



BUILDING DIA = $404^{+0.5}_0$
 ROUGH MACHINE DIA = 402 ± 0.5
 ROUGH M/C DIA
 FOR 5 COMM = $404^{+0.5}_0$

NOTES:-

- STEEL COMPONENTS SHALL BE VARNISHED WITH SUITABLE ANTI-RUST/ ANTI-TRACK VARNISH.
- THE ASSY. SHOULD BE DYNAMICALLY BALANCED FIRST AT LOWER RPM (750R.P.M.) AND THEN A HIGHER RPM(1500 RPM).
- ADJUST UNBALANCE BY FIXING BALANCE WEIGHT IN THE DOVETAIL OF COMMUTATOR STEEL V-RING.
- THE PERMISSIBLE UNBALANCE SHOULD NOT BE MORE THAN 3g.
- WHILE SUPPLYING THE SURFACE OF POLY-GLASS SHOULD BE COVERED WITH ONE LAYER OF POLYESTER FILM FOLLOWED BY 2 TO 3 LAYER OF POLYGLASS TAPE TO PREVENT ACCUMULATION OF DUST.
- INSULATION RESISTANCE TEST:-
) MEASURE THE INSULATION RESISTANCE BETWEEN ADJACENT COMMUTATOR BAR USING A 500V INSULATION RESISTANCE METER.
) APPLIED VOLTAGE (AC) : 8.010 V FOR ONE MINUTE.
- EARTH INSULATION TEST:-
) THIS DRG. IS EQUIVALENT TO CLW DRG. NO. 21WD 095 045 ALT.-1
) TM10454 SHALL BE PART OF THIS DRAWING.
- COMMUTATOR DYNAMIC SEASONING AND TIGHTENING AT 80 ± 2 TONS BE CARRIED OUT, TILL ZERO MOVEMENT OF COMMUTATOR NUT IS ACHIEVED.
- HOT IR OF COMMUTATOR ASSY. AT $120 \pm 10^\circ\text{C}$ TO BE ENSURED MORE THAN 100MM AT THE TIME OF FIRST ASSY. SEASONING CYCLE (REF. CLAUSE 9.0 OF TM 10454) BY PUTTING THE COMMUTATOR ASSY. IN BAKING-OVEN.

INSTRUCTION ON WORK.

- SEASONING PRESSURE AND DEFLECTION OF DISK SPRING IT.08.

SEASONING PRESSURE	DIMENSION "A", "M"	DEFLECTION(MM)
0 TONS	3.99	0
80 ~ 85 TONS	4.69~4.74	0.70~0.75

TOOL LIST

IT.NO	TOOL	DESCRIPTION
144462	ALIGNMENT GAUGE	
141463	PRESSING PLATE	
141464	LIFTING TACKLE	
141465	TURNING SPOBT	
141466	BALANCING MANDREL	
141470	CONMR. BAR PITCH KNG WITH SERATED RIE	
1414602	CONMR. BAR PITCH KNG	
1571052	CONMR. BUILDING RING	
1414261	SEASONING MANDREL	
1457125	PRESSING DEVICE	
1457126	SEASONING MANDREL	
1571248	PRESSING FIXTURE UR 300 TP	
157445	BALANCING	

NO.	ITEM NO.	DESCRIPTION	QTY.	UNIT	WT.
015	013	HEX. SOCKET HD SET SCREW M6xL20-P-12.9	002	KG	65.3
015	012	BALANCING WEIGHT	001	KG	0.30
001	011	POLY GLASS TAPE 0.33x20x40MMR	001	KG	0.10
002	010	PACKING	001	KG	5.56
001	009	COMMUTATOR NUT	001	KG	11.5
001	008	DISK SPRING	001	KG	28.0
001	007	COMMUTATOR VEE RING	001	KG	0.04
001	006	COMMUTATOR BAR AND SEGMENT MICA	00	KG	80.0
001	005	INSULATION RING OF COMMUTATOR	003	KG	0.30
001	004	INSULATION RING OF VEE INSULATION OF COMMUTATOR	002	KG	0.91
001	003	VEE INSULATION OF COMMUTATOR	001	KG	0.70
001	002	PITE	00	KG	0.4
001	001	COMMUTATOR SPIDER	001	KG	80.0

ADDITIONAL INFORMATION

STATUS OF DRAWING: TXM - 4

DISTRIBUTION OF PRINTS: TXM - 4

REVISIONS:

REV.	DATE	DESCRIPTION
01	08.10.10	APPROVED
02	19.10.10	APPROVED
03	21.12.11	APPROVED
04	13.01.12	APPROVED
05	23.09.10	APPROVED

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT

HS. 15250 A
 25KV AC LOGO

COMMUTATOR ASSEMBLY.

DRAWING NO. 14394260051

DATE: 23.09.10

BY: BHADRAURVA

CHECKED: 23.09.10

APPROVED: 23.09.10

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REV. DATE ALTERED CHECKED APPROVED

ZONE DIM.38 & DIM.46 WERE 40 & 48.

NOTE-10 & 11 WERE NOT ON.

ZONE DIM.135 WAS 130(E-3)

ZONE DRG. MODIFIED.

NOTE-9 WAS NOT ON. IN BOM

IT.007 DRG. NO. CHANGED.

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