



NOTE: -

ACCEPTANCE CRITERIA:

- A) CO2 (CARBON DIOXIDE) MIG. WELDING.
- B) SHAFT DIA SHOULD BE UNIFORM.
- C) STRAIGHTNESS OF LEVERS MUST BE MAINTAINED
- D) HOLES DIMENSION MUST BE MAINTAINED AS PER DRG.
- E) STRAIGHTNESS OF SHAFT MUST BE MAINTAINED WITHIN 0.1 mm.
- F) QUALITY OF PLATING OF SHAFT MUST BE GOOD.

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REV	DATE	DESCRIPTION	QTY	UNIT	WT.			
003	-	015 SPRING GUIDE	4	521 10 01544	0.169			
012	012	014 WASHER FOR SHAFT	2	521 10 01586	0.015			
002	002	013 CIRCLIP FOR SHAFT	AA 7167001066	-	0.002			
002	002	012 BRASS BUSH	4	521 10 01505	0.189			
003	003	011 BUSH (M.S.TUBE)	4	521 10 01545	0.011			
003	003	010 RUBBER SPRING	4	521 10 01631	0.003			
003	003	009 WASHER	2	521 10 01586	0.002			
002	002	008 CLIP	2	521 10 01588	0.002			
001	001	007 SUPPORT ROLLER	4	521 10 01621	0.018			
001	001	006 PIN FOR SUPPORT ROLLER	4	521 10 01512	0.02			
006	006	005 CLIP	2	521 10 01588	0.003			
003	003	004 PIN FOR BEARING	4	521 10 01595	0.048			
006	006	003 BEARING	4	521 10 01633	0.075			
-	003	002 SPRING GUIDE	4	521 10 01544	0.232			
001	001	001 MECHANISM SHAFT	1	521 10 01501	5.753			
VAR.01	VAR.00	REMARKS	VAR. NO	ITEM NO	DESCRIPTION	DRW. NO	MATL. CODE	UNIT WT.

VAR. 00 : MATERIAL CODE: BP9089125370
 GES NO.: 409531056, FOR C1 V.I.

VAR. 01 : MATERIAL CODE: BP9089125434
 GES NO.: 409531065, FOR B14 V.I.

ADDITIONAL INFORMATION		TYPE OF PRODUCT OR NAME OF CUSTOMER / PROJECT	
STATUS OF DRAWING M		VM12 (820)	
DISTRIBUTION OF PRINTS O/C-1 SWM-3 TCX-1		BHARAT HEAVY ELECTRICALS LTD. BHO PAL	
DRW. NO	DATE	SCALE	WEIGHT
0009	08.01.14	1:1	-
TITLE		DRW. NO	DATE
ASSY. OF MECHANISM SHAFT VM-12 (820)		00	08.01.14
SHEET NO. 01		REV	NO
		00	01

REV	DATE	ALTERNATED	REV	DATE	ALTERNATED	REV	DATE	ALTERNATED	REV	DATE	ALTERNATED	REV	DATE	ALTERNATED	REV	DATE	ALTERNATED
ZONE		CHECKED	ZONE		CHECKED	ZONE		CHECKED	ZONE		CHECKED	ZONE		CHECKED	ZONE		CHECKED