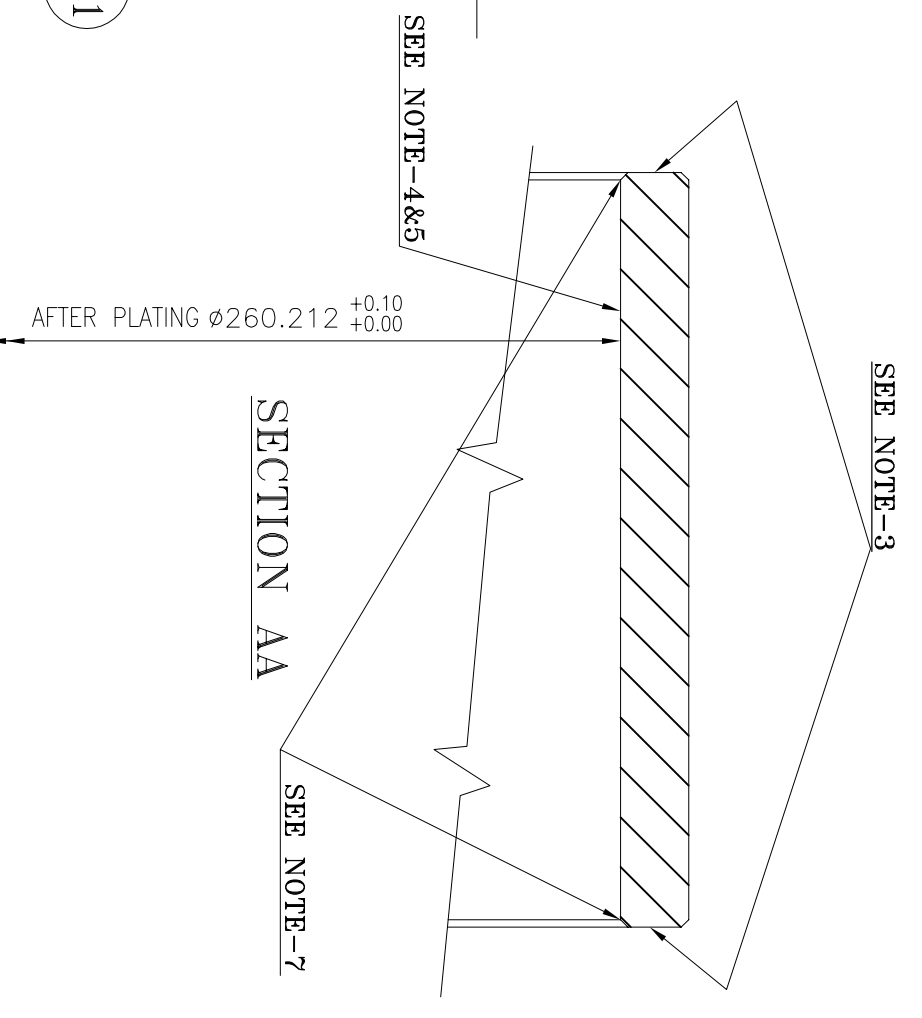
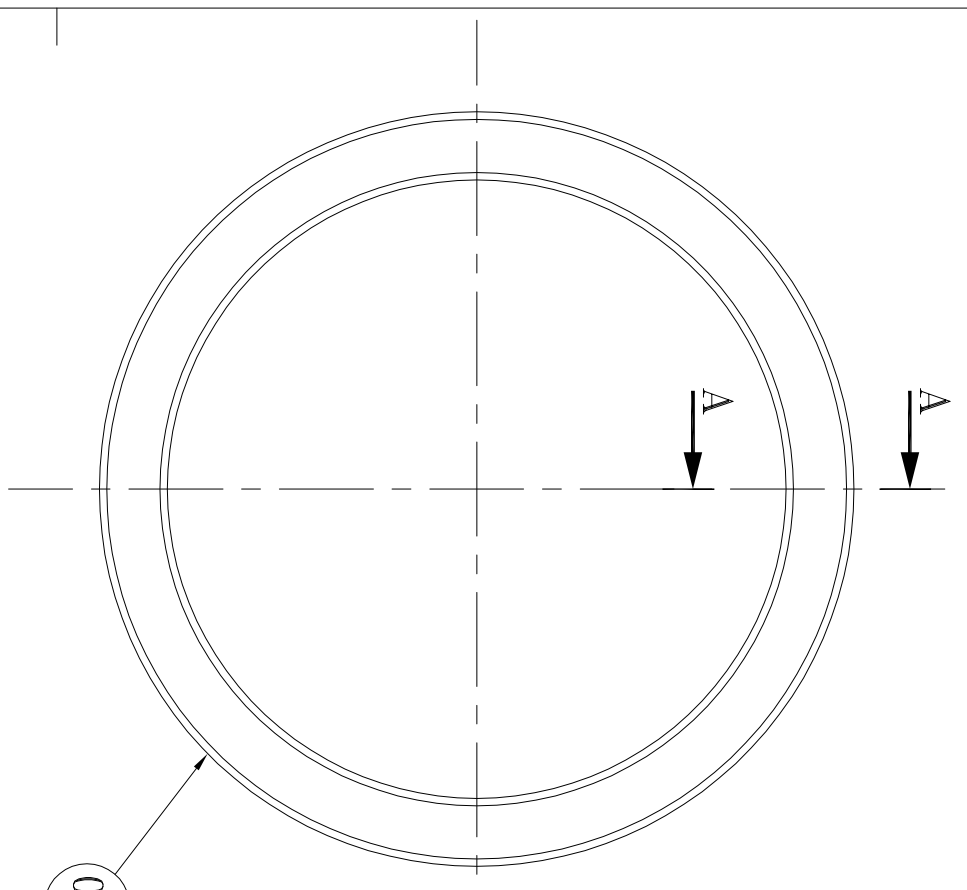


200 92 44 034 3 DRG. NO.



TOOL LIST		
IT NO.	TOOL NO.	DESCRIPTION
001	1580136	PIN GAUGE 260.212+0.05/+0

**NOTES:-**

1. SURFACES OF PARTS TO BE PLATED SHALL BE SMOOTH AND FREE FROM BLEMISHES, PITTS, TOOL MARKS AND OTHER IRREGULARITIES.
2. AREAS THAT ARE NOT TO BE PLATED SHALL BE MASKED OFF WITH WAX, INSULATING PAINT OR OTHER STOP OFF.
3. PLATING ON ENDS CONSISTENT WITH BORE PLATING THICKNESS IS PERMISSIBLE. PLATING IS NOT ALLOWED ON O.D.
4. BORE TO BE PLATED WITH ELECTROLESS NICKEL ELECTROLESS PLATING:-  
PLATE IN NICKEL SALT, SODIUM HYPO PHOSPHITE SOLUTION TO THICKNESS REQUIRED.
5. AFTER PLATING, RINSE AND REMOVE STOP-OFF & BAKE AT 171°C-182°C FOR 3 HOURS IMMEDIATELY AFTER PLATING TO RELIEVE HYDROGEN EMBRITTLEMENT.
6. POST PLATE OPERATIONS MUST NOT LEAVE ANY FEATHER EDGE REVEALING BASIS METAL.
7. PLATING ADHESION THE ELECTROLESS NICKEL PLATING MUST NOT BLISTER OR CRACK WHEN THE SLEEVE PLATED SURFACE IS SUBJECTED TO A 150KG. LOAD WITH ROCKWELL "C" BRALE DIAMOND INDENTER IN A ROCKWELL TESTER. THE ADHESION TEST MUST BE CONFINED TO A SURFACE WITHIN 3.0MM. OF EITHER END OF THE BORE TO AVOID DAMAGING AN OPERATING SURFACE.

REV.	DATE	ALTERED	CHECKED	APPROVED	REV.	DATE	ALTERED	CHECKED	APPROVED	REV.	DATE	ALTERED	CHECKED	APPROVED
07	14.08.12	CHECKED	<i>[Signature]</i>	APPROVED	06	27.07.09	CHECKED	<i>[Signature]</i>	APPROVED	05	30.11.04	CHECKED	<i>[Signature]</i>	APPROVED
04	11.11.04	CHECKED	<i>[Signature]</i>	APPROVED	03	02.11.04	CHECKED	<i>[Signature]</i>	APPROVED	02	03.07.03	CHECKED	<i>[Signature]</i>	APPROVED

DRG. DIGITIZED & UPLOADED.

NOTE 1 MODIFIED. WEIGHT 7.0 WAS 1.5

NOTE WAS NOT ON.

IN SECTION AA  $\phi 260.212^{+0.05}_{+0.00}$  WAS  $\phi 260^{+0.052}_{+0.00}$ . NOTE WAS ON.

VAR DD	REMARKS	VAR. N.D.	ITEM N.D.	DESCRIPTION
001	SLEEVE			

ADDITIONAL INFORMATION  
SIM DRG. NO. 8489656

STATUS OF DRAWING

DISTRIBUTION OF PRINTS  
TME - 1 TAM - 3  
TNX - 1

34304476004

DRAWING NO.

001

MATL. SPECN.

7.0

UNIT WT.

KG.

29.09.00

29.09.00

04.10.00

003

001

TRACTION ALTERNATOR  
TA 9901AZ

भारत हेवी इलेक्ट्रिकल्स लिमिटेड  
BHARAT HEAVY ELECTRICALS LTD.  
BHOBAL

DEPT CODE: 405  
UNTL.DIMS. GR. TM20079  
GR 'M'

SCALE: NTS  
WEIGHT (KG): 7.0

REF. TO ASSY. DRG. 14304476002

DRAWING NO. 3 430 44 76 002

REV. 09