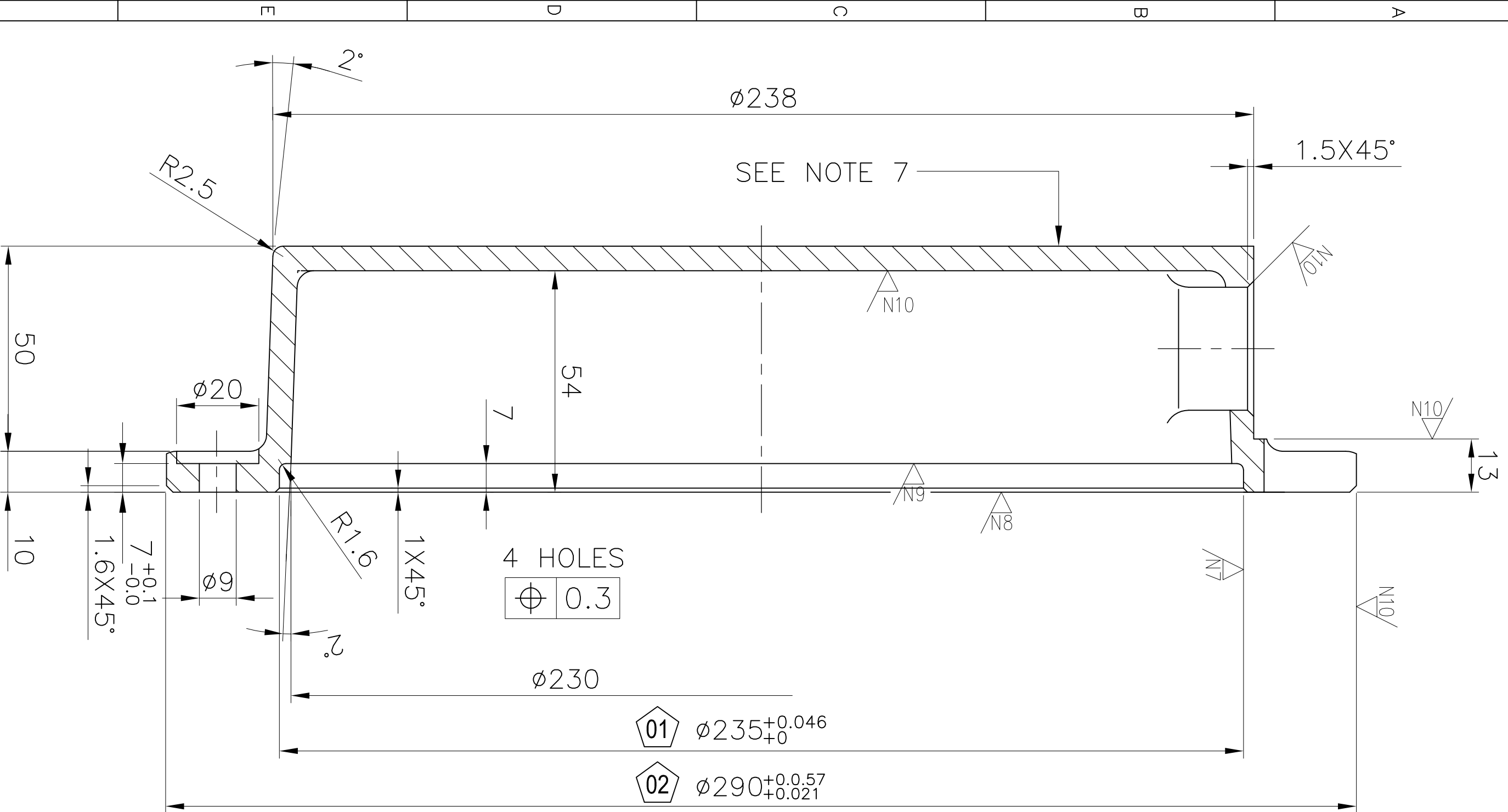


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SECTION A-A

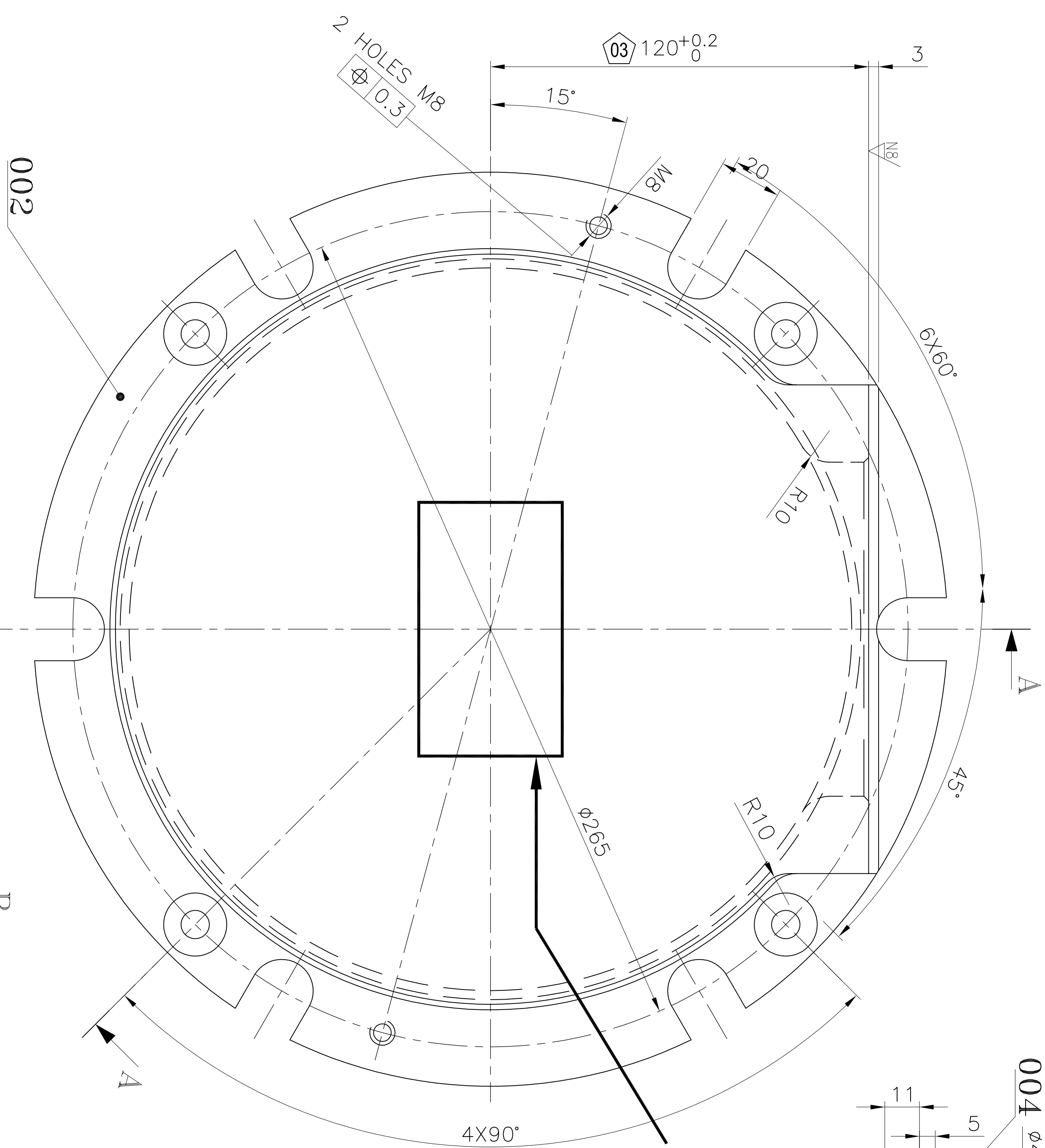
GAUGE LIST				
LIMIT	NOM.	SIZE	TOOL NO.	IT.NO. SYM
120+0.2/+0	—		1578008	001 BAR
290+0.052/+0.020	—		1578009	001 BAR
290+0.057/+0.021	—		1605054	001 SNAP

GENERAL TOLERANCE FOR LINEAR AND ANGULAR MEASUREMENTS ACCORDING TO ISO-2768

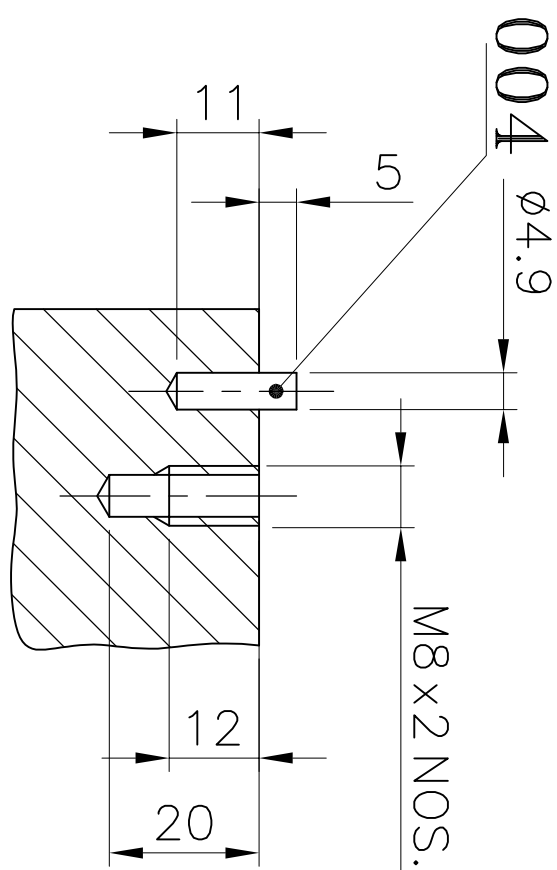
[illegible]

DEVIATION OF MEDIUM GRADE	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2
								±3
								±4
								±5
								±6

REV.	DATE	ALTERED	SDB	REV.	DATE	ALTERED	SDB	REV.	DATE	ALTERED	SDB
09	24.05.17	CHECKED AS	<i>W</i>	08	22.05.17	CHECKED AS	<i>W</i>	07	04.05.17	CHECKED AS	<i>W</i>
IN TOOL LIST, TOOL NO. 1605064 ADDED.				IN SECTION-AA DIM. 7+5.0 ADDED (E/2).				EMBOSSED LOCATION			
(TCM-350)				NOTE-7 MODIFIED & NOTES-11 TO 13 ADDED.				RAW WT. 15KG. WAS 40.49.			



SECTION B-B



	GEOMETRICAL TOLERANCE	20%
002	REMAINING DIMS.	5%

NOTES:—

1. MATERIAL: CARBON STEEL CASTING IS: 1030-89:
Gr. 230-450WE 4TM/096-059.
2. 1) C.E.D. NO. FOR 6FRA-6068-5780/059 5780/079
1) C.E.D. NO. FOR 6FRA-7059-5870/101
3. REMOVE ALL SHARP EDGES.
4. METALLURGICAL TESTS TO BE CARRIED OUT
5. MATERIAL: SPHEROIDAL GRAPHITE CAST IRON (SGGI) TO-
DN-1693 PART-1 GR.666/40 OR GR-400/48 OF-
IS-1865-1991(LATEST VERSION) TO SPECIFICATION NO. TM11491-
ALL 7 NOS. "◇" MARKED DIMENSION ARE CRITICAL TO QUALITY
(CTQ) & SL. NO. OF CTQ DIMENSION ARE INSCRIBED IN ◇ e.g. 107
6. EMBOSSING & PUNCHING TO BE DONE AT THE SHOWN LOCATION
BY CASTING SUPPLIER. SIZE OF EMBOSSING/PUNCHING TO BE
5-20mm. EMBOSSING & PUNCHING SHOULD NOT BE MACHINED/
DAMAGED DURING MACHINING AND SHALL BE RETAINED.
8. SURFACE FINISH OF UNMACHINED CASTED SURFACE TO BE AS
PER IS3073 (IN CASE MACHINING ALL OVER IS NOT MENTIONED
OR SOME SURFACES ARE NOT INDICATED FOR MACHINING BY
SYMBOL.)
9. MACHINING ALLOWANCE ON EACH TOOL POINT TO BE 5-7 MM IN
CASE CASTING IS SUPPLIED OR 3-5 MM IN CASE ROUGH
MACHINED CASTING IS SUPPLIED.
10. FOR QUALITY REQUIREMENT OF COMPONENT SPECIFICATION
TM12545 TO BE REFERRED.
1. QAP FOR CASTING TO BE AS PER QTM/QAP/VENDOR/13-14/001
(LATEST REV.).
2. ADDITIONAL MATERIAL SHALL NOT BE PROVIDED ON SURFACES
WHERE MACHINING SYMBOL IS NOT INDICATED. TOLERANCES ON
UNTOLERATED CASTING SURFACES SHALL BE AS PER IS:4897, CLASS-2
3. DIMENSIONS TO BE CHECKED ON SAMPLE BASIS. QUANTUM OF
INSPECTION SHALL BE AS GIVEN BELOW (AT LEAST ONE NUMBER).

CONTD.

TOOL LIST		
IT.NO.	TOOL NO.	DESCRIPTION
001	1578006	DRILL JIG FOR 4 HOLES
001	1578007	HOLDING FIXTURE WITH REFERENCE BLOCK
001	1578010	LENGTH GAUGE 54MM
001	1578005	DRILL JIG FOR ALL THE 6 HOLES ON FACE
001	1605064	OFFSET PIN GAUGE 235 +0.046/0

CONTD.

CHECKING PARAMETER		BHEL Q.C.
001	CTQ DIMS.	20%
	DIMENSIONAL TOLERANCE	20%
	GEOMETRICAL TOLERANCE	20%
002	REMAINING DIMS.	5%

[illegible]