

1000874637E ON INWARD/ 1235

TOOL LIST			
IT. NO.	TOOL NO.	DESCRIPTION	
001	1574589	VICE JAW	

GAUGE LIST				
LIMIT	NOMINAL SIZE	TOOL NO.	IT. NO.	TYPE
2.20 +0.1 -0.1		1574442	001	SLITTING CUTTER
1.20 -0.		1574443	002	SLITTING CUTTER

2.2±0.1

+0.013

5.08-0.029

46.5

38

4.906±0.020

2.13 ±0.020

1.2-0

1.2+0.1

9

9

1.955

22 +0.0
-0.2

107.5

90

35

7

155 ±0.8

EDGES TO BE SAWN & DEBURRED.

TO BE DEBURRED

ø20(CIRCUMFERENCIAL EDGES)

NOTES:-

1. SLITTING NOT TO BE DONE BY BLANK SUPPLIER.

2. TOLERANCE ON COMMUTATOR BARS TO BE TO BS 1434 UNLESS STATED OTHERWISE.

3. CONVEXITY / CONCAVITY TO BE WITHIN 0.020MM AS PER BS 1434 (CLAUSE 66).

4. REMOVE SHARP CORNERS.

5. DEPARTURE ANGLE TO BE WITHINE 0.0/0.020MM AS PER BS 1434 (CLAUSE 6.5).

6. NO. OF BARS PER COMMUTATOR 216.

REV

DATE

ALTERED

CHECKED

APPROVED

REV

DATE

ALTERED

CHECKED

APPROVED

06

05.12.12

WT. 0.28 KG. WAS NOT ON.
DRG. UPLOADED.

REF. DRG. NO.

SIGN. & DATE

INVENTORY No.

ADDITIONAL INFORMATION

STATUS OF DRAWING

DISTRIBUTION OF PRINTS

TME-1

TXM-3

TNX-1

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT

25 KV BG AC EMU 1400HP DEMU

TM 4303 BY,DY

73

74

DRN.

NAME

SIGN.

DATE

73

74

SKG

Sd/-

25.05.99

73

74

DK

Sd/-

25.05.99

73

74

APPD.

IMV/AKD

Sd/-

25.05.99

73

74

REF. TO ASSY.

24394280001

ITEM NO.

001

NO. OF

ITEM

001

DEPT.

TME

GRADE OF UN. TOL

DIM.φ/M/Y

SCALE

NTS

WEIGHT (K.G.)

0.28

REV.

DATE

ALTERED

CHECKED

APPROVED

405

05

09.07.09

DRG. UPDATED & DIGITIZED.

DRG. NO.

34394280001

REV.

06

VAR. 00

REMARKS

VAR NO.

ITEM NO.

DESCRIPTION

IS

DRAWING NO.

IT. NO.

MATL. CODE.

MATL. SPCN.

QTY.

59

64

65

75

78

79

25

27

29

58

59

60

77

29

31

34

45

55

56

57

58

65

72

RAW WT.

0.315KG.

001

COMMUTATOR BAR

TRAPEZOIDAL SILVER

BRG COPPER BAR

BP 12075

45

55

56

57

58

65

72

VAR.

00

REMARKS

VAR NO.

ITEM NO.

DESCRIPTION

IS

DRAWING NO.

IT. NO.

MATL. CODE.

MATL. SPCN.

QTY.

59

64

65

75

78

79

25

27

29

58

59

60

77

29

31

34

45

55

56

57

58

65

72

VAR.

00

REMARKS

VAR NO.

ITEM NO.

DESCRIPTION

IS

DRAWING NO.

IT. NO.

MATL. CODE.

MATL. SPCN.

QTY.

59

64

65

75

78

79

25

27

29

58

59

60

77

29

31

34

45

55

56

57

58

65

72

VAR.

00

REMARKS

VAR NO.

ITEM NO.

DESCRIPTION

IS

DRAWING NO.

IT. NO.

MATL. CODE.

MATL. SPCN.

QTY.