

THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED.
IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY
WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

FIRST ANGLE PROJECTION

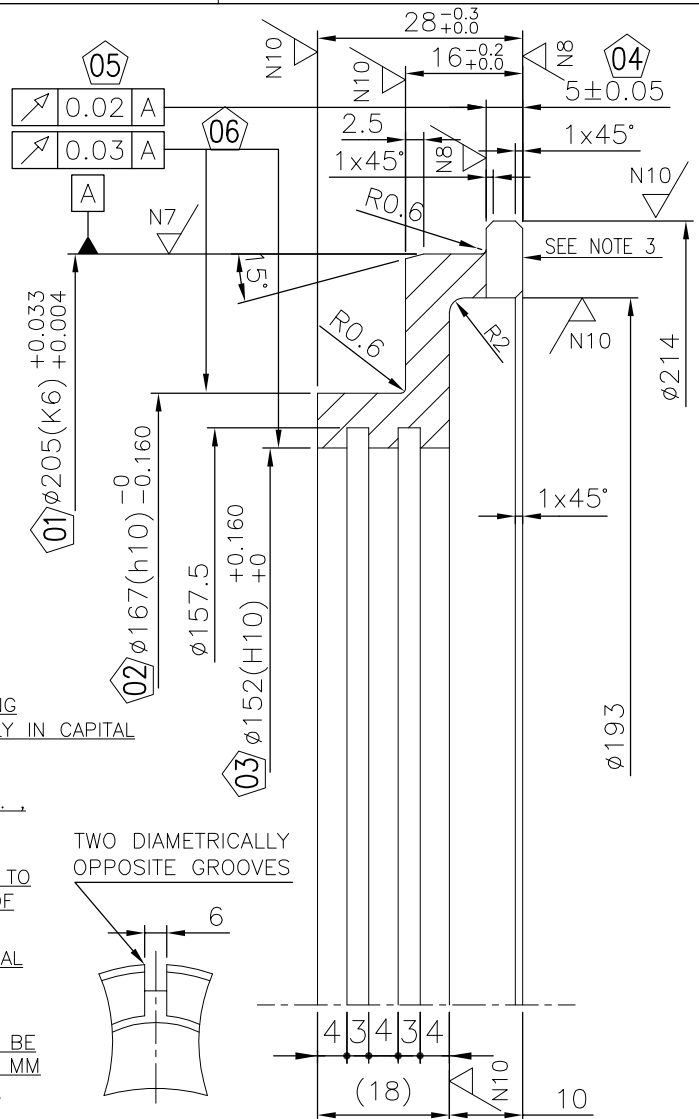
(ALL DIMENSIONS ARE IN mm)

REV.	DATE	ALT.	SDB	REV.	DATE	ALTERED	ADDITIONAL INFORMATION
07	08.01.18	CHK. ABHIJIT	APPD. ABHIJIT	06	29.06.13	CHECKED	4TWD.097.037, (ALT.02)
ZONE	DIMS. 28 ^{+0.3} ₋₀ , 16 ^{+0.2} ₋₀ & Ø214 WERE 28, 16 & Ø215.			ZONE	CRITICAL TO QUALITY DIMNS. ARE MARKED '◇' AND NUMBERED. LOCATION OF IDENTIFICATION SHOWN. NOTE 3 AMMENDED, NOTE 5 & 6 ADDED.		STATUS OF DRAWING
							DISTRIBUTION TME-1, TXM-3 OF PRINTS TNX-1

TOOL LIST	
TOOL NO.	DESCRIPTION
1578361	SNAP GAUGE 205(K6) ^{+0.033} _{+0.004}
1578523	SNAP GAUGE 167(h10) ⁻⁰ _{-0.160}
1578524	PIN GAUGE 152(h10) ^{+0.160} ₊₀
1578519	CAL. GAUGE 5±0.05
1578520	GROOVE GAUGE 3x2.75 DEEP
1578579	SNAP GAUGE 28-0.3/0
1578580	SNAP GAUGE 16-0.2/0

NOTES:-

- REMOVE ALL SHARP EDGES.
- GENERAL TOLERANCE±0.2 WHERE NOT SPECIFIED.
- COMPONENT SHALL BE ETCHED (BY PENCIL ETCHING M/C) AT SHOWN LOCATION, LEGIBLY AND INDELIBLY IN CAPITAL LETTERS WITH FOLLOWING DETAILS:-
 - MANUFACTURER'S INITIALS OR TRADEMARKS.
 - MANUFACTURER'S UNIQUE SL. NO., BHEL P.O. NO., BATCH NO./ HEAT NO., DATE OF MANUFACTURING IN MM-YY FORMAT.
- MATERIAL SPHEROIDALE GRAPHITE CAST IRON(SGCI) TO DIN 1693 PART-1, GR-GGG/40 OR GR-400/18 OF IS:1865-1991(LATEST VERSION)
- ALL 6 NOS. "◇" MARKED DIMENSIONS ARE CRITICAL TO QUALITY (CTQ) & SL. NO. OF CTQ DIMENSIONS ARE INSCRIBED IN ◇ e.g. ◇.
- 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.



	RAW WT. 6.10 KG.		001	INNER LABYRINTH DE (MACHD)							Kg.	1.25			
									TM-11491						
59	64	65	75	25	27	29	58	59	34	45	55	56	58	65	
VAR00		REMARKS		ITEM NO.		DESCRIPTION				STD	A C		UNIT WT.		
										46	54		QTY.		
														71	
28 → CARD TYPE-3						28 → CARD TYPE-1				28 → CARD TYPE-2					

बीएचईएल BHEL BHARAT HEAVY ELECTRICALS LTD. BHOPAL						NAME	SIGN	DATE	NO. OF VAR.		
					DRN.	BHAGAT	—SD—	07.09.10			
					CHD.	DK	—SD—	07.09.10			
					APPD.	A.S	—SD—	07.09.10			
DEPT. TME		UNTOL. DIMS. GR.			SCALE	WEIGHT (K.G.)	REF. TO ASSY. DRG.		ITEM NO.	NO. OF ITEM	
CODE 405		'M' AA0230208			NTS	1.25	04451066051		005	001	
TITLE							DRAWING NO.				REV.
INNER LABYRINTH (DE) MACHINED							4 445 43 66 051				08
6FXA 7059							SHT. NO.		NO. OF SHT.		
							01		01		

SIZE A4