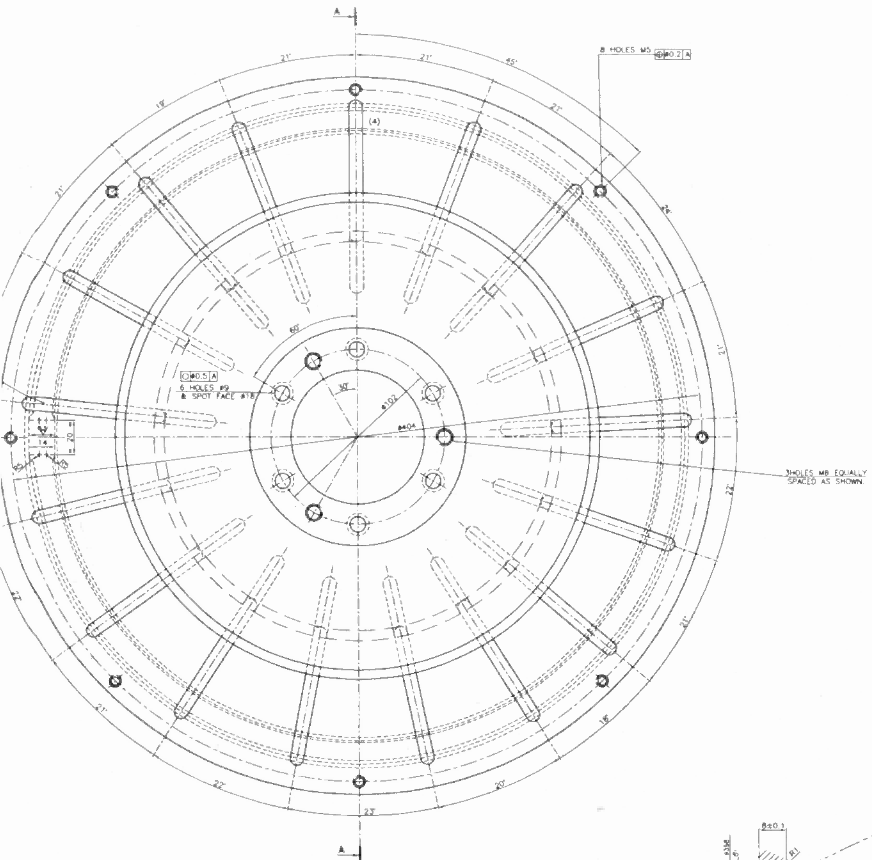
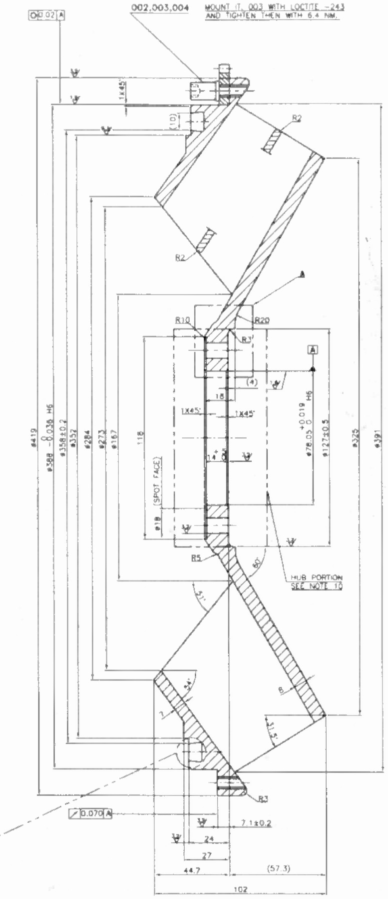
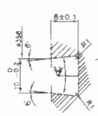
FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)





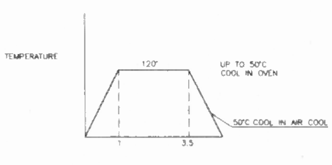
SECTION-AA



TOOL LIST		
IT. NO.	TOOL NO.	DESCRIPTION
001	1579019	DOVETAIL TOOL LH & RH
001	1579020	DOVETAIL :- CHECKING GAUGE
001	1579126	STEP GAUGE 27- (7.1+/-0.2)
001	1579127	STEP GAUGE 27- 14=13
001	1579128	CALLIPER GAUGE 352
001	1579130	OFFSET PIN GAUGE 127±0.5
001	1579131	SNAP GAUGE 14MM
001	1579132	DRILL JIG FOR ALL HOLES.
001	1579067	STATIC BALANCING MANDREL
001	1579018	CALLIPER GAUGE $388^{0}_{-0.036}$
001	1579174	DYNAMIC BALANCING MANDREL

NOTES:-

1. NON STATED RADII R=3.
2. MATERIAL TESTING AS PER SPECIFICATION. TM07375.
3. VENTILATOR TO BE STRESS RELIVED.
4. VENTILATOR TO BE GIVEN AN ACCURATE DYNAMIC BALANCE BY THE ADDITION OF BALANCE WEIGHTS OF SUITABLE QUANTITY AS PER DRAWING NO.34450203004.
5. CASTING TOLERANCES IS 4897 CLASS-I
6. MACHINING ALLOWANCES TO BE MAINTAINED 5^{+2}_{0}.
7. RADIOGRAPHY TO BE DONE AS PER SPEC TM07375 AT POSITION MARKED 'A' & DP TESTING TO AA 0850131 & AA 0850132 FOR REMAINING PORTION.



STRESS RELIEVING CYCLE

VAR.OO	REMARKS	VAR NO.	ITEM NO.	DESCRIPTION	STD.	DRAWING NO.	IT. NO. / VAR.	MATL. CODE / MATL. SPCN.	A/C	UNIT	UNIT WT. / QTY.	GS	ZONE
001			005	BALANCE WEIGHT		34450203005	00						
008			004	WASHER M/CD ø5.3				AA7161001030 AA7161001					
008			003	SOCKET HD SCREW M5X25,P8.8				AA7123125					
001			002	TOOTH RING		34450103001	001						
001			001	VENTILATOR G-Al Si 7Mg Wa				TM07375					

28 — CARD TYPE-3 · 28 — CARD TYPE-1 · 28 — CARD TYPE-2

ADDITIONAL INFORMATION	TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT: IM3601AZ
STATUS OF DRAWING	
DISTRIBUTION OF PRINTS TME-1 TXM-3 TNX-1	BHARAT HEAVY ELECTRICALS LTD. BHOPAL

	NAME	SIGN	DATE	NO. OF VAR.
DRN	A.JHARIA	[signature]	02.08.11	00
CKD	D.K.	[signature]	02.08.11	
APPD	A.S.	[signature]	02.08.11	

DEPT.	GRADE OF UN.TOL. DIM. F/M/F	SCALE	WEIGHT(K.G.)	REF.TO ASSY.DRG.	ITEM NO.	NO.OF ITEM
TME CODE 405	AA0230208	NTS	6.0	04451003001	007	005

REV.	DATE	ALTERED / CHECKED / APPD.	ZONE

TITLE: VENTILATOR 17 BLADES, NDE (R&D DEVELOPED)

DRAWING NO. 14450203004 REV. 00

SHT.NO. 01 NO. OF SHT. 01

RAILWAY BOARD CONTRACT NO. 2010/ELECT.(DEV.)/181/8 DATED:23-11-2010