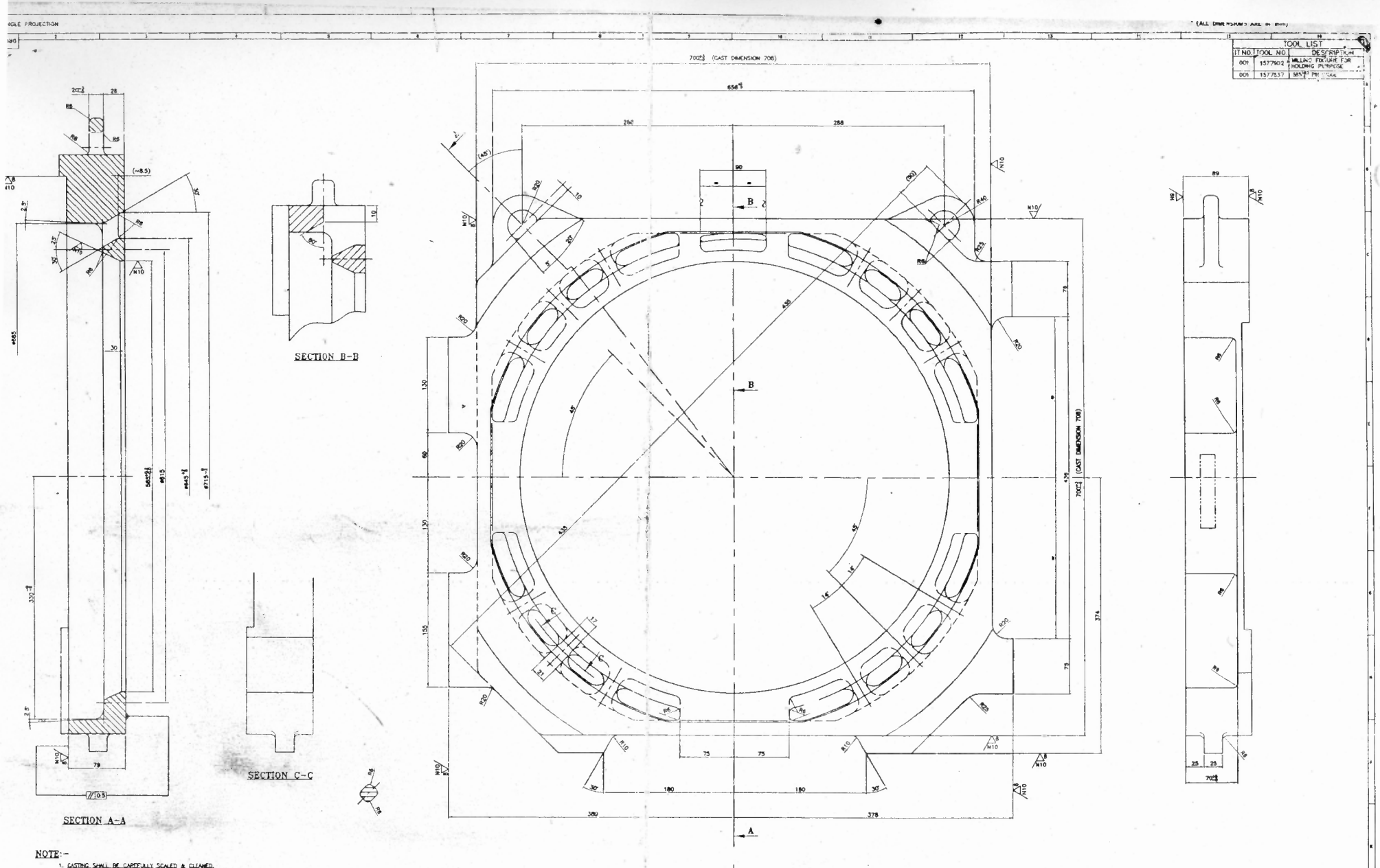


| TOOL LIST | | |
|---|---|---|
| IT NO. | TOOL NO. | DESCRIPTION |
| 001 | 1577902 | MILLING FIXTURE FOR HOLDING PURPOSE |
| 001 | 1577837 | [illegible] |

NOTE:-

1. CASTING SHALL BE CAREFULLY SCALED & CLEANED.
2. ~~MATERIAL CARBON STEEL CASTING Gr 230 450 W TO IS 1030/89~~
3. AIR POCKETS AND TERMINAL POCKET AT SECTION-B SHALL BE PROPERLY DRESSED & REQUIRED RADIUS SHALL BE CAREFULLY MAINTAINED.
4. RADIOGRAPHIC- CASTING MADE ACCORDING TO SPECN. NO TM-11488 (LATEST REV.) SHALL BE SUBJECT TO RADIOGRAPHIC TEST & DIMENSIONAL CHECKS TO BE CARRIED OUT 100%.
5. MATERIAL TESTS TO BE CARRIED OUT BY BHEL
6. FIRM SHOULD HAVE THEIR OWN FOUNDRY DULY APPROVED BY RDSO AS CLASS-A FOUNDRY FOR CASTING RAW MATERIAL OF SPECIFIED GRADE (CARBON STEEL CASTING TO IS : 1030/ 89 GRADE 230-450 W) FOR ITEM STATOR CHAMBER DE & NDE OR THEY HAVE TO SUBMIT ADEQUATE DOCUMENTARY EVIDENCE REGARDING SOURCING OF RAW MATERIAL (CASTING) FROM RDSO APPROVED CLASS-A FOUNDRY ONLY.

| SURFACE ROUGHNESS VALUE TO IS:3073 | GRADE NUMBER | N1 | N2 | N3 | N4 | N5 | N6 | N7 | N8 | N9 | N10 | N11 | N12 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | Ra μ m | 0.025 | 0.05 | 0.1 | 0.2 | 0.4 | 0.8 | 1.6 | 3.2 | 6.3 | 12.5 | 25 | 50 |
| | SYMBOL | ∇ | | | | ∇ | | ∇ | | ∇ | | ∇ | ~ |

| REV. | DATE | ALTERED CHECKED APPROVED | REV. | DATE | ALTERED CHECKED APPROVED | REV. | DATE | ALTERED CHECKED APPROVED | REV. | DATE | ALTERED CHECKED APPROVED |
|---|---|---|---|---|---|---|---|---|---|---|---|
| 04 | 28.08.13 | | 03 | 27.12.11 | | 02 | 12.06.11 | | 01 | 07.01.11 | |

BOM R.WT 115 KG & FINISH WT.94KG WERE NOT ON

TM-11488 WAS ON 4TH/06.06.06

ORIG. UPDATE & CHARTERED

| | | | |
|---|---|---|---|
| | | STATOR CHAMBER (NDE) CNC MACHD. | |
| R.WT.-115KG | | STATOR CHAMBER (NDE) (CAST) | TM-11488 |
| | | | TM-11488 |

ADDITIONAL INFORMATION 1TNO.084.016, (ALT.5)

STATUS OF DRAWING

DISTRIBUTION OF PRINTS TME-1, TMM-3, TMH-1

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT

BHARAT HEAVY ELECTRICALS LTD. BHOPAL

TRACTION MOTOR 6FRA-6058

| | | | |
|---|---|---|---|
| DRN. | ENGGR | -sd- | 01/08/10 |
| CHK. | D.K | -sd- | 01/08/10 |
| APPD. | A.S | -sd- | 01/08/10 |

0440 31 94 062

STATOR CHAMBER(NDE) CNC MACHD.

0 445 31 54 054

SIZE A0