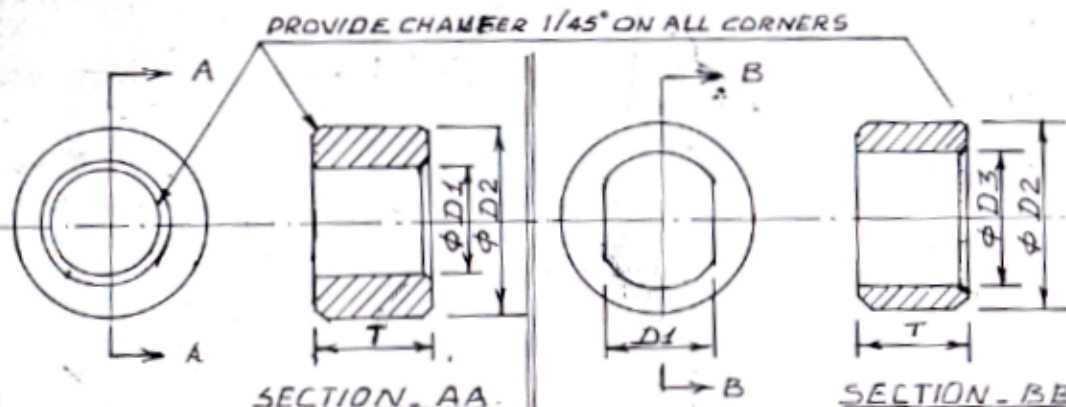


TABLE 1. DIMENSIONS OF BUSHES

Sl. No.	SIZE OF BUSH	D1	D2	D3	T
1	φ 20	20 ^{+0.052} _{-0.000}	34.5 ^{+0.095} _{-0.000}	26	20
2	φ 25	25 ^{+0.052} _{-0.000}	39.5 ^{+0.093} _{-0.000}	31	25
3	φ 30	30 ^{+0.062} _{-0.000}	42 ^{+0.100} _{-0.000}	36	25



ROUND BUSH

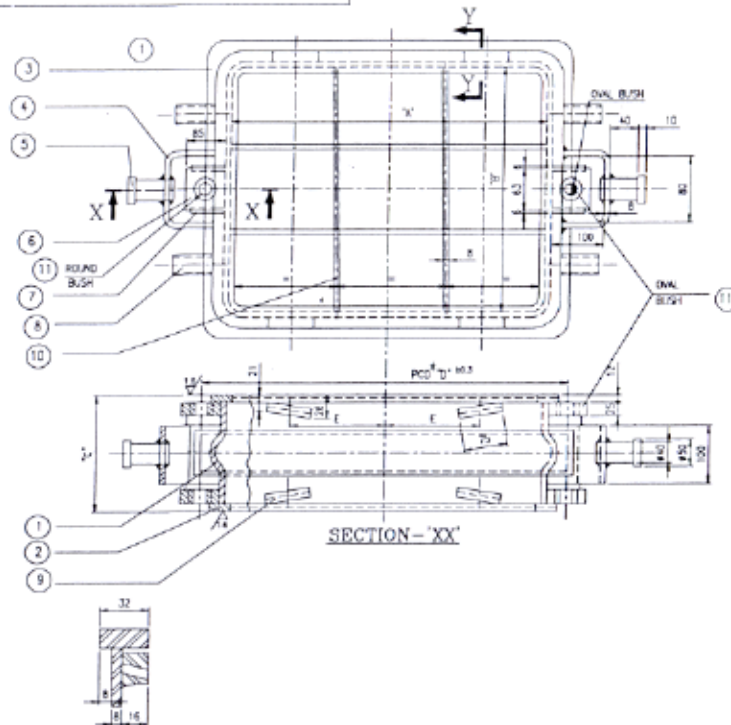
OVAl BUSH

NOTE: **MATERIAL.** 1. BUSHES SHALL BE MANUFACTURED FROM CASE HARDENING STEEL, CASE CARBONISED AND HARDENED TO 54±02 HRC.
2. THE BUSHES SHALL BE GROUND ON INSIDE AND OUT SIDE DIAMETER IN CASE OF ROUND AND ON OUTSIDE DIAMETER IN CASE OF ELONGATED.

VAR/00		REMARKS		VAR. NO.	ITEM NO.	DESCRIPTION		DWG NO.	REFER NOTE		UNIT WGT.		QTY															
29		CARD TYPE - 3		29		CARD TYPE - 1		29		CARD TYPE - 2		29																
ADDITIONAL INFORMATION						TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT																						
STATUS OF DRAWING						BHARAT HEAVY ELECTRICALS LTD HYDERABAD																						
DISTRIBUTION OF PRINTS						<table border="1"> <tr> <td>NAME</td> <td>G. NARSINGH</td> <td>SIGN.</td> <td>DATE</td> <td>22-7-87</td> </tr> <tr> <td>CHD.</td> <td>S.V. BHARGAVA</td> <td>SIGN.</td> <td>DATE</td> <td>22-7-87</td> </tr> <tr> <td>APPD.</td> <td>R.V. IYER</td> <td>SIGN.</td> <td>DATE</td> <td>22-7-87</td> </tr> </table>								NAME	G. NARSINGH	SIGN.	DATE	22-7-87	CHD.	S.V. BHARGAVA	SIGN.	DATE	22-7-87	APPD.	R.V. IYER	SIGN.	DATE	22-7-87
NAME	G. NARSINGH	SIGN.	DATE	22-7-87																								
CHD.	S.V. BHARGAVA	SIGN.	DATE	22-7-87																								
APPD.	R.V. IYER	SIGN.	DATE	22-7-87																								
REV.	DATE	ALTERED	CHECKED	DEPT.	GRADE OF UNTO/DIM. C/ M/ F	SCALE	WEIGHT (KGS)	REF. TO ASSY. DWG.	ITEM NO.	75	77	NO. OF ITEMS																
TITLE						BUSHES FOR Moulding BOXES		DRAWING NO.		3-04-11B		22-7-87																
CARD CODE						SHEET NO.		NO. OF SHEETS		100		REV.																

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

3-04-835
DRG. NO.

SCRAP SECTION ON-'YY'

VAR. NO.	BOX SIZE	A	B	C	D	E	SIZE OF BUSH LONG DIRT
01	600x600	600	600	200	750	150	32x16
02	700x700	700	700	200	850	200	-
03	800x800	800	800	250	950	250	-
04	900x900	900	900	250	1050	300	-
05	1000x1000	1000	1000	300	1150	300	-
06	1100x1100	1100	1100	300	1250	300	-
07	1200x1200	1200	1200	350	1350	350	-
08	1300x1300	1300	1300	350	1450	350	-
09	1400x1400	1400	1400	350	1550	350	-
10	1500x1500	1500	1500	350	1650	350	-
11	1600x1600	1600	1600	400	1750	400	-

REV.	DATE	ALTERED	REV.	DATE	ALTERED
04	06.12.08	CHECKED	03	03.04.08	CHECKED
BILL OF MATERIALS ADD' FOR VAR. NO. 08, 09, 10 & 11			DRAWING REDRAWN IN ACAD INCORPORATING ALL THE PREVIOUS REVISIONS		

Bill of Material for Steel Moulding Box Drawing no. 3-04-835 var. 08						
Item no.	Description	Raw material size	No. of pieces	Material code	Material spec.	Weight
1	FACE	1620 X 240 X 10	2	AA101180014	AA101180014	24.25 60.570
2	FACE FLANGE	1650 X 50 X 10	4	AA101180012	AA101180012	7.44 29.742
3	REINFORCEMENT CHANNEL FOR FACE	75 X 40 X 10/20	2	AA101200020	AA101200020	12.88 24.762
4	BEND PLATE	10 X 100 X 300	2	AA101180014	AA101180014	2.51 5.024
5	LIFTING HANDLE	Ø 60 X 80 mm	2	HY100000004	HY100000004	1.96 3.915
6	BUSH PLATE	Ø1 X 25 X 100	4	AA101180012	AA101180012	1.24 4.945
7	REINFORCEMENT FOR BUSH PLATE	10 X 75 X 300	4	AA101180014	AA101180014	1.16 4.71
8	HANDLE PIPE	Ø42 X 4.05 X 110	4	AA101180012	AA101180012	0.297 1.188
9	CLAMPING PIECES	12 X 12 X 85	8	AA101180000	AA101180000	0.10 0.7847
10	CROSS BAR (WALL)	1000 X 40 X 10	2	AA101180014	AA101180014	3.20 6.406
11	CROSS BAR (WALL)	700 X 40 X 10	2	AA101180014	AA101180014	2.36 4.728
12	BUSHES (ROUND & OVAL)	Ø 50 X 50 mm	4	HY100000004	HY100000004	0.77 3.0825
Gross Wt						157.90

Bill of Material for Steel Moulding Box Drawing no. 3-04-835 var. 10						
Item no.	Description	Raw material size	No. of pieces	Material code	Material spec.	Weight
1	FACE	2080 X 340 X 10	2	AA101180014	AA101180014	66.92 133.83
2	FACE FLANGE	2110 X 50 X 10	4	AA101180012	AA101180012	8.48 33.922
3	REINFORCEMENT CHANNEL FOR FACE	75 X 40 X 20/20	2	AA101200020	AA101200020	14.14 28.28
4	BEND PLATE	10 X 100 X 300	2	AA101180014	AA101180014	2.51 5.024
5	LIFTING HANDLE	Ø 60 X 80 mm	2	HY100000004	HY100000004	1.96 3.915
6	BUSH PLATE	Ø1 X 25 X 100	4	AA101180012	AA101180012	1.24 4.945
7	REINFORCEMENT FOR BUSH PLATE	10 X 75 X 300	4	AA101180014	AA101180014	1.16 4.71
8	HANDLE PIPE	Ø42 X 4.05 X 110	4	AA101180012	AA101180012	0.297 1.188
9	CLAMPING PIECES	12 X 12 X 85	8	AA101180000	AA101180000	0.10 0.7847
10	CROSS BAR (WALL)	1000 X 40 X 10	2	AA101180014	AA101180014	3.20 6.406
11	BUSHES (ROUND & OVAL)	Ø 50 X 50 mm	4	HY100000004	HY100000004	0.77 3.0825
Gross Wt						172.04

Bill of Material for Steel Moulding Box Drawing no. 3-04-835 var. 09						
Item no.	Description	Raw material size	No. of pieces	Material code	Material spec.	Weight
1	FACE	1500 X 340 X 10	2	AA101180014	AA101180014	40.56 81.118
2	FACE FLANGE	1530 X 50 X 10	4	AA101180012	AA101180012	7.54 29.742
3	REINFORCEMENT CHANNEL FOR FACE	75 X 40 X 10/20	2	AA101200020	AA101200020	12.88 24.762
4	BEND PLATE	10 X 100 X 300	2	AA101180014	AA101180014	2.51 5.024
5	LIFTING HANDLE	Ø 60 X 80 mm	2	HY100000004	HY100000004	1.96 3.915
6	BUSH PLATE	Ø1 X 25 X 100	4	AA101180012	AA101180012	1.24 4.945
7	REINFORCEMENT FOR BUSH PLATE	10 X 75 X 300	4	AA101180014	AA101180014	1.16 4.71
8	HANDLE PIPE	Ø42 X 4.05 X 110	4	AA101180012	AA101180012	0.297 1.188
9	CLAMPING PIECES	12 X 12 X 85	8	AA101180000	AA101180000	0.10 0.7847
10	CROSS BAR (WALL)	1000 X 40 X 10	2	AA101180014	AA101180014	3.20 6.406
11	BUSHES (ROUND & OVAL)	Ø 50 X 50 mm	4	HY100000004	HY100000004	0.77 3.0825
Gross Wt						150.82

Bill of Material for Steel Moulding Box Drawing no. 3-04-835 var. 11						
Item no.	Description	Raw material size	No. of pieces	Material code	Material spec.	Weight
1	FACE	2080 X 440 X 10	2	AA101180014	AA101180014	71.64 143.284
2	FACE FLANGE	2110 X 50 X 10	4	AA101180012	AA101180012	8.48 33.922
3	REINFORCEMENT CHANNEL FOR	75 X 40 X 20/20	2	AA101200020	AA101200020	14.14 28.28
4	BEND PLATE	10 X 100 X 300	2	AA101180014	AA101180014	2.51 5.024
5	LIFTING HANDLE	Ø 60 X 80 mm	2	HY100000004	HY100000004	1.96 3.915
6	BUSH PLATE	Ø1 X 25 X 100	4	AA101180012	AA101180012	1.24 4.945
7	REINFORCEMENT FOR BUSH PLATE	10 X 75 X 300	4	AA101180014	AA101180014	1.16 4.71
8	HANDLE PIPE	Ø42 X 4.05 X 110	4	AA101180012	AA101180012	0.297 1.188
9	CLAMPING PIECES	12 X 12 X 85	8	AA101180000	AA101180000	0.10 0.7847
10	CROSS BAR (WALL)	1000 X 40 X 10	2	AA101180014	AA101180014	3.20 6.406
11	BUSHES (ROUND & OVAL)	Ø 50 X 50 mm	4	HY100000004	HY100000004	0.77 3.0825
Gross Wt						184.509

NOTE:-

- FOR TECH DELIVERY CONDITIONS REF. TF-720 AND TF-717
- 1:1280-1075

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED...

- REF. TO HY0230261 FOR UNSPECIFIED TOLERANCES.
- CHAMFER M/CD SHARP EDGES 1.2 TO 1.0 AT 45°.
- INTERNAL M/CD CORNER RADI 1 TO 0.7.
- ALL SURFACE ROUGHNESS WHEREVER NOT SHOWN SHALL BE TAKEN FROM THE SURFACE ROUGHNESS SHOWN OUT SIDE BACK SLASHES GIVEN AT THE TOP MOST RIGHT CORNER OF THE DRG.

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT

भारत हेवी इलेक्ट्रिकल्स लिमिटेड
हैदराबाद
BHARAT HEAVY ELECTRICALS LTD.
HYDERABAD

DEPT. SCALE WEIGHT (KG)
CODE NTS -NA-
TITLE PRESS-STEEL MOULDING BOX

NAME	SIGN	DATE	NO. OF VAR.
DRN. POORNIWA		03.04.08	-NA-
CHD. T.S		03.04.08	-NA-
APPD. N.A		03.04.08	-NA-

REV. TO ASSY DRG. ITEM NO. -NA- NO. OF ITEMS -NA-
DRAWING NO. 3-04-835 REV. 04
SHEET NO. 01 NO. OF SHEETS 01



UPD COPY
REV 00

Sub. No. - 1984/94

B H E L HYD 32	TECHNICAL INSTRUCTIONS: FOUNDRY SPECIFICATION FOR M.S. FABRICATED MOULDING BOXES (WITH BUSHES)	TIF : 717 REV 00
		PAGE 1 OF 7

1.0 SCOPE

- 1.1 This specification covers the requirements of moulding boxes fabricated from steel and their main components.
- 1.2 The ranges of sizes covered are from 600 x 600 x 200 to 1600 x 1000 x 400.
- 1.3 This specification applies only to the boxes with pin holes on the longitudinal side and fitted with round bushes on one end and elongated on the other end.

2.0 COMPLIANCE WITH NATIONAL STANDARD

- 2.1 This specification is generally based on I.S 1280-1975 "specification for foundry moulding boxes of steel construction".

3.0 MANUFACTURE OF BOX FRAME

- 3.1 The moulding boxes shall be manufactured from M.S. Plate (I.S 226). The construction shall be such that plate will be pressed into channel shape (C-shape) and the two channel shapes welded together to form the box as indicated clearly in the figure of Table 1 of I.S. 1280-1975.

For thickness of plate, refer to Table-I. Sharp corners in the boxes are to be avoided.

4.0 SAND RETAINER

- 4.1 The boxes should be provided with sand retainer of specified size and continuously welded all round on top and bottom faces. Ref. Table-I.

ISSUED BY FOUNDRIES & PATTERN SHOP			
REVISION: 00	PREPARED BY <i>S.V. Bhargava</i>	APPROVED BY <i>S.C.M. Rao</i>	DATE:
DATE: 12/05/94	S.V. Bhargava (Manager, F&P.)	S.C.M. RAO (Sr. Manager, F&P.)	12/05/94

B H E L HYD 32	TECHNICAL INSTRUCTIONS: FOUNDRY SPECIFICATION FOR M.S. FABRICATED MOULDING BOXES (WITH BUSHES)	TIF : 717 REV 00
		PAGE 2 OF 7

5.0 CORRUGATIONS

The boxes should be provided corrugations on inside (concave inside, convex outside) as per Table-I

6.0 OUTSIDE REINFORCEMENT

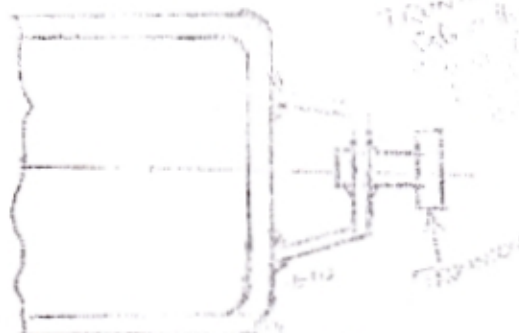
6.1 The boxes should be reinforced outside by welding channel all round as per Table-I of this specification

7.0 TRUNNIONS

7.1 All boxes should be provided with machined trunnions for lifting purposes. (Machined out of solid bar stock.)

Welding of trunnion should be as per the sketch, and welded from both inside and outside of the handle.

Diameter of TRUNNION: 50mm



8.0 WEDGES

8.1 All the boxes should be provided with wedges for clamping purposes. Wedges on boxes are to be designed to suit to the clamps of Drg.No. 4-04-365 enclosed

Size, location and angle of wedges should be correctly maintained, with the help of jigs. This is important because it has been often observed that clamps when driven on to the wedges do not fit properly

If the manufacturer of boxes envisages any change in the design of above 'C' clamp the same can be communicated to BHEL for prior approval.

9.0 INSIDE REINFORCEMENT

9.1 Unless otherwise stated on purchase order, all boxes upto 1000 x 1000 size shall be provided with steel ribs (50 x 8mm) inside the box two each on length and two each on width side.

For boxes above 1000 x 1000 size three ribs are to be provided on each side.

B H E L HYD 32	TECHNICAL INSTRUCTIONS:FOUNDRY SPECIFICATION FOR M.S.FABRICATED MOULDING BOXES (WITH BUSHES)	TIF :717 REV 00
		PAGE 3 OF 7

10.0 JOINT FACES

- 10.1 The joint faces shall be machined so that the joint faces are dead true and parallel.
Tolerances are as specified at clause 14.0.

11.0 LUGS

- 11.1 a) The boxes should have double lugs on each side of the box.

The lugs should be suitable to the bushes specified in drg.no. 3-04-118.

- c) The lugs should be duly machined, drilled and reamed with proper jigs and fixtures to maintain interchangeability of bushes.
- d) The holes in the lugs shall be at right angles to the joint faces.
- e) Both the lugs should be reinforced by welding M.S. Plates vertically.

12.0 PITCH DISTANCE

- 12.1 The pitch distance between the bush centres shall be as per Table-I of this specification. Tolerances as per cl 14.0.

13.0 BUSHES

- 13.1 a) Bushes shall be manufactured from case hardening steel, case carborised and hardened to 54 to 62 HRC.
- b) The size and dimensions of the bush shall be as per Table-I and drg.no. 3-04-118 enclosed herewith.
- c) the bushes shall be ground inside and outside.
- d) the bushes shall be press fit and tack welded.

14.0 TOLERANCES

- 14.1 The tolerance on the centre distance between the guide holes for bushes shall be $\pm 0.5\text{mm}$.

B H E L HYD 32	TECHNICAL INSTRUCTIONS:FOUNDRY SPECIFICATION FOR M.S.FABRICATED MOULDING BOXES (WITH BUSHES)	TIF :717 REV 00
		PAGE 4 OF 7

14.2 The centre line that is the axis of the guide hole centres shall not shift on either side by more than 12mm.

14.3 Joint faces shall be level and true within the following permissible error in straightness.

Box Size:	Permissible Tolerance:
600 x 600	
700 x 600	± 0.5
700 x 700	
800 x 800	
1000 x 700	± 0.75
1000 x 800	
1000 x 1000	
1250 x 1000	
1250 x 1250	± 1.0
1600 x 1000	± 1.5

14.4 The following tolerances apply on inside dimensions of boxes.

Inside Size:	Tolerance Permissible:
600 x 600	
700 x 600	± 1.5
700 x 700	
800 x 800	
1000 x 700	± 2.0
1000 x 800	
1000 x 1000	
1250 x 1000	
1250 x 1250	± 2.5
1600 x 1000	± 3.0

15.0 STRESS RELIEVING

15.1 All boxes shall be stress relieved at 600°C - 620°C for a minimum soaking time of 2 hours.



B H E L HYD 32	TECHNICAL INSTRUCTIONS:FOUNDRY SPECIFICATION FOR M.S.FABRICATED MOULDING BOXES (WITH BUSHES)	TIF :717 REV 00
		PAGE 5 OF 7

16.0 CONFORMANCE OF BOX SHAPE AND CONSTRUCTION

- 16.1 The boxes shall be free of all types of weld defects and other process defects. The boxes should be sound and fit for use in all respects.
- 16.2 The construction, weld joints and other features of the boxes should be similar with standard boxes already in use in our foundries. In case any clarifications are required, the manufacturer is advised to contact BHEL before the work is commenced.
- 16.3 The party is at liberty to submit drawings as per this specification for prior consent by BHEL.

17.0 INSPECTION

- 17.1 Moulding boxes shall be inspected at supplier's works before despatch. Boxes shall be offered in unpainted condition.
- 17.2 BHEL representative shall have free entry and access to all areas where the manufacture of boxes ordered is carried out. All reasonable facilities shall be provided to him including labour where necessary.
- 17.3 Heat Treatment charts carried out for stress relieving shall be submitted to BHEL.

18.0 PAINTING

- 18.1 The boxes will be allowed to be painted only after inspection and approval by BHEL.
- 18.2 The boxes should be finished with two coats of heat resisting, black enamel paint prior to delivery.

19.0 MARKING

- 19.1 Each moulding box shall be marked with the manufacturer's name or trade mark and the size of the box.



B H E L HYD 32	TECHNICAL INSTRUCTIONS: FOUNDRY SPECIFICATION FOR M.S. FABRICATED MOULDING BOXES (WITH BUSHES)	TIF : 717 REV 00
		PAGE 6 OF 7

20.0 ACCESSORIES

20.1 CLAMPS

Each box shall be supplied with two numbers of clamps i.e., four clamps per pair of boxes, to facilitate clamping.

The box supply is deemed complete only when box supply is accompanied by the required quantity of bushes *clamps* *all*

20.2 BUSHES (SPARE)

When specifically ordered only bushes shall be supplied as per drawing 3-04-118 in the required type and quantity.

21.0 REJECTION AND REPLACEMENT

The final decision regarding acceptance or rejection rests with BHEL if the moulding boxes are not found as per this specification, at any time during further operations using the moulding boxes. The supplier shall replace the rejected moulding boxes at his own cost and the rejected boxes shall be returned after all commercial terms and conditions are satisfied.

B H E L
HYD 32

TECHNICAL INSTRUCTIONS: FOUNDRY
SPECIFICATION FOR M.S. FABRICATED
MOULDING BOXES (WITH BUSHES)

TIF : 717
REV 00

PAGE
7 OF 7

TABLE - I.

(dim. in mm)

Sl. No.	Size of box	Ht. of box	Th. of box frame	Pitch dis. of bush	Bush hole	Sand retnr. size	Lugs on each side of box	Outside channel reinforcement:	Corrugations
1)	600 x 600	200 250 300 350	8	750	25	16	Double	Single 50 Single 50 Single 50 Single 75	Single
2)	700 x 600	200 250 300 350	8	850	25	16	Double	Single 50 Single 50 Single 75 Single 75	Single
3)	700 x 700	200 250 300 350	8	850	25	16	Double	Single 50 Single 50 Single 75 Single 75	Single
4)	800 x 800	200 250 300 350	8	950	25	16	Double	Single 50 Single 50 Single 75 Single 75	Single
5)	1000 x 700	200 250 300 350	8	1110	25	16	Double	Single 50 Single 75 Single 75 Single 75	Single -do- -do- Double
6)	1000 x 800	200 250 300 350	8	1180	25	16	Double	Single 50 Single 75 Single 75 Single 75	Single -do- -do- Double
7)	1000 x 1000	200 300 400	8	1180	25	16	Double	Single 75 Single 75 Double 50	Single -do- Double
8)	1250 x 1000	200 300 400	12	1450	30	20	Double	Single 50 Single 75 Double 50	Single -do- Double
9)	1250 x 1250	200 300 400	12	1450	30	20	Double	Single 50 Single 75 Double 50	Single -do- Double
10)	1600 x 1000	200 300 400	12	1830	30	20	Double	Single 50 Single 75 Double 50	Single -do- Double

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IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

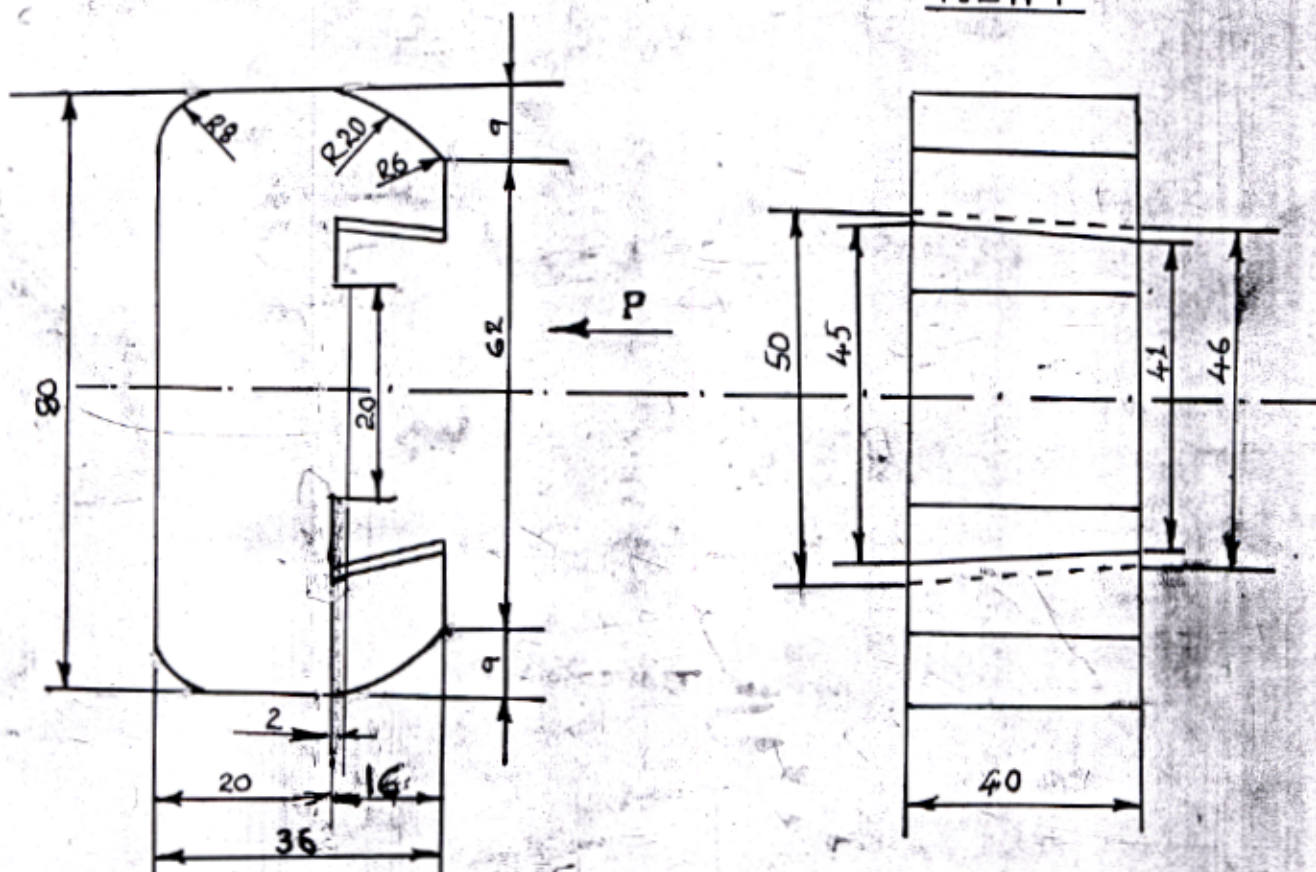
ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED
01	1-11-96	CHECKED SVB			CHECKED			CHECKED
ZONE	View 'P' - Dim 40 was 30 2 mm Projection added.		ZONE			ZONE		

AS CAST FINISH

VIEW-P



NOTE: Clamp for moulding boxes specified as per TIF 718.

REMARKS		ITEM NO.	DESCRIPTION	STD.	34	MATL. CODE	45	55	56	58	UNIT WT.	65
		25	27	29	46	MATL. SPCN.	54	A/C	UNIT	66	QTY.	71
CARD TYPE-3		28	28	CARD TYPE-2		28	CARD TYPE-1					
Bharat Heavy Electricals Ltd		HYDERABAD		DRN.	NAME		SIGN.		DATE		73	74
				CHD.	B.T. RAM.		B.T. Ram		12.12.95		NO. OF VAR.	
				APPD.	M.N.A		M.N.A		12.12.95			
					SVB		SVB		12.12.95			
DEPT.	GRADE OF TOL. DIM. C/M/F	SCALE	WEIGHT (Kg)	REF. TO ASSY. DRG.				ITEM NO.	75 77 NO. OF ITEMS			
CODE		NTS.	0.6									
TITLE C CLAMP FOR MOULDING BOXES				DRAWING NO. 4-04-811				REV. 01				
				SHEET NO.				NO. OF SHEETS				

FIRST ANGLE PROJECTION

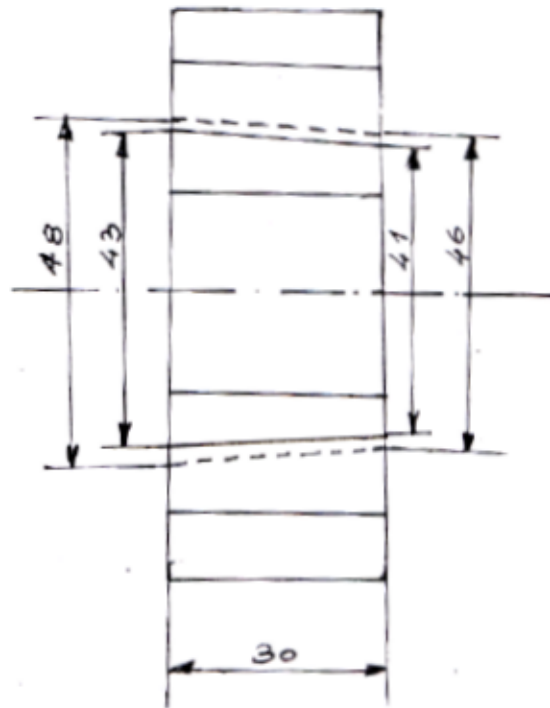
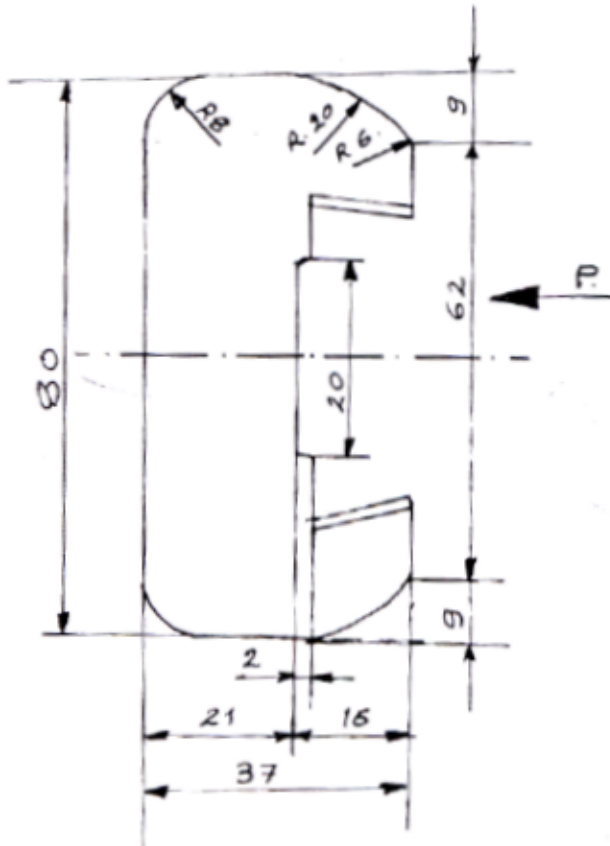
(ALL DIMENSIONS ARE IN mm)

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IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED
01	11/5/54	CHECKED SVB			CHECKED			CHECKED
ZONE	(i) Material IS 210 FG 200 Spec IS 210 Gr. 20/28 (2) Tracing hydrodynamic.					ZONE		

AS CAST FINISH

VIEW - P



M-04-125

15210 FG200		0.5 KG	
CAST IRON			
34	MATL. CODE	45	58
45	MATL. SPCN.	54	57
58	UNIT WT.	65	
59	QTY.	71	
CARD TYPE-3		CARD TYPE-2	
CARD TYPE-1			
BHARAT HEAVY ELECTRICALS LTD		HYDERABAD	
DRN.	NAME	SIGN.	DATE
CHD.	M.S.	SVB	11/5/54
APPD.	SVB	SVB	11/5/54
DEPT.	GRADE OF	SCALE	WEIGHT (Kg)
CODE	TOL. DIM.	NTS	
TITLE		REF TO ASSY DRG	
C. CLAMP FOR		ITEM NO.	
MOULDING BOXES.		NO. OF ITEMS	
DRAWING NO.		SHEET NO.	
4-04-365		NO. OF SHEETS	
REV.		REV.	
01		01	