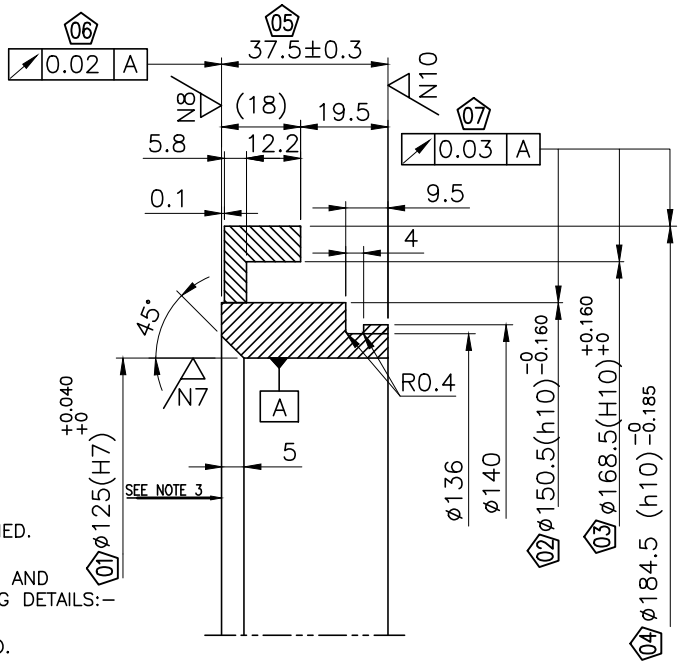
FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

REV.	DATE	ALTERED	REV.	DATE	ALTERED	ADDITIONAL INFORMATION	4TWD.097.035, (ALT.02)
02	05.05.11	CHECKED −sd− APPROVED −sd−	03	13.12.11	CHECKED −sd− APPROVED −sd−	STATUS OF DRAWING	
ZONE	TOOL LIST WAS NOT ON. IN BOM TM−11491 WAS ON 4TMS.096.068. (TCM 333)		ZONE	RAW WT. 6.10 KG. WAS NOT ON. FIN. WT. 2.22 KG WAS 2.35 KG.		DISTRIBUTION OF PRINTS	TME−1, TXM−3 TNX−1

REV.	DATE	ALTERED	ZONE
04	03.07.13	ALTERED SB; CHECKED NK; APPROVED NK	CRITICAL TO QUALITY DIMENSIONS ARE '⬠' MARKED & NUMBERED. LOCATION OF IDENTIFICATION SHOWN. NOTE−3 AMMANDED. NOTE 5 & 6 ADDED.



NOTES:−

1. REMOVE ALL SHARP EDGES.
2. GENERAL TOLERANCE±0.2 WHERE NOT SPECIFIED.
3. COMPONENT SHALL BE ETCHED (BY PENCIL ETCHING M/C) AT SHOWN LOCATION , LEGIBLY AND INDELIBLY IN CAPITAL LETTERS WITH FOLLOWING DETAILS:−
   A. MANUFACTURER'S INITIALS OR TRADEMARKS.
   B. MANUFACTURER'S UNIQUE SL. NO. , BHEL P.O. NO. , BATCH NO./ HEAT NO. , DATE OF MANUFACTURING IN MM−YY FORMAT.
4. MATERIAL:− SPHEROIDALE GRAPHITE CAST IRON (SGCI) TO DIN 1693 PART−1, GR−GGG/40 OR GR−400/18 OF IS:1865−1991 (LATEST VERSION)
5. ALL 7 NOS. "⬠" MARKED DIMENSIONS ARE CRITICAL TO QUALITY (CTQ) & SL. NO. OF CTQ DIMENSIONS ARE INSCRIBED IN ⬠ e.g.⑦.
6. 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.

TOOL LIST

IT.NO.	TOOL NO.	DESCRIPTION
	1578506	SNAP GAUGE ø150.5 $^{0}_{-0.160}$
	1578505	GROOVE GAUGE 9x12.2
	1578389	PIN GAUGE ø125 $^{+0.04}_{+0}$
	1578325	SNAP GAUGE ø184.5 $^{-0}_{-0.185}$

REF. DRG. NO.

VAR00 (59–64)	REMARKS (65–75)	ITEM NO. (25–27)	DESCRIPTION (29–58)	STD (59)	MATL. CODE (34–45) / MATL. SPCN. (46–54)	A I C (55)	UNIT (56)	UNIT WT. (58–65) / QTY. (68–71)
	RAW WT. 6.10 KG.	001	INNER LABYRINTH DE (MACHD)		TM−11491		KG.	2.22

28 → CARD TYPE−3 | 28 → CARD TYPE−1 | 28 → CARD TYPE−2

SIGN. & DATE

BHARAT HEAVY ELECTRICALS LTD. BHOPAL

	NAME	SIGN	DATE	NO. OF VAR.
DRN.	BHAGAT	−sd−	03/09/10	
CHD.	DK	−sd−	03/09/10	
APPD.	A.S	−sd−	03/09/10	

INVENTORY NO.

DEPT.	UNTOL. DIMS. GR.	SCALE	WEIGHT (K.G.)	REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEM
TME		NTS	2.22	0 445 45 66 052	003	001
CODE 405						

TITLE: INNER LABYRINTH (DE) MACHINED 6FXA 7059

DRAWING NO. 4 445 43 66 052 REV. 04

SHT. NO. 01 NO. OF SHT. 01

SIZE A4

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