

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

1900924634E - ON DRG

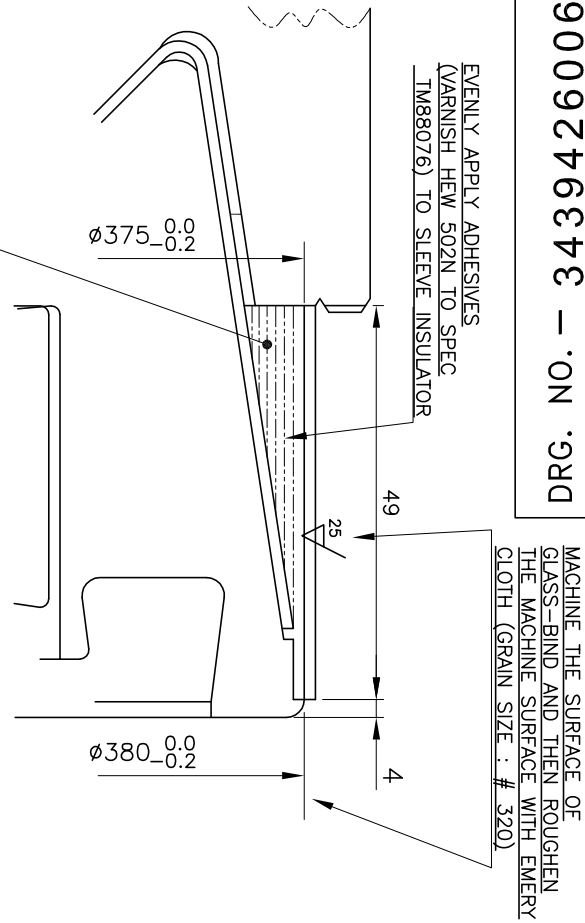


FIG - 4

INSTRUCTIONS FOR TEFLON RING INSERTION:-

1. BEFORE FITTING TEFLON RINGS, WORK THE SURFACE OF GLASS BIND (FIG.4).
2. COMPLETELY DEGREASE SURFACES TO WHICH PTFE RING IS ADHERED AND SURFACES WHICH ARE SODIUM TREATED.
3. EVENLY APPLY ADHESIVES (VARNISH:HEW502N TO SPEC TM88076) TO SLEEVE INSULATION AND INNER SURFACE OF PTFE RING PARTS.
4. REMOVE THE PTFE RING FROM PVC TUBE AND INSERT IT INTO COMMUTATOR SLEEVE INSULATION PART.
5. HEAT EVENLY AROUND OUTER CIRCUMFERENCE OF PTFE RING TO SHRINK IT BY HEAT.
6. STOP HEATING WHEN THE PTFE RING SHRINKS COMPLETELY AROUND THE SLEEVE INSULATION PART.
7. CURE ADHESIVES (VARNISH:HEW502N TO SPEC TM88076) (VARNISH CURING:130°Cx12HR). AFTER THE ADHESIVE HAS HARDENED CHECK VISUALLY ADHESION OF PTFE RING.
8. CHECK IF THERE IS NO OPENING AT BOTH ENDS OF PTFE RING (PARTS (A) AND (B)), PARTICULARLY CHECK PART (A) CAREFULLY SHOULD ANY OPENING BE FOUND FILL IT WITH VARNISH (HEW501N TO SPEC TM88076).
9. ALTHOUGH THE PTFE RING IS SHIPPED AS INSERTED TO PVC TUBE, REMOVE THE PTFE RING FROM THE TUBE IMMEDIATELY BEFORE INSERTING INTO THE SLEEVE INSULATION PARTS SINCE THE RING CONTRACTS IN RADIUS DIRECTION.

NOTES:-

1. THE SUPPLIER SHALL INDICATE THE THICKER END OF THE RING BY (COLOURED/BLACK BASED) ADHESIVE STICKER ON GLOSSY (NON-ETCHED) SURFACE.
2. MANUFACTURERS IDENTIFICATION TO BE STAMPED AT THE LOCATION SHOWN.
3. THIS DRG. IS EQUIVALENT TO CLW DRG. NO. 10R812-076 ALT.F.

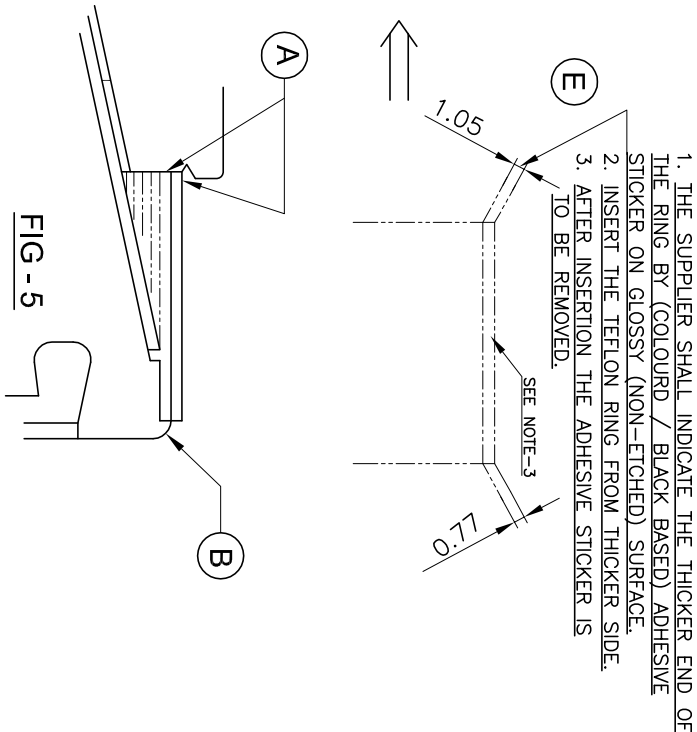


FIG - 5

INSTRUCTIONS TO PROCESS THE TEFLON RING (BY MANUFACTURER):-

1. EXPAND A CIRCULAR SHAPED PTFE RING (BY MANUFACTURER) SHOWN IN FIG.1 MATERIAL DRAWING (* ØD SHALL BE DETERMINED BY THE MANUFACTURER) TO THE SHAPE SHOWN IN FIG.2 DELIVER IT AS BEING INSERTED TO PVC TUBE.
2. THOROUGHLY ROUGHEN THE INNER CIRCUMFERENCE OF TEFLON RING AND SODIUM TREAT IT.
3. SODIUM TREATMENT SHALL BE APPLIED EVENLY CARE SHALL BE TAKEN NOT TO HAVE GREASE OR DUST ON SODIUM TREATED SURFACE.
4. WHILE PACKING AND HANDLING CARE SHALL BE TAKEN NO TO DAMAGE ANY SURFACE OF PTFE RING.
5. THE PTFE RING SHALL BE STORED AND HANDLED WITH CARE NOT TO EXPOSE IT TO ULTRAVIOLET RAYS WHICH WILL DETEIORATE THE SODIUM TREATED SURFACE.
6. SINCE THE PRODUCT IS SHAPED FROM THE CIRCULAR SHAPE SHOWN IN FIG.1 TO THE ONE IN FIG.2 THICKNESS OF THE PTFE RING VARIES ON BOTH SIDES MAKE SURE TO ATTAIN TARGET SIZES IN FIG.3

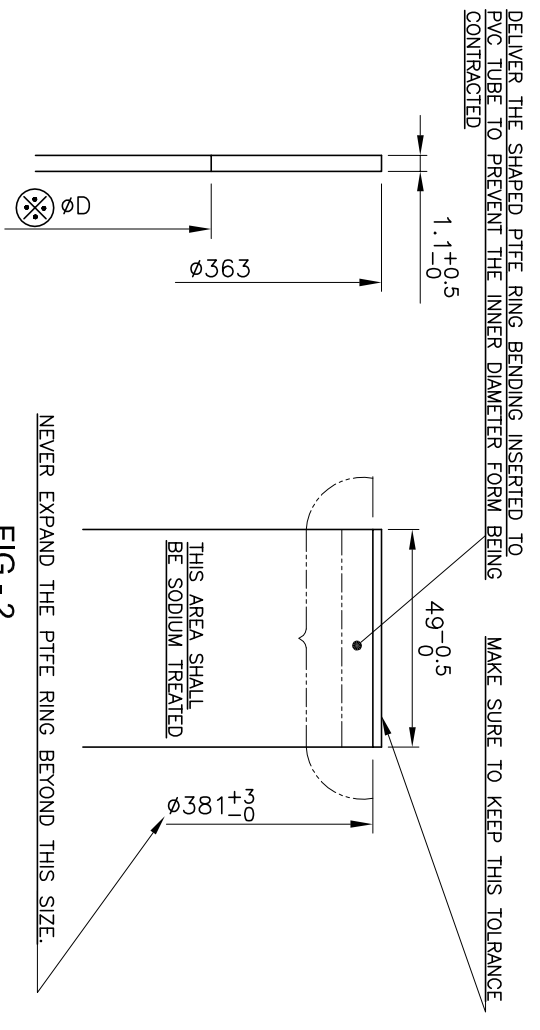


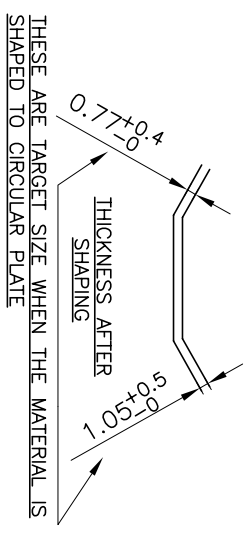
FIG - 1

MATERIAL DRAWING

FIG - 2

SHAPE DRAWING OF PTFE RING (AS DELIVERED)

FIG - 3



INVENTORY NO.	SIGN. & DATE	REF. DRG. NO.

ADDITIONAL INFORMATION STATUS OF DRAWING DISTRIBUTION OF PRINTS TME-1, TXM-3, TNX-1		TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT TRACTION MOTOR HS:15250A	
DEPT. TIME UNTOL. DIMS. GR. SCALE WEIGHT (K.G.) REF. TO ASSY. DRG. 14394260051		BHARAT HEAVY ELECTRICALS LTD. BHOPAL DRN. S.D.BHAGAT CHD. D.K. APPD. SPAL SIGN DATE 21/09/10 21/09/10 21/09/10	
PTFE RING DRAWING NO. 77		PTFE MATL. CODE 45 MATL. SPCN. 54 UNIT WT. 65 QTY. 71	
PTFE RING DRAWING NO. 77		PTFE MATL. CODE 45 MATL. SPCN. 54 UNIT WT. 65 QTY. 71	

REV.	DATE	ALTERED	REV.	DATE	ALTERED
02	20.09.12	CHECKED APPROVED	01	20.10.10	CHECKED APPROVED
ZONE		WT.O.4KG WAS NOT ON.	ZONE		DRG. UPDATED.

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SIZE A3