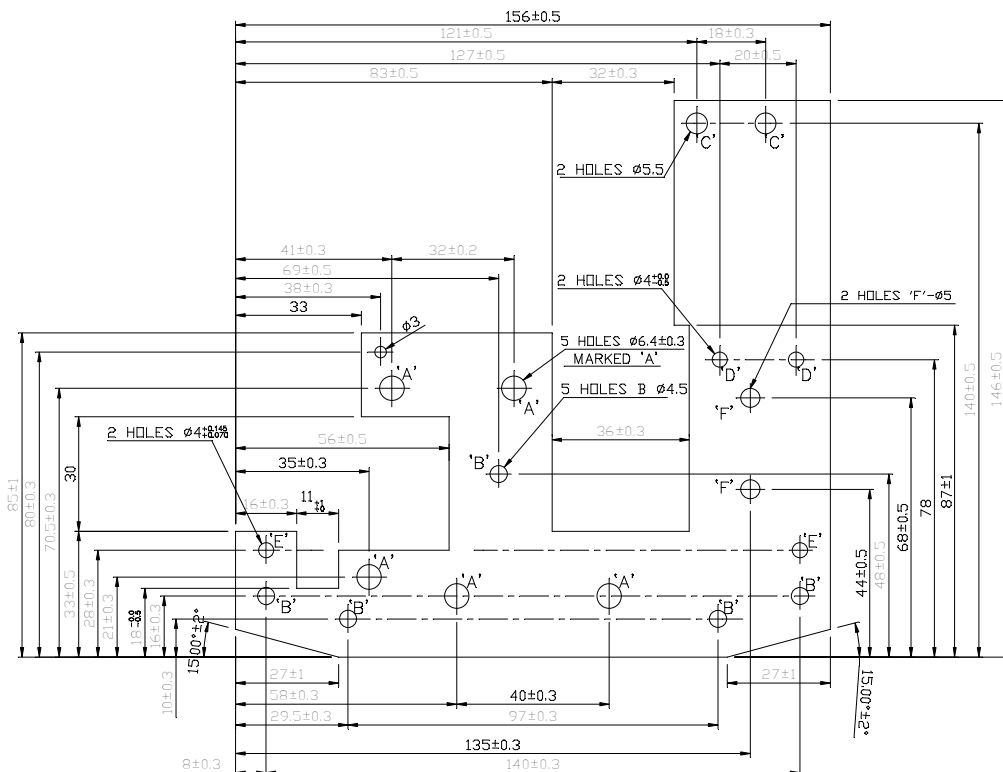
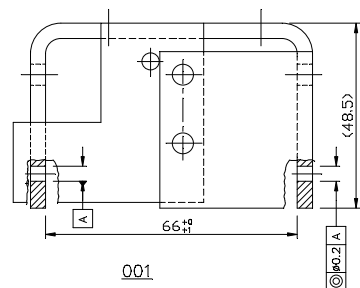
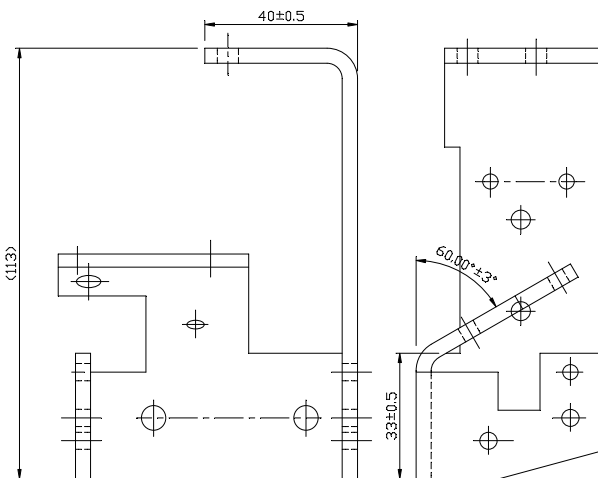


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INVENTORY NO.	SIGN. & DATE	REF. DRG. NO.
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17257/2024/HEP-SWM20900



DEVELOPED VIEW OF IT.001

NOTES: —

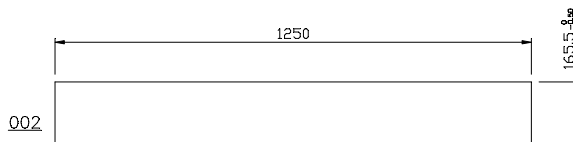
IT. 001 WILL BE MADE 6. NOS. FROM IT. 002.

FINISH: –

ZINC PLATE AND PASSIVATE TO PROCESS SPEC. AA 0673603.
& AA 0673604 (0.013 TO 0.015 Tk.)



BENDING RADIUS = 4 ± 0.5
UNSPECIFIED RADIUS = 1.5 TO 2 mm.

TOOL LIST		
ITEM	TOOL	DESCRIPTION
—	1492673	BENDING TOOL
—	1498837	PIERCING AND BLANKING TOOL
—	1498850	DRILL JIG
—	1564214	PRESS TOOL
—	1564225	SNAP GAUGE
—	—	—



VIEW OF STRIP FOR PUNCHING

	SEE NOTE		002	4 Tk.x165.5x1250 Lg. H.R.P.S SHEET		-		BP 1011798042			KG.	6.49		
								BP 10198				001		
	BP9099436190		001	BRACKET		2 521 10 01505					KG.	6.5		
							002					001		
VAR 00	REMARKS	VAR NO	ITEM NO	DESCRIPTION	STD	DRAWING NO.	IT.NO.	MATL CODE		UNIT		UNIT WT		
							VAR	MATL SPCN				QTY.		CS ZONE

ADDITIONAL INFORMATION			TYPE OF PRODUCT OR NAME OF CUSTOMER / PROJECT		V.C.B.					
STATUS OF DRAWING B										
DISTRIBUTION OF PRINTS □/C -1 SWM -3 TCX -1			 BHARAT HEAVY ELECTRICALS LTD. BHOPAL		DRN. CKD.	NAME BDV -	SIGN Sd/- -	DATE 3.9.82 -	NO. OF VAR -	
					APPD.	RKG	DRG/-	9.9.82	-	
REV.	DATE	ALTERED Sd/- CHECKED Sd/- APPROVED Sd/-	DEPT SWE CODE 409	UNTL. DIMS. GR. M		SCALE 1:1	WEIGHT (K.G.)	REF. TO ASSY. DRG. 3 521 10 01 556	ITEM NO 024	NO. OF ITEM 002
ZONE	IT. 002 & NOTE ADDED. IT.001 BRACKET TO DRG. 25211001505-02 WAS MATL. SIZE 414x146x156 H.R.P.S. SHEET. (DCA : 09426)		TITLE BRACKET				DRAWING NO. 2 521 10 01505		REV 15	
							SHEET NO. 01		NO. OF SHEETS 01	

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TOOL LIST

1492725	BLANKING & PIERCING TOOL (FOR 300/500T PRESS)
1492726	BENDING TOOL
1492729	MANDRILL
1492655	16E9 REAMER
1492656	16E9 OLUG GAUGE
1498734	10C11 REAMER
1498735	10C11 PLUG GAUGE
1498752	HOLDING FIXTURE FOR CNC
1498857	HARDENED BLOCK FOR 31 DIMENSION
1498866	CHECKING TAMPLATE
1564104	DRILL JIG
1564105	MILLING FIXTURE
1564106	UNIVERSAL BASE PLATE
1564213	PRESS TOOL
1564223	SNAP GAUGE
BENDING RADIUS = 10±0.3	

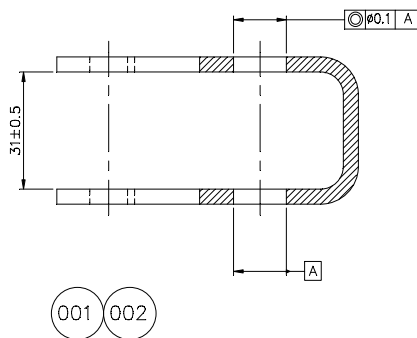
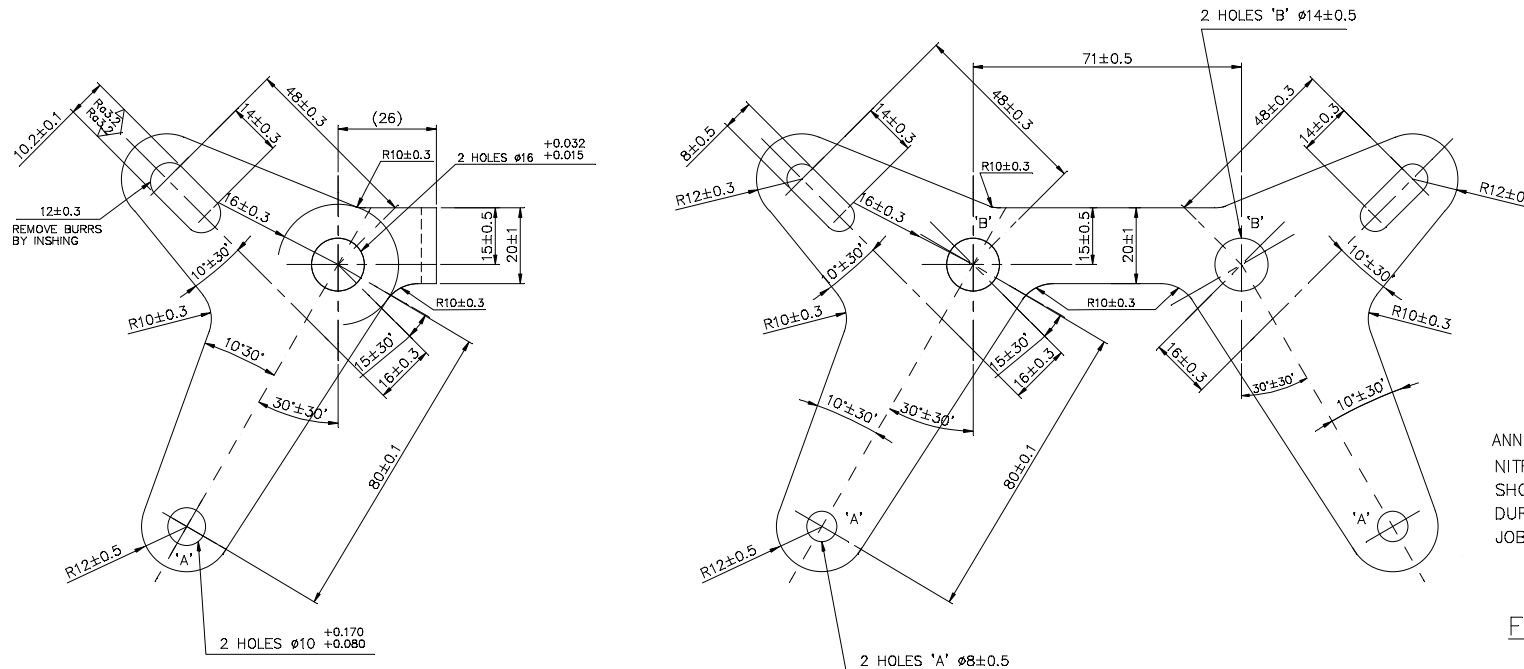
NOTES :-

ANNEAL IN NITROGEN GAS AFTER BENDING AS PER SPEC. 7104.
NITROGEN SUPPLY SHOULD BE INTRODUCED AT 400°C AND
SHOULD BE MAINTAINED DURING HEATING SOAKING AND
DURING COOLING, NITROGEN TO BE DISCONNECTED WHEN
JOB COOLED TO 400°C.

FINISH :-

FOR IT. 001-NITRIDE AS PER TF-2 SG 15001.

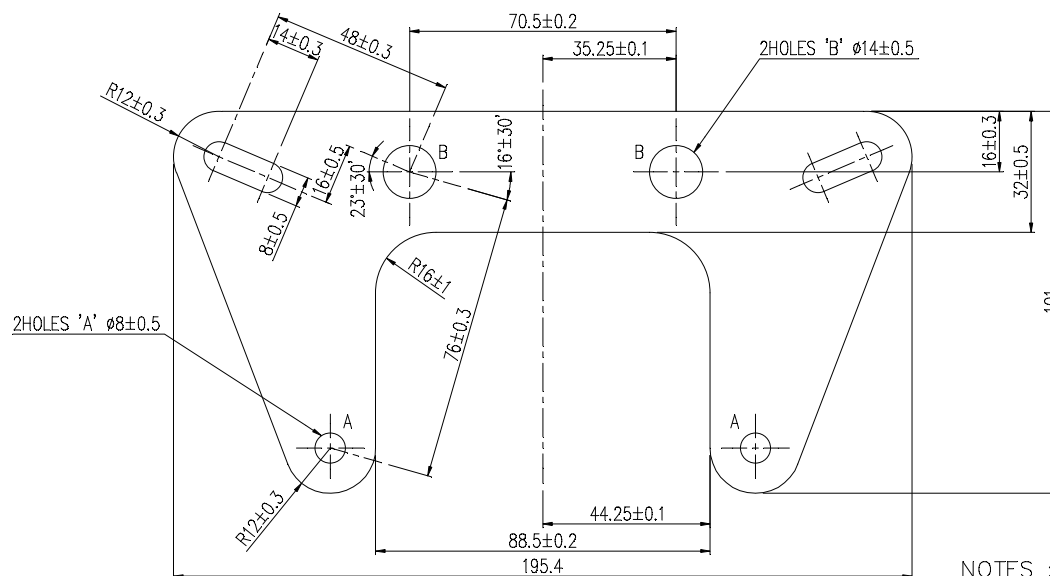
DEVELOPED VIEW OF IT. 002



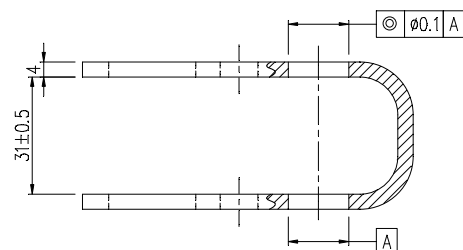
VIEW OF STRIP FOR PUNCHING

ST 943430	002	4R X 8L3X482 LG HRCS	AA1011713160	0.3783	001
ST 943086	001	LEVER	25211001510	0.381	001
VAR00	REMARKS	VAR NO. ITEM NO.	DESCRIPTION	STD	DRAWING NO.
65	75	78 79 25 27	29	58 59 60	77 29 31 34
38	33	46	54	68	71
28	CARD TYPE-3		28	CARD TYPE-1	
28	CARD TYPE-3		28	CARD TYPE-2	
ADDITIONAL INFORMATION					
mRikn dk l-dkj ;k xk-gd@fjkstuk dk uke TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT					
STATUS OF DRAWING B					
DISTRIBUTION OF PRINTS					
O.COPY-----1 SWM-----3 TCX-----1					
HAKjy gsoh bysfDV&dYl fyfeVsM HAKsiky BHARAT HEAVY ELECTRICALS LTD. BHOPAL					
uqe@NAME lglrk_@IGNlmuak@DATEosfj_ ch B.D.V. Sd/- 31.8.82 lql;k R.J.G. Sd/- 26.9.82 lql;k VAR. NO. OF ITEM NO. OF ITEM NO. OF					
fahAkx w_Vky_ukl dh js.kh DEPT SWE UNTOL. DIMS. GR. vuqlkr 3-250-00-1-01404 SCALE 1:1 HAKg fd_@ REF. TO ASSY. DRG. 35211001533 M&kbZax d_@BROWNG NO. 2 521 10 01510 lq_@REV. 11 lq_@REV. 11					
DRG. REDRAWN (DCA NO. 21432)					
FINISH FOR IT. 001 WAS PARKERISE TO PR.S. 7609. (DCA NO 09115)					
LEVER					
2 521 10 01510					
lq_@REV. 11					
lq_@REV. 11					

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DEVELOPED VIEW OF IT. 002



TOOL LIST

- | | |
|--------------------|---|
| 1492747 | BLANKING & PIERCING TOOL
(FOR 300/500T PRESS) |
| 1492748 | BENDING TOOL |
| 1492749 | DRILL JIG |
| 1498750 | MILLING FIXTURE |
| 1492751 | MANDRILL |
| 1492655 | 6E9 REAMER |
| 1492656 | 6E9 PLUG GAUGE |
| 1498734 | 10C11 REAMER |
| 1498735 | 10C11 PLUG GAUGE |
| 1498753 | HOLDING FIXTURE FOR CNC |
| 1498857 | HARDENED BLOCK FOR 31 DIMENSION |
| 1564109 | DRILL JIG |
| 1564110 | MILLING FIXTURE |
| 1564106 | UNIVERSAL BASE PLATE (FOR KEY WAY
MILLING M/C) |

NOTES :-

1. FOR IT.001-NITRIDE AS PER TF-2 SG15001.
2. BENDING RADIUS = 10±0.3MM.
3. ANNEL IN NITROGEN GAS AFTER BENDING AS PER SPEC. BP 0640299
NITROGEN SUPPLY SHOULD BE INTRODUCED AT 400° C AND SHOULD
BE MAINTAINED DURING HEATING SOAKING & DURING COOLING.
4. NITROGEN SUPPLY SHOULD BE INTRODUCED WHEN
JOW COOLED TO 400°C.

FINISH :-



Mn PHOSPHATING TO PR.S. AA 0673616 FOR IT. 001.

[illegible]

28 → CARD TYPE-3

28	→ CARD TYPE-1
----	---------------

VAR.	
28 →	CARD TYPE-2

ADDITIONAL INFORMATION			TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT			V.C.B.					
STATUS OF DRAWING M			 BHARAT HEAVY ELECTRICALS LTD BHOPAL			DRN	NAME	SIGN	DATE	No. of VAR.	
DISTRIBUTION OF PRINTS						CKD	B.D.V.	Sd/-	1.9.82		
O/C - 1			APPD	R.J.G.	Sd/-	26.9.82					
SWM - 3											
TCX - 1											
REV.	DATE	ALTERED CHECKED APPD.	DEPT.	SWE	UNTOL. DIMS. GR.		SCALE	WEIGHT(K.G.)	REF. TO ASSY.DRG.	ITEM NO.	NO. OF ITEMS
06	16.11.04	RM	CODE	409	AA20.30208		1:1	—	35211001533	019	002
ZONE	DRG. REDRAWN		TITLE					DRAWING NO.			REV.
	(DCA NO 21093)		LEVER					2 521 10 01518			08
								SHT. NO. 01		NO. OF SHT. 01	