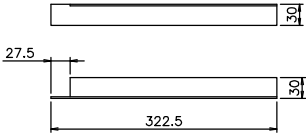


		2				1			
MACHINING DEVIATIONS		RANGE	0 - 6	6 - 30	30 - 120	120 - 315	315 - 1000	1000 - 2000	2000 - 4000
FOR LINEAR DIMENSIONS		TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227									
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM)									
VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS. 1012.C.									
QUALITY OF WELD JOINTS REF. ISO: 5817									

UNCONTROLLED



DETAIL "31"

NOTE

- ITEM NO.12-15 SHALL BE WELDED ON FRAME BY SPOT WELDING.(PITCH=100)
- FLATNESS OF ITEM NO.12-15 SHALL BE MAXIMUM 3 AFTER SPOT WELDING.
- A-B=±3
- C-D=±1
- REMOVE ALL EDGES AND BURRS.
- WELDING AREAS IN FRONT SURFACE SHALL BE CLEANED WITH SUS CLEANER.
- UNSPECIFIED WELDING PARTS SHALL BE INNER WELDING.
- INSULATION SHALL BE FITTED WITH GLASS WOOL PIN WITH APPROX. PITCH OF 300.
- WELDING SYMBOLS ACCORDING TO ISO:2553.
- STOCK NO. FOR 50 THK GLASS WOOL IS R347988005.
- 3 NOS OF ITEM-37 TO BE SUPPLIED AS LOOSE ITEMS



SL No.	QTY	DRG. / STOCK No.	DESCRIPTION	SIZE	COMPANY STD./S.DTD	Wt.(Kg)
39	X5	909-42051	EARTH TERMINAL			
38	X4	909-55020-038	FRAME	PL30x30x12.5	SUS304	
37	X4	909-55020-037	WIRE SUPPORT	Ø6	SUS304	
36	1	909-55120	BRACKET ASSY		ASSY	
35	1	909-55020-035	WIRE SUPPORT	Ø6	SUS304	
34	2	909-55020-034	WIRE SUPPORT	Ø6	SUS304	
33	1	909-55020-033	WIRE SUPPORT	Ø6	SUS304	
32	X2	909-55020-032	FRAME	PL30x30x12.5	SUS304	
31	X2	909-55020-031	FRAME	PL30x30x12.5	SUS304	
30	4	RFW0920820	SPRING WASHER	B8		
29	4	RFS5160816	HEX. HEAD SCREW	M8x16		
28	1	909-55115	KEY BOX FRAME		ASSY	
27	2	909-46060	EARTH TERMINAL Z2-TYPE		ASSY	
26	X4	909-55020-026	WIRE SUPPORT	Ø6	SUS304	
25	AR	R601192000	ADHESIVE SEVEN RESIN		-	
24	20	909-19075	GLASS WOOL PIN ASSY		ASSY	
23	1	909-55020-023	INSULATION	t50x350x581.5	GLASS WOOL	
22	1	909-55020-022	INSULATION	t50x322.5x581.5	GLASS WOOL	
21	1	909-55020-021	INSULATION	t50x367x427	GLASS WOOL	
20	2	909-55020-020	INSULATION	t50x151.5x427	GLASS WOOL	
19	1	909-55020-019	INSULATION	t50x350x475	GLASS WOOL	
18	1	909-55020-018	INSULATION	t50x322.5x475	GLASS WOOL	
17	3	909-50151	BRACKET	t2.5	ASSY	
16	3	909-50152-2	BRACKET	t2.5	ASSY	
15	1	909-55020-015	PANEL	t0.8	SUS304	
14	1	909-55020-014	PANEL	t0.8x149x418	SUS304	
13	1	909-55020-013	PANEL	t0.8	SUS304	
12	1	909-55020-012	PANEL	t0.8	SUS304	
11	X26	909-55020-011	SEAT, SCREW	25x25x12.5	SUS304	
10	1	909-55020-010	FRAME	PL40x30x12.5	SUS304	
9	1	909-55020-009	FRAME	PL40x30x12.5	SUS304	
8	1	909-55020-008	FRAME	PL30x30x12.5	SUS304	
7	1	909-55020-007	FRAME	PL30x30x12.5	SUS304	
6	1	909-55020-006	FRAME	PL30x30x12.5	SUS304	
5	1	909-55020-005	FRAME	PL30x30x12.5	SUS304	
4	1	909-55020-004	FRAME	PL30x30x12.5	SUS304	
3	2	909-55020-003	FRAME	PL30x30x12.5	SUS304	
2	4	909-55020-002	FRAME	PL30x30x12.5	SUS304	
1	2	909-55020-001	FRAME	PL30x30x12.5	SUS304	

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36	1	909-55120	BRACKET ASSY		ASSY	
35	1	909-55020-035	WIRE SUPPORT	Ø6	SUS304	
34	2	909-55020-034	WIRE SUPPORT	Ø6	SUS304	
33	1	909-55020-033	WIRE SUPPORT	Ø6	SUS304	
32	X2	909-55020-032	FRAME	PL30x30x12.5	SUS304	
31	X2	909-55020-031	FRAME	PL30x30x12.5	SUS304	
30	4	RFW0920820	SPRING WASHER	B8		
29	4	RFS5160816	HEX. HEAD SCREW	M8x16		
28	1	909-55115	KEY BOX FRAME		ASSY	
27	2	909-46060	EARTH TERMINAL Z2-TYPE		ASSY	
26	X4	909-55020-026	WIRE SUPPORT	Ø6	SUS304	
25	AR	R601192000	ADHESIVE SEVEN RESIN		-	
24	20	909-19075	GLASS WOOL PIN ASSY		ASSY	
23	1	909-55020-023	INSULATION	t50x350x581.5	GLASS WOOL	
22	1	909-55020-022	INSULATION	t50x322.5x581.5	GLASS WOOL	
21	1	909-55020-021	INSULATION	t50x367x427	GLASS WOOL	
20	2	909-55020-020	INSULATION	t50x151.5x427	GLASS WOOL	
19	1	909-55020-019	INSULATION	t50x350x475	GLASS WOOL	
18	1	909-55020-018	INSULATION	t50x322.5x475	GLASS WOOL	
17	3	909-50151	BRACKET	t2.5	ASSY	
16	3	909-50152-2	BRACKET	t2.5	ASSY	
15	1	909-55020-015	PANEL	t0.8	SUS304	
14	1	909-55020-014	PANEL	t0.8x149x418	SUS304	
13	1	909-55020-013	PANEL	t0.8	SUS304	
12	1	909-55020-012	PANEL	t0.8	SUS304	
11	X26	909-55020-011	SEAT, SCREW	25x25x12.5	SUS304	
10	1	909-55020-010	FRAME	PL40x30x12.5	SUS304	
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8	1	909-55020-008	FRAME	PL30x30x12.5	SUS304	
7	1	909-55020-007	FRAME	PL30x30x12.5	SUS304	
6	1	909-55020-006	FRAME	PL30x30x12.5	SUS304	
5	1	909-55020-005	FRAME	PL30x30x12.5	SUS304	
4	1	909-55020-004	FRAME	PL30x30x12.5	SUS304	
3	2	909-55020-003	FRAME	PL30x30x12.5	SUS304	
2	4	909-55020-002	FRAME	PL30x30x12.5	SUS304	
1	2	909-55020-001	FRAME	PL30x30x12.5	SUS304	

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21	1	909-55020-021	INSULATION	t50x367x427	GLASS WOOL	
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12	1	909-55020-012	PANEL	t0.8	SUS304	
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7	1	909-55020-007	FRAME	PL30x30x12.5	SUS304	
6	1	909-55020-006	FRAME	PL30x30x12.5	SUS304	
5	1	909-55020-005	FRAME	PL30x30x12.5	SUS304	
4	1	909-55020-004	FRAME	PL30x30x12.5	SUS304	
3	2	909-55020-003	FRAME	PL30x30x12.5	SUS304	
2	4	909-55020-002	FRAME	PL30x30x12.5	SUS304	
1	2	909-55020-001	FRAME	PL30x30x12.5	SUS304	