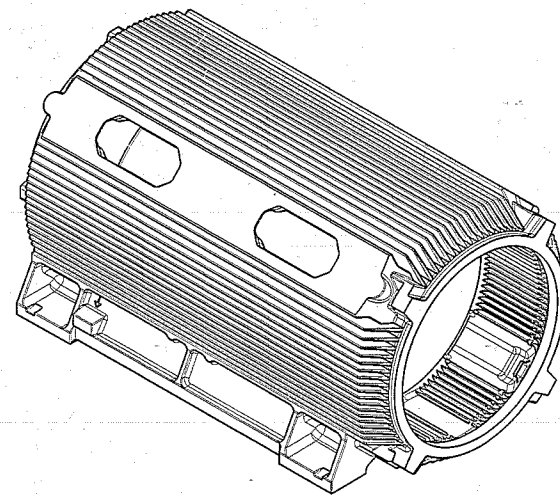
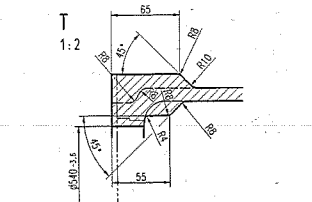
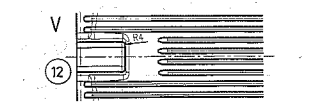
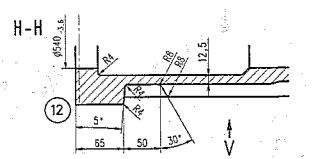
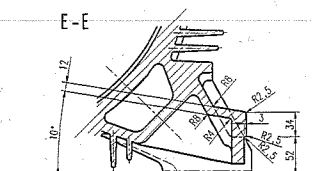
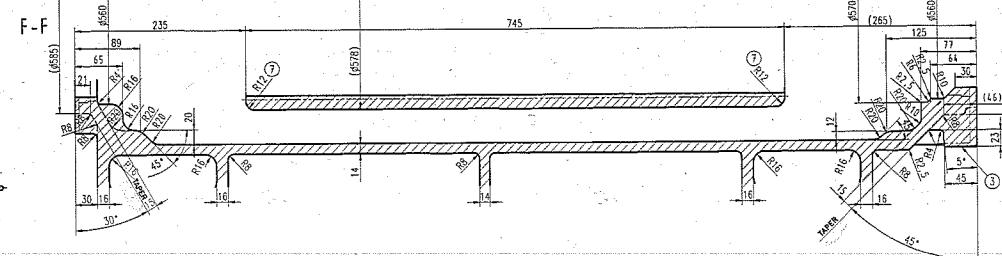
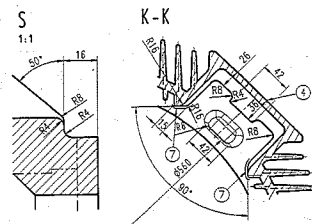
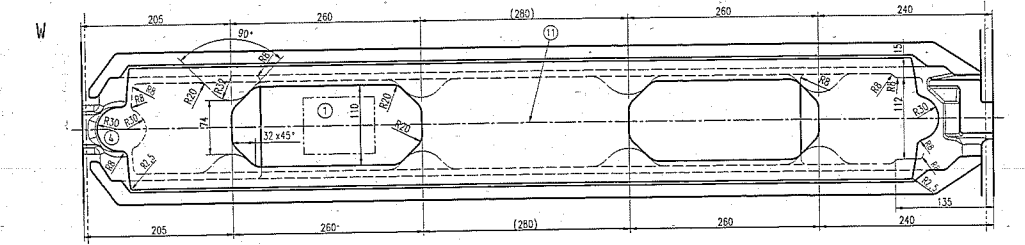
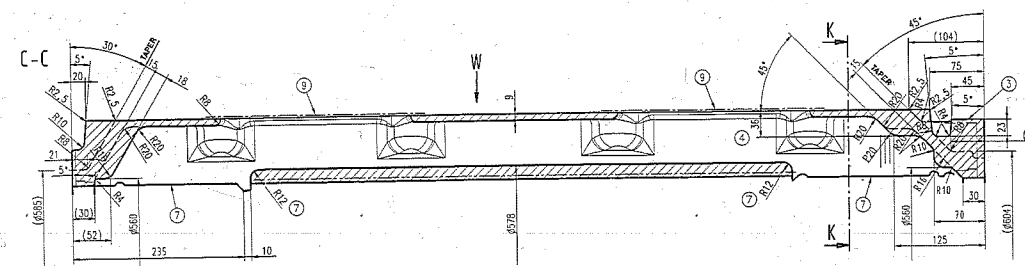
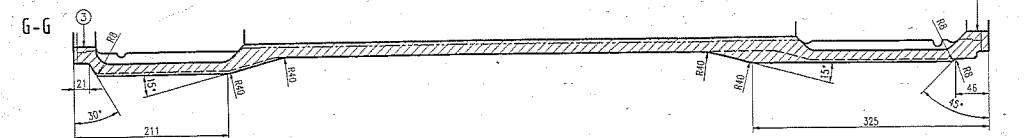
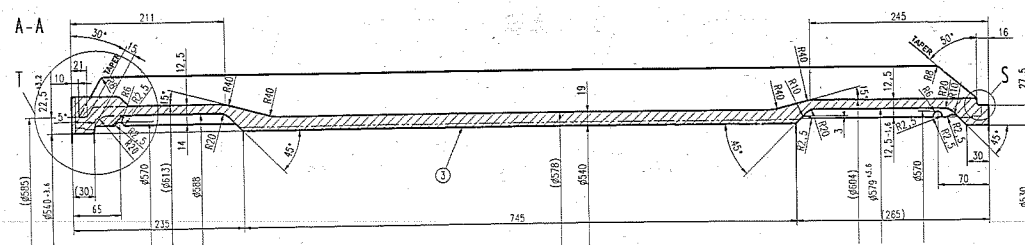
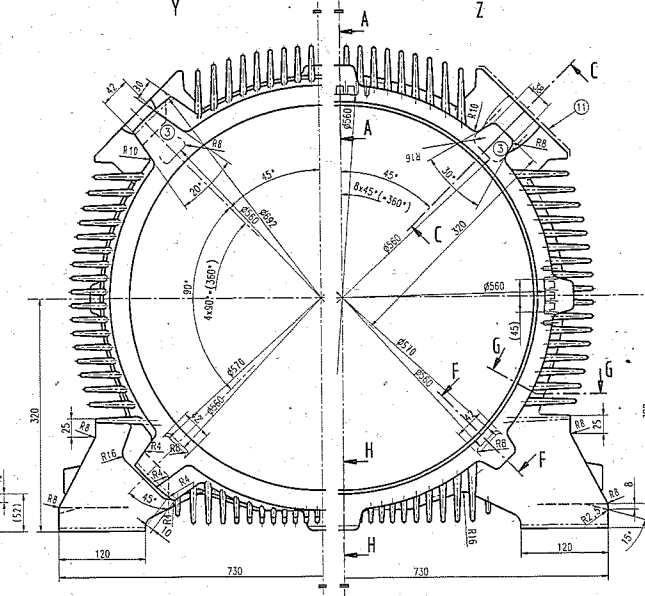
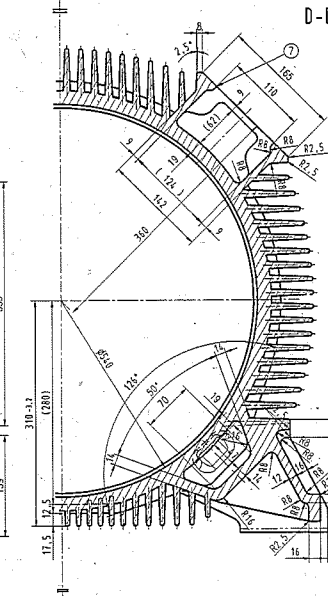
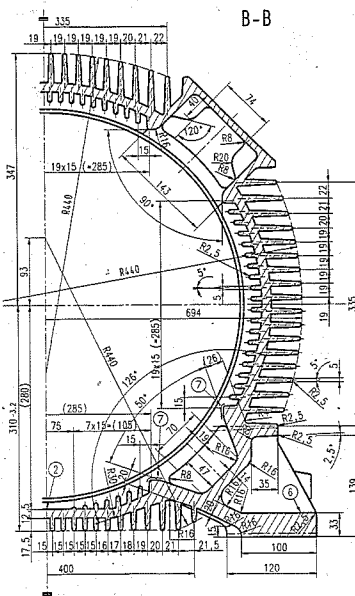




1. PATTERN INFORMATION TO BE CAST DERESSED IN THE AREA SHOWN AS-①
PATTERN NO.-1241226-C444430---WITH FOOT.
PATTERN NO.-1241227-C444431---WITHOUT FOOT.
2. 'DRIVE END' , 'NON-DRIVE END' TO BE CAST DERESSED AT RESPECTIVE END, IN THE AREA SHOWN AS-②
3. AT SURFACES SHOWN AS-③ MAXIMUM BRINELL HARDNESS VALUE TO BE 230, TESTED AS PER DIN 50351-HBS 10/30/10.
4. BRINELL HARDNESS VALUE TO BE 180---230, TESTED AS PER DIN 50351-HBS 10/30/10. ON ALL FOUR R30 PADS (2-AT EACH END) FOR LIFTING EYE BOLT (VIEW-'W', SECTION-'KK') AND ON 36 MM RANGE BELOW BOTH PADS ON NON-DRIVE END (SECTION-'CC','KK' MARKED AS-④)
5. RIB ENDS SHOWN AS-⑤ TO BE ROUNDED TO RADIUS $R = 1/2$ RIB THICKNESS.
6. MAXIMUM FORM OBLIQUENESS/SKEW PERMISSIBLE IS 1' ON SURFACES SHOWN AS-⑥ ON MOTOR FEET.
7. EDGES, SURFACES, RADIUS' R12 SHOWN AS-⑦ (SECTION-'CC') MUST BE BURR FREE & WITHOUT ANY SHARP EDGES.
8. EARTHING SYMBOL AS PER DIN 40011-A25-GIS-H (HEIGHT 25) AT ⑧
9. ON ALL THE 4-OPENINGS ON 300x150 AREA AROUND EDGES FLATNESS WITHIN 0.5 & FINISH Rz 250 MICRONS AS CAST AS PER DIN 4766, AT-⑨ (SECTION 'CC')
10. STARTING DIMENSIONS FOR MACHINING SHOWN AS-⑩ TO BE MAINTAINED ON NON-DRIVE END.
11. NO PATTERN JOINT PERMISSIBLE ON THESE FACES SHOWN AS-⑪ (VIEW-'W') ON BOTH SIDE.
12. MATERIAL TO AA19702.
13. PRETREATMENT FINISH, PRIMER COATING AS PER AM 54257.
14. FORM OBLIQUENESS/SKEW AS PER DIN 1511.
15. MACHINING ALLOWANCE 5mm ON DE & 10mm ON NDE DUE TO POURS/FOAMING.
16. RADIOUS AT INSIDE/OUTSIDE RIB ROOT R4 AT ROOT.
17. ONLY ON DE BOTTOM SIDE SHOWN AS ⑫.
18. "FOR SOAKING TIME IN HEAT TREATMENT CYCLE, REFER PLANT STANDARD BP0640295".

REV. DATE	ALTD.-YM	REV. DATE	ALTD.-DIPTI	REV. DATE	ALTD.-K.N.P.	REV. DATE	ALTD.-K.N.P.-sd	REV. DATE	ALTERED (SD)	DEPT. AMO	GRADE OF	SCALE	WEIGHT	REF. TO ASSY. DGS	ITEM NO.	ITEM
05	06.06.19	04	10.06.19	03	06.08.15	02	20.01.15	01	04.06.15	402	104	1/4"	700			
APPD.-AKM		APPD.-M.K.M.		APPD.-J.K.		APPD.-J.K.-sd		CHECKED		402	104	1/4"	700			
WT. 700 WAS 850. DRAWING REDRAWN.		NOTE 18 ADDED DGR. REVISED.		WT. 850 WAS 900. DRAWING REDRAWN.		WT. 980 WAS 740. DRAWING REDRAWN.		ST. NO. 4422. TAX WAS 070.		TITLE		DRAWING NO.		04027140171		05
										STATOR FRAME CASTING						