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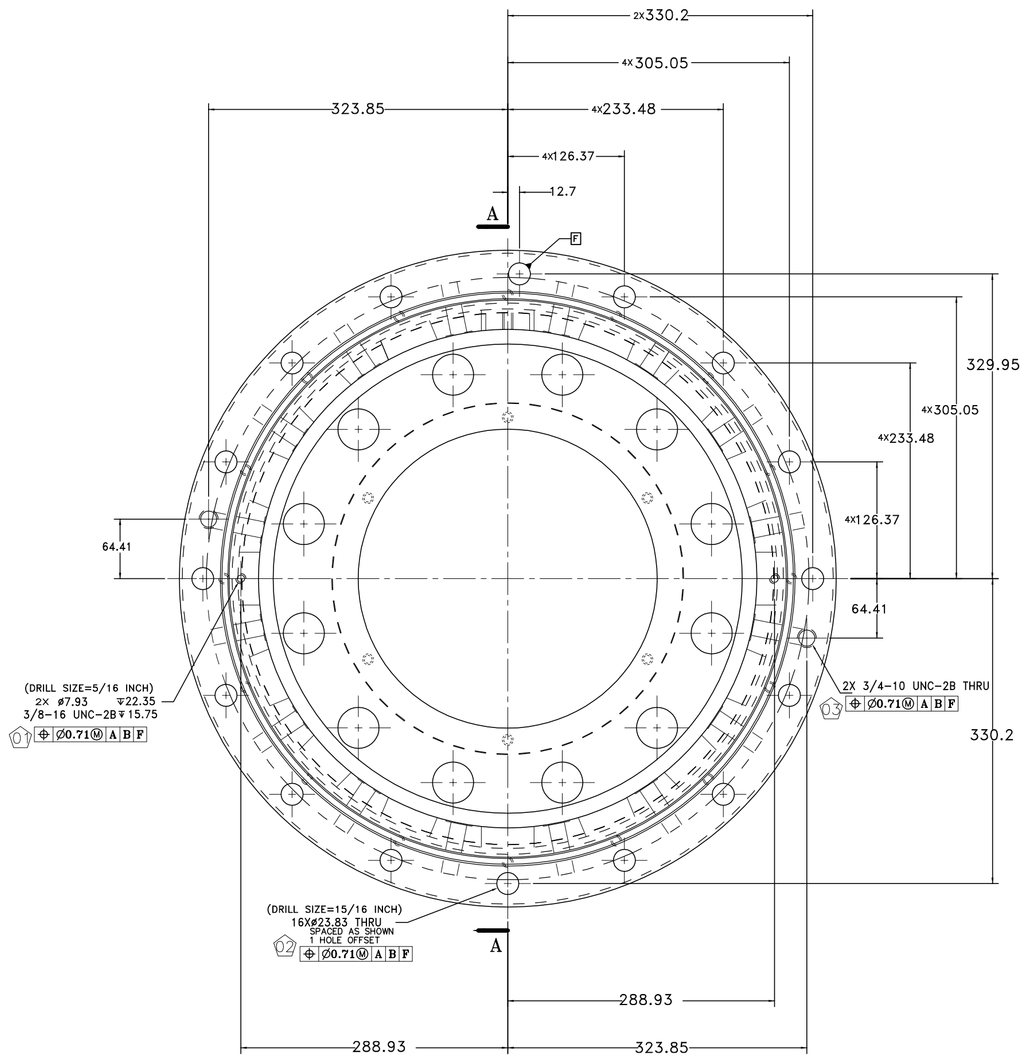
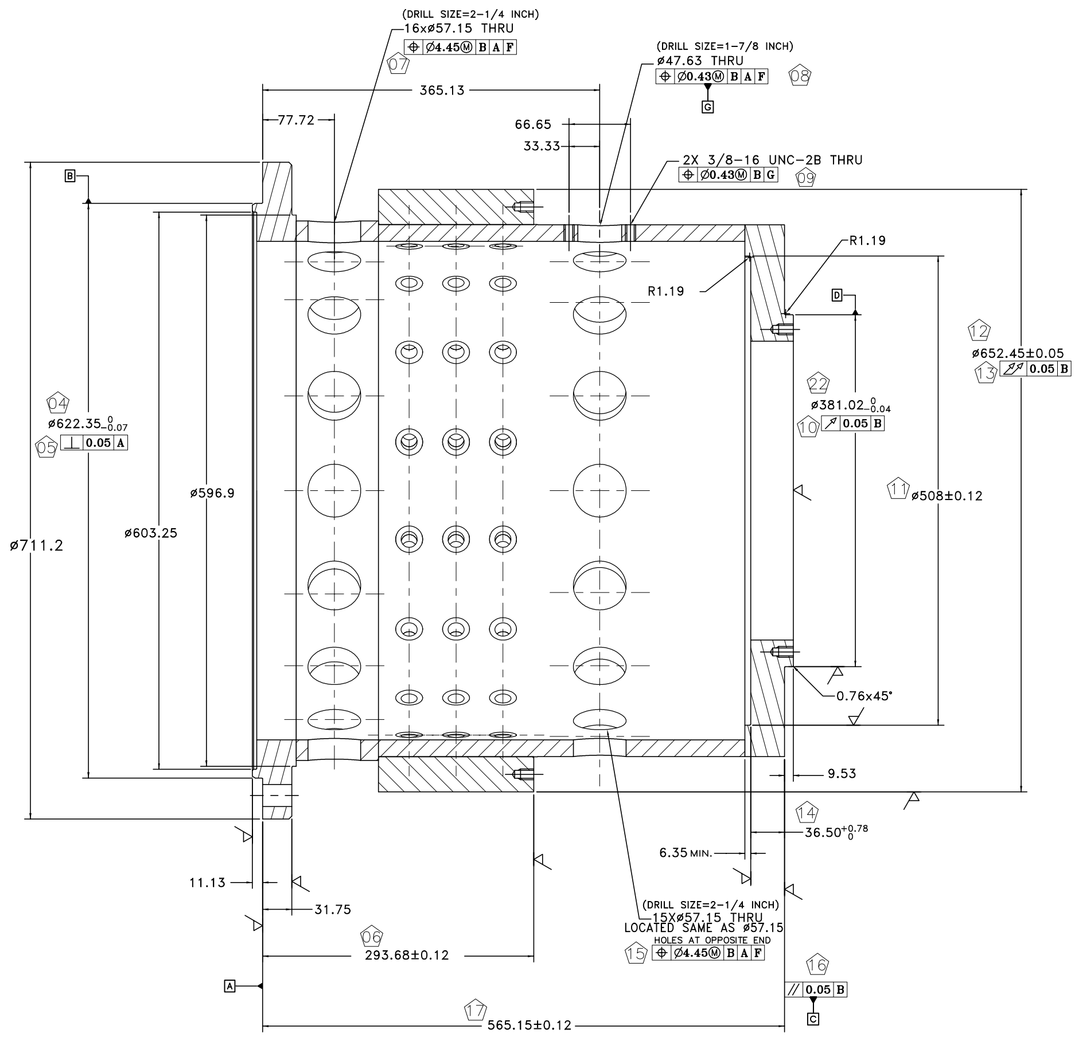
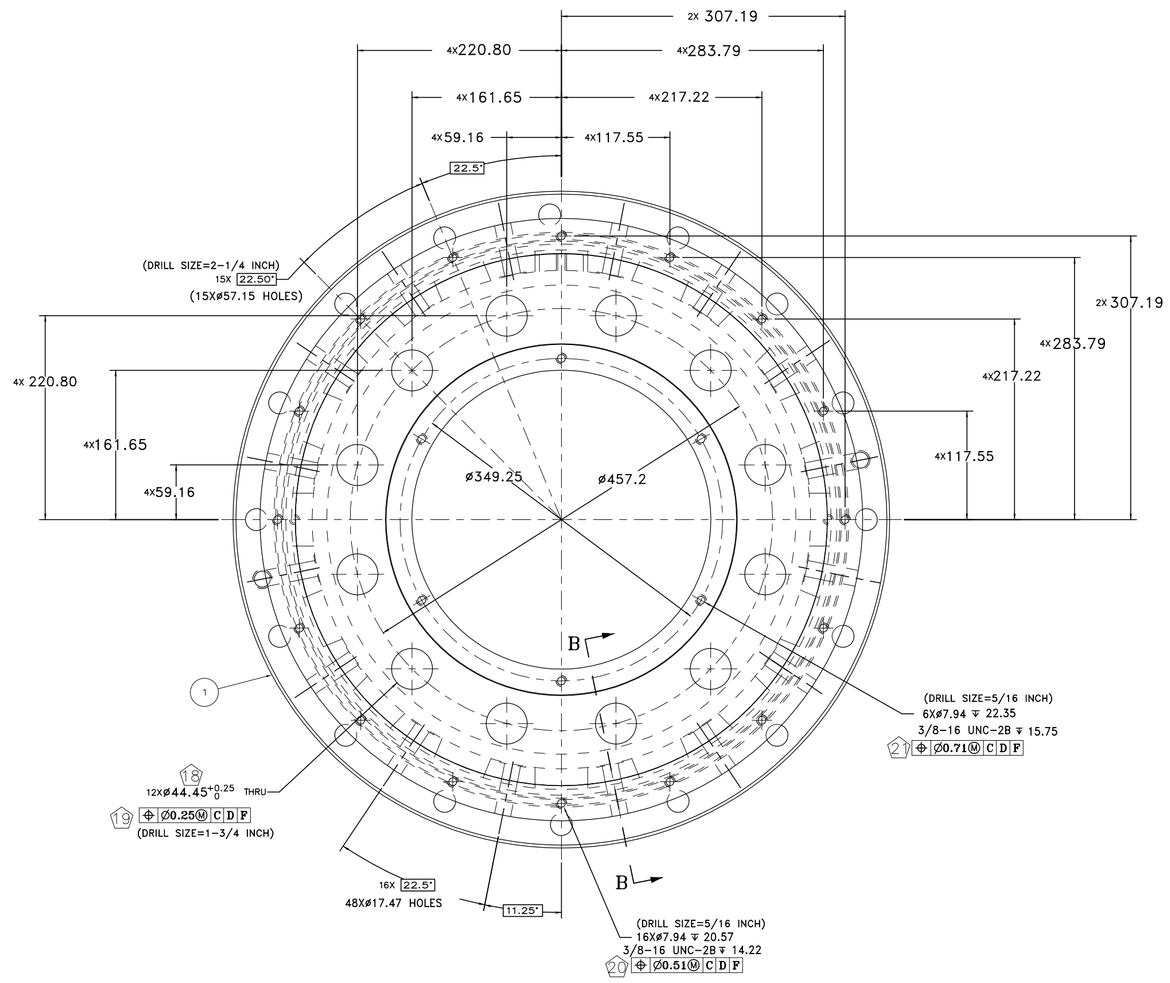
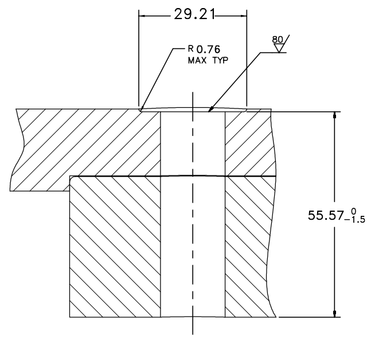
IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.





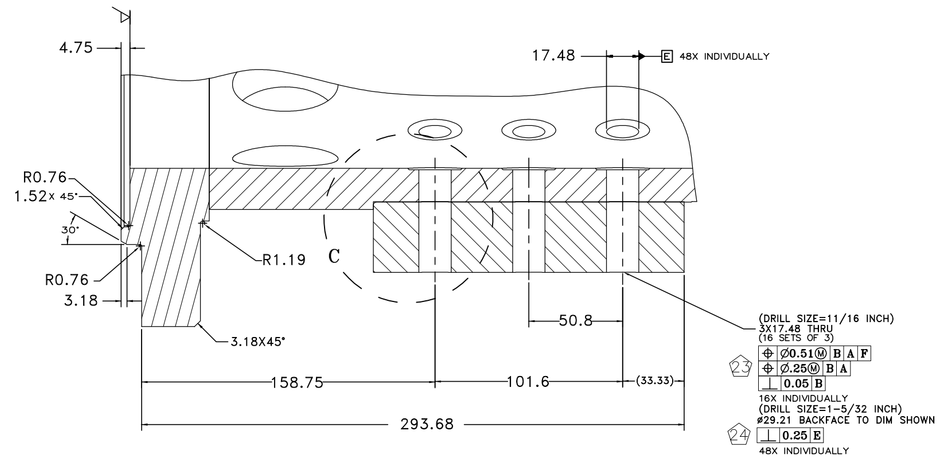
SECTION–AA





ENLARGED VIEW–C

TOOL LIST		
IT. NO.	TOOL NO.	DESCRIPTION
–	1607202	DRILL JIG FOR 12 X 1–3/4" AT ø457.2 + 6 x 5/16" AT ø349.25
–	1607203	DRILL JIG FOR 16 X 5/16"
–	1607204	DRILL JIG FOR 16 X 15/16" + 2 X 5/16"
–	1607205	SPIGOT FOR VB/LATHE ø 622.35–0.07/0
–	1607206	SNAP GAUGE ø 622.35–0.07/0
–	1607207	SNAP GAUGE 381.02–0.04/0
–	1607208	OFFSET PIN GAUGE 508 ± 0.12
–	1607209	TRUNION DRILLING FIXTURE AND PLATES
–	1607210	ARM DRILLING JIG
–	1607211	HSS TS DRILL ø 5/16"
–	1607212	HSS TS DRILL ø 15/16
–	1607213	HSS TS DRILL ø 2–1/4"
–	1607214	HSS TS DRILL ø 1–7/8"
–	1607215	HSS TS DRILL ø 1–3/4"
–	1607216	HSS TS DRILL ø 17.47
–	1607217	HSS TAP 3/8–16 UNC–2B
–	1607218	HSS TAP 3/4–10 UNC–2B



SECTION–BB
ROTATED FOR CLARITY

NOTES:–

1. DRAWING IS IN THIRD ANGLE PROJECTION.
2. QAP FOR MACHINE COMPONENTS TO BE AS PER QTM/QAP/MACHINED ITEMS/PRL/VENDOR/18–19/03 (LATEST REV.).
3. ALL 24 NOS. "⬠" MARKED DIMENSIONS ARE CRITICAL TO QUALITY (CTQ) & SL. NO. OF CTQ DIMENSIONS ARE INSCRIBED IN ⬠ e.g. ⬠24.
4. IN CASE OF HOLES DIMENSIONS INDICATED IN '( )' ARE STANDARD DRILL SIZES IN INCHES.
5. THREAD SIZES ARE INDICATED IN INCHES.
6. COORDINATE OF ALL HOLES ARE CRITICAL TO QUALITY.
7. QUALITY REQUIREMENTS OF CASTING OR FABRICATION SHALL BE AS PER THE REQUIREMENTS MENTIONED IN RESPECTIVE SUB–ASSEMBLY DRAWINGS,CASTING DRAWINGS AND FABRICATED DRAWINGS.

QTY VAR 00	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.NO. / VAR.	MATL. CODE / MATL. SPCN.	A CI	UNIT	UNIT WT. / QTY.	KG.	CS	ZONE
001	R/WT.=760KG.		001	SPIDER SUB ASM		2 432 45 77 101	001				399.0			

ADDITIONAL INFORMATION :
REF. DRG. NO. 40309800

STATUS OF DRAWING :

DISTRIBUTION OF PRINTS :
TME–1, TAM–3, TNX–1

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT: AUXILIARY ALTERNATOR AA9204AZ

BHARAT HEAVY ELECTRICALS LTD. BHOPAL

	NAME	SIGN	DATE	NO. OF VAR.
DRN.	S.D.B.		06/02/19	01
CHD.	ABHISHEK		06/02/19	
APPD.	ABHISHEK		06/02/19	

REV.	DATE		REV.	DATE		REV.	DATE		DEPT.	SCALE	WEIGHT (K.G.)	REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEM
03	09.11.19	ALTERED / CHECKED / APPROVED	02	22.08.19	ALTERED / CHECKED / APPROVED	01	15.05.19	ALTERED / CHECKED / APPROVED	TME	NTS	302.09	0 432 45 77 101	001	001
ZONE	ROUGH WEIGHT ADDED.		ZONE	NOTE 7 ADDED.		ZONE	TOOL LIST ADDED.		CODE 405	UNTOLERATED DIMS. TM20219				

TITLE: SPIDER MACH.

DRAWING NO. 1 432 45 77 101 REV. 03

SHEET NO. 01 NO. OF SHEET 01

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

SIZE A1