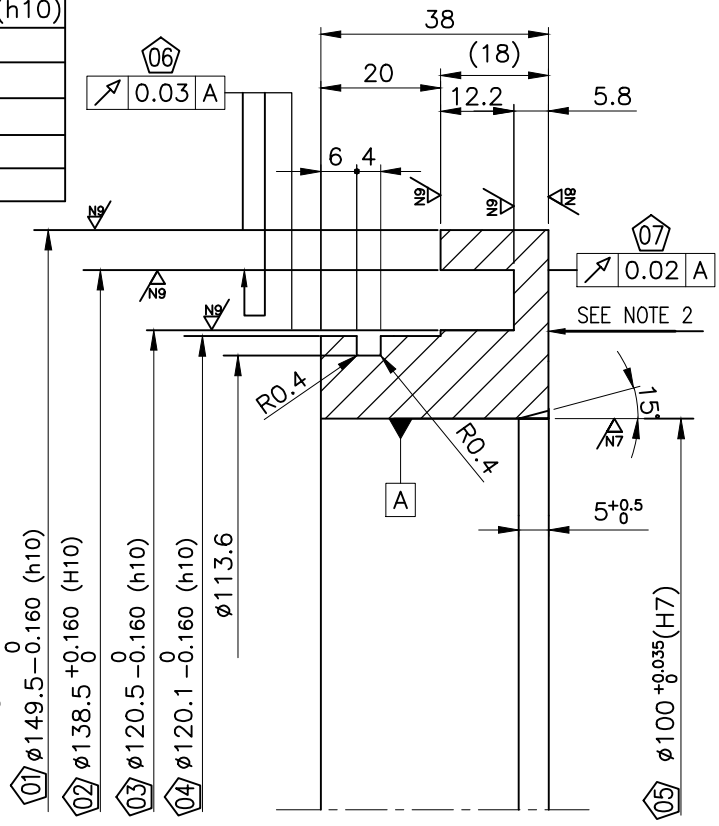
FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

REV.	DATE	ALTERED	REV.	DATE	ALTERED CKSB	ADDITIONAL INFORMATION 4TWD.097.034, (ALT.02)
04	03.07.13	CHECKED	03	13.12.11	CHECKED DK	
		APPROVED			APPROVED MEENAKSHI	
ZONE	CRITICAL TO QUALITY DIMENSIONS ARE '⬠' MARKED & NUMBERED. LOCATION OF IDENTIFICATION SHOWN. NOTE-2 AMENDED. NOTE 4 & 5 ADDED.		ZONE	RAW WT. 4.20 KG. WAS NOT ON. FIN. WT. 1.40 WAS 1.31 KG.		STATUS OF DRAWING
						DISTRIBUTION OF PRINTS TME-1, TXM-3 TNX-1

TOOL LIST

TOOL NO.	DESCRIPTION
1578504	SNAP GAUGE $\phi 120.5^{+0}_{-0.160}$(h10)
1578505	GROOVE GAUGE 9x12.2
1578373	PIN GAUGE $\phi 100^{+0.035}_{0}$
1577860	STEP GAUGE 20.00
1578367	SNAP GAUGE $\phi 149.5^{0}_{-0.160}$
1578370	PIN GAUGE ø99.6 (S.F.)



NOTES:-

1. REMOVE ALL SHARP EDGES.
2. 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.
3. MATERIAL:- SPHEROIDALE GRAPHITE CAST IRON(SGCI.) TO DIN- 1693 PART-1,GR-GGG/40 OR GR-400/18 OF IS: 1865-1991 (LATEST VERSION.)
4. ALL 7 NOS. "⬠" MARKED DIMENSIONS ARE CRITICAL TO QUALITY (CTQ) & SL. NO. OF CTQ DIMENSIONS ARE INSCRIBED IN ⬠ e.g.⑦.
5. 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.

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.

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/C (55)	UNIT (56)	UNIT WT. (58–65) / QTY. (68–71)
	RAW WT. 4.20 KG	001	INNER LABYRINTH NDE		TM-11491		Kg	1.40
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.	ASWINI	-SD-	02.09.10	
CHD.	D.K.	-SD-	02.09.10	
APPD.	A.S.	-SD-	02.09.10	

INVENTORY NO.

DEPT.	UNTOL. DIMS. GR.	SCALE	WEIGHT (K.G.)	REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEM
TME		NTS	1.40	0 445 45 66 052	002	001
CODE 405						

TITLE

INNER LABYRINTH(NDE)
6FXA 7059

DRAWING NO. 4 445 44 66 052 REV. 04

SHT. NO. 01 NO. OF SHT. 01

SIZE A4