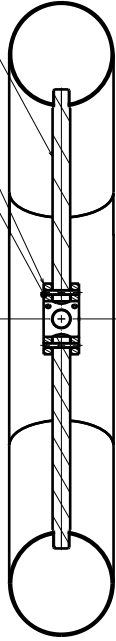


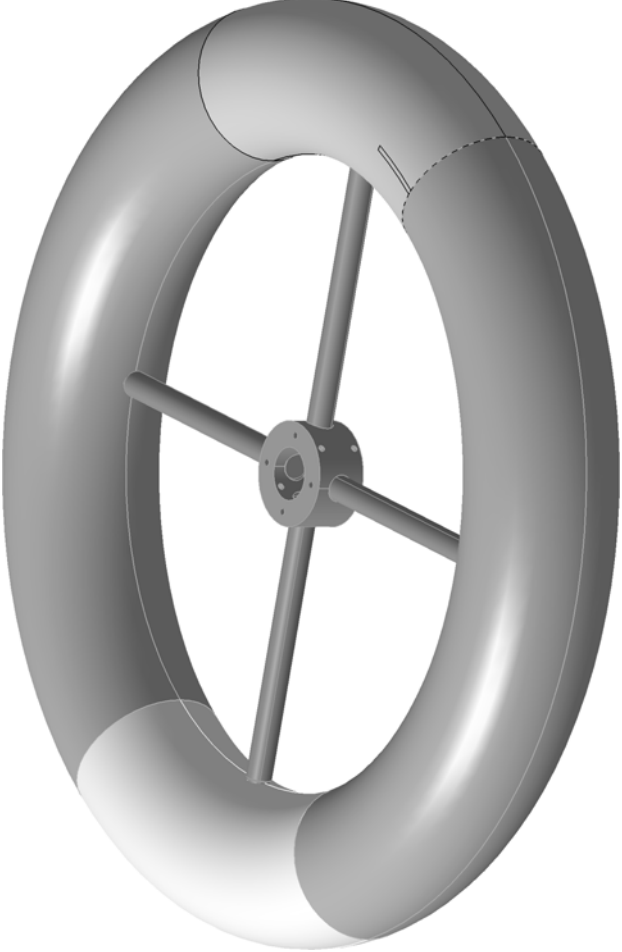
Front View  
Scale: 1:3



Section View A-A  
Scale: 1:3

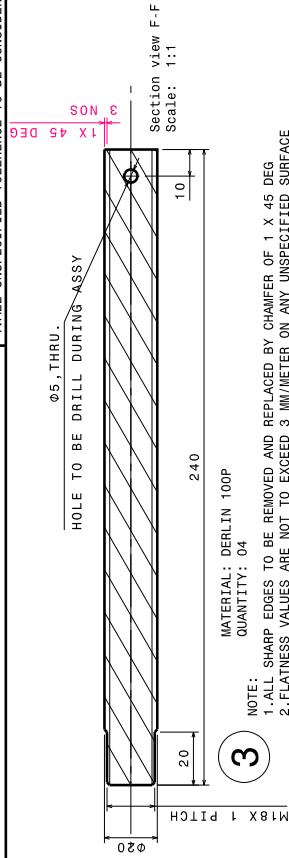
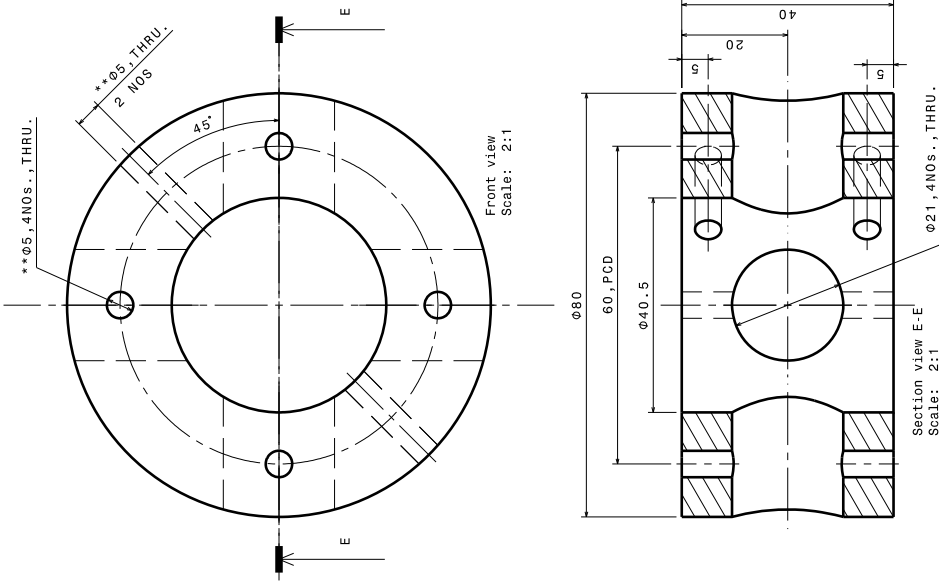
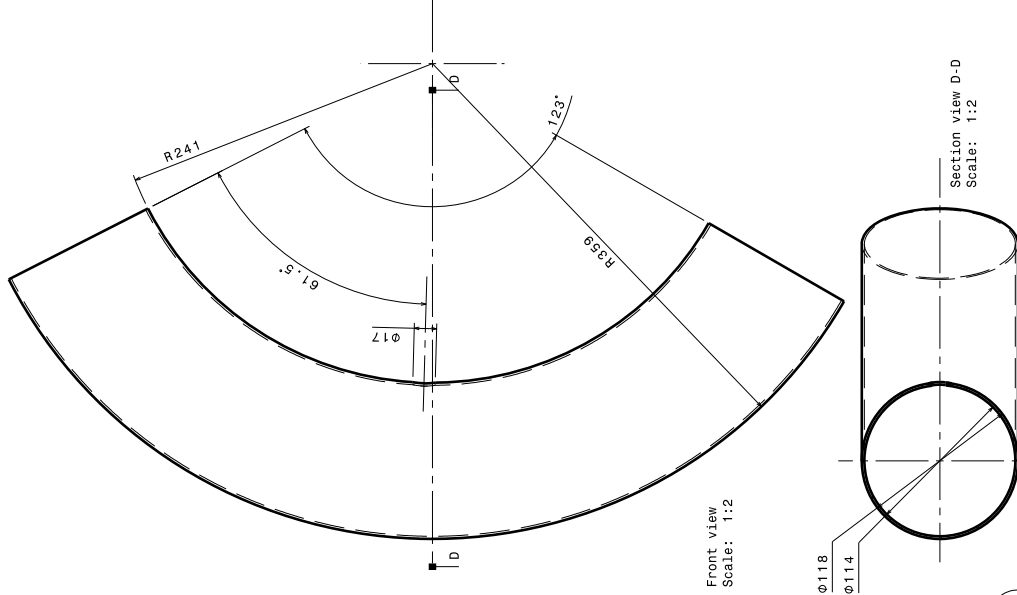
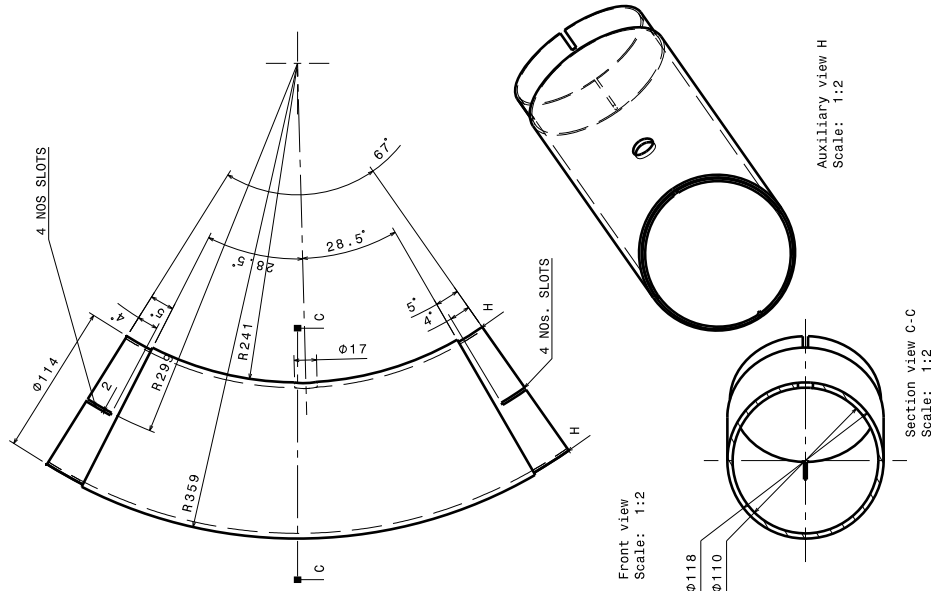
NOTE:  
1. ALL EDGES AND JOINTS, TO BE SMOOTH AFTER ASSEMBLY.  
2. ALL JOINTS ARE PUSH FIT.

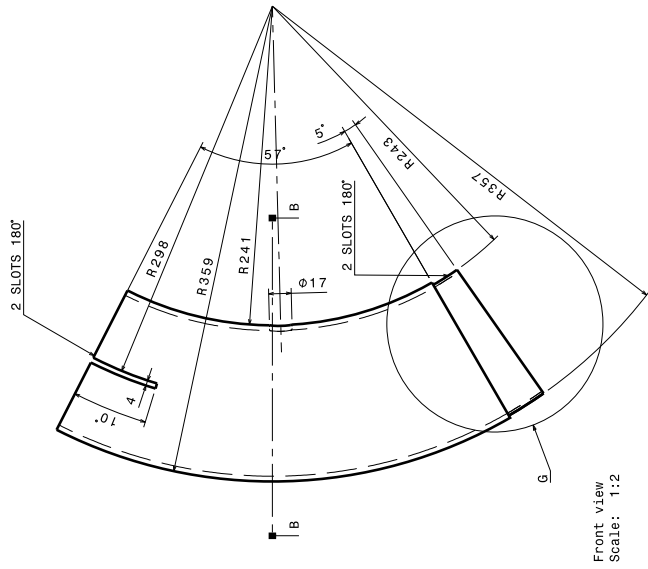
Isometric View  
Scale: 1:2



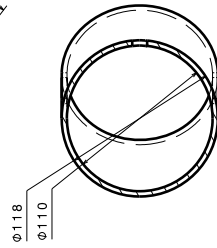
6	IC-RING-DERLIN-4	DERLIN 100 P	2	-
7	IC-RING-DERLIN-2	DERLIN 100 P	1	-
6	IC-RING-DERLIN-3	DERLIN 100 P	1	-
5	ISO 2338 PIN 5x40 STEEL PARALLEL UNHARDENED SS		6	-
4	COUPLING	ALUMINIUM 6061 T6	1	-
3	SUPPORT ROD	DERLIN 100 P	4	-
2	IC-RING-CU	EIP COPPER	2	-
1	IC-RING-DERLIN	DERLIN 100 P	1	-
Item No. Part Number		Material	Quantity	Revision

DIN-NO		8-25	1.6.8	2.625-1.6	WVP	0.005	REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED BY	SCALE	DATE	TITLE
ITER-INDIA, INSTITUTE FOR PLASMA RESEARCH															
IC-RING-ASSY															
DESIGNED / ASSEMBLED / APPROVED / AM															
REF. DRG. NO. - 11/15H/12 INCH/DPST/001															
DIN-NO 11/15H/12 INCH/DPST/01/01															

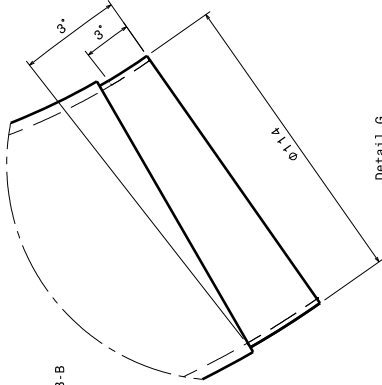
[illegible]



Front view  
Scale: 1:2



Section view B-B  
Scale: 1:2

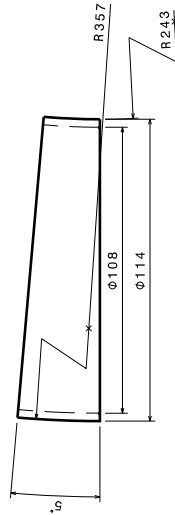


Detail G  
Scale: 1:1

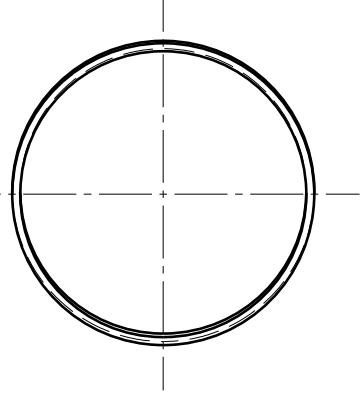
MATERIAL: DERLIN 100P  
QUANTITY: 01

NOTE:

1. ALL SHARP EDGES TO BE REMOVED AND REPLACED BY CHAMFER OF 1 X 45 DEG
2. FLATNESS VALUES ARE NOT TO EXCEED 3 MM/METER ON ANY UNSPECIFIED SURFACE
3. ROUGHNESS OF ALL UNSPECIFIED SURFACES DO NOT EXCEED Ra 8.3  $\mu$ m
4. ALL UNSPECIFIED TOLERANCE TO BE CONSIDERED AS PER ISO 2768-1:1989



Front view  
Scale: 1:1

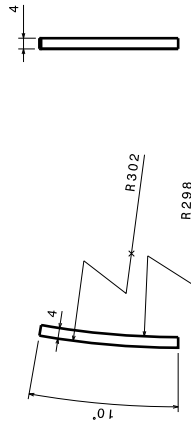


Bottom view  
Scale: 1:1

MATERIAL: DERLIN 100P  
QUANTITY: 01

NOTE:

1. ALL SHARP EDGES TO BE REMOVED AND REPLACED BY CHAMFER OF 1 X 45 DEG
2. FLATNESS VALUES ARE NOT TO EXCEED 3 MM/METER ON ANY UNSPECIFIED SURFACE
3. ROUGHNESS OF ALL UNSPECIFIED SURFACES DO NOT EXCEED Ra 8.3  $\mu$ m
4. ALL UNSPECIFIED TOLERANCE TO BE CONSIDERED AS PER ISO 2768-1:1989



Front view  
Scale: 1:1

Right view  
Scale: 1:1

∞

MATERIAL: DERLIN 100P  
QUANTITY: 02

NOTE:

1. ALL SHARP EDGES TO BE REMOVED AND REPLACED BY CHAMFER OF 1 X 45 DEG
2. FLATNESS VALUES ARE NOT TO EXCEED 3 MM/METER ON ANY UNSPECIFIED SURFACE
3. ROUGHNESS OF ALL UNSPECIFIED SURFACES DO NOT EXCEED Ra 8.3  $\mu$ m
4. ALL UNSPECIFIED TOLERANCE TO BE CONSIDERED AS PER ISO 2768-1:1989

DRS NO	Q	R	S	T	U	V	W	X	Y	Z	AA	AB	AC	AD	AE	AF	AG	AH	AI	AJ	AK	AL	AM	AN	AO	AP	AQ	AR	AS	AT	AU	AV	AW	AX	AY	AZ	BA	BB	BC	BD	BE	BF	BG	BH	BI	BJ	BK	BL	BM	BN	BO	BP	BQ	BR	BS	BT	BU	BV	BW	BX	BY	BZ	CA	CB	CC	CD	CE	CF	CG	CH	CI	CJ	CK	CL	CM	CN	CO	CP	CQ	CR	CS	CT	CU	CV	CW	CX	CY	CZ	DA	DB	DC	DD	DE	DF	DG	DH	DI	DJ	DK	DL	DM	DN	DO	DP	DP	DR	DS	DT	DU	DV	DW	DX	DY	DZ	EA	EB	EC	ED	EE	EF	EG	EH	EI	EJ	EK	EL	EM	EN	EO	EP	EQ	ER	ES	ET	EU	EV	EW	EX	EY	EZ	FA	FB	FC	FD	FE	FF	FG	FH	FI	FJ	FK	FL	FM	FN	FO	FP	FQ	FR	FS	FT	FU	FV	FW	FX	FY	FZ	GA	GB	GC	GD	GE	GF	GG	GH	GI	GJ	GK	GL	GM	GN	GO	GP	GQ	GR	GS	GT	GU	GV	GW	GX	GY	GZ	HA	HB	HC	HD	HE	HF	HG	HH	HI	HJ	HK	HL	HM	HN	HO	HP	HQ	HR	HS	HT	HU	HV	HW	HX	HY	HZ	IA	IB	IC	ID	IE	IF	IG	IH	II	IJ	IK	IL	IM	IN	IO	IP	IQ	IR	IS	IT	IU	IV	IW	IX	IY	IZ	JA	JB	JC	JD	JE	JF	JG	JH	JI	IJ	JK	KL	LM	LN	LO	LP	LQ	LR	LS	LT	LU	LV	LW	LX	LY	LZ	MA	MB	MC	MD	ME	MF	MG	MH	MI	MJ	MK	ML	MM	MN	MO	MP	MQ	MR	MS	MT	MU	MV	MW	MX	MY	MZ	NA	NB	NC	ND	NE	NF	NG	NH	NI	NJ	NK	NL	NM	NN	NO	NP	NQ	NR	NS	NT	NU	NV	NW	NX	NY	NZ	OA	OB	OC	OD	OE	OF	OG	OH	OI	OJ	OK	OL	OM	ON	OO	OP	OQ	OR	OS	OT	OU	OV	OW	OX	OY	OZ	PA	PB	PC	PD	PE	PF	PG	PH	PI	PJ	PK	PL	PM	PN	PO	PP	PQ	PR	PS	PT	PU	PV	PW	PX	PY	PZ	QA	QB	QC	QD	QE	QF	QG	QH	QI	QJ	QK	QL	QM	QN	QO	QP	QQ	QR	QS	QT	QU	QV	QW	QX	QY	QZ	RA	RB	RC	RD	RE	RF	RG	RH	RI	RJ	RK	RL	RM	RN	RO	RP	RQ	RR	RS	RT	RU	RV	RW	RX	RY	RZ	SA	SB	SC	SD	SE	SF	SG	SH	SI	SJ	SK	SL	SM	SN	SO	SP	SQ	SR	SS	ST	SU	SV	SW	SX	SY	SZ	TA	TB	TC	TD	TE	TF	TG	TH	TI	TJ	TK	TL	TM	TN	TO	TP	TQ	TR	TS	TT	TU	TV	TW	TX	TY	TZ	UA	UB	UC	UD	UE	UF	UG	UH	UI	UJ	UK	UL	UM	UN	UO	UP	UQ	UR	US	UT	UU	UV	UW	UX	UY	UZ	VA	VB	VC	VD	VE	VF	VG	VH	VI	VJ	VK	VL	VM	VN	VO	VP	VQ	VR	VS	VT	VU	VV	VW	VX	VY	VZ	WA	WB	WC	WD	WE	WF	WG	WH	WI	WJ	WK	WL	WM	WN	WO	WP	WQ	WR	WS	WT	WU	WV	WW	WX	WY	WZ	XA	XB	XC	XD	XE	XF	XG	XH	XI	XJ	XK	XL	XM	XN	XO	XP	XQ	XR	XS	XT	XU	XV	XW	XX	
CO ORIGINATED BY		DATE		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY		QTY																																																			











ISOMETRIC TOP VIEW  
Scale: 1:5

ISOMETRIC BOTTOM VIEW  
Scale: 1:5

Auxiliary view B  
Scale: 1:5

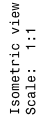
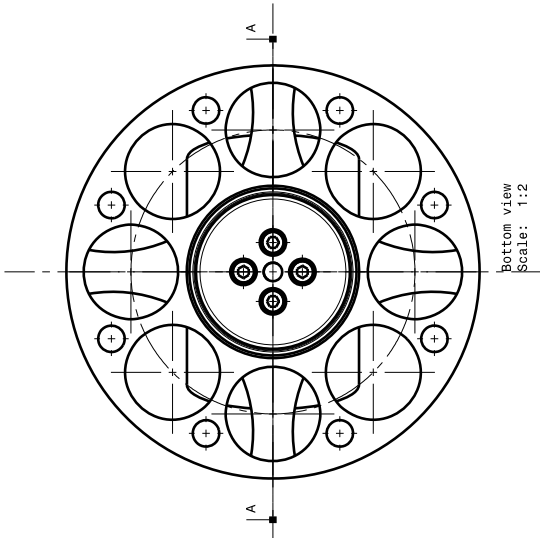
PCD900

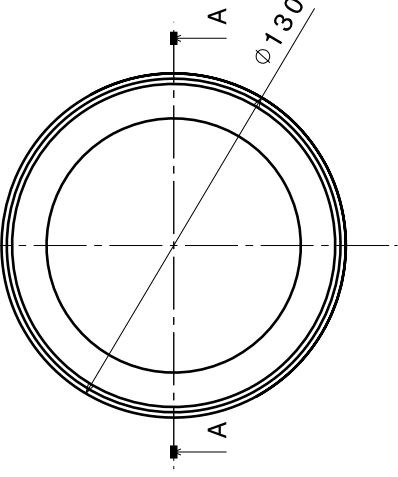
5

Section view A-A  
Scale: 1:5

5	EYE BOLT OF M10 SIZE	SS 304	4	
4	INSERT M10X25L	BRASS	92	DRG. NO : II/ICH/12 INGH/DPDT/01/02/01 ITEM NO 3
3	OC O-RING	SILICON RUBBER	4	-
2	DOWELL PIN	SS 304	4	-
1	OC UPPER	ALUMINIUM ALLOY LM6	-	DRG. NO : II/ICH/12 INGH/DPDT/01/02/01 ITEM NO 2
	Item No, Part Number	Material	Quantity	DRG. NO : II/ICH/12 INGH/DPDT/01/02/01 ITEM NO 1
				Revision

[illegible]

[illegible][illegible]



MATERIAL: BRASS (60:40)  
QUANTITY: 01


ASS'Y GROUP :	
ALL DIMENSIONS UNLESS OTHERWISE	
SCALE	-
DRAWN	DR
CHECKED	PJ
APPROVED	

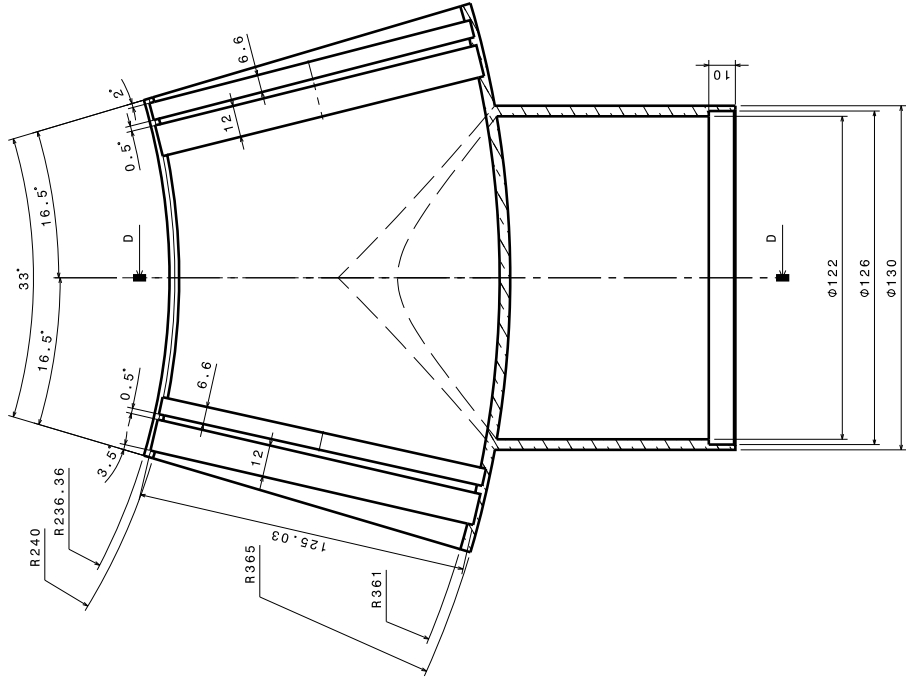
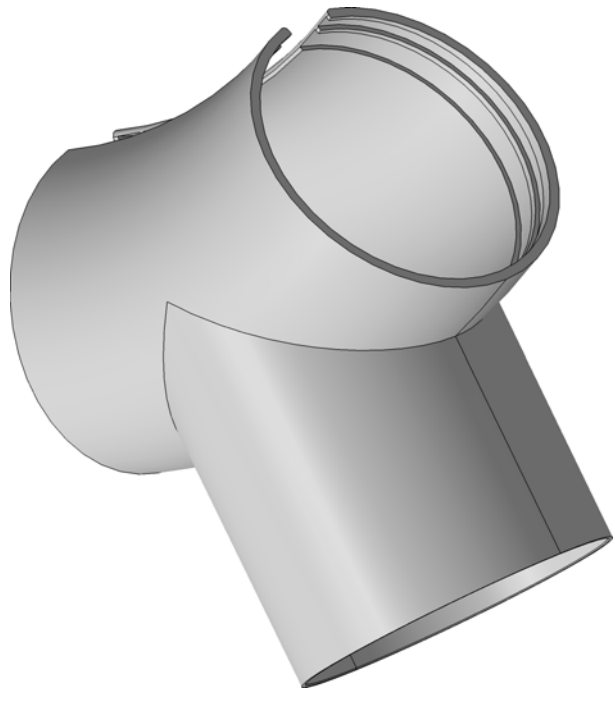


# IC TX BRASS

REF	DRG NO: II/ICH/12 INCH/DPDT/00	REV 00
DRG.NO	II/ICH/12 INCH/DPDT/01/03	SHEET 2 OF 10

A

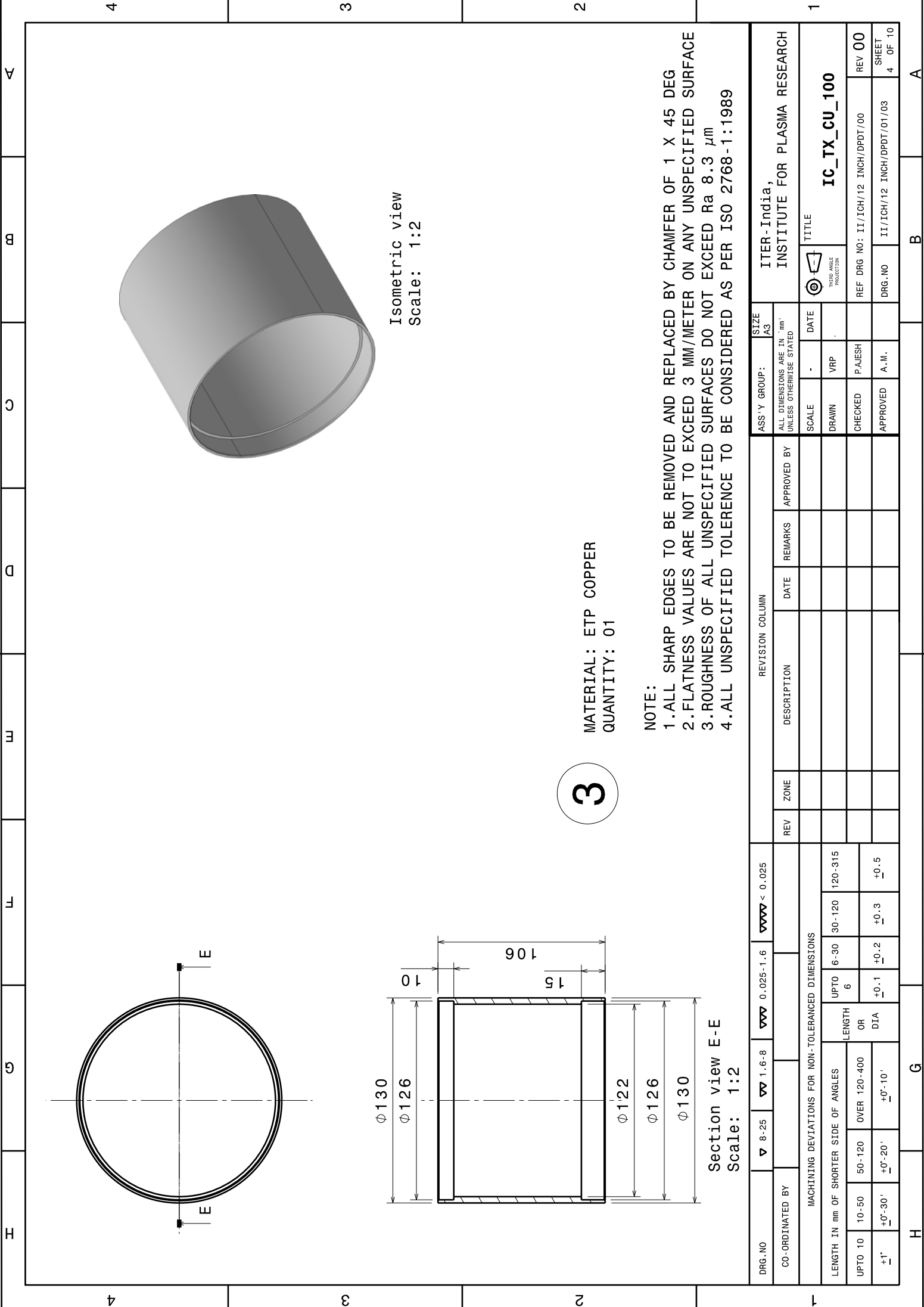
DRG.NO	▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN					ASS'Y GROUP:		SIZE A3	ITER-India, INSTITUTE FOR PLASMA RESEARCH		
CO-ORDINATED BY						DESCRIPTION	DATE	REMARKS	APPROVED BY	ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED					
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS														TITLE	IC_TX_BRASS
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH		UPTO 6	6-30	30-120	120-315			SCALE	-	DATE	
UPTO 10	10-50	50-120	OVER 120-400	OR	DIA	+0.1 -0.2	+0.3 -0.5				CHECKED	PAJESH		DRAWN	
+1' -1'	+0'-30'	+0'-20'	+0'-10'								APPROVED	A.M.			
													REF DRG NO: II/ICH/12 INCH/DPDT/00	REV 00	
													DRG.NO	II/ICH/12 INCH/DPDT/01/03	SHEET 2 OF 10



**NOTE:**

1. ALL SHARP EDGES TO BE REMOVED AND REPLACED BY CHAMFER OF 1 X 45 DEG
2. FLATNESS VALUES ARE NOT TO EXCEED 3 MM/METER ON ANY UNSPECIFIED SURFACE
3. ROUGHNESS OF ALL UNSPECIFIED SURFACES DO NOT EXCEED Ra 8.3  $\mu\text{m}$
4. ALL UNSPECIFIED TOLERANCE TO BE CONSIDERED AS PER ISO 2768-1:1989

[illegible]



Isometric view  
Scale: 1:2

MATERIAL: ETP COPPER  
QUANTITY: 01

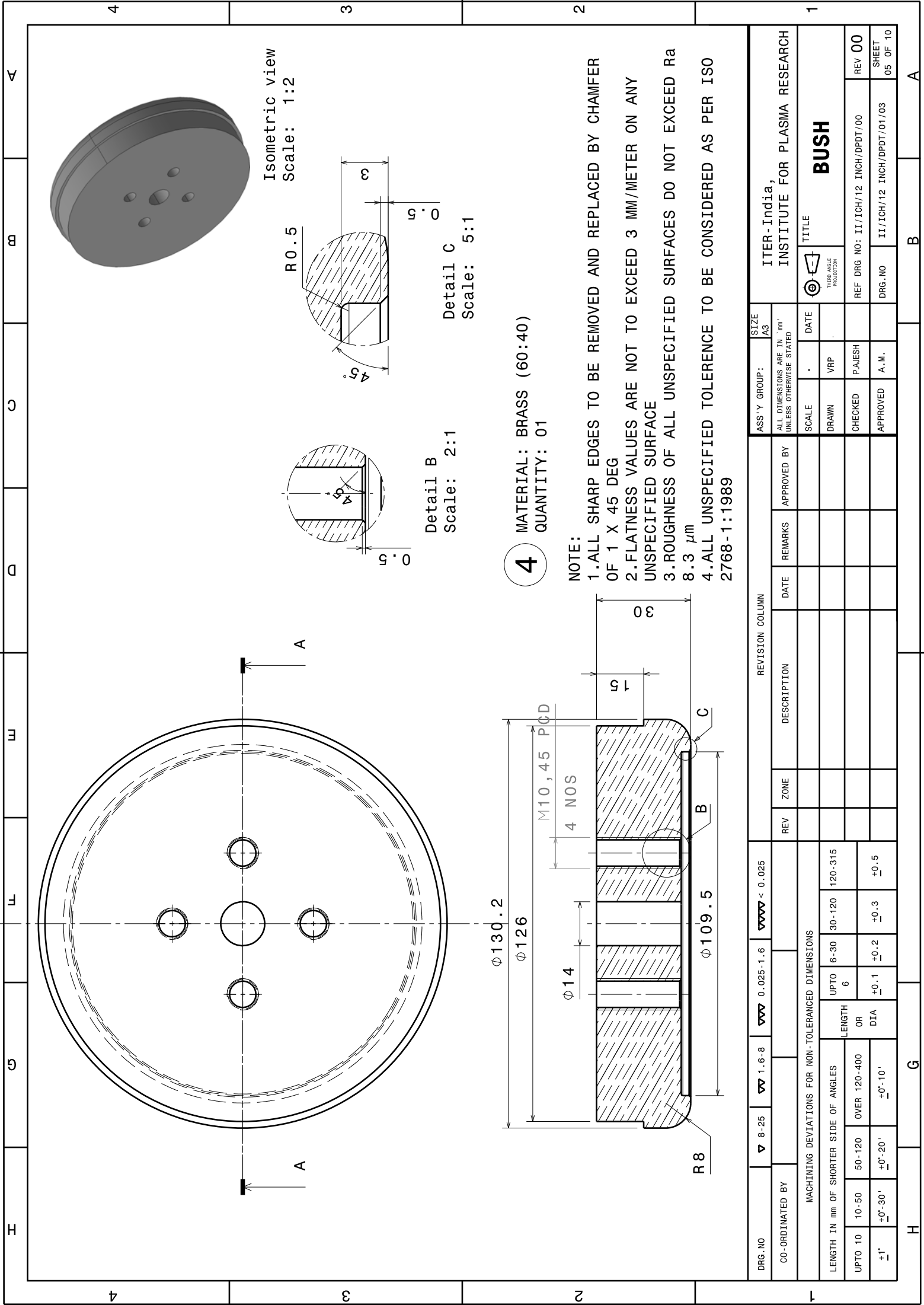
NOTE:

- 1.ALL SHARP EDGES TO BE REMOVED AND REPLACED BY CHAMFER OF 1 X 45 DEG
- 2.FLATNESS VALUES ARE NOT TO EXCEED 3 MM/METER ON ANY UNSPECIFIED SURFACE
- 3.ROUGHNESS OF ALL UNSPECIFIED SURFACES DO NOT EXCEED Ra 8.3  $\mu$ m
- 4.ALL UNSPECIFIED TOLERANCE TO BE CONSIDERED AS PER ISO 2768-1:1989

3

DRG.NO		▽ 8-25	▽▽ 1.6-8	▽▽ 0.025-1.6	▽▽▽ $< 0.025$	REVISION COLUMN				ASS'Y GROUP:		SIZE	ITER-India, INSTITUTE FOR PLASMA RESEARCH	
CO-ORDINATED BY						REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED BY	A3		
MACHINING DEVIATIONS FOR NON-TOLERANGED DIMENSIONS														
LENGTH IN mm OF SHORTER SIDE OF ANGLES		UPTO 6		6-30	30-120	120-315								
UPTO 10	10-50	50-120	OVER 120-400	LENGTH OR DIA									IC_TX_CU_100	
+1° —	+0°-30'	+0°-20'	+0°-10'	+0.1 —	+0.2 —	+0.3 —					CHECKED	PAJESH	REF DRG NO: II/1CH/12 INCH/DPDT/00	REV 00
											APPROVED	A.M.	DRG.NO	II/1CH/12 INCH/DPDT/01/03
													SHEET 4	OF 10





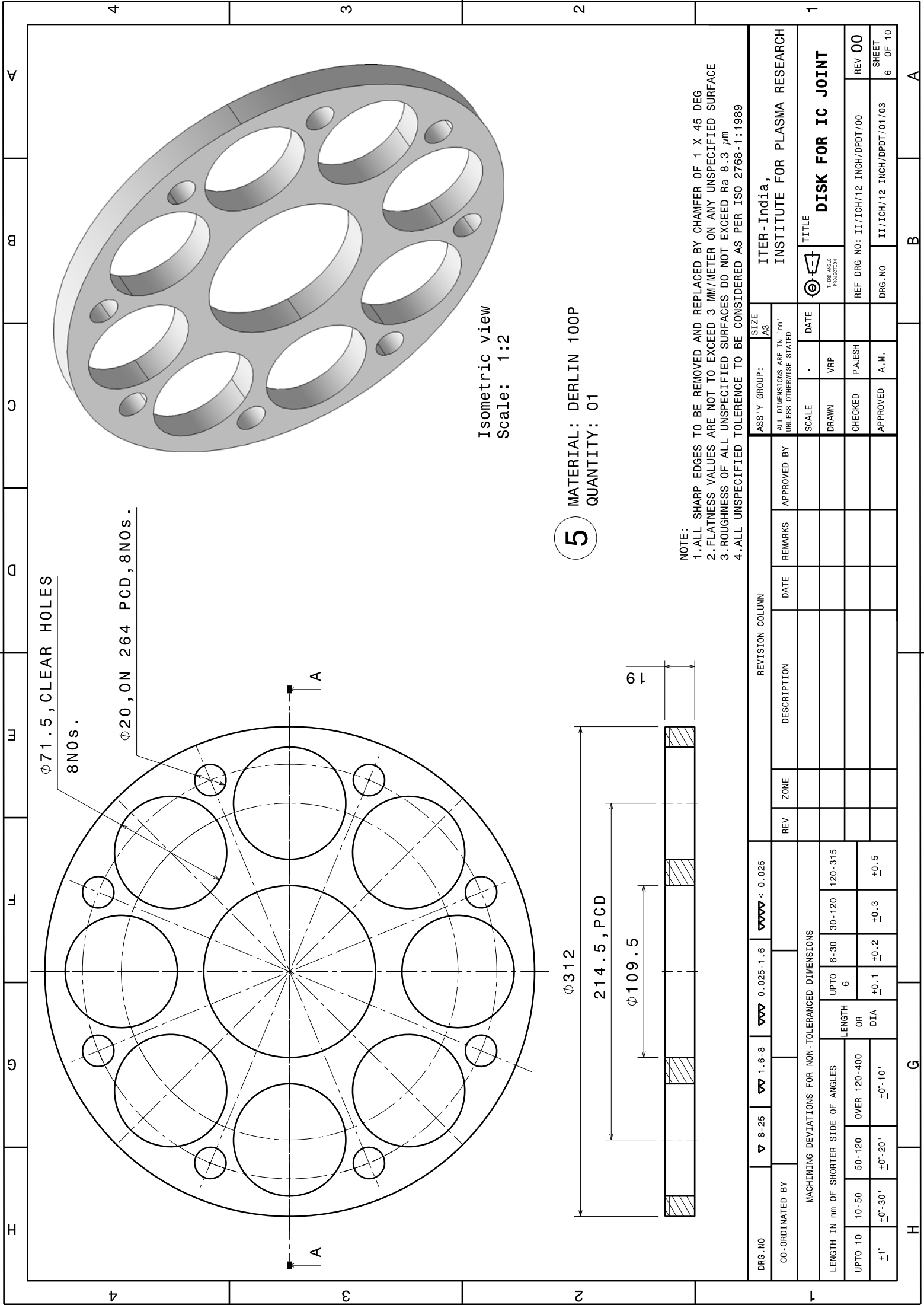
4

MATERIAL: BRASS (60:40)  
QUANTITY: 01

NOTE:

- 1.ALL SHARP EDGES TO BE REMOVED AND REPLACED BY CHAMFER OF 1 X 45 DEG
- 2.FLATNESS VALUES ARE NOT TO EXCEED 3 MM/METER ON ANY UNSPECIFIED SURFACE
- 3.ROUGHNESS OF ALL UNSPECIFIED SURFACES DO NOT EXCEED Ra 8.3  $\mu\text{m}$
- 4.ALL UNSPECIFIED TOLERANCE TO BE CONSIDERED AS PER ISO 2768-1:1989

DRG.NO	▽ 8-25	▽ 1.6-8	▽ 0.025-1.6	▽ 0.025 < 0.025	REVISION COLUMN					ASS'Y GROUP:		SIZE	ITER-India, INSTITUTE FOR PLASMA RESEARCH														
CO-ORDINATED BY					REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED BY	ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED																
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS															TITLE		BUSH										
LENGTH IN mm OF SHORTER SIDE OF ANGLES		UPTO 6		6-30	30-120	120-315									SCALE	-	DATE										
UPTO 10	10-50	50-120	OVER 120-400	OR	LENGTH										DRAWN	VRP											
+0'-30' -	+0'-20' -	+0'-10' -	DIA	+0.1 -	+0.2 -	+0.3 -	+0.5 -									CHECKED	PAJESH										
+1' -	+0'-30' -	+0'-20' -	+0'-10' -	+0.1 -	+0.2 -	+0.3 -	+0.5 -									APPROVED	A.M.										
															REF DRG NO:	II/ICH/12 INCH/DPDT/00										REV 00	
															DRG.NO	II/ICH/12 INCH/DPDT/01/03										SHEET 05 OF 10	



Ø 71.5, CLEAR HOLES


8 NOS.

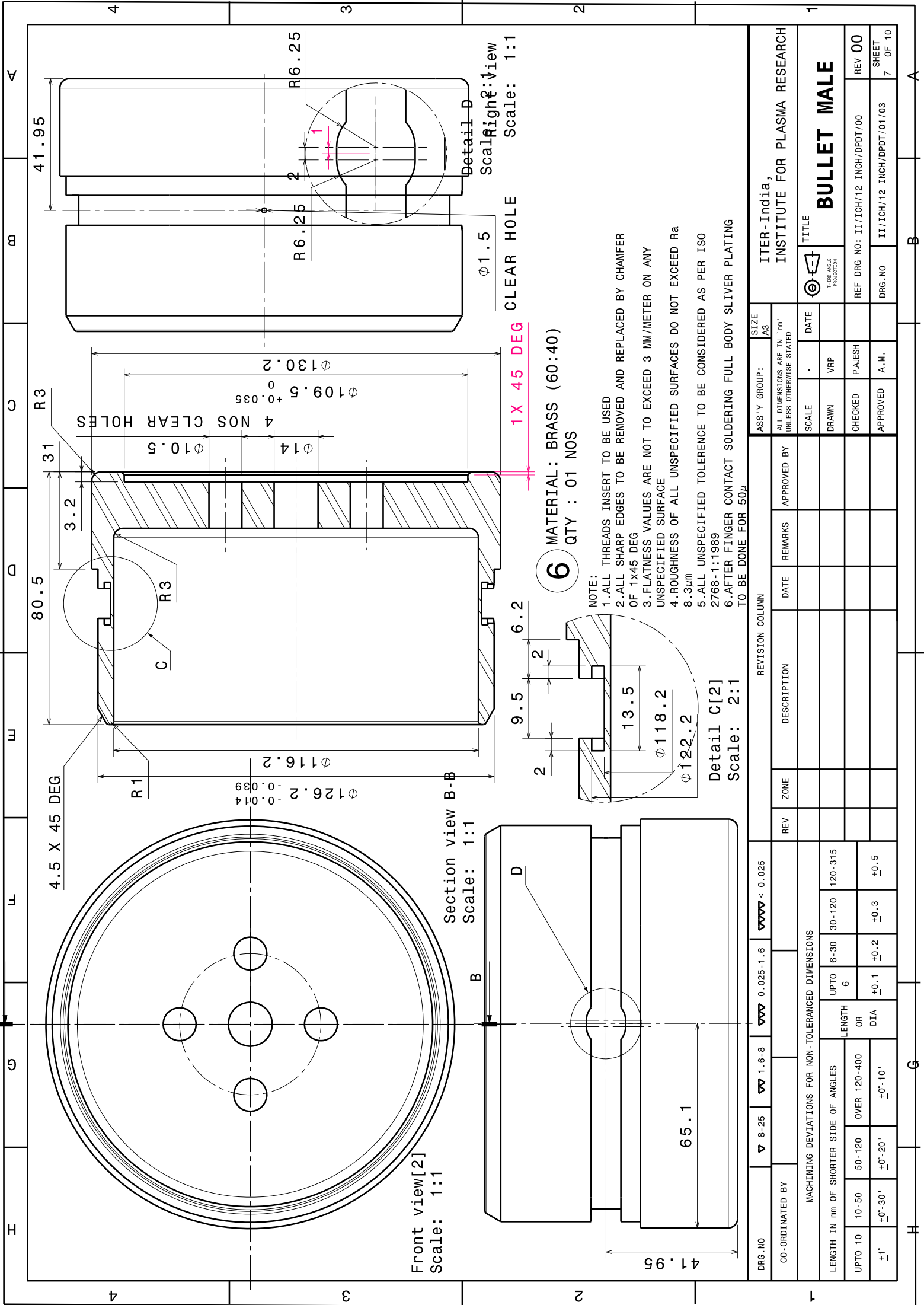
Ø 20, ON 264 PCD, 8 NOS.

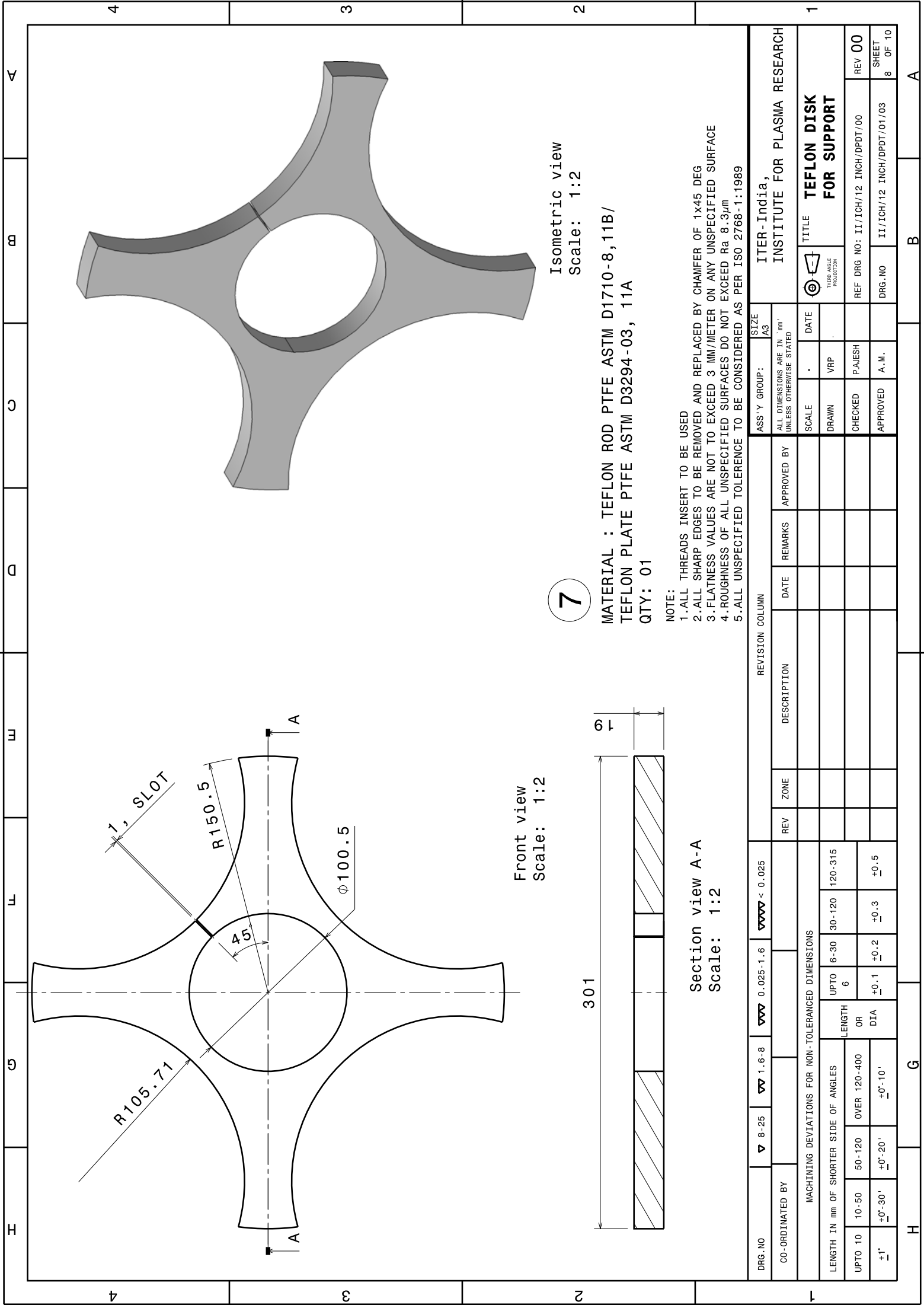
Isometric view  
Scale: 1:2

MATERIAL: DERLIN 100P  
QUANTITY: 01

NOTE:  
1. ALL SHARP EDGES TO BE REMOVED AND REPLACED BY CHAMFER OF 1 X 45 DEG  
2. FLATNESS VALUES ARE NOT TO EXCEED 3 MM/METER ON ANY UNSPECIFIED SURFACE  
3. ROUGHNESS OF ALL UNSPECIFIED SURFACES DO NOT EXCEED Ra 8.3 µm  
4. ALL UNSPECIFIED TOLERANCE TO BE CONSIDERED AS PER ISO 2768-1:1989

DRG.NO		▽ 8-25		▽ 1.6-8		▽ 0.025-1.6		▽ 0.025		REVISION COLUMN				ASS'Y GROUP:		SIZE		ITER-India, INSTITUTE FOR PLASMA RESEARCH					
CO-ORDINATED BY										REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED BY	A3							
																		TITLE		DISK FOR IC JOINT			
																							
																		SCALE		-		DATE	
																		DRAWN		VRP			
																		CHECKED		PAJESH			
																		APPROVED		A.M.			
																		REF DRG NO: II/ICH/12 INCH/DPDT/00		REV 00			
																		DRG.NO		II/ICH/12 INCH/DPDT/01/03		SHEET 6 OF 10	





7

Isometric view  
Scale: 1:2

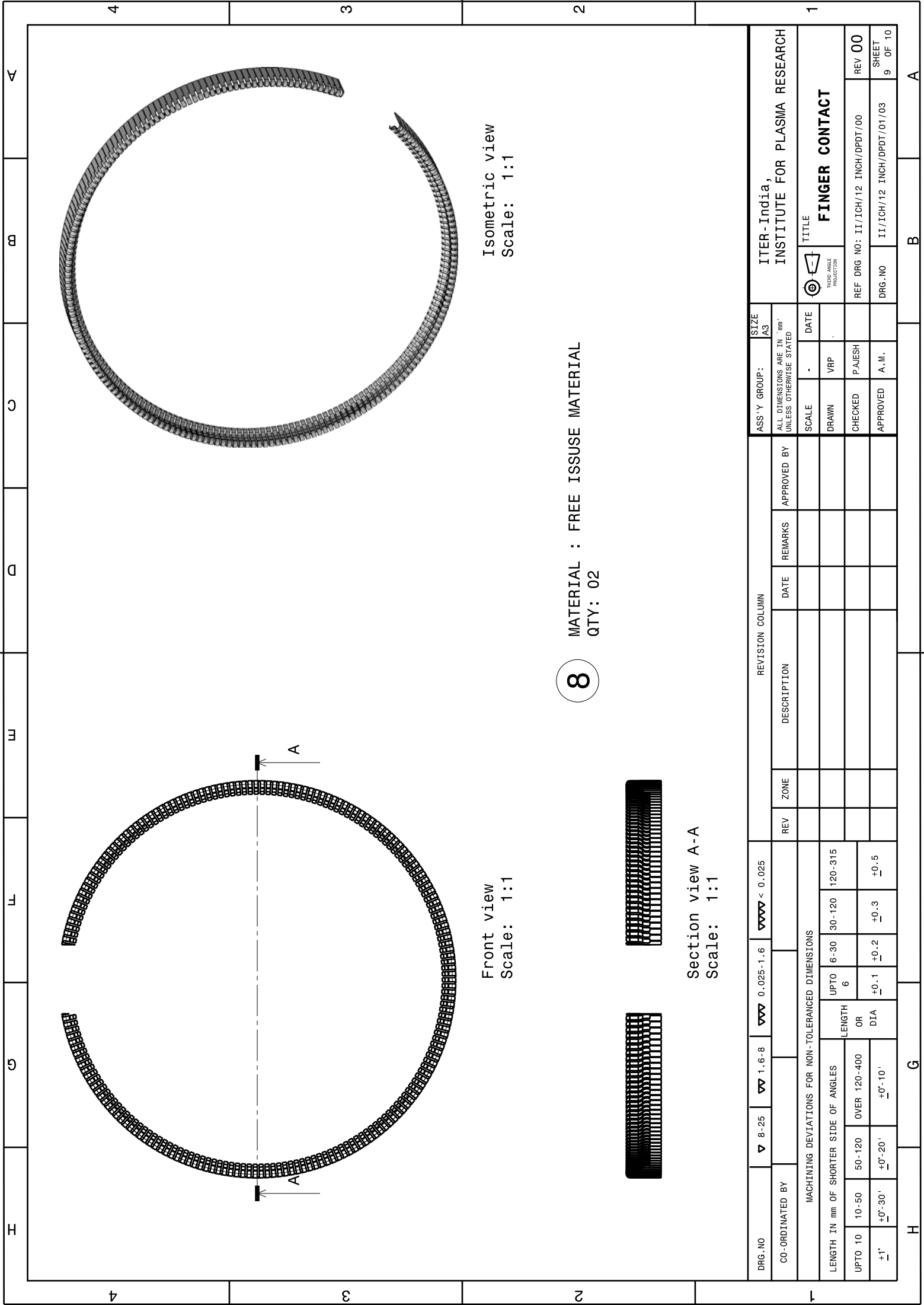
Front view  
Scale: 1:2

Section view A-A  
Scale: 1:2

MATERIAL : TEFLON ROD PTFE ASTM D1710-8,11B /  
TEFLON PLATE PTFE ASTM D3294-03, 11A  
QTY: 01

- NOTE:
- 1.ALL THREADS INSERT TO BE USED
  - 2.ALL SHARP EDGES TO BE REMOVED AND REPLACED BY CHAMFER OF 1x45 DEG
  - 3.FLATNESS VALUES ARE NOT TO EXCEED 3 MM/METER ON ANY UNSPECIFIED SURFACE
  - 4.ROUGHNESS OF ALL UNSPECIFIED SURFACES DO NOT EXCEED Ra 8.3µm
  - 5.ALL UNSPECIFIED TOLERANCE TO BE CONSIDERED AS PER ISO 2768-1:1989

DRG.NO	CO-ORDINATED BY	MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS				REVISION COLUMN				ASS'Y GROUP:		SIZE		ITER-India, INSTITUTE FOR PLASMA RESEARCH		TITLE TEFLON DISK FOR SUPPORT	REV 00
		LENGTH IN mm OF SHORTER SIDE OF ANGLES		LENGTH OR DIA		REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED BY	ALL DIMENSIONS ARE IN "mm" UNLESS OTHERWISE STATED		SCALE	DATE		
1	UPTO 10	10-50	50-120	OVER 120-400	UPTO 6									DRAWN	VRP		
		+0'-30'	+0'-20'	+0'-10'	+0.1									CHECKED	PAJESH		REF DRG NO: II/TC/H/12 INCH/DPDT/00
	+1													APPROVED	A.M.		DRG.NO II/IC/H/12 INCH/DPDT/01/03
																ITER-India, INSTITUTE FOR PLASMA RESEARCH	
																TEFLON DISK FOR SUPPORT	
																REF DRG NO: II/TC/H/12 INCH/DPDT/00	
																DRG.NO II/IC/H/12 INCH/DPDT/01/03	
																REV 00	
																SHEET 8 OF 10	




Isometric view  
Scale: 1:1

Front view  
Scale: 1:1

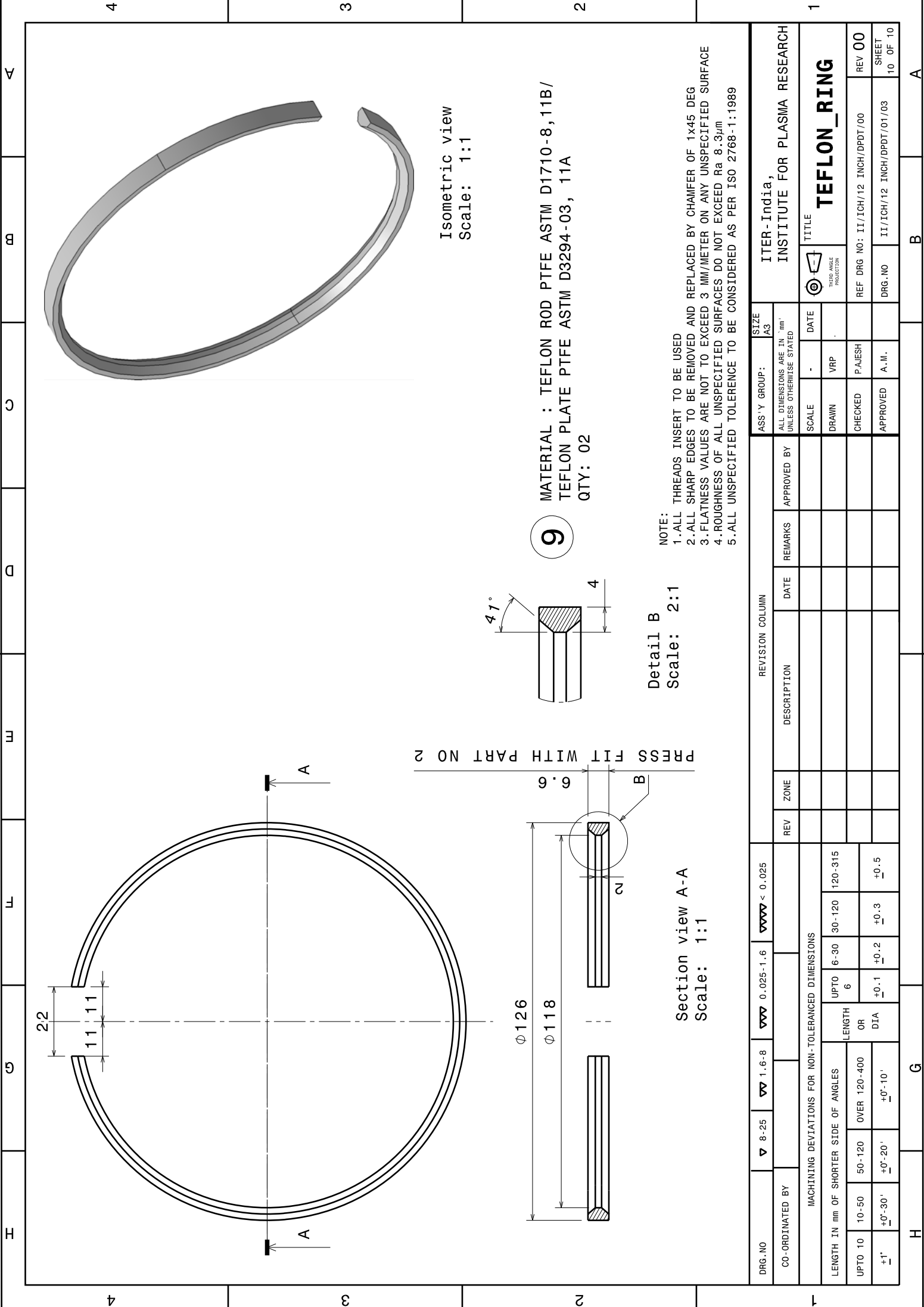
MATERIAL : FREE ISSUE MATERIAL  
QTY: 02


8

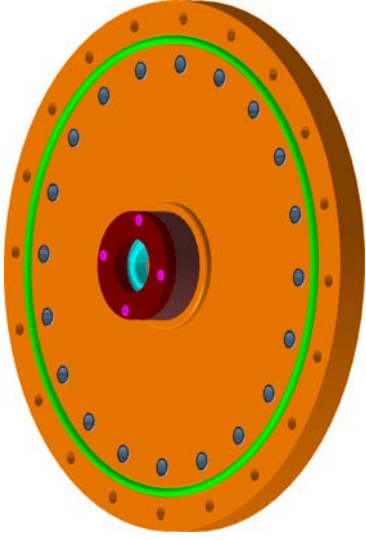
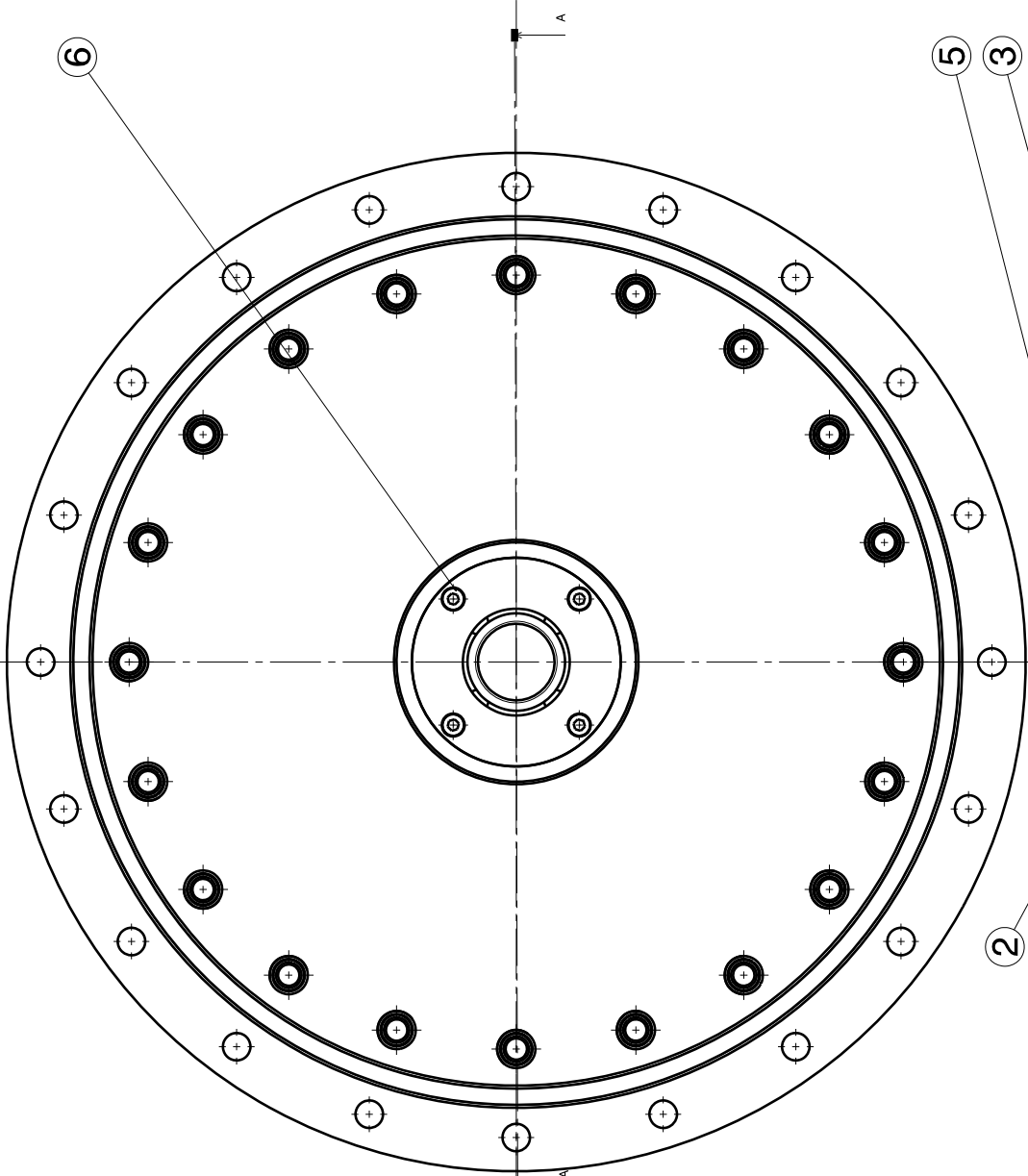
Section view A-A  
Scale: 1:1

DRG. NO		▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN				ASS'Y GROUP:		SIZE A3	ITER-India, INSTITUTE FOR PLASMA RESEARCH					
CO-ORDINATED BY						REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED BY	ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED						
MACHINING DEVIATIONS FOR NON-TOLERANGED DIMENSIONS																	TITLE <b>FINGER CONTACT</b>	
LENGTH IN mm OF SHORTER SIDE OF ANGLES		UPTO 6		6-30		30-120		120-315		SCALE		DATE						
UPTO 10	10-50	50-120	OVER 120-400	OR	DIA	UPTO 6	6-30	30-120	120-315	DRAWN	VRP			REF DRG NO: II/ICH/12 INCH/DPDT/00	REV 00			
+1*	+0*-30'	+0*-20'	+0*-10'			+0.1	+0.2	+0.3	+0.5	CHECKED	PAJESH							
										APPROVED	A.M.			DRG.NO	II/ICH/12 INCH/DPDT/01/03	SHEET 9 OF 10		

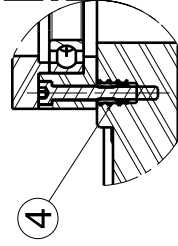




DRG. NO		▽ 8-25		▽ 1.6-8		▽ 0.025-1.6		▽ 0.025 < 0.025		REVISION COLUMN				ASS'Y GROUP:		SIZE A3		ITER-India, INSTITUTE FOR PLASMA RESEARCH													
CO-ORDINATED BY										REV		ZONE		DESCRIPTION		DATE				REMARKS		APPROVED BY									
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS																		TITLE		 THIRD ANGLE PROJECTION		TEFLON_RING									
LENGTH IN mm OF SHORTER SIDE OF ANGLES																															
UPTO 10		10-50		50-120		OVER 120-400		LENGTH OR DIA		UPTO 6		6-30		30-120		120-315		SCALE		DATE		REF DRG NO: II/ICH/12 INCH/DPDT/00		REV 00							
+1° —		+0°-30' —		+0°-20' —		+0°-10' —				+0.1 —		+0.2 —		+0.3 —		+0.5 —		CHECKED		PAJESH		DRG.NO		SHEET 10 OF 10							
																				APPROVED		A.M.									

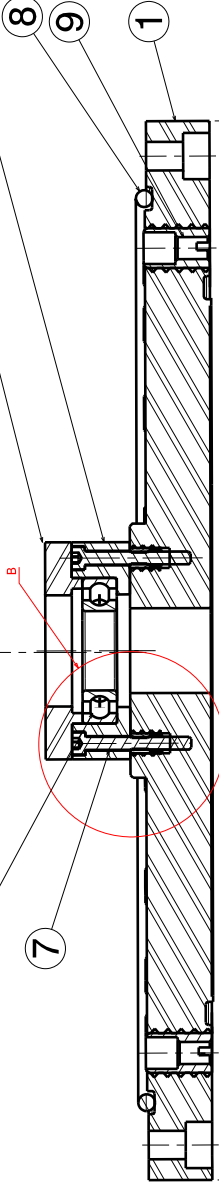


Isometric view  
Scale: 1:2



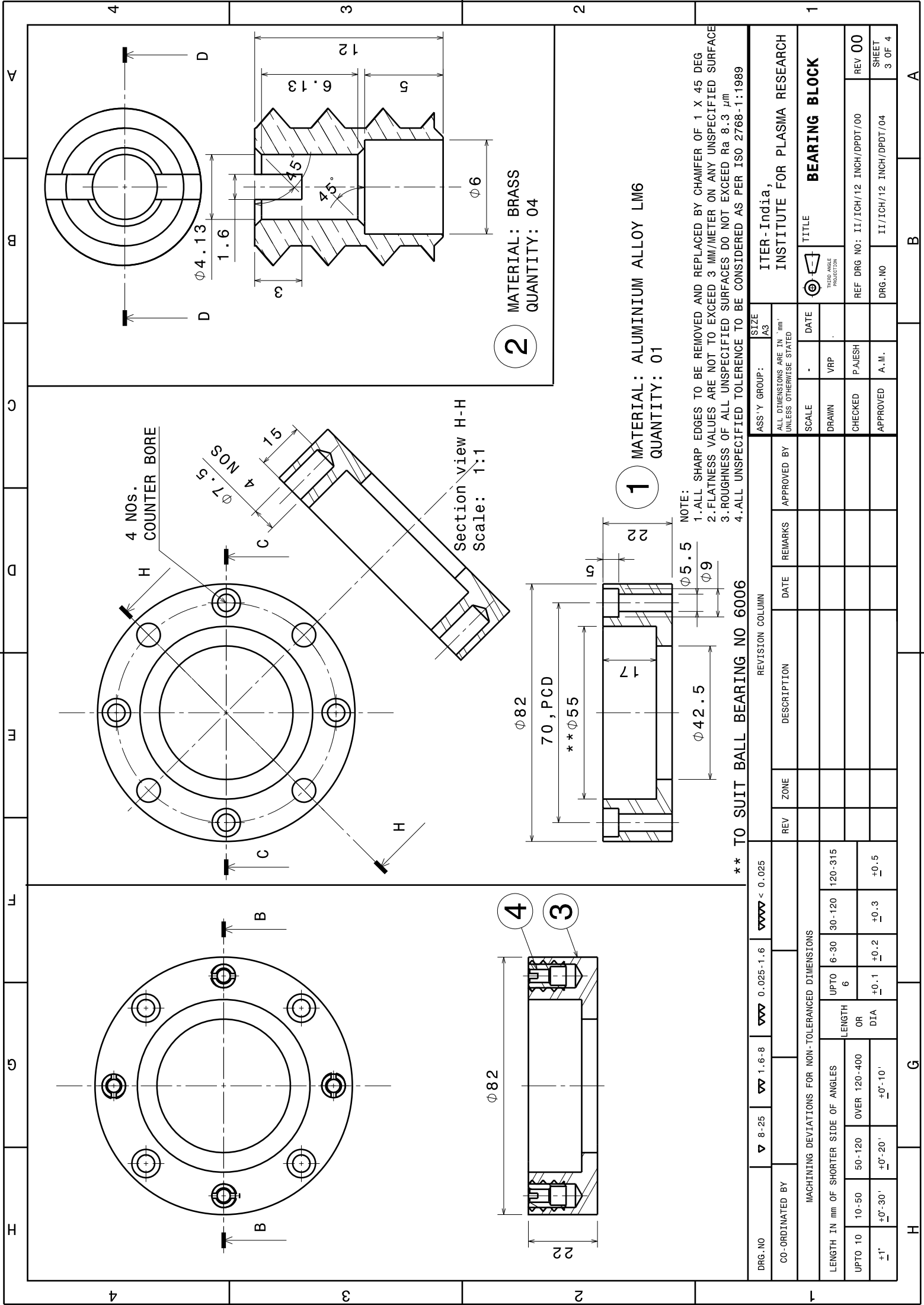
Detail B  
Scale: 1:1

9	INSERT M10 X 25L	SS 304	20	-
8	O-RING	SILICON RUBBER	1	-
7	ISO 4762 SCREW M5X40 STEEL HEXAGON SOCKET HEAD CAP	SS 304	4	-
6	ISO 4762 SCREW M5X20 STEEL HEXAGON SOCKET HEAD CAP	SS 304	4	-
5	BEARING BLOCK COVER	ALUMINIUM ALLOY LM6	1	-
4	INSERT M5 X 12L	SS 304	8	-
3	BEARING BLOCK	ALUMINIUM ALLOY LM6	1	-
2	SKF BALL BEARING NO 6006	SS	1	-
1	COVER PLATE	ALUMINIUM ALLOY LM6	1	-
Item No. Part Number			Quantity Revision	
			Material	



ITER-India, INSTITUTE FOR PLASMA RESEARCH		TITLE COVER PLATE ASSY	
DESIGNED BY VPR	DATE 11/12/12	APPROVED BY AM	DATE 11/12/12
REVISIONS	DESCRIPTION	REVISIONS	DESCRIPTION
1	COVER PLATE ASSY	1	COVER PLATE ASSY






2 MATERIAL: BRASS  
QUANTITY: 04

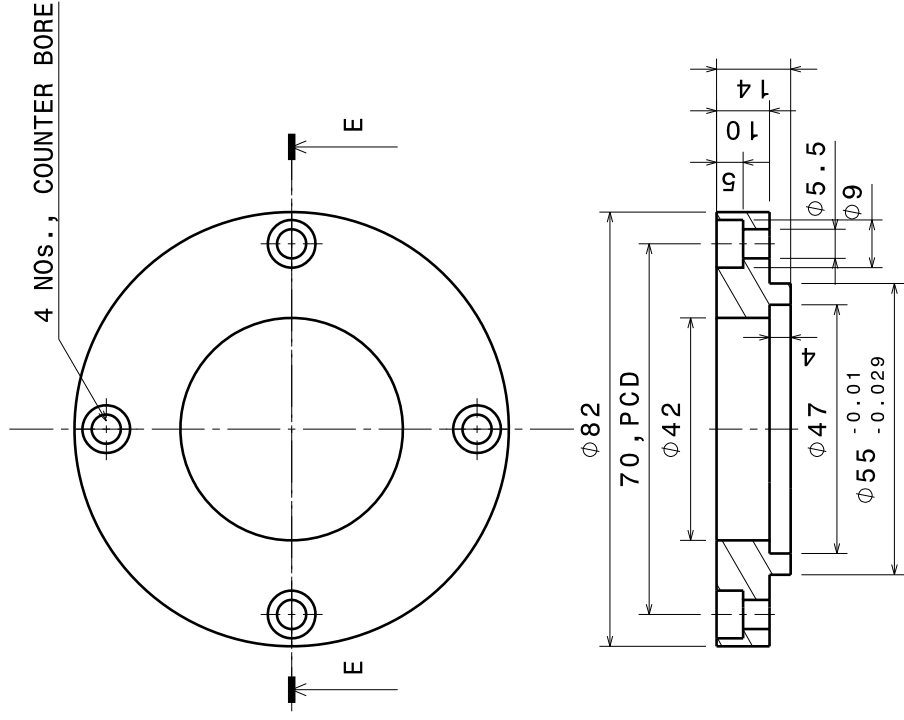
1 MATERIAL: ALUMINIUM ALLOY LM6  
QUANTITY: 01

NOTE:

- 1. ALL SHARP EDGES TO BE REMOVED AND REPLACED BY CHAMFER OF 1 X 45 DEG
- 2. FLATNESS VALUES ARE NOT TO EXCEED 3 MM/METER ON ANY UNSPECIFIED SURFACE
- 3. ROUGHNESS OF ALL UNSPECIFIED SURFACES DO NOT EXCEED Ra 8.3  $\mu$ m
- 4. ALL UNSPECIFIED TOLERANCE TO BE CONSIDERED AS PER ISO 2768-1:1989

\*\* TO SUIT BALL BEARING NO 6006

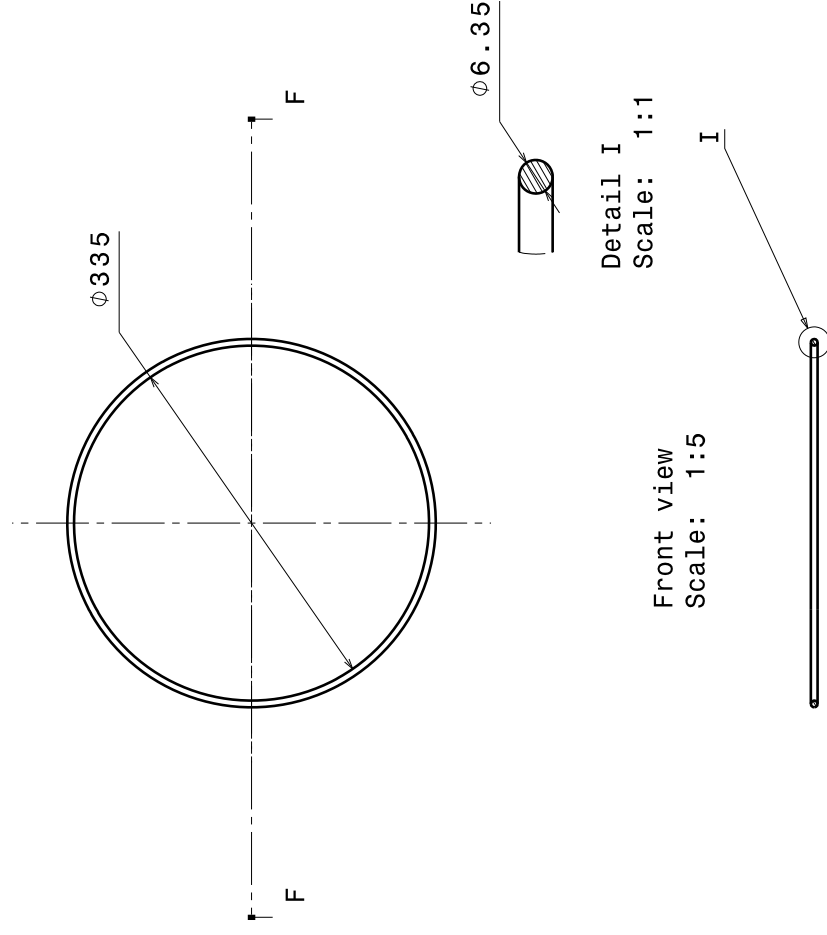
DRG. NO		▽ 8-25	▽▽ 1.6-8	▽▽ 0.025-1.6	REVISION COLUMN				ASS'Y GROUP:		SIZE		ITER-India, INSTITUTE FOR PLASMA RESEARCH							
CO-ORDINATED BY											A3									
ALL DIMENSIONS ARE IN "mm" UNLESS OTHERWISE STATED																				
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS													SCALE		-	DATE	TITLE  BEARING BLOCK			
													DRAWN		VRP					
LENGTH IN mm OF SHORTER SIDE OF ANGLES		UPTO 6				6-30		30-120		120-315		REF DRG NO: II/ICH/12 INCH/DPDT/00				REV 00				
		LENGTH OR DIA																		
UPTO 10		10-50		50-120		OVER 120-400						CHECKED		PAJESH						
+1' -		+0'-30'		+0'-20'		+0'-10'		+0.1 -		+0.3 -		+0.5 -		APPROVED		A.M.				
														DRG.NO		II/ICH/12 INCH/DPDT/04				
																SHEET 3 OF 4				



5 MATERIAL: ALUMINIUM ALLOY LM6  
QUANTITY: 01

NOTE:

1. ALL SHARP EDGES TO BE REMOVED AND REPLACED BY CHAMFER OF 1 X 45 DEG
2. FLATNESS VALUES ARE NOT TO EXCEED 3 MM/METER ON ANY UNSPECIFIED SURFACE
3. ROUGHNESS OF ALL UNSPECIFIED SURFACES DO NOT EXCEED Ra 8.3  $\mu\text{m}$
4. ALL UNSPECIFIED TOLERANCE TO BE CONSIDERED AS PER ISO 2768-1:1989



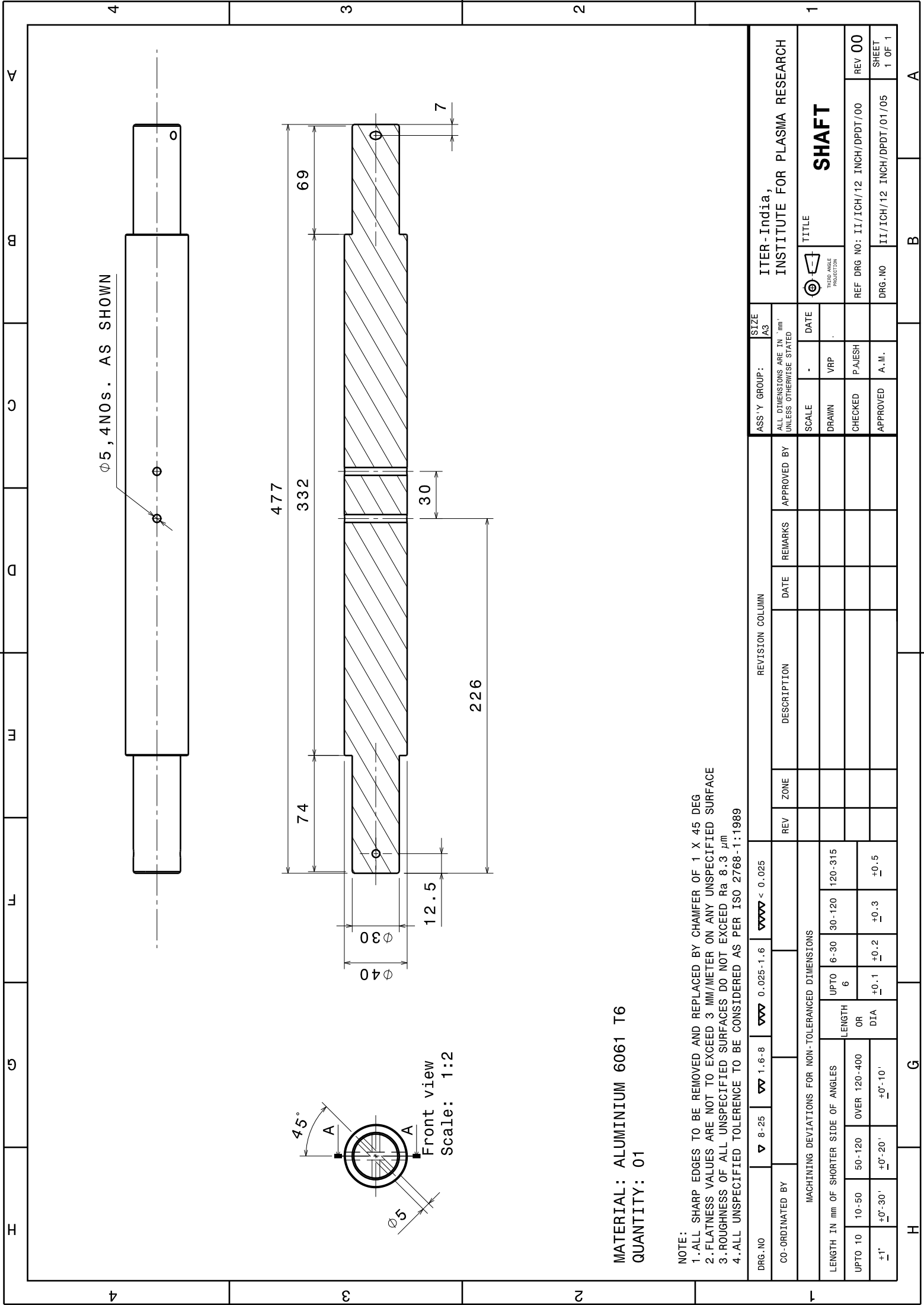
Section view F-F  
Scale: 1:5

MATERIAL: RUBBER SILICON  
QUANTITY: 01

oo

DRG. NO	▽ 8-25	▽ 1.6-8	▽ 0.025-1.6	▽ 0.025	REVISION COLUMN				ASS'Y GROUP:		SIZE	ITER-India, INSTITUTE FOR PLASMA RESEARCH		
CO-ORDINATED BY					REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED BY	A3			
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS													TITLE	
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH		UPTO 6	6-30	30-120	120-315			BEARING BLOCK COVER		
UPTO 10	10-50	50-120	OVER 120-400	OR						CHECKED	PAJESH	REF DRG NO: II/ICH/12 INCH/DPDT/00	REV 00	
+1'	+0'-30'	+0'-20'	+0'-10'	+0.1	+0.2	+0.3	+0.5			APPROVED	A.M.	DRG. NO	II/ICH/12 INCH/DPDT/04	
H				G				B				A		

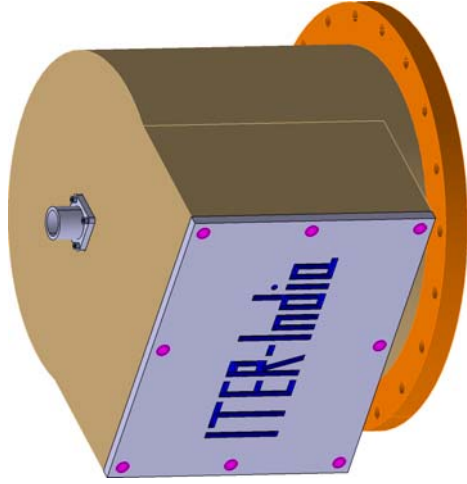




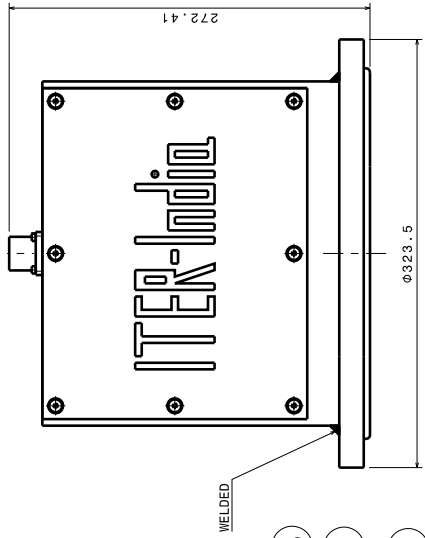
ITER-India, INSTITUTE FOR PLASMA RESEARCH									
SHAFT									
REF DRG NO: II/ICH/12 INCH/DPDT/00									
REV 00									
SHEET 1 OF 1									

MATERIAL: ALUMINIUM 6061 T6  
QUANTITY: 01

- NOTE:
- 1. ALL SHARP EDGES TO BE REMOVED AND REPLACED BY CHAMFER OF 1 X 45 DEG
  - 2. FLATNESS VALUES ARE NOT TO EXCEED 3 MM/METER ON ANY UNSPECIFIED SURFACE
  - 3. ROUGHNESS OF ALL UNSPECIFIED SURFACES DO NOT EXCEED Ra 8.3 μm
  - 4. ALL UNSPECIFIED TOLERANCE TO BE CONSIDERED AS PER ISO 2768-1:1989



Isometric view  
Scale: 1:2

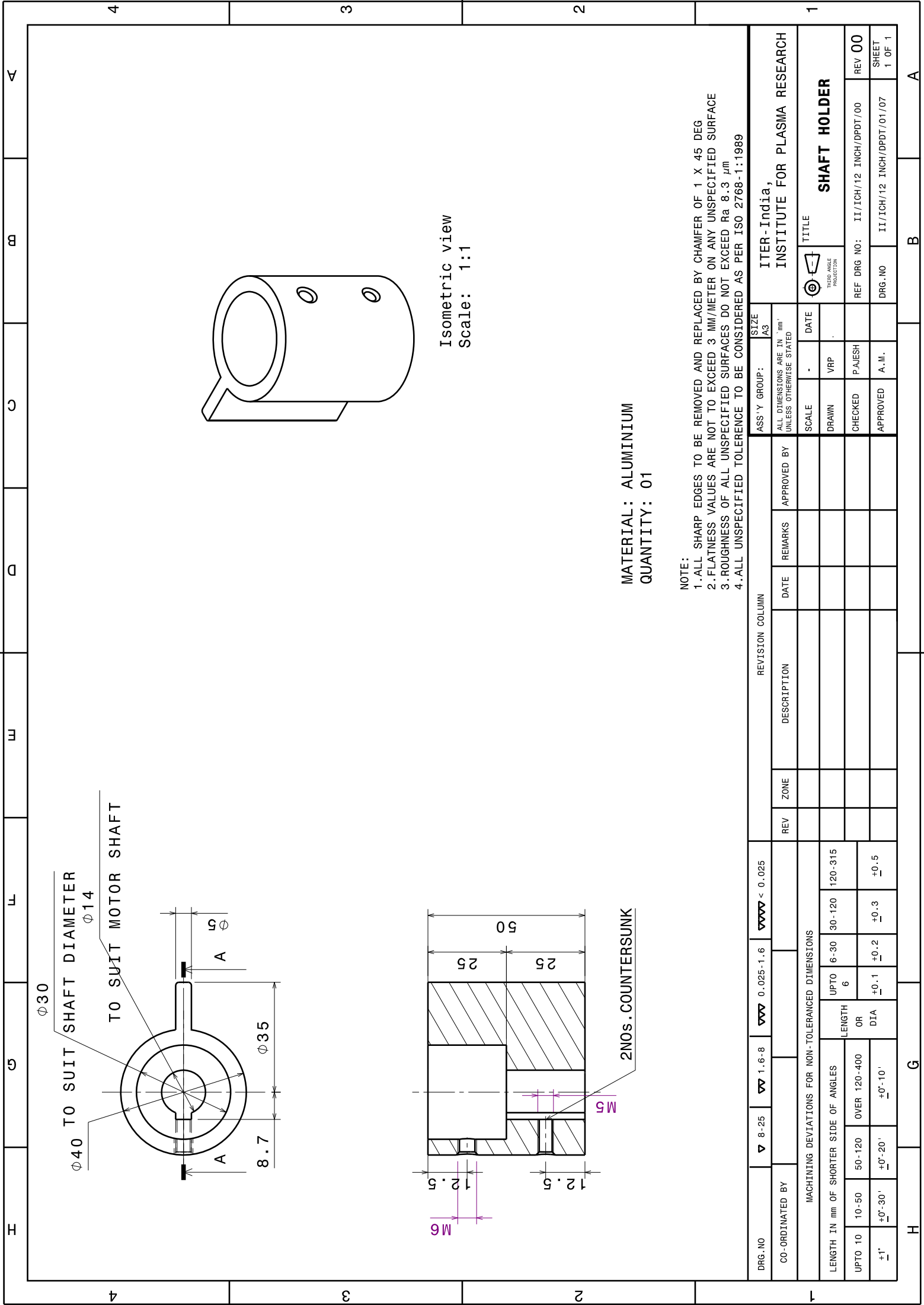


8	SCREW M5x12	SS 304	8	-
7	INSERT M5 X 12L	BRASS	8	-
6	COVER PLATE	ALUMINIUM ALLOY LM6	1	-
5	O-RING FOR FIX FLANGE	SILICON RUBBER	1	-
4	ISO 4762 SCREW M3x10 STEEL HEXAGON SOCKET HEAD CAP	SS 304	4	-
3	ALLIED CONNECTOR 1 INCH	STD	1	-
2	12 INCH FIXED FLANGE 260	ALUMINIUM ALLOY LM6	1	-
1	MOTOR TOP COVER-SW	ALUMINIUM ALLOY LM6	1	-
Item No. Part Number			Quantity	Revision
			Material	

DRG-NO	Q	R	S	T	U	V	W	X	Y	Z	AA	AB	AC	AD	AE	AF	AG	AH	AI	AJ	AK	AL	AM	AN	AO	AP	AQ	AR	AS	AT	AU	AV	AW	AX	AY	AZ	BA	BB	BC	BD	BE	BF	BG	BH	BI	BJ	BK	BL	BM	BN	BO	BP	BQ	BR	BS	BT	BU	BV	BW	BX	BY	BZ	CA	CB	CC	CD	CE	CF	CG	CH	CI	CJ	CK	CL	CM	CN	CO	CP	CQ	CR	CS	CT	CU	CV	CW	CX	CY	CZ	DA	DB	DC	DD	DE	DF	DG	DH	DI	DJ	DK	DL	DM	DN	DO	DP	DQ	DR	DS	DT	DU	DV	DW	DX	DY	DZ	EA	EB	EC	ED	EE	EF	EG	EH	EI	EJ	EK	EL	EM	EN	EO	EP	EQ	ER	ES	ET	EU	EV	EW	EX	EY	EZ	FA	FB	FC	FD	FE	FF	FG	FH	FI	FJ	FK	FL	FM	FN	FO	FP	FQ	FR	FS	FT	FU	FV	FW	FX	FY	FZ	GA	GB	GC	GD	GE	GF	GG	GH	GI	GJ	GK	GL	GM	GN	GO	GP	GQ	GR	GS	GT	GU	GV	GW	GX	GY	GZ	HA	HB	HC	HD	HE	HF	HG	HH	HI	HJ	HK	HL	HM	HN	HO	HP	HQ	HR	HS	HT	HU	HV	HW	HX	HY	HZ	IA	IB	IC	ID	IE	IF	IG	IH	II	IJ	IK	IL	IM	IN	IO	IP	IQ	IR	IS	IT	IU	IV	IW	IX	IY	IZ	JA	JB	JC	JD	JE	JF	JG	JH	JI	IJ	JK	JL	JM	JN	JO	JP	JQ	JR	JS	JT	JU	JV	JW	JX	JY	JZ	KA	KB	KC	KD	KE	KF	KG	KH	KI	KJ	KK	KL	KM	KN	KO	KP	KQ	KR	KS	KT	KU	KV	KW	KX	KY	KZ	LA	LB	LC	LD	LE	LF	LG	LH	LI	LJ	LK	LL	LM	LN	LO	LP	LQ	LR	LS	LT	LU	LV	LW	LX	LY	LZ	MA	MB	MC	MD	ME	MF	MG	MH	MI	MJ	MK	ML	MM	MN	MO	MP	MQ	MR	MS	MT	MU	MV	MW	MX	MY	MZ	NA	NB	NC	ND	NE	NF	NG	NH	NI	NJ	NK	NL	NM	NN	NO	NP	NQ	NR	NS	NT	NU	NV	NW	NX	NY	NZ	OA	OB	OC	OD	OE	OF	OG	OH	OI	OJ	OK	OL	OM	ON	OO	OP	OQ	OR	OS	OT	OU	OV	OW	OX	OY	OZ	PA	PB	PC	PD	PE	PF	PG	PH	PI	PJ	PK	PL	PM	PN	PO	PP	PQ	PR	PS	PT	PU	PV	PW	PX	PY	PZ	QA	QB	QC	QD	QE	QF	QG	QH	QI	QJ	QK	QL	QM	QN	QO	QP	QR	QS	QT	QU	QV	QW	QX	QY	QZ	RA	RB	RC	RD	RE	RF	RG	RH	RI	RJ	RK	RL	RM	RN	RO	RP	RQ	RR	RS	RT	RU	RV	RW	RX	RY	RZ	SA	SB	SC	SD	SE	SF	SG	SH	SI	SJ	SK	SL	SM	SN	SO	SP	SQ	SR	SS	ST	SU	SV	SW	SX	SY	SZ	TA	TB	TC	TD	TE	TF	TG	TH	TI	TJ	TK	TL	TM	TN	TO	TP	TQ	TR	TS	TT	TU	TV	TW	TX	TY	TZ	UA	UB	UC	UD	UE	UF	UG	UH	UI	UJ	UK	UL	UM	UN	UO	UP	UQ	UR	US	UT	UU	UV	UW	UX	UY	UZ	VA	VB	VC	VD	VE	VF	VG	VH	VI	VJ	VK	VL	VM	VN	VO	VP	VQ	VR	VS	VT	VU	VV	VW	VX	VY	VZ	WA	WB	WC	WD	WE	WF	WG	WH	WI	WJ	WK	WL	WM	WN	WO	WP	WQ	WR	WS	WT	WU	WV	WW	WX	WY	WZ	XA	XB	XC	XD	XE	XF	XG	XH	XI	XJ	XK	XL	XM	XN	XO	XP	XQ	XR	XS	XT	XU	XV	XW	XX	XY	XZ	YA	YB	YC	YD	YE	YF	YG	YH	YI	YJ	YK	YL	YM	YN	YO	YP	YQ	YR	YS	YT	YU	YV	YW	YX	YZ	ZA	ZB	ZC	ZD	ZE	ZF	ZG	ZH	ZI	ZJ	ZK	ZL	ZM	ZN	ZO	ZP	ZQ	ZR	ZS	ZT	ZU	ZV	ZW	ZX	ZY	ZZ																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																											
CO ORIGINATED BY		Q		R		S		T		U		V		W		X		Y		Z		AA		AB		AC		AD		AE		AF		AG		AH		AI		AJ		AK		AL		AM		AN		AO		AP		AQ		AR		AS		AT		AU		AV		AW		AX		AY		AZ		BA		BB		BC		BD		BE		BF		BG		BH		BI		BJ		BK		BL		BM		BN		BO		BP		BQ		BR		BS		BT		BU		BV		BW		BX		BY		BZ		CA		CB		CC		CD		CE		CF		CG		CH		CI		CJ		CK		CL		CM		CN		CO		CP		CQ		CR		CS		CT		CU		CV		CW		CX		CY		CZ		DA		DB		DC		DD		DE		DF		DG		DH		DI		DJ		DK		DL		DM		DN		DO		DP		DQ		DR		DS		DT		DU		DV		DW		DX		DY		DZ		EA		EB		EC		ED		EE		EF		EG		EH		EI		EJ		EK		EL		EM		EN		EO		EP		EQ		ER		ES		ET		EU		EV		EW		EX		EY		EZ		FA		FB		FC		FD		FE		FF		FG		FH		FI		FJ		FK		FL		FM		FN		FO		FP		FQ		FR		FS		FT		FU		FV		FW		FX		FY		FZ		GA		GB		GC		GD		GE		GF		GG		GH		GI		GJ		GK		GL		GM		GN		GO		GP		GQ		GR		GS		GT		GU		GV		GW		GX		GY		GZ		HA		HB		HC		HD		HE		HF		HG		HH		HI		HJ		HK		HL		HM		HN		HO		HP		HQ		HR		HS		HT		HU		HV		HW		HX		HY		HZ		IA		IB		IC		ID		IE		IF		IG		IH		II		IJ		IK		IL		IM		IN		IO		IP		IQ		IR		IS		IT		IU		IV		IW		IX		IY		IZ		JA		JB		JC		JD		JE		JF		JG		JH		JI		IJ		JK		JL		JM		JN		JO		JP		JQ		JR		JS		JT		JU		JV		JW		JX		JY		JZ		KA		KB		KC		KD		KE		KF		KG		KH		KI		KJ		KK		KL		KM		KN		KO		KP		KQ		KR		KS		KT		KU		KV		KW		KX		KY		KZ		LA		LB		LC		LD		LE		LF		LG		LH		LI		LJ		LK		LM		LN		LO		LP		LQ		LR		LS		LT		LU		LV		LW		LX		LY		LZ		MA		MB		MC		MD		ME		MF		MG		MH		MI		MJ		MK		ML		MM		MN		MO		MP		MQ		MR		MS		MT		MU		MV		MW		MX		MY		MZ		NA		NB		NC		ND		NE		NF		NG		NH		NI		NJ		NK		NL		NM		NN		NO		NP		NQ		NR		NS		NT		NU		NV		NW		NX		NY		NZ		OA		OB		OC		OD		OE		OF		OG		OH		OI		OJ		OK		OL		OM		ON		OO		OP		OQ		OR		OS		OT		OU		OV		OW		OX		OY		OZ		PA		PB		PC		PD		PE		PF		PG		PH		PI		PJ		PK		PL		PM		PN		PO		PP		PQ		PR		PS		PT		PU		PV		PW		PX		PY		PZ		QA		QB		QC		QD		QE		QF		QG		QH		QI		QJ		QK		QL		QM		QN		QO		QP		QR		QS		QT		QU		QV		QW		QX		QY		QZ		RA		RB		RC		RD		RE		RF		RG		RH		RI		RJ		RK		RL		RM		RN		RO		RP		RQ		RR		RS		RT		RU		RV		RW		RX		RY		RZ		SA		SB		SC		SD		SE		SF		SG		SH		SI		SJ		SK		SL		SM		SN		SO		SP		SQ		SR		SS		ST		SU		SV		SW		SX		SY		SZ		TA		TB		TC		TD		TE		TF		TG		TH		TI		TJ		TK		TL		TM		TN		TO		TP		TQ		TR		TS		TT		TU		TV		TW		TX		TY		TZ		UA		UB		UC		UD		UE		UF		UG		UH		UI		UJ		UK		UL		UM		UN		UO		UP		UQ		UR		US		UT		UU		UV		UW		UX		UY		UZ		VA		VB		VC		VD		VE		VF		VG		VH		VI		VJ		VK		VL		VM		VN		VO		VP		VQ		VR		VS		VT		VU		VV		VW		VX		VY		VZ		WA		WB		WC		WD		WE		WF		WG		WH		WI		WJ		WK		WL		WM		WN		WO		WP		WQ		WR		WS		WT		WU		WV		WW		WX		WY		WZ		XA		XB		XC		XD		XE		XF		XG		XH		XI		XJ		XK		XL		XM		XN		XO		XP		XQ		XR		XS		XT		XU		XV		XW		XX		XY		XZ		YA		YB		YC		YD		YE		YF		YG		YH		YI		YJ		YK		YL		YM		YN		YO		YP		YQ		YR		YS		YT		YU		YV		YW		YX		YZ		ZA		ZB		ZC		ZD		ZE		ZF		ZG		ZH		ZI		ZJ		ZK		ZL		ZM		ZN		ZO		ZP		ZQ		ZR		ZS		ZT		ZU		ZV		ZW		ZX		ZY		ZZ	
MACHINE DEVIATIONS FOR NON-TOLERANCED DIMENSIONS		Q		R		S		T		U		V		W		X		Y		Z		AA		AB		AC		AD		AE		AF		AG		AH		AI		AJ		AK		AL		AM		AN		AO		AP		AQ		AR		AS		AT		AU		AV		AW		AX		AY		AZ		BA		BB		BC		BD		BE		BF		BG		BH		BI		BJ		BK		BL		BM		BN		BO		BP		BQ		BR		BS		BT		BU		BV		BW		BX		BY		BZ		CA		CB		CC		CD		CE		CF		CG		CH		CI		CJ		CK		CL		CM		CN		CO		CP		CQ		CR		CS		CT		CU		CV		CW		CX		CY		CZ		DA		DB		DC		DD		DE		DF		DG		DH		DI		DJ		DK		DL		DM		DN		DO		DP		DQ		DR		DS		DT		DU		DV		DW		DX		DY		DZ		EA		EB		EC		ED		EE		EF		EG		EH		EI		EJ		EK		EL		EM		EN		EO		EP		EQ		ER		ES		ET		EU		EV		EW		EX		EY		EZ		FA		FB		FC		FD		FE		FF		FG		FH		FI		FJ		FK		FL		FM		FN		FO		FP		FQ		FR		FS		FT		FU		FV		FW		FX		FY		FZ		GA		GB		GC		GD		GE		GF		GG		GH		GI		GJ		GK		GL		GM		GN		GO		GP		GQ		GR		GS		GT		GU		GV		GW		GX		GY		GZ		HA		HB		HC		HD		HE		HF		HG		HH		HI		HJ		HK		HL		HM		HN		HO		HP		HQ		HR		HS		HT		HU																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																													








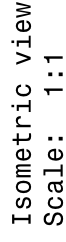
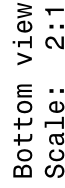
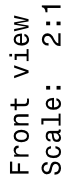
Isometric view  
Scale: 1:1

MATERIAL: ALUMINIUM  
QUANTITY: 01

- NOTE:
- 1.ALL SHARP EDGES TO BE REMOVED AND REPLACED BY CHAMFER OF 1 X 45 DEG
  - 2.FLATNESS VALUES ARE NOT TO EXCEED 3 MM/METER ON ANY UNSPECIFIED SURFACE
  - 3.ROUGHNESS OF ALL UNSPECIFIED SURFACES DO NOT EXCEED Ra 8.3  $\mu$ m
  - 4.ALL UNSPECIFIED TOLERANCE TO BE CONSIDERED AS PER ISO 2768-1:1989

DRG. NO		▽ 8-25		▽▽ 1.6-8		▽▽ 0.025-1.6		▽▽▽ $< 0.025$		REVISION COLUMN				ASS'Y GROUP:		SIZE		ITER-India, INSTITUTE FOR PLASMA RESEARCH							
CO-ORDINATED BY										REV		ZONE		DESCRIPTION		DATE				REMARKS		APPROVED BY			
MACHINING DEVIATIONS FOR NON-TOLERANGED DIMENSIONS																		 THIRD ANGLE PROJECTION		TITLE		SHAFT HOLDER			
LENGTH IN mm OF SHORTER SIDE OF ANGLES		UP TO 6		LENGTH		120-315																			
				30-120																					
10-50		50-120		OVER 120-400		OR		DIA		+0.1		+0.2		+0.3		+0.5									
+1° —		+0°-30' —		+0°-20' —		+0°-10' —																			
																		REF DRG NO:		II/ICH/12 INCH/DPDT/00		REV 00			
																		APPROVED		A.I.M.					
																				DRG.NO		II/ICH/12 INCH/DPDT/01/07			
																						SHEET 1 OF 1			



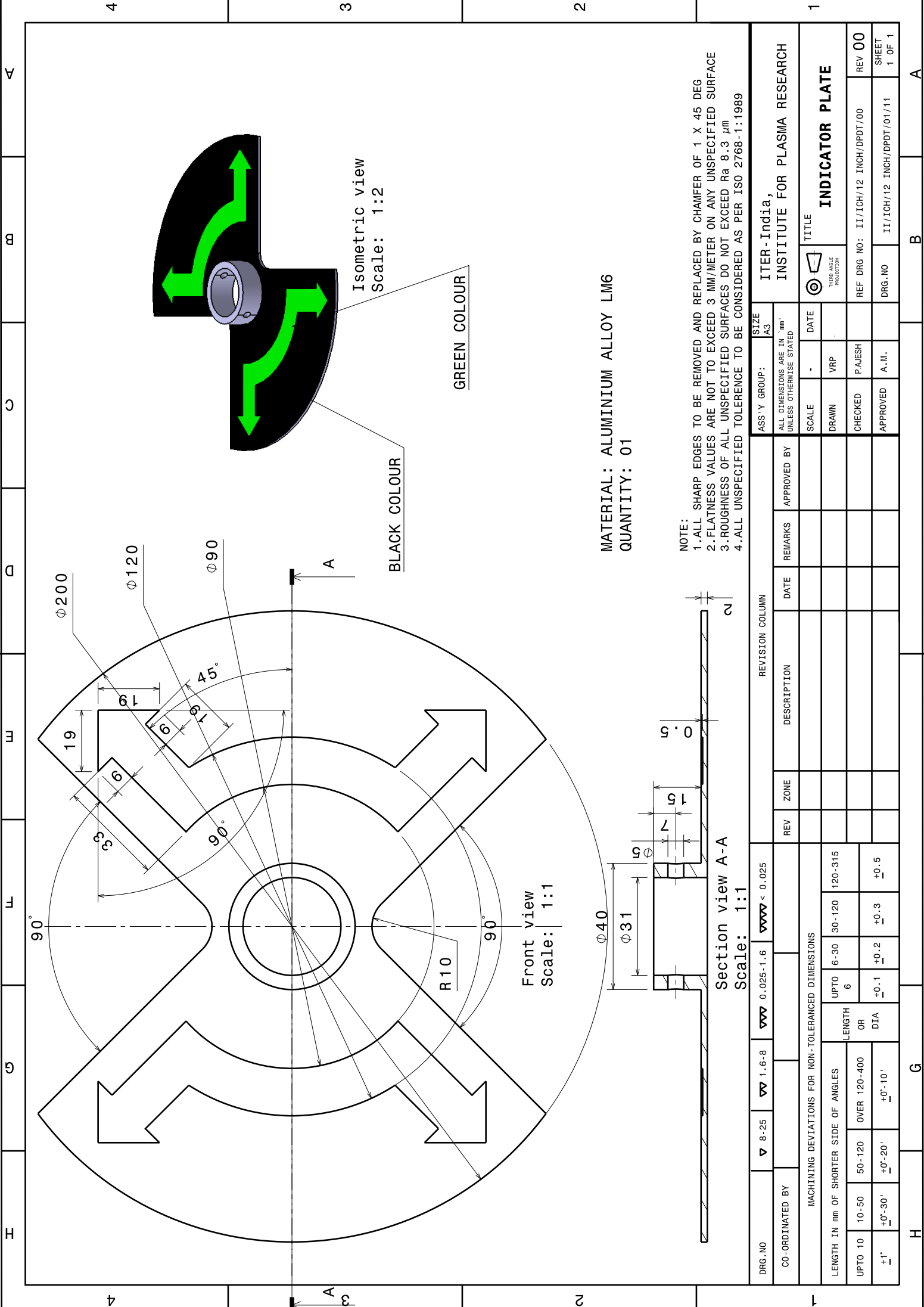


MATERIAL: ALUMINIUM  
QTY: 4 NOS

[illegible]








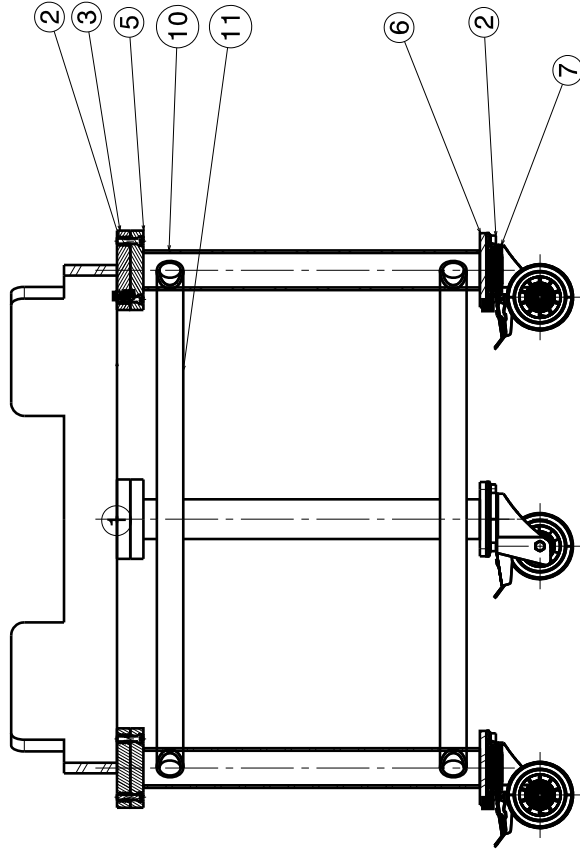
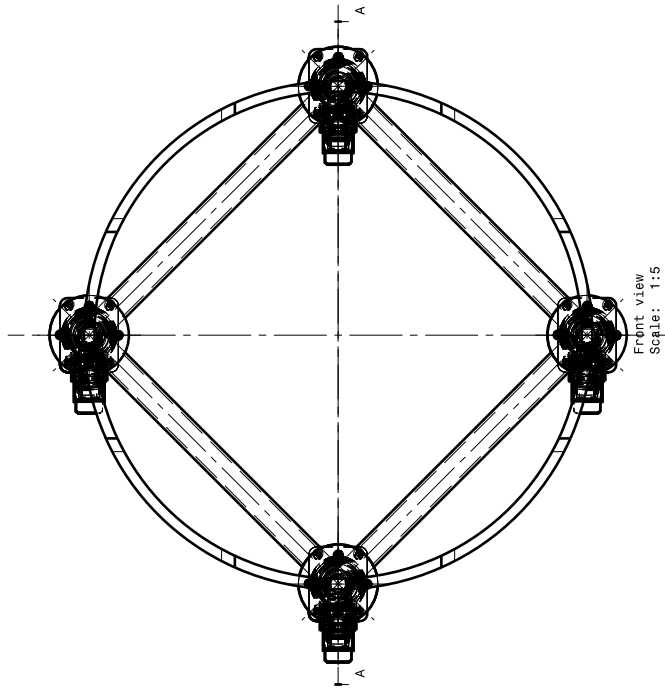
MATERIAL: ALUMINIUM ALLOY LM6  
QUANTITY: 01

- NOTE:
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ITER-India, INSTITUTE FOR PLASMA RESEARCH		ASS'Y GROUP:		SIZE	
		A3			
ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED					
SCALE		DATE			
DRAWN		VRP			
CHECKED		PAJESH			
APPROVED		A.M.			
REF		DRG NO:		II/ICH/12 INCH/DPDT/00	
DRG.NO		II/ICH/12 INCH/DPDT/01/11		SHEET 1 OF 1	

INDICATOR PLATE									
		TITLE							
</									





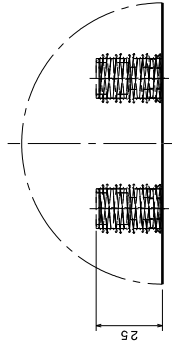
Section view A-A  
Scale: 1:5

Isometric view  
Scale: 1:5

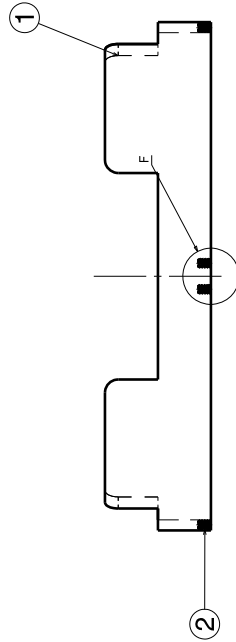
NOTE: EXCEPT ALUMINIUM RING, ALL OTHER PARTS ARE POWER COATED WITH BLUE COLOR

11	HOLLOW PIPE-2	MS	8	-
10	HOLLOW PIPE	MS	4	-
9	ISO 7091 WASHER 10x20 STEEL GRADE A PLAIN	SS 304	16	-
8	NORMAL SERIES ISO 4782 SCREW M10x20 STEEL HEXAGON SOCKET HEAD CAP	SS 304	16	-
7	200 KG CAPACITY SWIVEL CASTOR WHEEL WITH LOCKING ARRANGEMENT	STD	4	-
6	CASTOR WHEEL BASE PLATE	MS	4	-
5	ROUND PLATE-2	MS	4	-
4	HEXAGON SOCKET HEAD CAP SCREW M10 X40L	SS 304	24	-
3	ROUND PLATE-1	MS	4	-
2	INSERT M10X25L	BRASS	24	-
1	ALUMINIUM RING	ALUMINIUM	1	-
	Item No. : Part Number	Material	Quantity	Revision

[illegible]



Detail F  
Scale: 1:1

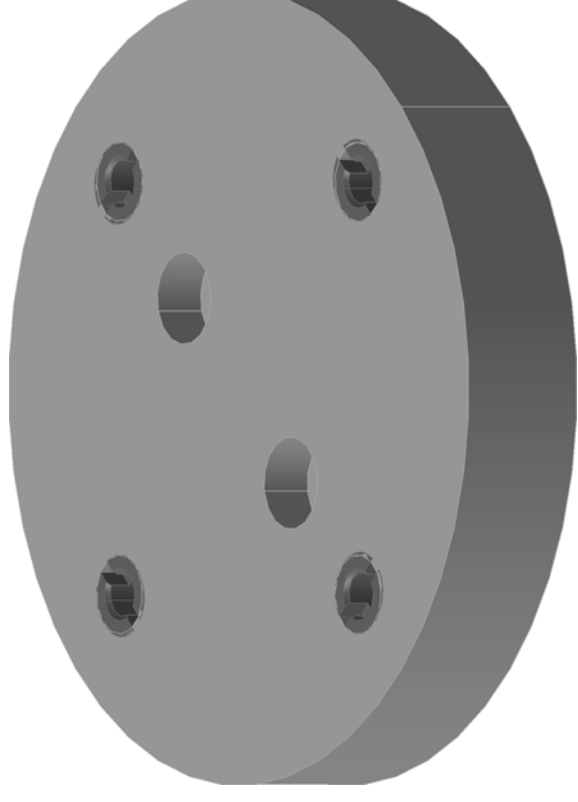
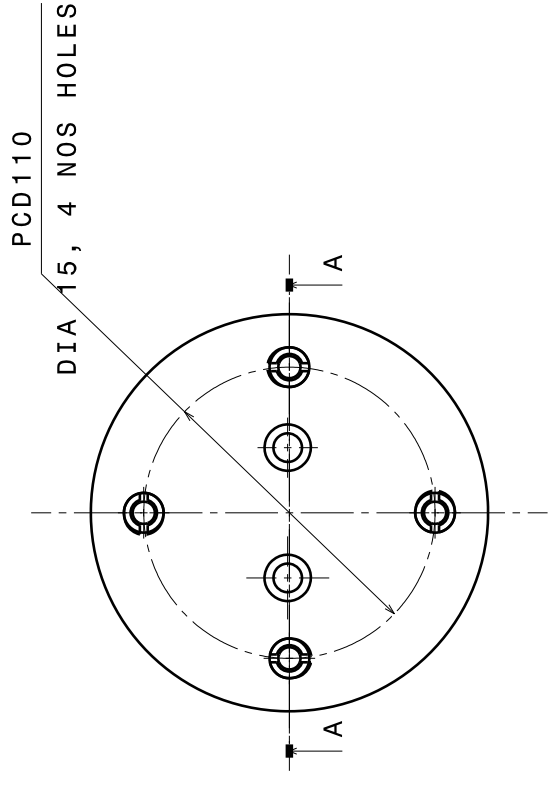


NOTE:

- 1.-ALL SHARP EDGES TO BE REMOVED AND REPLACED BY CHAMFER OF 1 X 45 DEG
- 2.FLATNESS VALUES ARE NOT TO EXCEED 3 MM/METER ON ANY UNSPECIFIED SURFACE
- 3.ROUGHNESS OF ALL UNSPECIFIED SURFACES DO NOT EXCEED Ra 8.3  $\mu$ m
- 4.-ALL UNSPECIFIED TOLERANCE TO BE CONSIDERED AS PER ISO 2768.1:1989

[illegible]





Isometric view  
Scale: 1:1

MATERIAL: MS  
QUANTITY: 04

3

**NOTE:**

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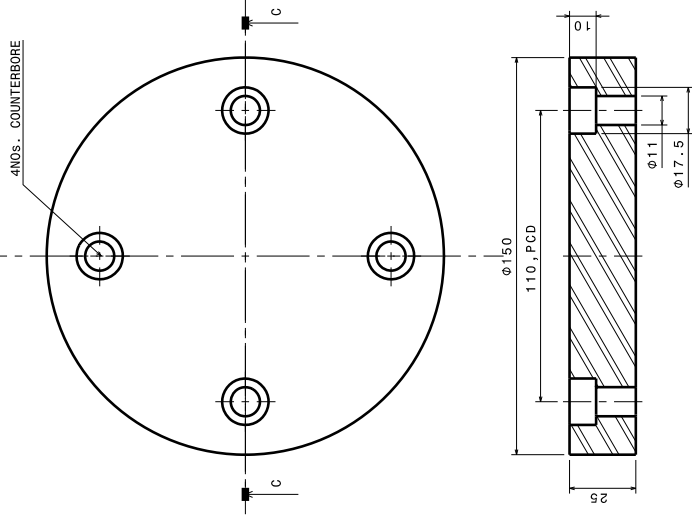
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6



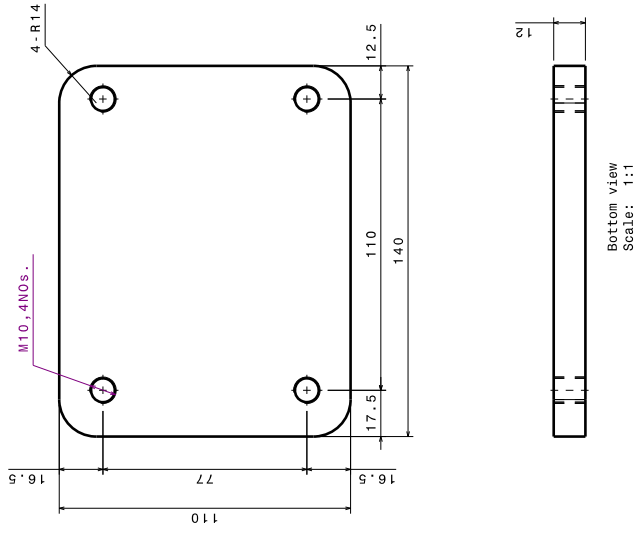
A



5 MATERIAL: MS  
QUANTITY: 04

NOTE:

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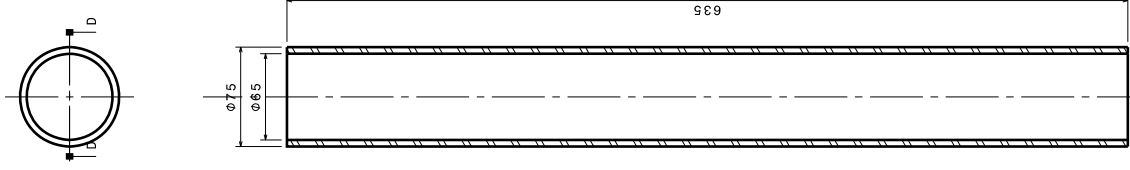


ALL DIAMENSION TO SUIT CASTOR WHEEL BASE

6 MATERIAL: MS  
QUANTITY: 04

NOTE:

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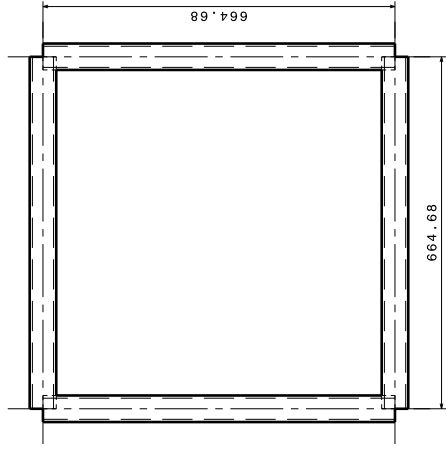
10 MATERIAL: MS  
QUANTITY: 04

NOTE:

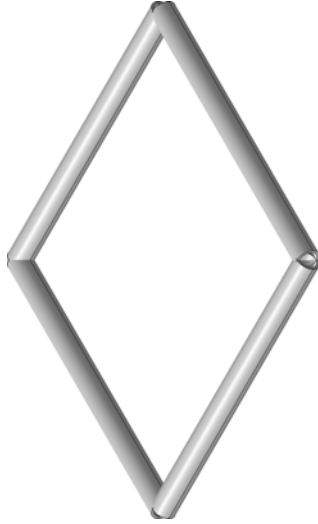
1. ALL SHARP EDGES TO BE REMOVED AND REPLACED BY CHAMFER OF 1 X 45 DEG
2. FLATNESS VALUES ARE NOT TO EXCEED 3 MM/METER ON ANY UNSPECIFIED SURFACE
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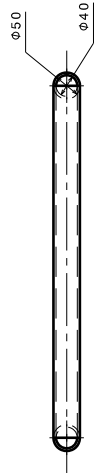
	P	O	N	M	L	K
1						



Front view  
Scale: 1:5



Isometric view  
Scale: 1:5



Bottom view  
Scale: 1:5

MATERIAL: MS  
QUANTITY: 01

NOTE:  
1. ALL SHARP EDGES TO BE REMOVED AND REPLACED BY CHAMFER OF 1 X 45 DEG  
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3. ROUGHNESS OF ALL UNSPECIFIED SURFACES DO NOT EXCEED Ra 8.3  $\mu$ m  
4. ALL UNSPECIFIED TOLERANCE TO BE CONSIDERED AS PER ISO 2768-1:1989

UNR342	9	9-25	W	1.5-4	W	3.0-25 / 1.5	W	W	3.0-25	REV	ZONE	DESCRIPTION	REVISION COLUMN	APPROVED BY	DATE	SCALE	DATE	VP	MAIN	VP	REVISION	DATE	APPROVED	A.M.	REV	NO	DATE	REV	NO	DATE	
CO-ORDINATED BY: _____																															
MAINTENANCE DEVIATIONS FOR NON-TOLERANCED DIMENSIONS																															
LENGTH IN IN. OF SHORTER SIDE OF ANGLES																															
UP TO 10 0.05 0.05-25 0.075 125-425 0.10 125-300 0.125 300-600 0.15 600-1200 0.20 1200-2400 0.25 2400-4800 0.30 4800-9600 0.375 9600-19200 0.50 19200-38400 0.625 38400-76800 0.75 76800-153600 1.00 153600-307200 1.25 307200-614400 1.50 614400-1228800 2.00 1228800-2457600 2.50 2457600-4915200 3.00 4915200-9830400 4.00 9830400-19660800 5.00 19660800-39321600 6.00 39321600-78643200 8.00 78643200-157286400 10.00 157286400-314572800 12.50 314572800-629145600 15.00 629145600-1258291200 20.00 1258291200-2516582400 25.00 2516582400-5033164800 30.00 5033164800-10066329600 40.00 10066329600-20132659200 50.00 20132659200-40265318400 60.00 40265318400-80530636800 75.00 80530636800-161061273600 100.00 161061273600-322122547200 125.00 322122547200-644245094400 150.00 644245094400-1288490188800 200.00 1288490188800-2576980377600 250.00 2576980377600-5153960755200 300.00 5153960755200-10307921510400 400.00 10307921510400-20615843020800 500.00 20615843020800-41231686041600 600.00 41231686041600-82463372083200 700.00 82463372083200-164926744166400 800.00 164926744166400-329853488332800 1000.00 329853488332800-659706976665600 1250.00 659706976665600-1319413953331200 1500.00 1319413953331200-2638827906662400 2000.00 2638827906662400-5277655813324800 2500.00 5277655813324800-10555311626649600 3000.00 10555311626649600-21110623253299200 4000.00 21110623253299200-42221246506598400 5000.00 42221246506598400-84442493013196800 6000.00 84442493013196800-168884986026393600 7000.00 168884986026393600-337769972052787200 8000.00 337769972052787200-675539944105574400 10000.00 675539944105574400-1351079888211148800 12500.00 1351079888211148800-2702159776422297600 15000.00 2702159776422297600-5404319552844595200 20000.00 5404319552844595200-10808639105689190400 25000.00 10808639105689190400-21617278211378380800 30000.00 21617278211378380800-43234556422756761600 40000.00 43234556422756761600-86469112845513523200 50000.00 86469112845513523200-172938225691027046400 60000.00 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