

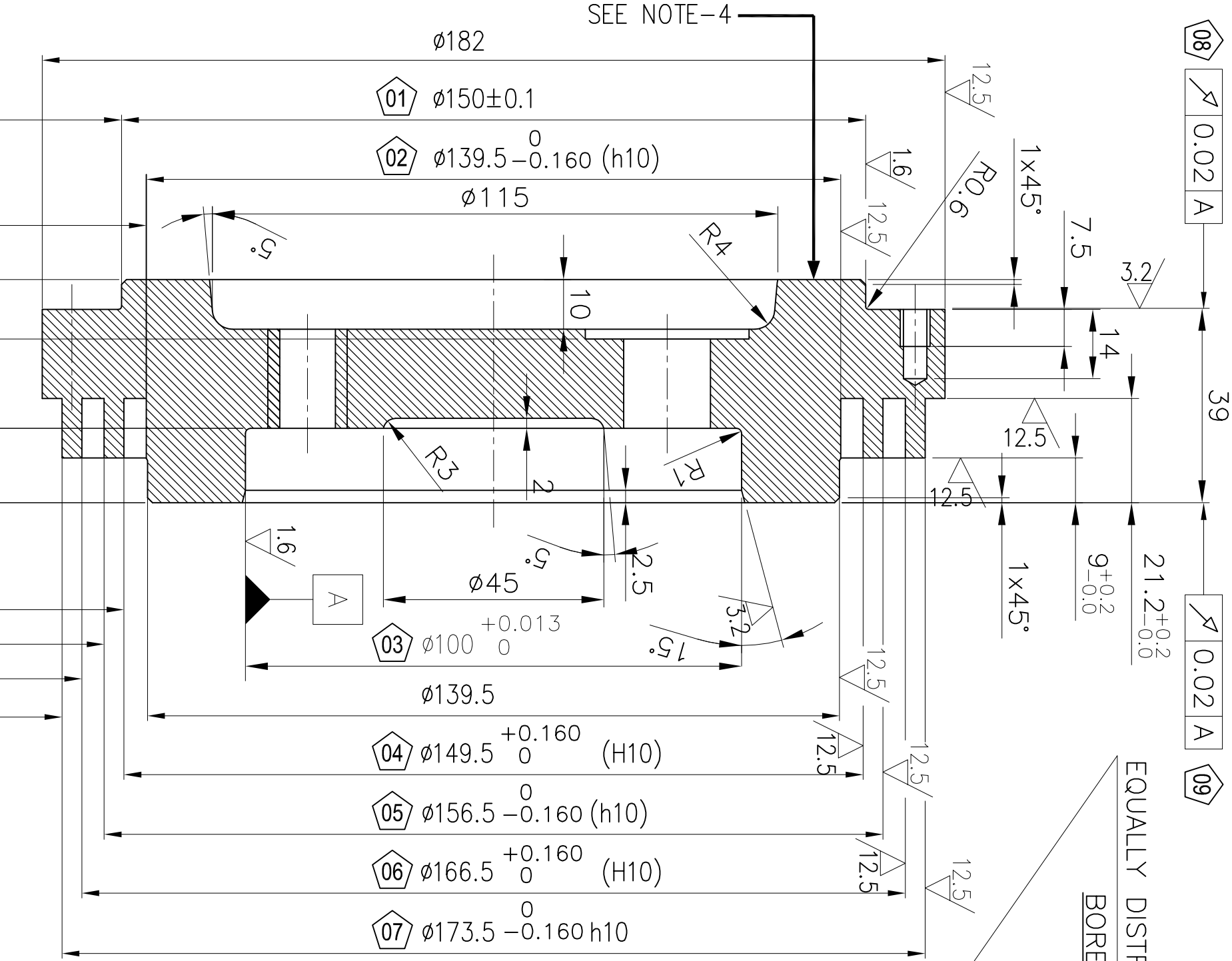
150 49 44 544 2 ON GRD

SURFACE ROUGHNESS VALUE TO IS:3073	GRADE NUMBER	7										8			
		N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12		
		Ra μ m	0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50	~
IS:3073	SYMBOL	√													

TOOL LIST	
IT.NO.	TOOL NO. DESCRIPTION
	1605006 SNAP GAUGE $\phi 173.5-0.160$
	1605007 PIN GAUGE $\phi 149.5+0.160(H10)$
	1605008 SNAP GAUGE $\phi 156.5-0.160(h10)$
	1605009 PIN GAUGE $\phi 166.5+0.160(H10)$
	1577971 PIN GAUGE $\phi 100+0.013$
	1605003 SNAP GAUGE $\phi 139.5-0.160(H10)$
	1577975 SNAP GAUGE $\phi 150\pm 0.1$
	1577976 DRILL JIG FOR ALL HOLES
	1577977 SPOT FACE CUTTER FOR $\phi 33$
	1605010 GROOVE GAUGE 5x12.2

EQUALLY DISTRIBUTED 3 COUNTER
BORED HOLES

6 EQUALLY DISTRIBUTED M6 TAPPED HOLES



3 EQUALLY DISTRIBUTED M16 TAPPED HOLE

SL.NO.	CHECKING PARAMETER	BHEL Q.C.
001	CTQ DIMS.	20%
	GEOMETRICAL TOLERANCE	20%
002	REMAINING DIMS.	5%

GENERAL TOLERANCE FOR LINEAR AND ANGULAR MEASUREMENTS FOR MACHINING ACCORDING TO ISO-2768 ISO-2768	
RATED MEASUREMENT RANGE	ISO-2768
> 0.5 to 3.0	> 3 to 6
> 3.0 to 120	> 6 to 30
> 120 to 400	> 30 to 120
DEVIATION GRADE	±0.1 ±0.1 ±0.2 ±0.3 ±0.5

REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT	REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT
09	06.10.16	CHECKED AS	ABHJIT	APPD.	ABHJIT	10	06.12.17	CHECKED AS	ABHJIT	APPD.	ABHJIT
08	18.12.14	CHECKED AS	ABHJIT	APPD.	ABHJIT	07	10.10.13	CHECKED AS	ABHJIT	APPD.	ABHJIT
07	10.10.13	CHECKED AS	ABHJIT	APPD.	ABHJIT	06	08.07.13	CHECKED AS	ABHJIT	APPD.	ABHJIT
06	18.10.18	CHECKED AS	ABHJIT	APPD.	ABHJIT	05	18.10.18	CHECKED AS	ABHJIT	APPD.	ABHJIT
05	18.10.18	CHECKED AS	ABHJIT	APPD.	ABHJIT	04	18.10.18	CHECKED AS	ABHJIT	APPD.	ABHJIT
04	18.10.18	CHECKED AS	ABHJIT	APPD.	ABHJIT	03	18.10.18	CHECKED AS	ABHJIT	APPD.	ABHJIT
03	18.10.18	CHECKED AS	ABHJIT	APPD.	ABHJIT	02	18.10.18	CHECKED AS	ABHJIT	APPD.	ABHJIT
02	18.10.18	CHECKED AS	ABHJIT	APPD.	ABHJIT	01	18.10.18	CHECKED AS	ABHJIT	APPD.	ABHJIT
01	18.10.18	CHECKED AS	ABHJIT	APPD.	ABHJIT	00	18.10.18	CHECKED AS	ABHJIT	APPD.	ABHJIT

GENERAL TOLERANCE FOR LINEAR AND ANGULAR MEASUREMENTS FOR MACHINING ACCORDING TO ISO-2768 ISO-2768	
RATED MEASUREMENT RANGE	ISO-2768
> 0.5 to 3.0	> 3 to 6
> 3.0 to 120	> 6 to 30
> 120 to 400	> 30 to 120
DEVIATION GRADE	±0.1 ±0.1 ±0.2 ±0.3 ±0.5

REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT	REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT
09	06.10.16	CHECKED AS	ABHJIT	APPD.	ABHJIT	10	06.12.17	CHECKED AS	ABHJIT	APPD.	ABHJIT
08	18.12.14	CHECKED AS	ABHJIT	APPD.	ABHJIT	07	10.10.13	CHECKED AS	ABHJIT	APPD.	ABHJIT
07	10.10.13	CHECKED AS	ABHJIT	APPD.	ABHJIT	06	08.07.13	CHECKED AS	ABHJIT	APPD.	ABHJIT
06	18.10.18	CHECKED AS	ABHJIT	APPD.	ABHJIT	05	18.10.18	CHECKED AS	ABHJIT	APPD.	ABHJIT
05	18.10.18	CHECKED AS	ABHJIT	APPD.	ABHJIT	04	18.10.18	CHECKED AS	ABHJIT	APPD.	ABHJIT
04	18.10.18	CHECKED AS	ABHJIT	APPD.	ABHJIT	03	18.10.18	CHECKED AS	ABHJIT	APPD.	ABHJIT
03	18.10.18	CHECKED AS	ABHJIT	APPD.	ABHJIT	02	18.10.18	CHECKED AS	ABHJIT	APPD.	ABHJIT
02	18.10.18	CHECKED AS	ABHJIT	APPD.	ABHJIT	01	18.10.18	CHECKED AS	ABHJIT	APPD.	ABHJIT
01	18.10.18	CHECKED AS	ABHJIT	APPD.	ABHJIT	00	18.10.18	CHECKED AS	ABHJIT	APPD.	ABHJIT

INVENTORY NO. SIGN. & DATE REF. DRG. NO.

REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT	REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT
05	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	04	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
03	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	02	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
02	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	01	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT
01	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	00	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT

REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT	REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT
05	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	04	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
03	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	02	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
02	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	01	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT
01	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	00	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT

INVENTORY NO. SIGN. & DATE REF. DRG. NO.

REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT	REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT
05	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	04	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
03	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	02	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
02	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	01	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT
01	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	00	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT

REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT	REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT
05	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	04	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
03	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	02	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
02	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	01	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT
01	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	00	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT

INVENTORY NO. SIGN. & DATE REF. DRG. NO.

REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT	REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT
05	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	04	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
03	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	02	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
02	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	01	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT
01	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	00	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT

REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT	REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT
05	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	04	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
03	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	02	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
02	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	01	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT
01	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	00	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT

INVENTORY NO. SIGN. & DATE REF. DRG. NO.

REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT	REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT
05	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	04	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
03	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	02	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
02	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	01	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT
01	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	00	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT

REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT	REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT
05	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	04	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
03	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	02	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
02	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	01	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT
01	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	00	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT

INVENTORY NO. SIGN. & DATE REF. DRG. NO.

REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT	REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT
05	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	04	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
03	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	02	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
02	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	01	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT
01	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	00	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT

REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT	REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT
05	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	04	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
03	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	02	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
02	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	01	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT
01	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	00	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT

INVENTORY NO. SIGN. & DATE REF. DRG. NO.

REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT	REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT
05	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	04	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
03	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	02	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
02	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	01	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT
01	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	00	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT

REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT	REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT
05	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	04	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
03	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	02	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
02	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	01	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT
01	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	00	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT

INVENTORY NO. SIGN. & DATE REF. DRG. NO.

REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT	REV.	DATE	CHK.	ABHJIT	APPD.	ABHJIT
05	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	04	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
03	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	02	22.11.12	CHECKED	ABHJIT	APPD.	ABHJIT
02	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	01	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT
01	13.03.13	CHECKED	ABHJIT	APPD.	ABHJIT	00	13.01.11	CHECKED	ABHJIT	APPD.	ABHJIT

DEPT.	UNTOOL DIMS. GR.		SCALE	WEIGHT (K.G.)	REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEM
TIME			N.T.S.	5.70	0 445 10 64 051		001
CODE							
405							
TITLE	<u>CLAMP PLATE (NDE)</u> (CNC MACHINED)				DRAWING NO.	REV.	
					2 445 44 64 051	12	
					SHT. NO.	NO. OF SHT.	01
					01		