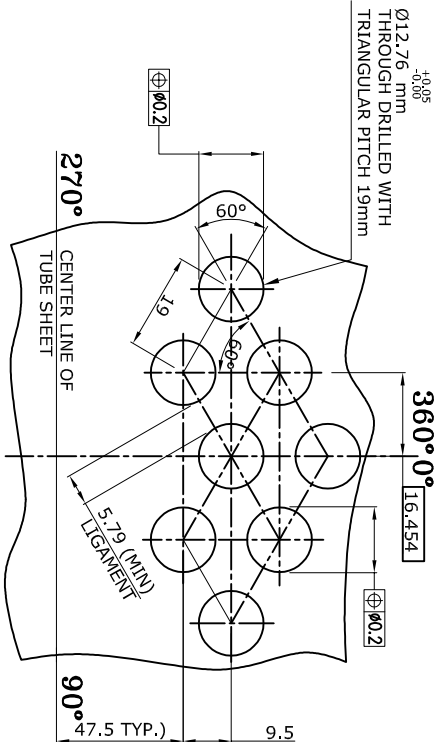
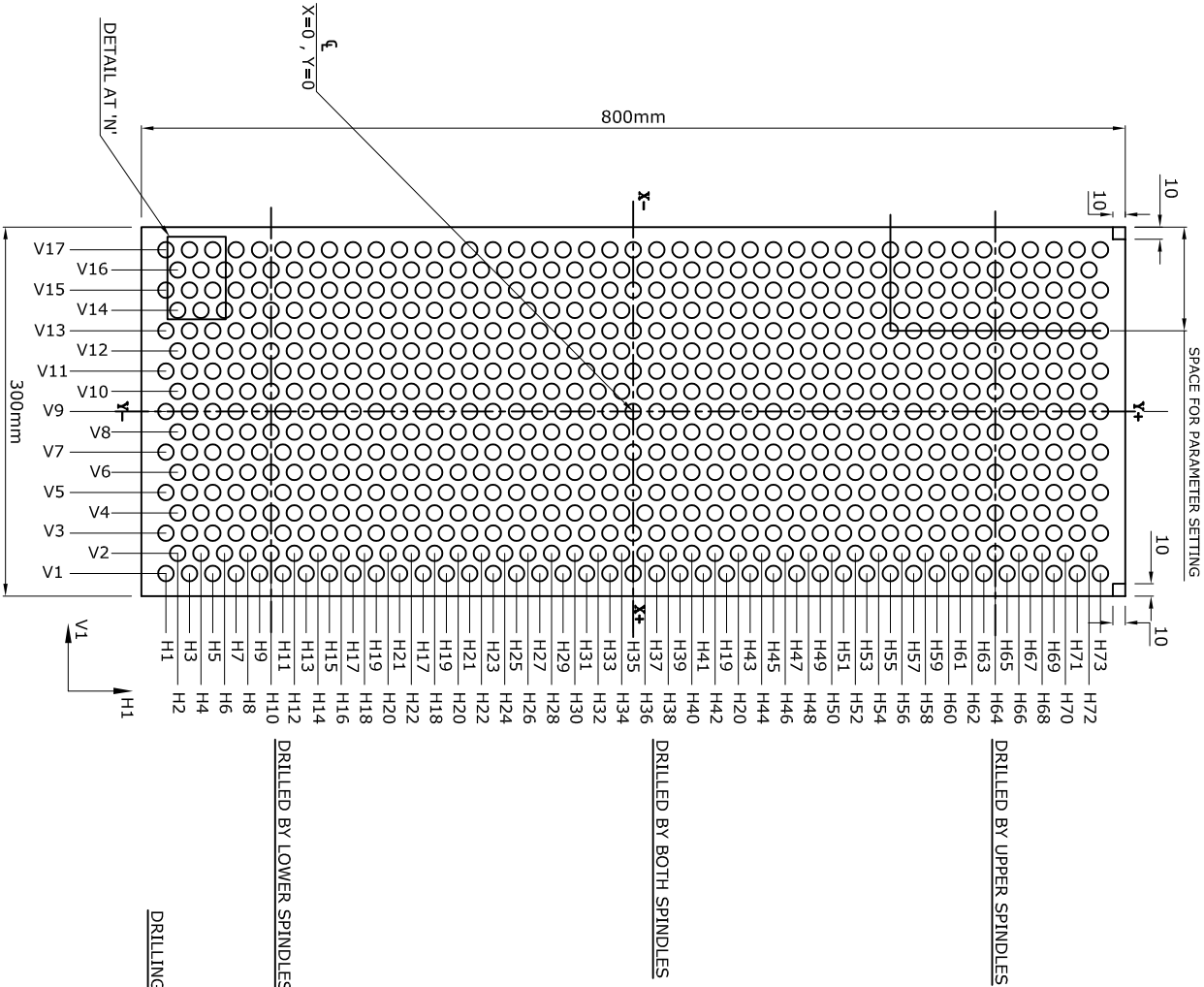


DETAILS OF QUALIFICATION BLOCK FOR TUBE SHEET DRILLING

SKETCH-1



DETAILS AT 'N'

ALL DIMENSION REQUIREMENT ARE AS PER APPROVED JOB

DRAWING 1-16503-40825 SHEET NO. 02

NOTE:-

1. BLOCK DIMENSION 800x300x150 TK.
2. NO. OF HOLES 611

ACCEPTANCE CRITERIA

1. DRILL DRIFT = 0.10 MAX
2. POSITIONAL ACCURACY = $\varnothing 0.2$
3. HOLE SIZE = $\varnothing 12.76^{+0.05}_{-0.05}$
4. SURFACE FLATNESS SHALL BE WITHIN 0.2 MM.
5. PARALLELISM OF ENTIRE BLOCK SHALL BE WITHIN 0.1 MM.
6. SURFACE FINISH IN SIDE HOLE $\sqrt{16}$

