



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.

NO	QTY	DESCRIPTION	UNIT	QTY	REMARKS	DATE	BY	CHKD	APPD
001	4	SPRING GUIDE	001	0.169					
002	2	WASHER FOR SHAFT	007	0.015					
003	2	CIRCLIP FOR SHAFT	-	0.002					
004	4	BRASS BUSH	001	0.189					
005	4	BUSH (AUSTUBE)	001	0.011					
006	4	RUBBER SPRING	001	0.003					
007	2	WASHER	002	0.002					
008	2	CLIP	002	0.002					
009	4	SUPPORT ROLLER	001	0.018					
010	4	PIN FOR SUPPORT ROLLER	001	0.02					
011	2	CLIP	006	0.003					
012	4	PIN FOR BEARING	001	0.048					
013	4	BEARING	001	0.075					
014	4	SPRING GUIDE	003	0.232					
015	1	MECHANISM SHAFT	001	5.725					

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

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

REV	DATE	ALTERED	REASON	ZONE	REV	DATE	ALTERED	REASON	ZONE	REV	DATE	ALTERED	REASON	ZONE	REV	DATE	ALTERED	REASON	ZONE	REV	DATE	ALTERED	REASON	ZONE
001					001					001					001					001				

INVENTORY NO.	SIGN & DATE	REF. DRG. NO.	THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.																						
ADDITIONAL INFORMATION		TYPE OF PRODUCT		NAME OF CUSTOMER / PROJECT		VM12 (920)		STATUS OF DRAWING		M		DISTRIBUTION OF PRINTS		O/C-1 SWM-3		REV		DATE		ALTERED		REASON		ZONE	
BHM/UNIT/DIRS/DR		BHARAT HEAVY ELECTRICALS LTD.		BHM/UNIT/DIRS/DR		VM12 (920)		O/C-1 SWM-3		M		BHM/UNIT/DIRS/DR		VM12 (920)		M		1:1		VM12 (920)		M		VM12 (920)	
ASSY. OF MECHANISM SHAFT		VA-12 (920)		SHEET NO. 01		NO. OF SHEETS 01		DATE		01/14		REV		00		DATE		01/14		REV		00		DATE	