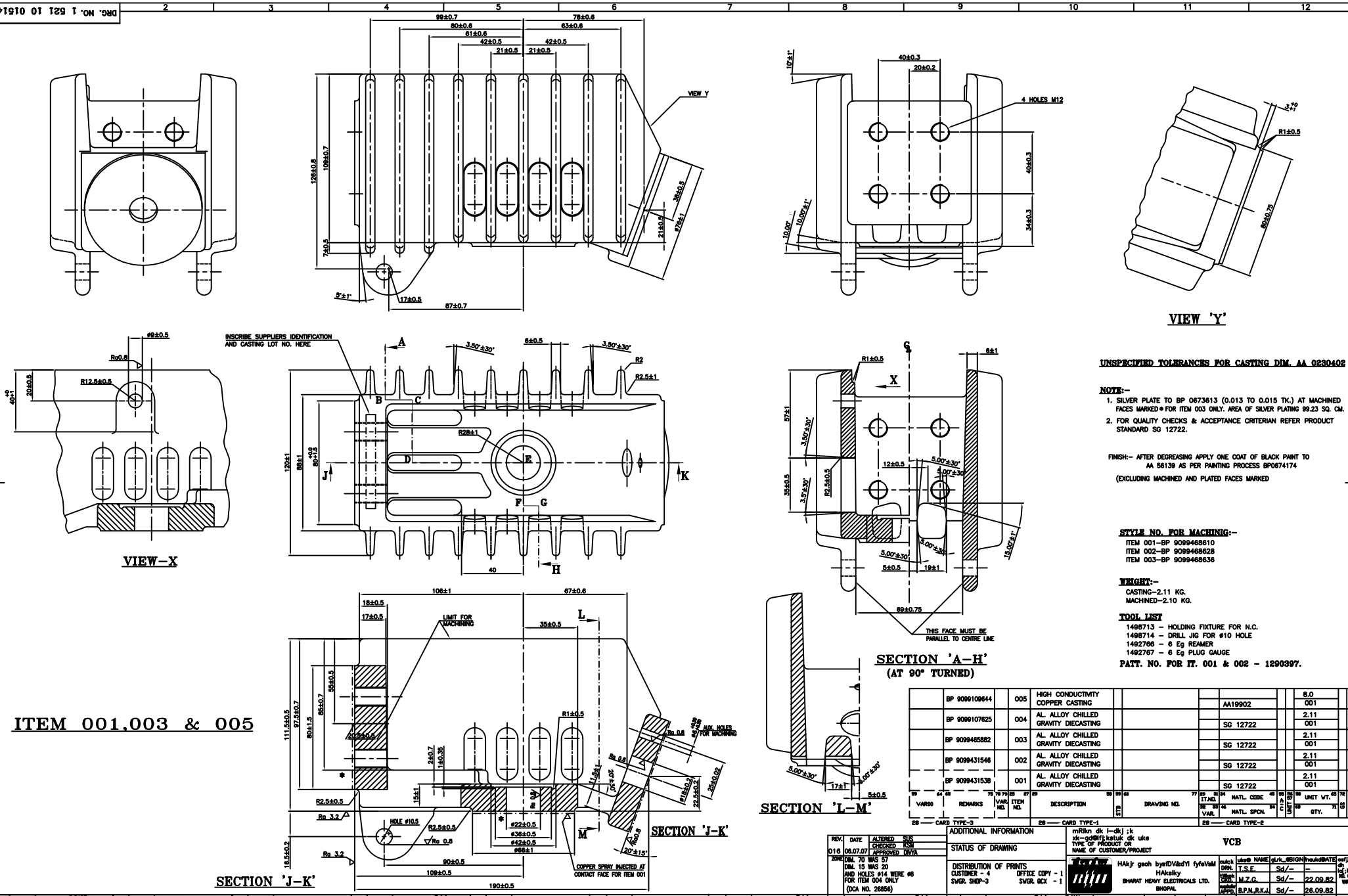
FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

DRG. NO. 1 521 10 01614



ITEM 001,003 & 005

UNSPECIFIED TOLERANCES FOR CASTING DIM. AA 0230402

NOTE:-

1. SILVER PLATE TO BP 0673613 (0.013 TO 0.015 TK.) AT MACHINED FACES MARKED ⊕ FOR ITEM 003 ONLY. AREA OF SILVER PLATING 99.23 SQ. CM.
2. FOR QUALITY CHECKS & ACCEPTANCE CRITERIAN REFER PRODUCT STANDARD SG 12722.

FINISH:- AFTER DEGREASING APPLY ONE COAT OF BLACK PAINT TO AA 56139 AS PER PAINTING PROCESS BP0674174

(EXCLUDING MACHINED AND PLATED FACES MARKED

STYLE NO. FOR MACHINIG:-

ITEM 001-BP 9099468610
ITEM 002-BP 9099468628
ITEM 003-BP 9099468636

WEIGHT:-

CASTING-2.11 KG.
MACHINED-2.10 KG.

TOOL LIST

1498713 - HOLDING FIXTURE FOR N.C.
1498714 - DRILL JIG FOR ø10 HOLE
1492766 - 6 Eg REAMER
1492767 - 6 Eg PLUG GAUGE

PATT. NO. FOR IT. 001 & 002 - 1290397.

VAR00	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.NO. / VAR.	MATL. CODE / MATL. SPCN.	UNIT SYS	UNIT WT. / QTY.	CS	ZONE
			BP 9099109644	005	HIGH CONDUCTIVITY COPPER CASTING			AA19902		8.0 / 001		
			BP 9099107625	004	AL. ALLOY CHILLED GRAVITY DIECASTING			SG 12722		2.11 / 001		
			BP 9099465882	003	AL. ALLOY CHILLED GRAVITY DIECASTING			SG 12722		2.11 / 001		
			BP 9099431546	002	AL. ALLOY CHILLED GRAVITY DIECASTING			SG 12722		2.11 / 001		
			BP 9099431538	001	AL. ALLOY CHILLED GRAVITY DIECASTING			SG 12722		2.11 / 001		

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

REV.	DATE	ALTERED / CHECKED / APPROVED	REV.	DATE	ALTERED / CHECKED / APPROVED	REV.	DATE	ALTERED / CHECKED / APPROVED	REV.	DATE	ALTERED / CHECKED / APPROVED	REV.	DATE	ALTERED / CHECKED / APPROVED	REV.	DATE	ALTERED / CHECKED / APPROVED	REV.	DATE	ALTERED / CHECKED / APPROVED	REV.	DATE	ALTERED / CHECKED / APPROVED	REV.	DATE	ALTERED / CHECKED / APPROVED
015	20.02.07	P.PARE / KSM / M.AZAM	014	02.11.06	/ / DIVYA	014	02.11.06	/ / DIVYA	013	24.08.06	/ / Sd/-	12	25.5.04	/ / RM	11	10.06.03	/ / H.R.P.	10	05.12.00	/ / Sd/-	09	06.10.99	/ / Sd/-	08	08.08.97	/ / Sd/-
ZONE	NOTE FOR PAINTING CHANGED (DCA-26241)		ZONE	NOTE FOR MACHINING OF FINS ADDED FOR IT. 004.		ZONE	NOTE FOR MACHINING OF FINS ADDED FOR IT. 003. (DCA NO.-)		ZONE	NOTE FOR COPPER SPRAY DELETED. (DCA NO.-26074)		ZONE	IT.005 ADDED. SHT.04 ADDED. (DCA NO. 20250)		ZONE	DRAWING REDRAWN. SHT. 02 & 03 ADDED. IT 005 ADDED & FINISH MODIFIED. (DCA NO. 10439)		ZONE	ITEM 004 ADDED. (DCA 10311)		ZONE	NOTE 1 TO 4 DELETED. MATERIAL SPEC. SG 12722 WAS BP 19990 LM 9 WP FINISH COLOUR WAS CREAM TO SHADE NO. 885. (DCA 9701)		ZONE	STYLE NO. FOR MACHINING ADDED. CASTING WT. WAS 2.28 KG. MACHINED WT. ADDED. (DCA 08577)

REV.	DATE	ALTERED / CHECKED / APPROVED
016	06.07.07	SUS / KSM / DIVYA

ZONE DIM. 70 WAS 57
DIM. 15 WAS 20
AND HOLES ø14 WERE ø8
FOR ITEM 004 ONLY
(DCA NO. 26856)

ADDITIONAL INFORMATION

STATUS OF DRAWING

DISTRIBUTION OF PRINTS
CUSTOMER - 4 OFFICE COPY - 1
SVGR. SHOP-3 SVGR. QCX - 1

mRlkn dk i-dkj ;k
xk-gdØlf;kstuk dk uke
TYPE OF PRODUCT OR
NAME OF CUSTOMER/PROJECT

VCB

HAkjr gaoh byefDVªdVl fyfeVsM
HAkelky
BHARAT HEAVY ELECTRICALS LTD.
BHOPAL

	NAME	SIGN	DATE
drawn	T.S.E.	Sd/-	-
checked	M.Z.G.	Sd/-	22.09.82
approved	B.P.N.,R.K.J.	Sd/-	26.09.82

HAkjr ln ;kstuk dk ladsr ;k
DEPT. SYM. INTDL. DIMS. GR. 409 M 0230409
'AN'AZIBLE

HAkjr ln ;kstuk dk laHkkZ
BHEL

TOP POLE HEAD

Mkhdsu ekMZ DRAWING NO. 1 521 10 01514

ITEM NO. 012, 013 & 084 ITEM 005

SHT. NO. 01 OF SHT. 04

016

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