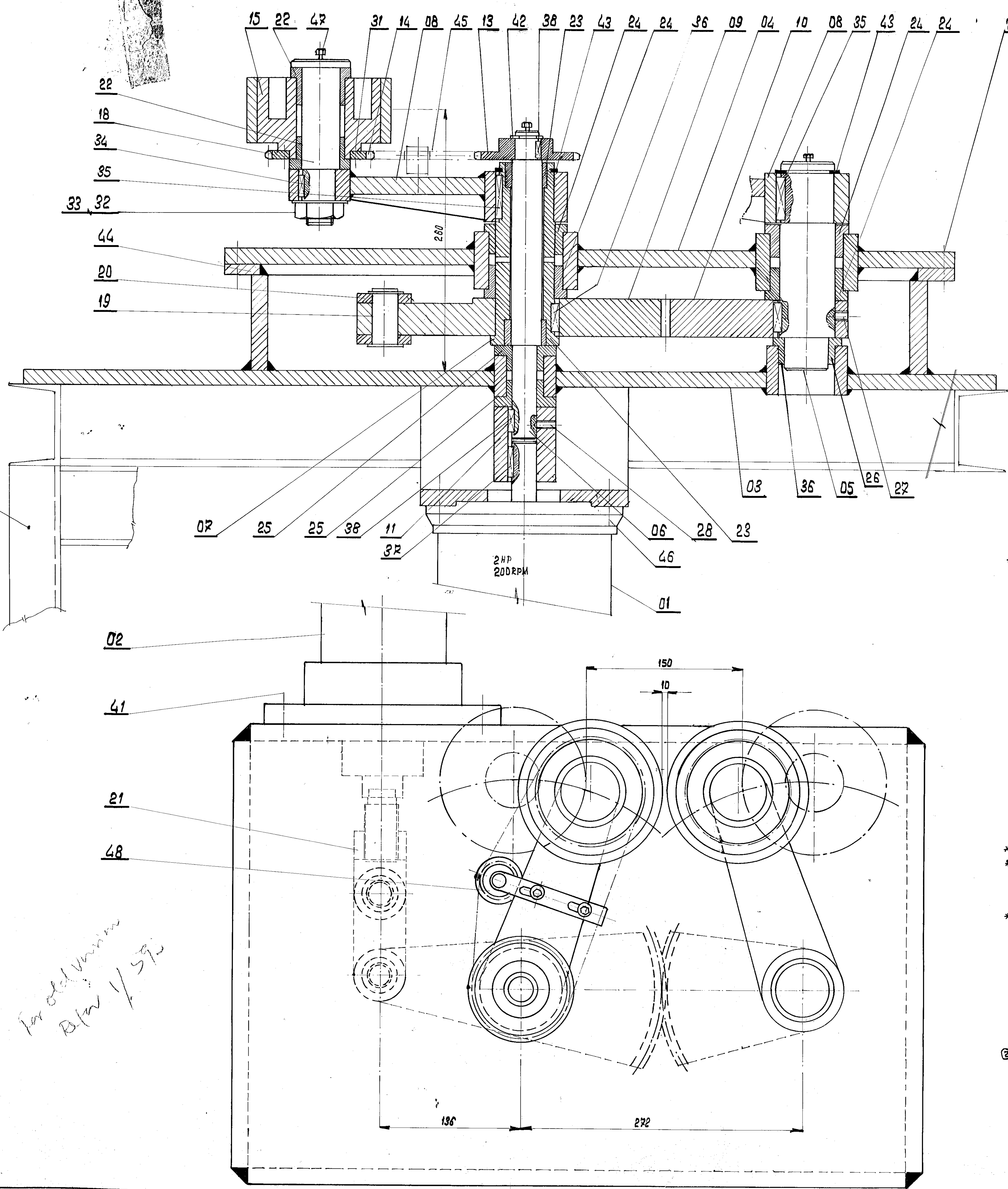


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20-870

- * 16
- * 17
- * 12
- * 40



DATA:

PERIPHERAL SPEED OF WHEEL - 88 M/MIN.
PIPE ϕ 10MM TO 150MM.

PNEUMATIC CYLINDER:

CYLINDER ϕ 5"
STROKE - 3"
WORKING PRESSURE: 6B.P.
MOUNTING: FRONT FLANGE MOUNTED

GEARED MOTOR:

HORSE POWER: 2
OUTPUT RPM: 200

NOTE:

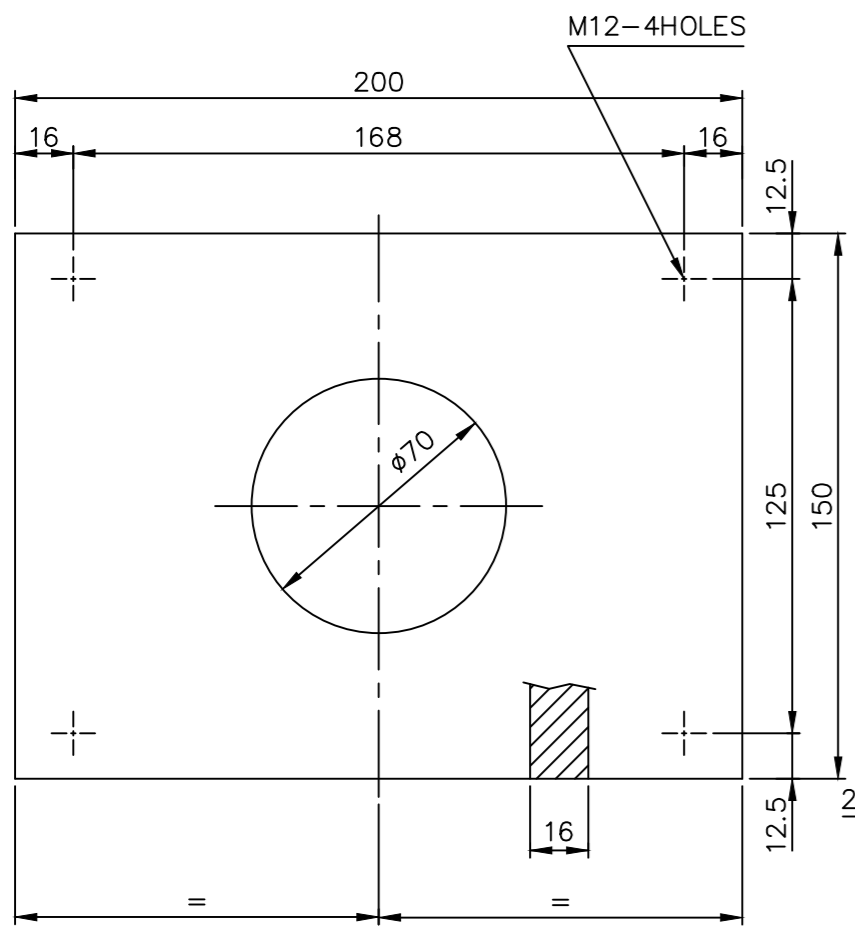
* REFER ITEM NOS. 12, 16, 17 & 40 FOR ASSY. 1.M.021.2049 ONLY.

NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	NET GROSS WT.	NET WT.	DRAWING NO.	REV.
1	TENSIONING ARRANGEMENT						3.M.021.6304	48
3	BREASE WIPPLE M6	ØS: 414 504						47
4	HEX. HD. SCREW M12 x 50	ØS: 412 22						46
1	CHAIN 3/4" 250L PITCH 19.05, ROLLER ϕ 12.07							45
4	CIRCLIP LIGHT Ø2.4	18: 3075						44
1	CIRCLIP LIGHT ASS	18: 3075						43
1	CIRCLIP LIGHT R25	18: 3075						42
4	HEX. SCREW M12 x 30	ØS: 412 22						41
4	SP. WASHER 16	ØS: 414 42						40
18	HEX. NUT. M8	ØS: 413 04						39
2	PARALLEL KEY 8 x 7.25 L	ØS: 415 01						38
1	PARALLEL KEY 12 x 8.50 L	ØS: 415 01						37
2	PARALLEL KEY 18 x 10.25 L	ØS: 415 01						36
2	PARALLEL KEY 18 x 10.25 L	ØS: 415 01						35
2	PARALLEL KEY 8 x 7.25 L	ØS: 415 01						34
2	PUNCHED WASHER M18	ØS: 414 08						33
2	HEX. NUT M8	ØS: 413 04						32
4	SLOTTED CSK. SCREW M6 x 80 L	ØS: 412 05						31
2	CYLINDRICAL PIN ϕ 6 x 40 L	ØS: 412 07						30
16	HEX. HD. BOLT M8 x 40 L	ØS: 412 21						29
1	GRUB SCREW M6 x 16 L	ØS: 412 10						28
2	GRUB SCREW M6 x 16 L	ØS: 412 10						27
1	BUSH ϕ 50	BU-C13					4.M.021.18820	26
2	BUSH ϕ 25	BU-C13					4.M.021.18820	25
4	BUSH ϕ 60	BU-C13					4.M.021.18820	24
2	BUSH	BU-C13					4.M.021.18821	23
4	BUSH ϕ 35	BU-C13					4.M.021.18820	22
1	CONNECTOR	C45					4.M.021.3887	21
2	LINK	C45					4.M.021.3882	20
2	PIV	CQ45					4.M.021.3884	19
2	PIV	CQ45					4.M.021.3990	18
4	BOLT FDN. M16 x 200 L	ØS: 41223						17
1	STAND						3.M.021.10498	16
2	ROLLER						4.M.021.19665	15
1	SPROCKET WHEEL 16T. 3/4" PITCH	C45					4.M.021.38876	14
1	SPROCKET WHEEL 16T. 3/4" PITCH	C45					4.M.021.12819	13
4	HEX. NUT M16	ØS: 41304						12
1	COUPLING	C30					4.M.021.18929	11
1	SEGMENTAL GEAR 68T. OVER 360°	C45					4.M.021.38872	10
1	SEGMENTAL GEAR 87T. OVER 360°	C45					3.M.021.2669	09
2	ARM	C20					2.M.021.3268	08
1	SLEEVE	C30					4.M.021.12817	07
1	SHAFT	CQ45					4.M.021.12816	06
1	SHAFT	CQ45					4.M.021.18815	05
1	COVER	C20					3.M.021.4839	04
1	GEAR 80x						2.M.021.2484	03
1	AIR CYLINDER ϕ 5" x 3" STROKE							02
1	REMI. GEARED MOTOR TYPE E3 KR 100 1. 2HP 200RPM - FLANGE MOUNTING							01

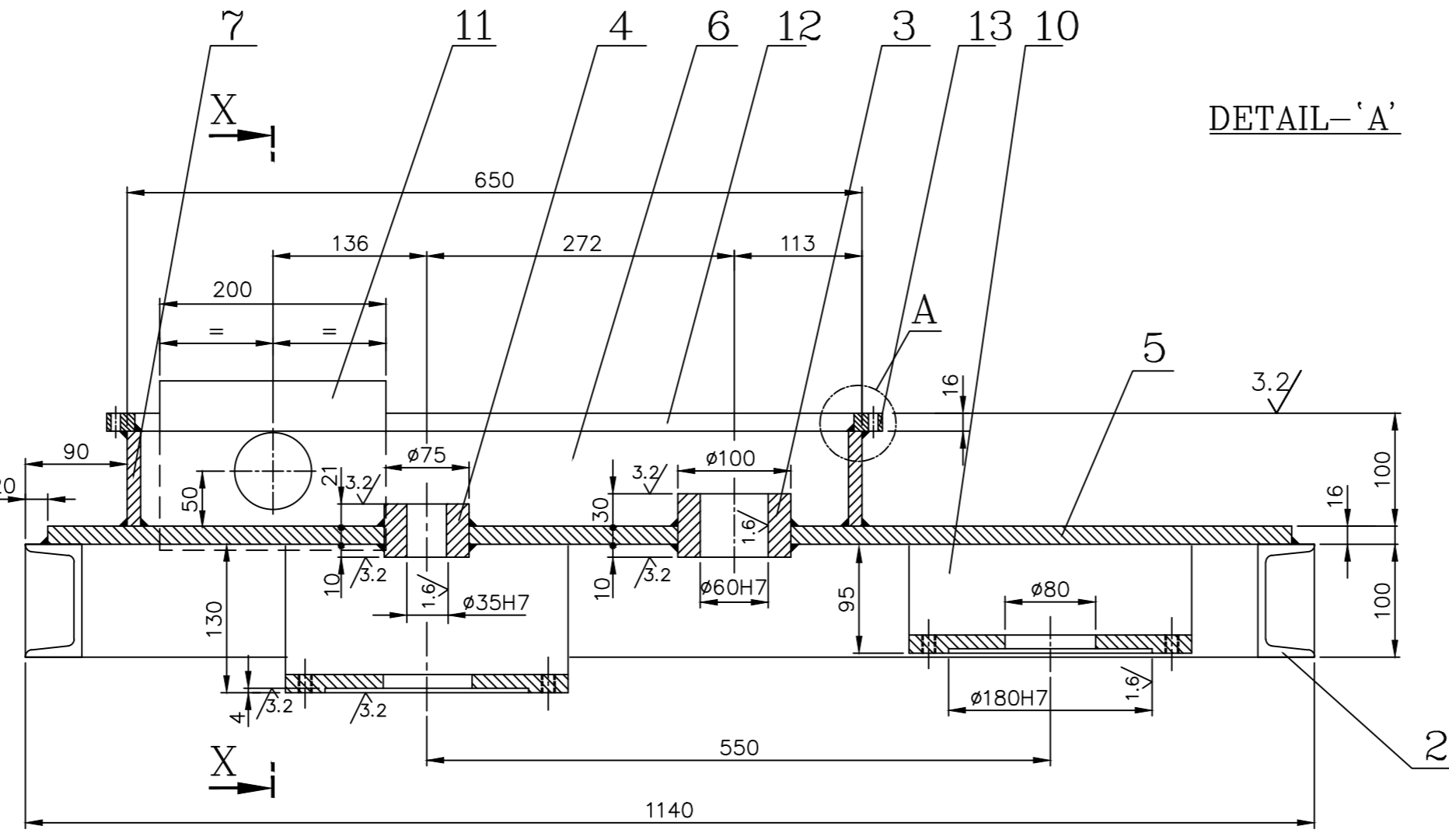
NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	NET GROSS WT.	NET WT.	DRAWING NO.	REV.
REMARKS								
SCALE	DRAWN	CHKD	APPROVED	DATE	ALTERATIONS	DATE	SIGNATURE	INITIALS
1:2	W. LITTLE (LAWRENCE) (MMA)			100380	GEARED MOTOR CHANGE	100380		
DATE: 100380								
MACHINE: PINCH ROLL				TYPE: PRG				
TITLE: PINCH ROLL ASSY.				DRAWING NO. 1.M.021.0804				
NO. OF SHEETS: 2								

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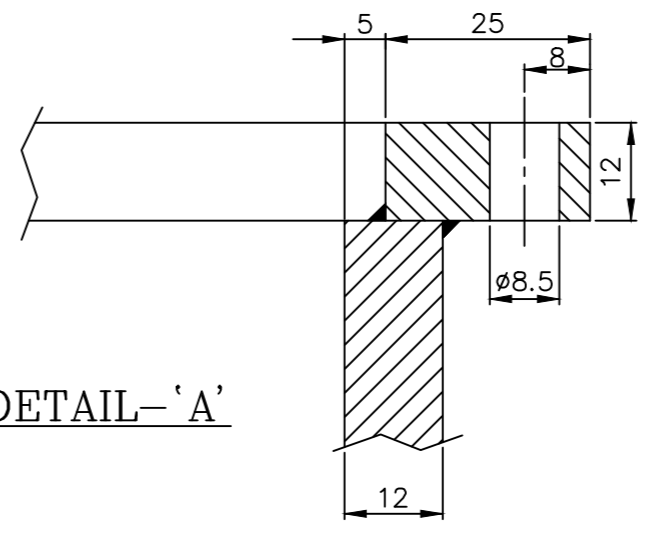
ALL DIMENSIONS ARE IN MM



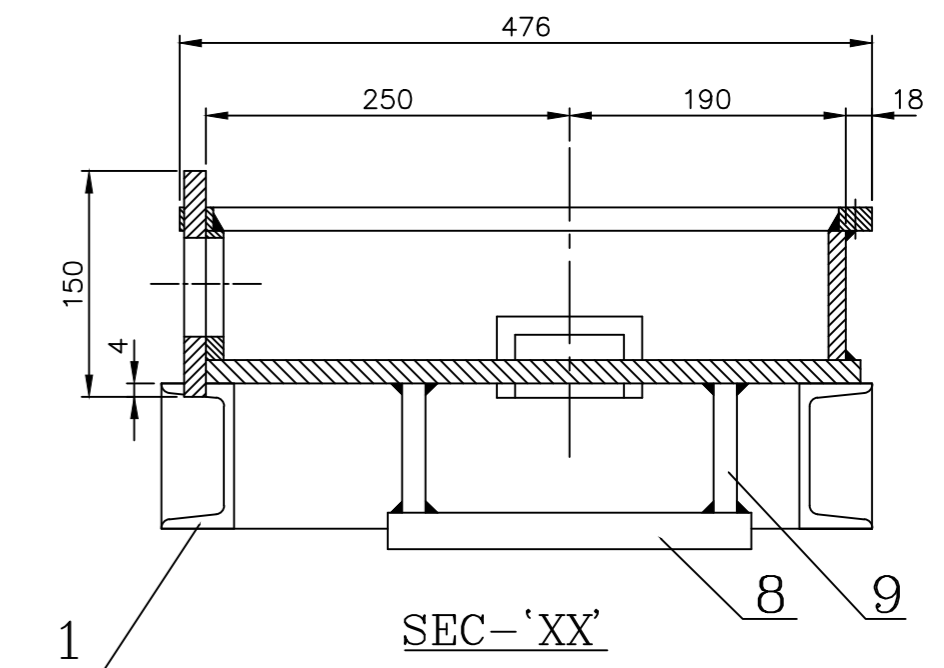
DETAIL FOR ITEM-4



DETAIL-'A'

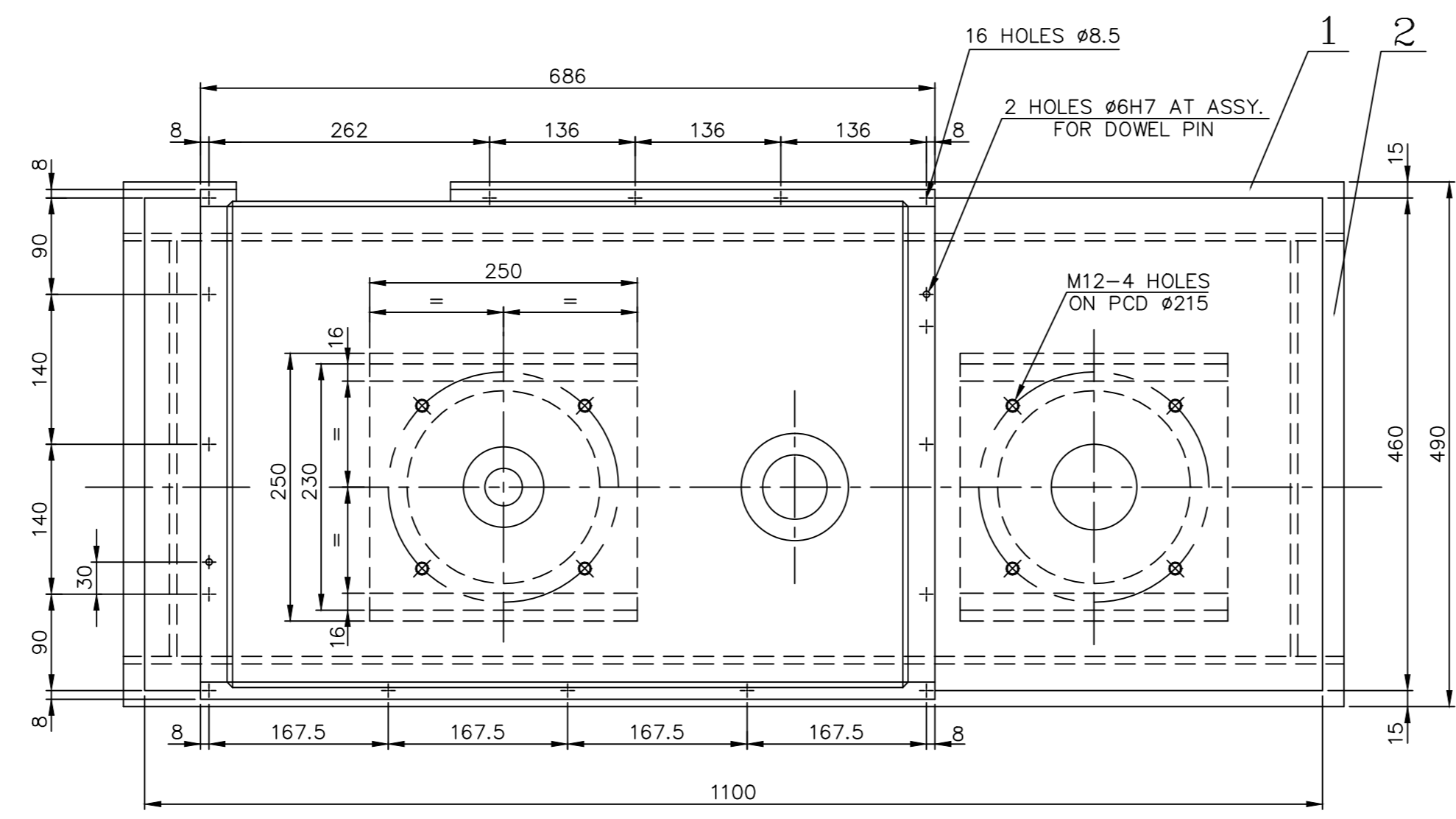


ø35H7	+0.025 +0.000	ø6H7	+0.012 +0.000	√3.2/1.6/
ø60H7	+0.030 +0.000	ø130H7	+0.040 +0.000	



NOTE: -

- ø180 H7 AND M12-4HOLES ON PCD 215 IS SUITABLE FOR "REMI" GEARED MOTOR TYBE: Z3KR-2HP. 200RPH FLANGE MOUNTING.
- ALL WELDED CONSTRUCTION.



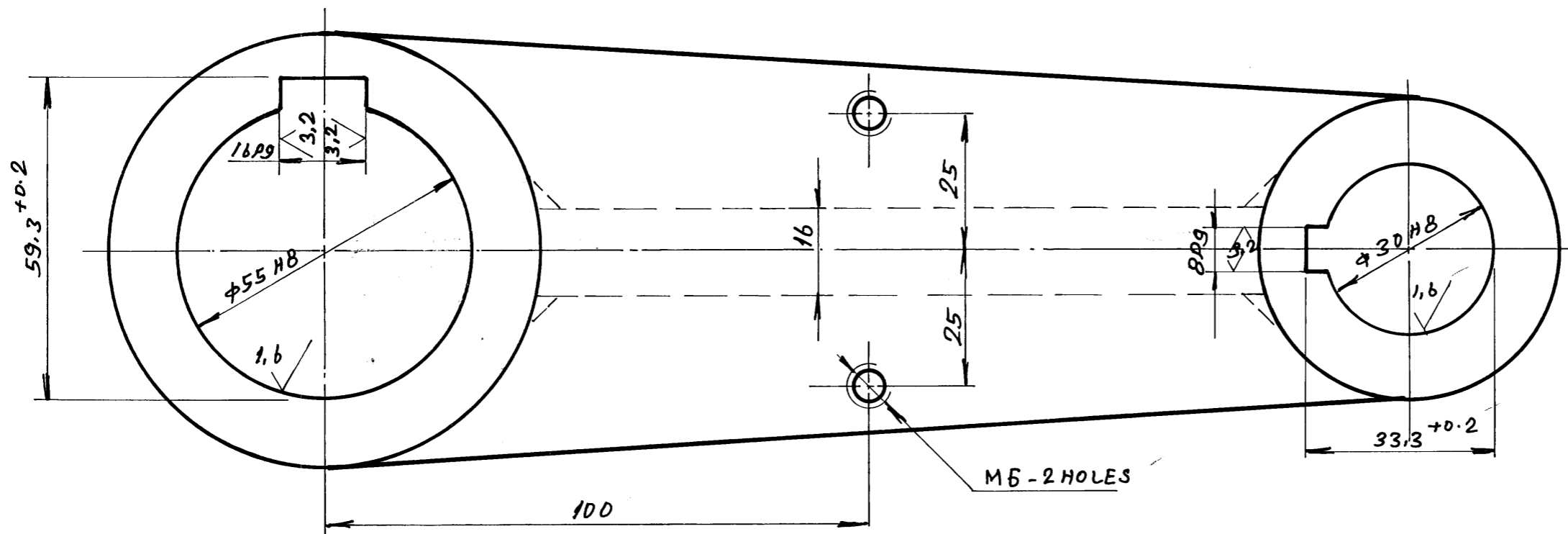
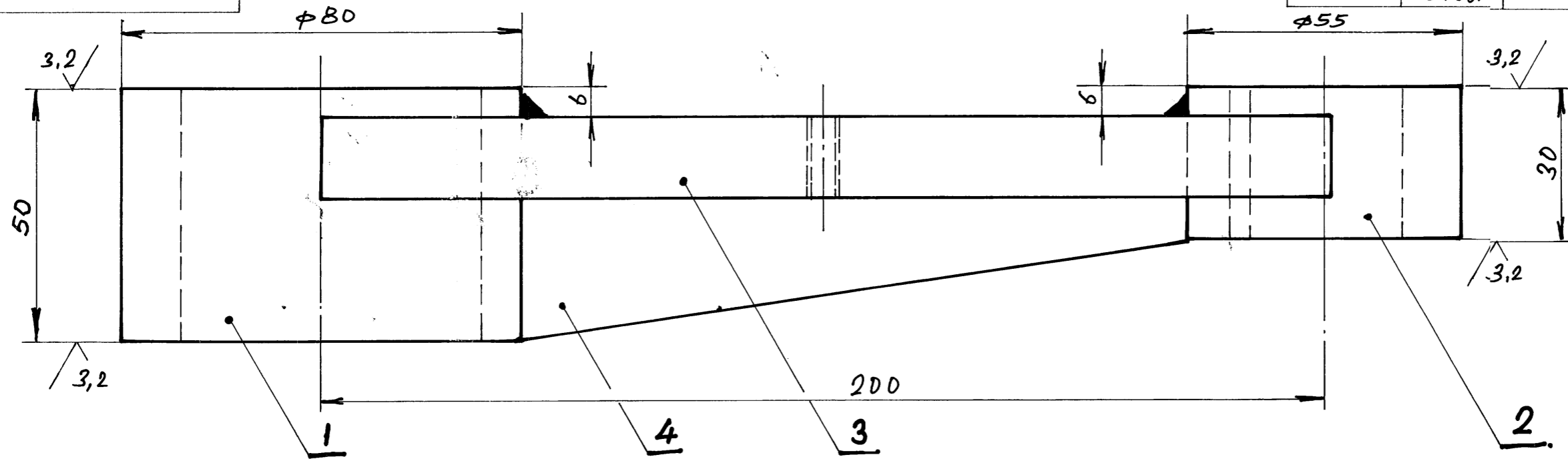
No. of Pieces	DESCRIPTION	MATERIAL	STANDARD	NET.WT.IN KGS	DRAWING No.	ITEM No
02	PL 16tx25x426	Fe410WA	IS: 2062	2.0		13
02	PL 16tx25x686	Fe410WA	IS: 2062	3.22		12
01	PL 16tx150x200	Fe410WA	IS: 2062	3.5		11
02	PL 16tx95x250	Fe410WA	IS: 2062	2.0		10
02	PL 16tx110x250	Fe410WA	IS: 2062	2.6		09
02	PL 25tx250x250	Fe410WA	IS: 2062	9.4		08
02	PL 12tx88x416	Fe410WA	IS: 2062	6.86		07
02	PL 12tx88x626	Fe410WA	IS: 2062	10.32		06
01	PL 16tx460x1100	Fe410WA	IS: 2062	63.6		05
01	ROD ø75x60L	45C8	IS: 7283	2.0		04
01	ROD ø100x65L	45C8	IS: 7283	4.0		03
02	ISMC 100x390L	Fe410WA	IS: 2062	7.2		02
02	ISMC 100x1140L	Fe410WA	IS: 2062	21.00		01
				137.7	1M02F1400804	03

DESCRIPTION	MATERIAL	STANDARD	NET.WT.IN KGS	DRAWING No.	ITEM No
REFERENCE:		ALTERATIONS:	DCN REF	DATE	SIGN.
SCALE	DRAWN/TCD	CHECKED	APPROVED	DATE	
1:5	N.M.A.V.O.F	R.RAMAMOORTHY	C.S.JAYASHEELAN	28-03-80/28-01-09	
MACHINE:	PRODUCTION FACILITY	TYPE:	STWD-PRG		
TITLE:	GEAR BOX (PINCH ROLL ASSY)	DRAWING No:	2M02F1402494		REV.
		Sheet No:		No. of Sheets:	

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8P9	-0.015	φ30H8	+0.033	12.5	3.2	1.6
	-0.051		+0.000			
16P9	-0.018	φ55H8	+0.046			
	-0.061		+0.000			

39-609 A



ALL WELDED CONSTRUCTION

2	BM-C20				1-M-02f-0804	B
					1-M-02f-0593	B
No. of pcs.	DESCRIPTION	MATERIAL	STD/BPS	Net wt. (kg)	Gross wt. (kg)	DRAWING No.
REFERENCE :	ALTERATIONS		CC:00/EG:14	DATE	SIGN.	Index
SCALE	DRAWN/TRD	A. BABU.				
1:1	CHECKED	<i>[Signature]</i>				
	APPROVED	<i>[Signature]</i>				
	DATE	04-11-91/10.573				
MACHINE : PINCH ROLL			TYPE: PRG		Total wt. (kg.)	
TITLE			DRAWING No.		REV.	
ARM			3-M-02f-3858			
No. of Sheets:			Sheet No.			

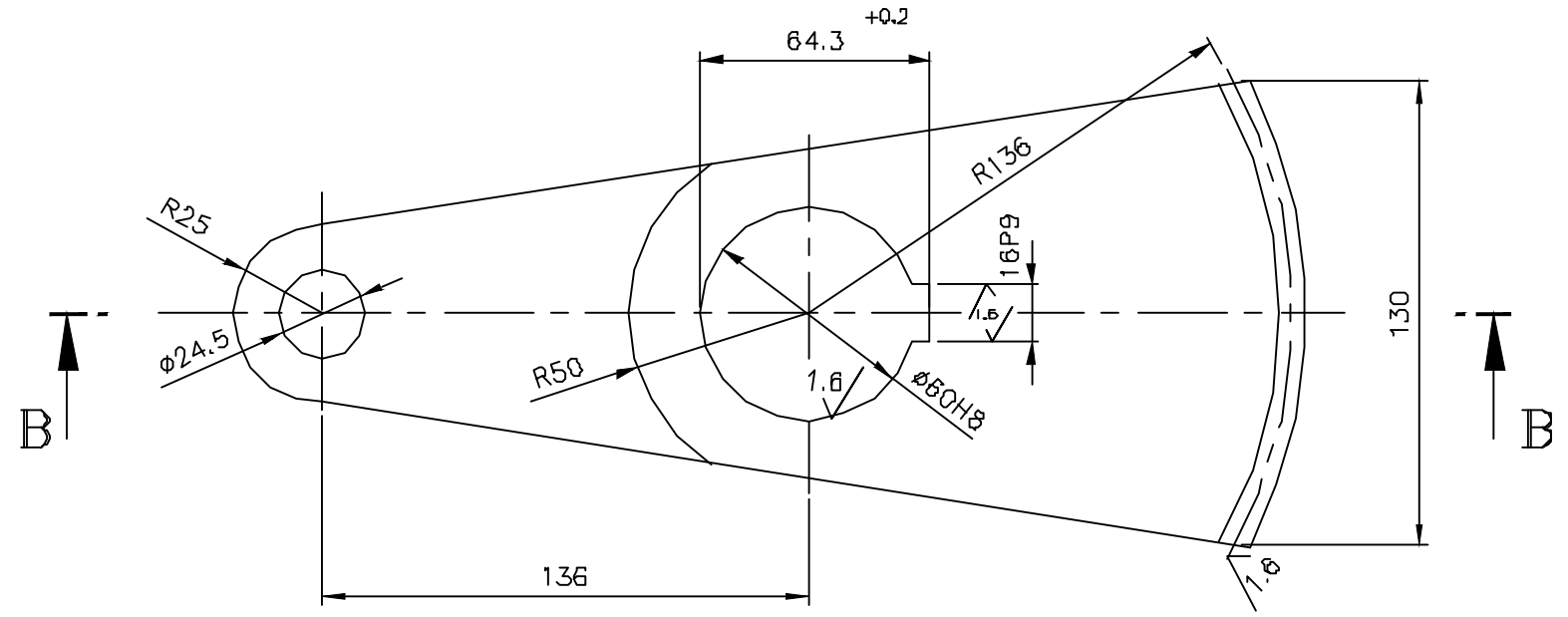
1	PLATE 182x18x16t	BM-C20				4
1	PLATE 200x80x16t	"				3
1	BOSS φ55x40	"				2
1	BOSS φ80x60	"				1

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ALL DIMENSIONS ARE IN MM

16P9	-0.018	Ø60H8	+0.046
	-0.061		+0.000

3.2/1.6



SEC - BB

NO.OF TEETH	68T OVER 360°
MODULE	4
PRESSURE ANGLE	20°
WIDTH ACROSS B TEETH	92.3728 -0.063 -0.083
CORRECTION FACTOR	-
QLTY.&TOL.ZONE	9c DIN 3967
MATING GEAR NO.OF TEETH	68T OVER 360°
MATING GEAR DRAWING NO:	4-M-02F-09872
CENTRE DISTANCE	272

NOTE:

ALL CORNERS TO BE CHAMFERED 1/45°

				1M-02F14-00804	09	
				1M-02F14-00593	09	
No. of Pieces	DESCRIPTION	MATERIAL	STANDARD	NET.VT.IN KGS.	DRAWING No.	ITEM No.
1	REFERENCE:					
SCALE	DRAWN/TCD.	G.Govindaraj	DRG. MODIFIED TO DATE	15.03.12	CSJ	01
1:2	CHECKED	R.Ramamoorthy				
	APPROVED	C.S.Jayasheelan				
	DATE	27/05/08				
MACHINE: PINCH ROLL			TYPE: PRG			
TITLE: SEGMENTAL GEAR			DRAWING No: 3M02F140386901			
			REV. 01			
			Sheet No: No. of Sheets:			

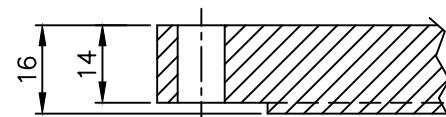
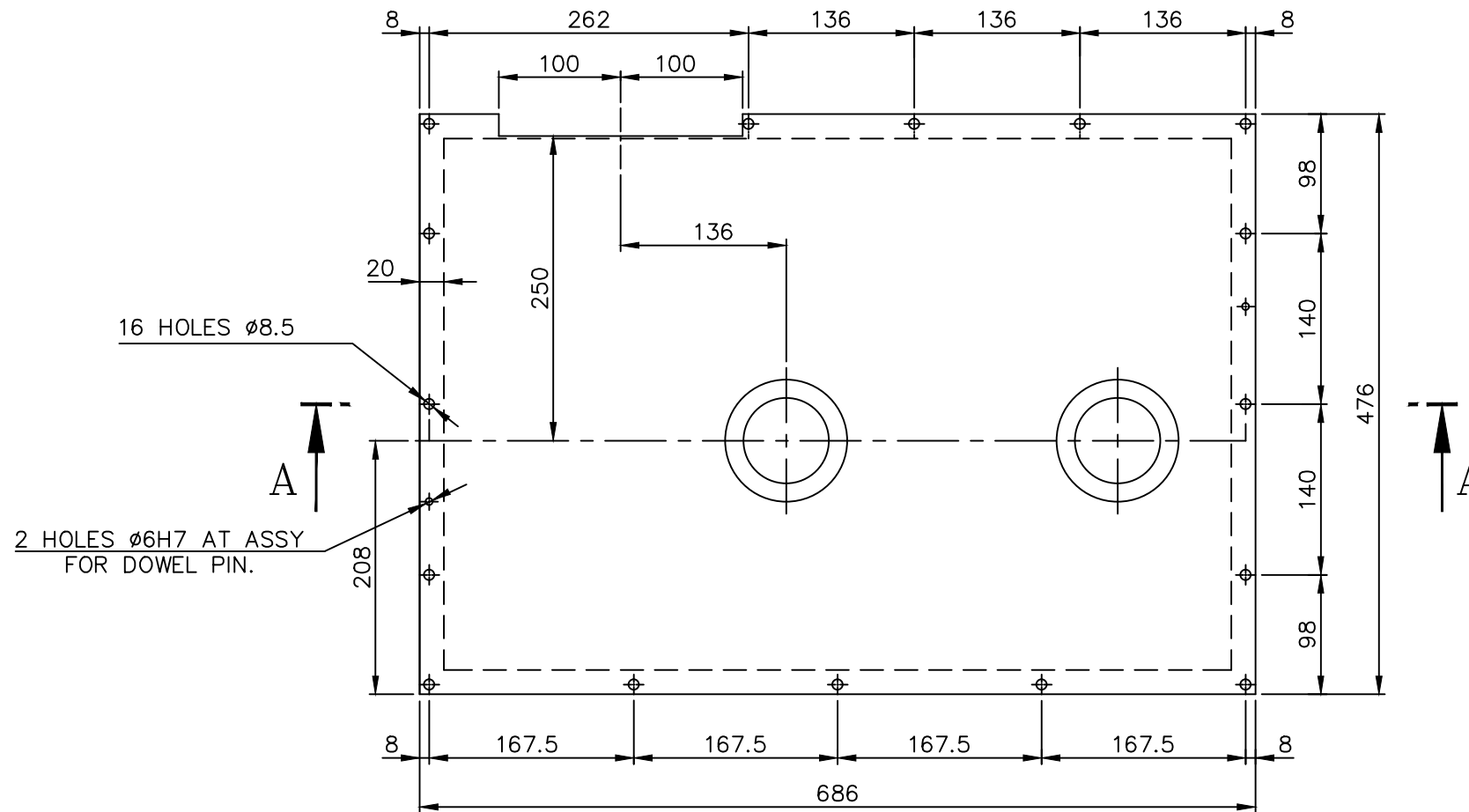
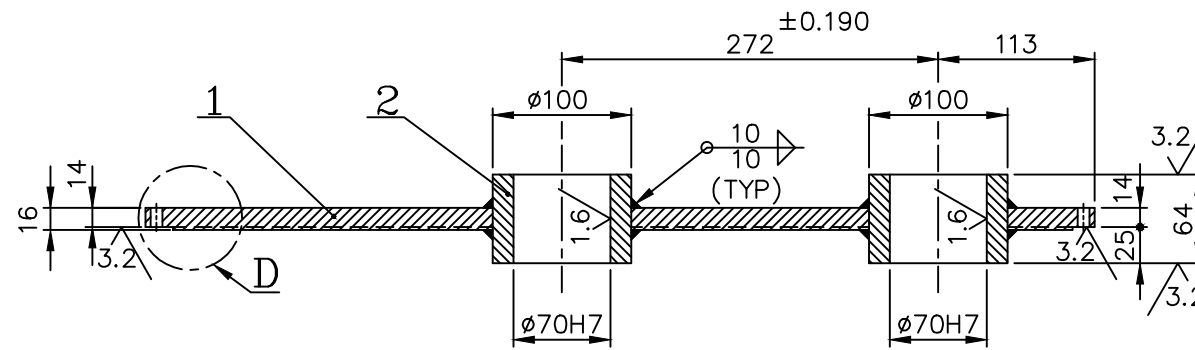
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CAUTION:

ALL DIMENSIONS ARE IN MM

ø70H7	+0.030
	+0.000

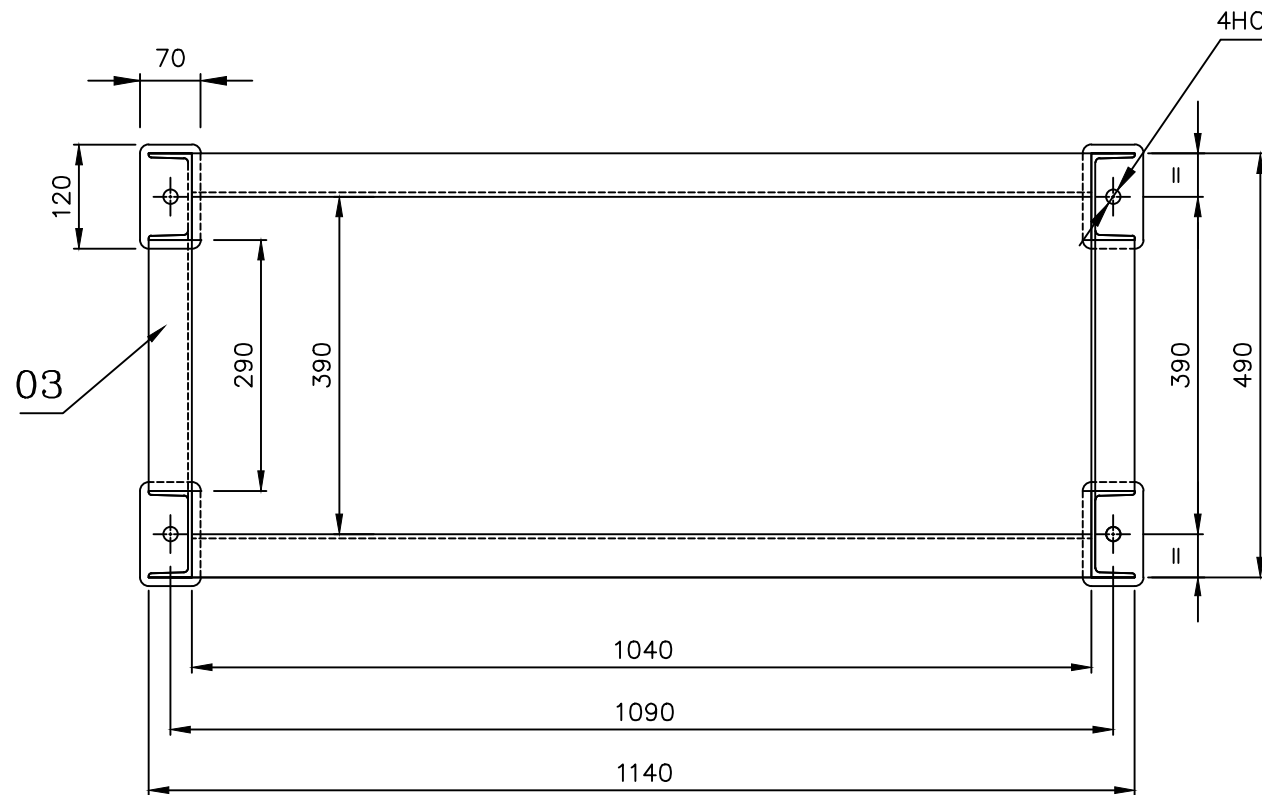
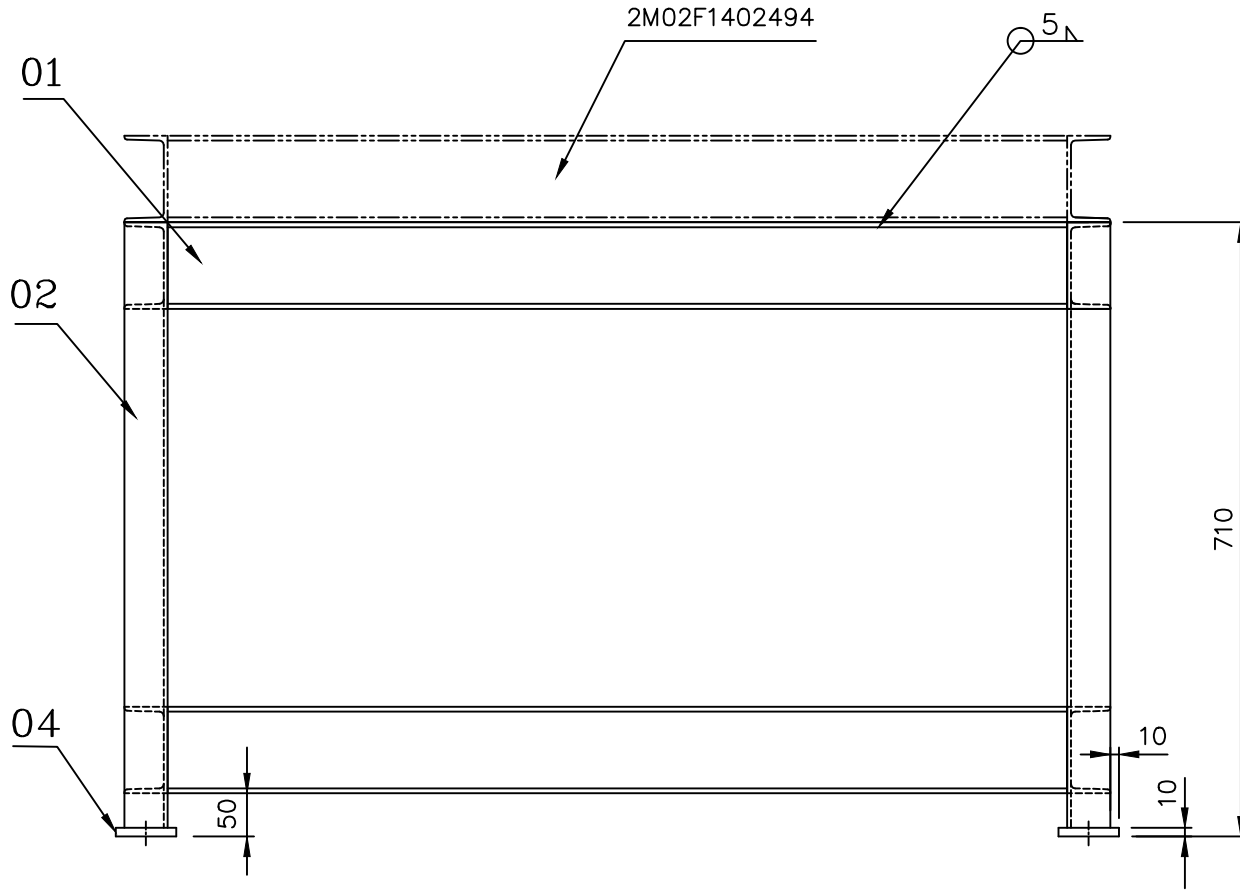
√/3.2/1.6/



02	PL 64txID70xOD100	Fe410WB	IS: 2062	3.98		02
01	PL 16tx476x686	Fe410WA	IS: 2062	36.00		01
				39.98	2M02F1400804	04
No. of Pieces	DESCRIPTION	MATERIAL	STANDARD	NET.WT.IN KGS.	DRAWING No.	ITEM No.
	REFERENCE:		ALTERATIONS:	DCN REF	DATE	SIGN.
SCALE	DRAWN/TCD	DRG. MODIFIED TO DATE			15.03.12	CSJ
1:5	CHECKED	R.RAMAMOORTHY				
	APPROVED	C.S.JAYASHEELAN				
	DATE	20-11-74/09-02-09				
MACHINE: PRODUCTION FACILITY			TYPE: STWD-PRG			
TITLE: COVER (PINCH ROLL ASSY)			DRAWING No:			REV.
			3M02F140483901			
			Sheet No:			No. of Sheets:

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ALL DIMENSIONS ARE IN MM



NOTE: -

ALL WELDS ARE OF 5MM FILLET.

04	PL.10tx70x120	Fe410WA	IS: 2062	2.8		04
04	ISMC 100x50....290L	Fe410WA	IS: 2062	11.2		03
04	ISMC 100x50....700L	Fe410WA	IS: 2062	26.8		02
04	ISMC 100x50....1040L	Fe410WA	IS: 2062	39.6		01

				80.04	1M02F1400804	16
--	--	--	--	-------	--------------	----

No. of Pieces	DESCRIPTION	MATERIAL	STANDARD	NET.WT.IN KGS.	DRAWING No.	ITEM No.
	REFERENCE:		ALTERATIONS:	DCN REF	DATE	SIGN.
SCALE	DRAWN/TCD	DRG. MODIFIED TO DATE			15.03.12	CSJ
NTS	CHECKED	R.RAMAMOORTHY				
	APPROVED	C.S.JAYASHEELAN				
	DATE	04.12.89/05.02.09				

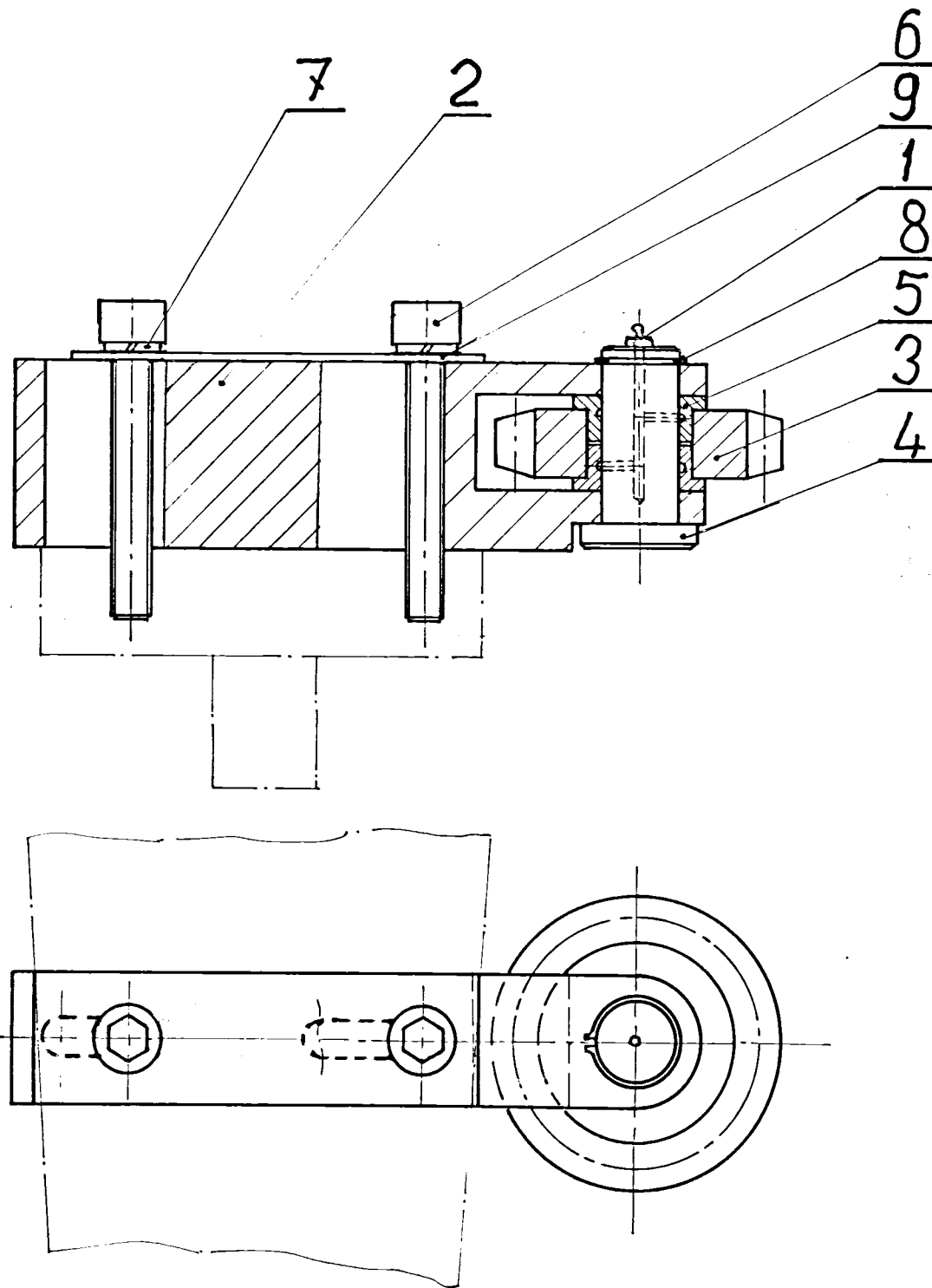
MACHINE:	PRODUCTION FACILITY	TYPE:	STWD-PRG
TITLE:	STAND (PINCH ROLL ASSY)		REV.
	DRAWING No:	3M02F1410498 01	
	Sheet No:	No. of Sheets:	

CAUTION

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BHARAT HEAVY ELECTRICALS LIMITED
TIRUCHIRAPALLI-620 014

INDEX No. 39-608



1	WASHER		BM-C20						4-M-02f-16925	9
1	EX. CIRCLIP A12	BPS: 419-02								8
2	SPRING WASHER 6	BPS: 414-05								7
2	HEX. SOCKET HEAD CAP SCREW M6x40 L	BPS: 412-02								6
2	BUSH		BN-CA3						4-M-02f-16839	5
1	PIN		BM-C45						4-M-02f-16838	4
1	SPROCKET 6T/19.05P		BN-C45						4-M-02f-16837	3
1	HOLDER		BM-C3D						4-M-02f-16836	2
1	GREASE NIPPLE 1/4 BS WHITWORTH STRAIGHT									1
1	ASSY								1-M-02f-0804	49

NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET WT(kg)	GROSS WT(kg)	DRAWING NO.	ITEM NO.	
REMARKS				TOTAL NET WT. (kg.)						
SCALE	DRAWN	CHECKED	APPROVED	STDS. OFFICER	DATE	REFERENCE	ALTERATIONS	DATE	SIGNATURE	INDEX
1:1					29.6.77					

MACHINE: PINCH ROLL
 TYPE: PRG
 TITLE: TENSIONING ARRANGEMENT
 DRAWING NO. 3-M-02f-6504
 NO. OF SHEETS. SHEET No.:

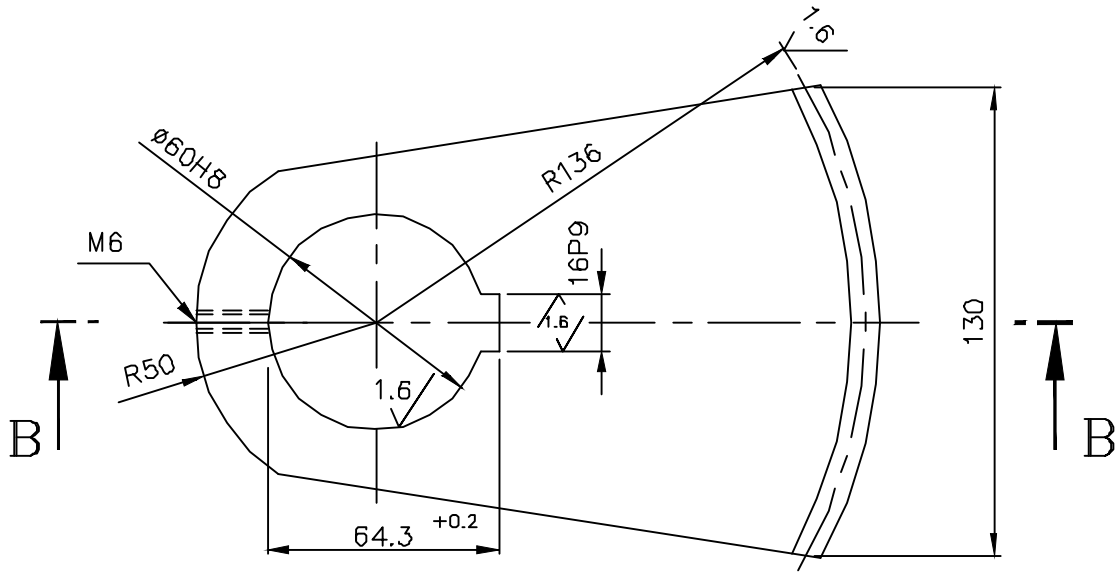


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ALL DIMENSIONS ARE IN MM

16P9	-0.018	ø60H8	+0.046
	-0.061		+0.000

3.2 // 1.6 // ✓



SEC - BB

NO.OF TEETH	68T OVER 360°
MODULE	4
PRESSURE ANGLE	20°
WIDTH ACROSS 8 TEETH	92.3728 -0.063 -0.083
CORRECTION FACTOR	-
QLTY.&TOL.ZONE	9c DIN 3967
MATING GEAR NO.OF TEETH	68T OVER 360°
MATING GEAR DRAWING NO;	3-M-02F14-03869
CENTRE DISTANCE	272

NOTE:

ALL CORNERS TO BE CHAMFERED 1/45°

						1M-02F14-00804	10
<input checked="" type="checkbox"/>		45C8	IS: 7283	-	1M-02F14-00593		10
No. of Pieces	DESCRIPTION		MATERIAL	STANDARD	NET.WT.IN KGS.	DRAWING No.	ITEM No.
	REFERENCE:		ALTERATIONS:		DCN REF	DATE	SIGN.
SCALE 1:2	DRAWN/TCO.	G.Govindaraj	DRG. MODIFIED TO DATE		15.03.12	CSJ	01
	CHECKED	R.Ramamoorthy					
	APPROVED	C.S.Jayasheelan					
	DATE	27/05/08					
MACHINE: PINCH ROLL			TYPE: PRG				
TITLE: 			DRAWING No:		REV.		
SEGMENTAL GEAR			4M02F140987201				
			Sheet No		No. of Sheets:		

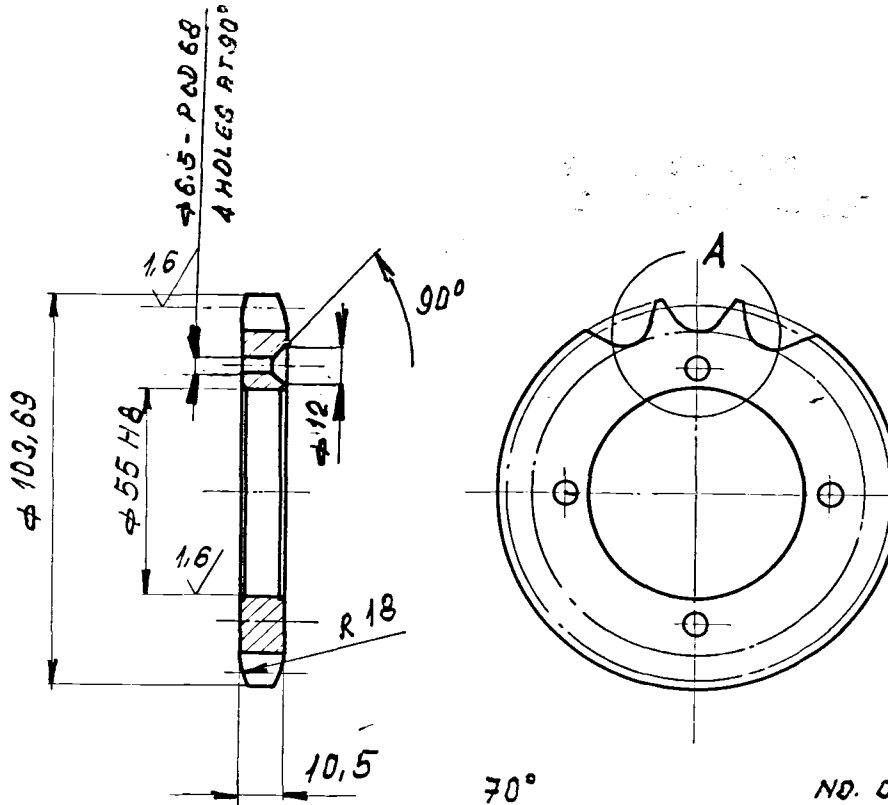
INDEX NO 39-607

CAUTION

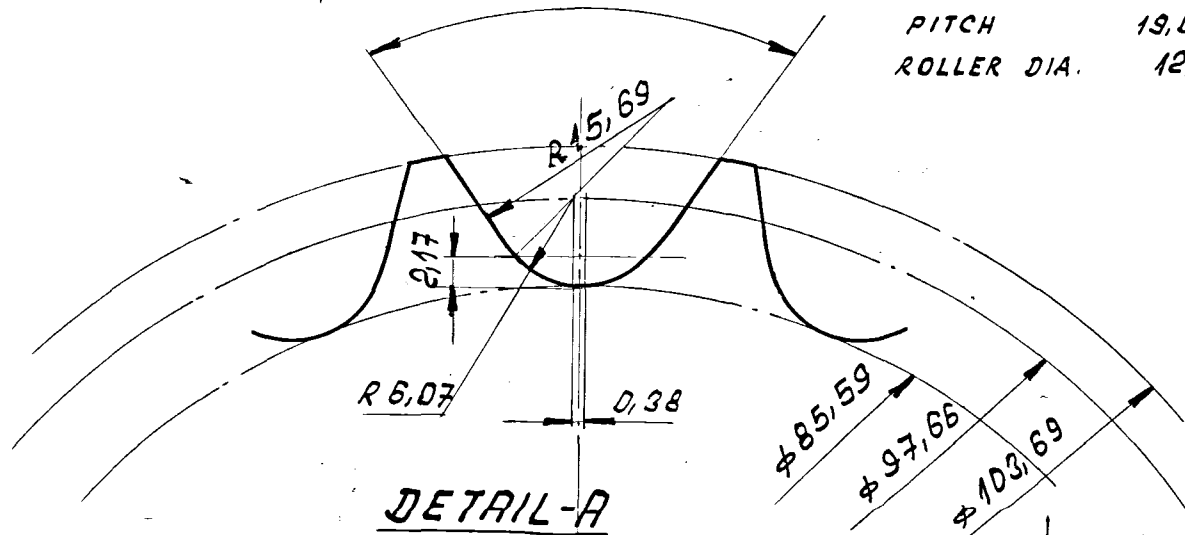
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3,2 / 1,6 /

$\phi 55 H8$	+0,046
	+0,000



NO. OF TEETH 16
 PITCH 19,05 [3/4"]
 ROLLER DIA. 12,07

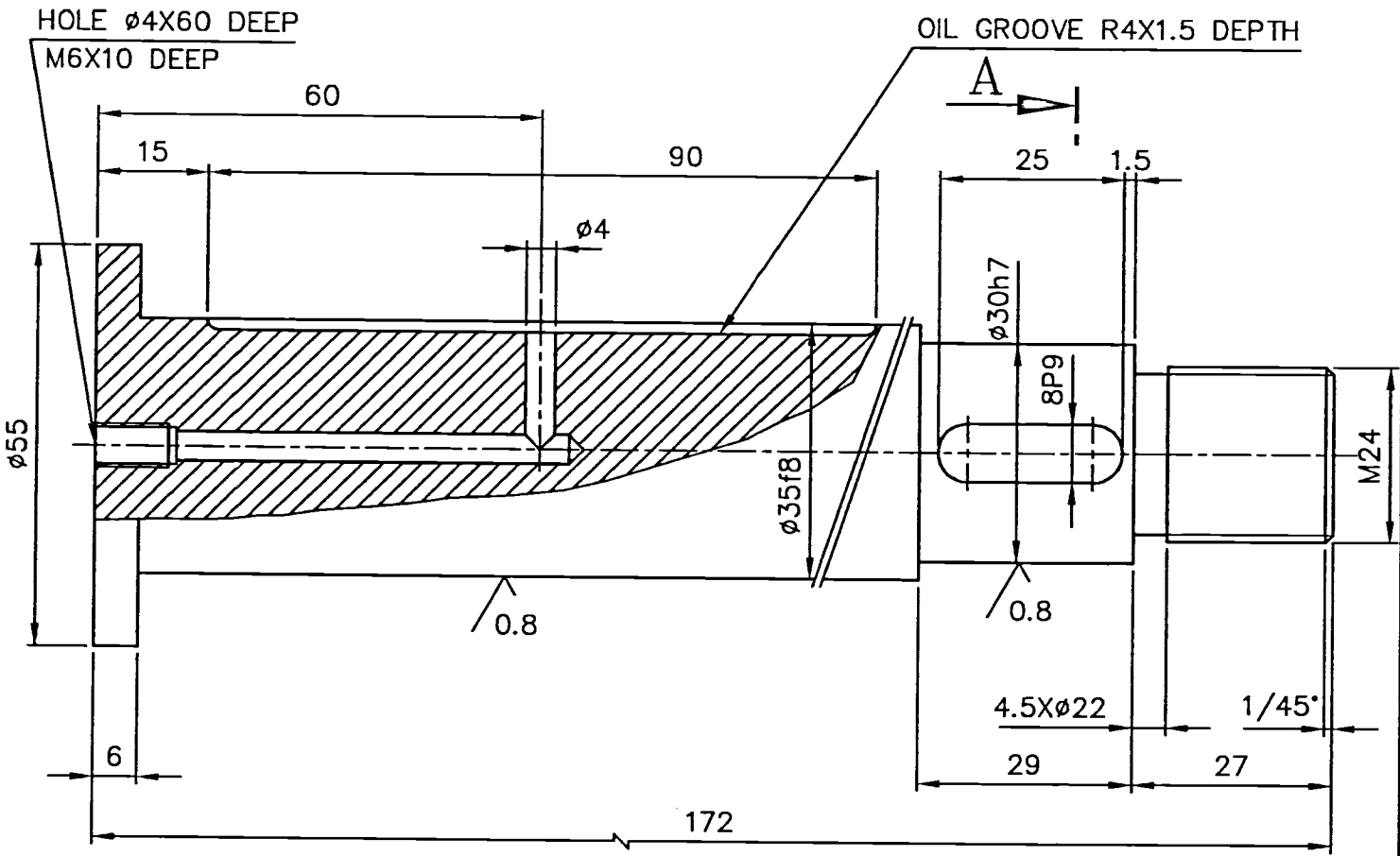


2				CL IV	45CB			1-M-02f-0804		14
IS 1875				IS: 7283			1-M-02f-0593		14	
NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET WT(kg)	GROSS WT(kg)	DRAWING NO.	ITEM NO.	
REMARKS					TOTAL NET wt (kg) CC:22 / EC:14					
SCALE 1:2	DRAWN BY	S. V. [Signature]		REFERENCE	ALTERATIONS		DATE	SIGNATURE	INDEX	
	CHECKED BY									
	APPROVED BY	[Signature]								
	STDS. OFFICER									
DATE	10.5.73									
MACHINE		PINCH ROLL			TYPE:		PRG			
TITLE:		SPROCKET			DRAWING NO.		4-M-02f-9876			
TIRUCHY		16t 1 3/4" b			NO. OF SHEETS:		SHEET NO:			

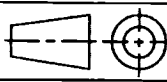

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ALL DIMENSIONS ARE IN MM

ø35f8	-0.025	ø30h7	-0.000	3.2 // 1.6 / 0.8 /
	-0.084		-0.021	
8P9	-0.015			
	-0.051			



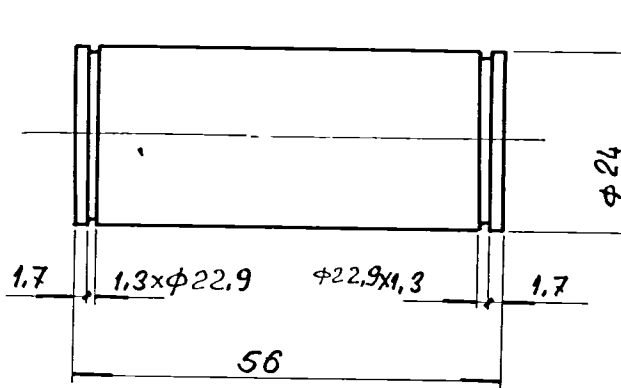
SECTION-AA

					1-M-02F-00804	18								
02	ROD ø55X172	45c8	IS: 7283	1.30	1-M-02F-00593	18								
No. of Pieces		DESCRIPTION	MATERIAL	STANDARD	NET.WT.IN KGS.	DRAWING No.	ITEM No.							
REFERENCE:			 COMPONENT CODE: 31		EQUIPMENT CODE: 14									
SCALE		DRAWN/TCD	ALTERATIONS: <table border="1"> <tr> <td>DCN REF</td> <td>DATE</td> <td>SIGN.</td> <td>INDEX</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> </tr> </table>				DCN REF	DATE	SIGN.	INDEX				
DCN REF	DATE	SIGN.	INDEX											
1:1		CHECKED												
		APPROVED												
		DATE	08.05.73/28.06.03											
MACHINE PRODUCTION FACILITY			TYPE: STWD-PRG											
TITLE: PIN ø55X172L			DRAWING No: 14		REV.									
			4-M-02F-09880											
			No. of Sheets:		Sheet No:									

CAUTION

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BHARAT HEAVY ELECTRICALS LTD.,
TIRUCHIRAPALLI-14.

3/2 ✓



1.M-02f-0804 19

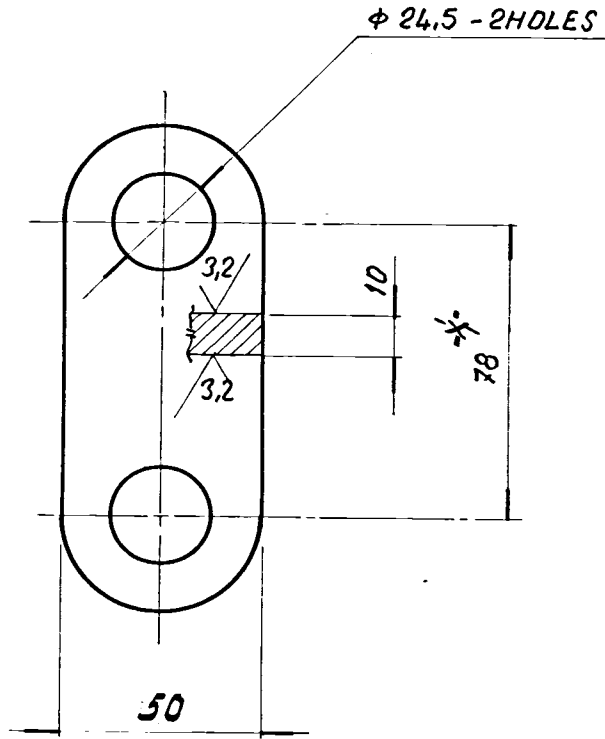
2			BM-CQ45	45 CB IS:7282				1-M-02f-0593	20
NO OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET wt(kg)	GROSS wt(kg)	DRAWING NO.	ITEM NO.
REMARKS				TOTAL NET wt (kg) CC: 31/EC: 14					
SCALE	DRAWN BY	REFERENCE		ALTERATIONS		DATE	SIGNATURE	INDEX	
1:1	<i>S. Kumar</i>								
	CHECKED BY								
	APPROVED BY								
	STDS. OFFICER								
	DATE	10-5-73							
<p>TIRUCHY</p>		MACHINE PINCH ROLL		TYPE: PRG					
		TITLE: PIN		DRAWING NO. 4-M-02f-9881 ¹⁴					
				NO. OF SHEETS:		SHEET NO:			

INDEX NO 39-607

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6.3 / 3.2



* NOTE:
TO CONFIRM AFTER RECEIPT
OF AIR CYLINDER.

1-M-02f-0804 | 20

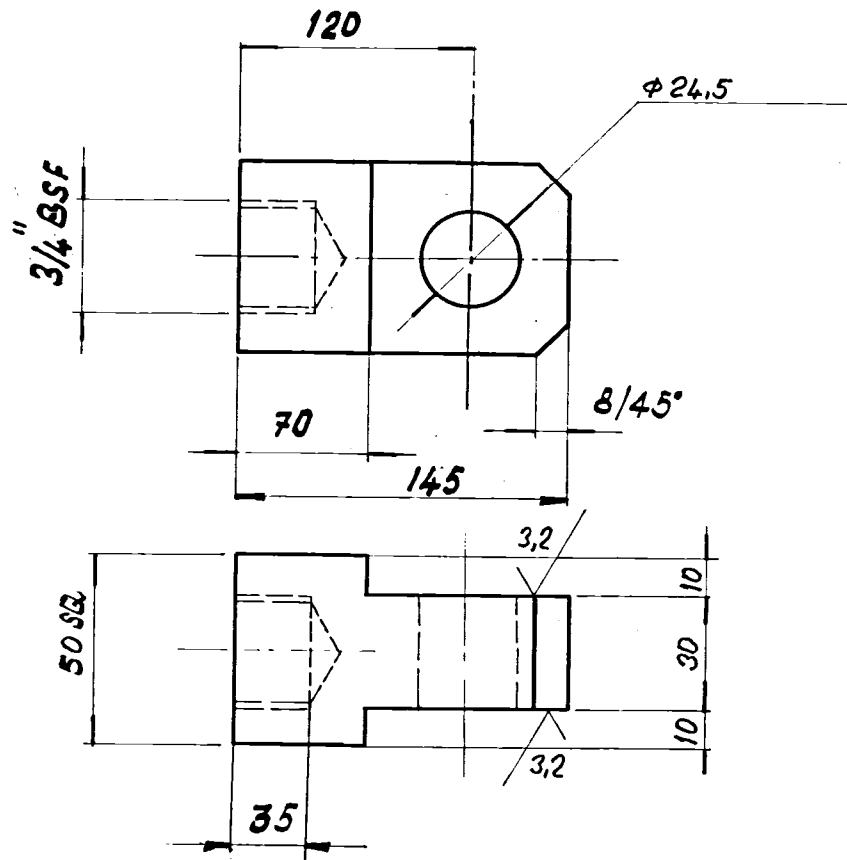
2			BM-C45	45CB IS:7283				1-M-02f-0593	21
NO OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET WT(kg)	GROSS WT(kg)	DRAWING NO.	ITEM NO.
REMARKS				TOTAL NET WT (kg) CC:00 / EC:14					
SCALE	DRAWN BY	REFERENCE		ALTERATIONS		DATE	SIGNATURE	INDEX	
1:2	<i>S. An</i>								
	CHECKED BY								
	APPROVED BY								
	STDS. OFFICER								
	DATE	10-5-73							
MACHINE PINCH ROLL			TYPE: PRG						
TITLE: LINK			DRAWING NO. 4-M-02f-9882						
TIRUCHY			NO. OF SHEETS:			SHEET NO:			

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TIRUCHIRAPALLI-14.

6,3 / 3,2



1-M-02f-0804 21

1-M-02f-0593 22

1			45 C 8	IS: 7283						
NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET wt(kg)	GROSS wt(kg)	DRAWING NO.	ITEM NO.	

REMARKS				TOTAL NET wt (kg) CG: 00 / EG: 14						
SCALE 1:2	DRAWN BY	<i>S. Rajan</i>		REFERENCE	ALTERATIONS		DATE	SIGNATURE	INDEX	
	CHECKED BY	<i>S. Rajan</i>								
	APPROVED BY	<i>Prasad</i>								
	STDS. OFFICER									
	DATE	10-5-73								



MACHINE PINCH ROLL	TYPE: PRG
TITLE: CONNECTOR	DRAWING NO. 4-M-02f-9883
	NO. OF SHEETS: SHEET NO:

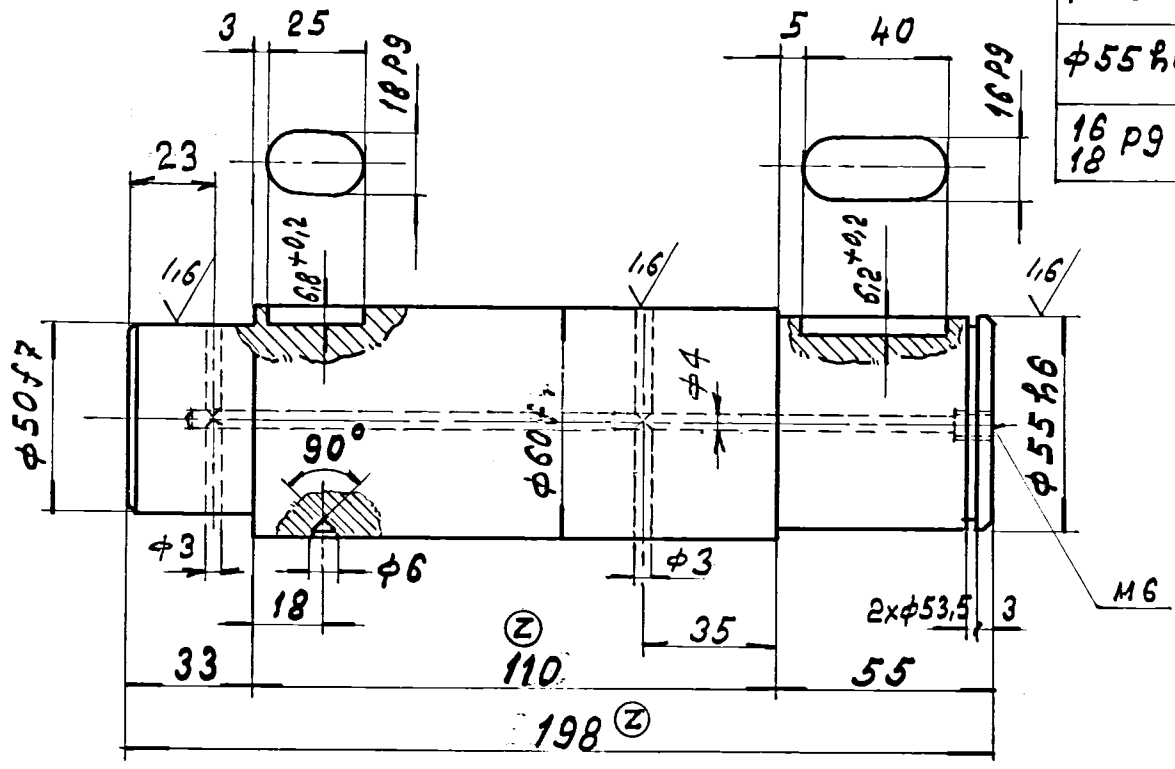
INDEX No. 39-607

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 TIRUCHIRAPALLI-14

3,2 / 1,6 /

φ60f7	-0,030
	-0,060
φ50f7	-0,026
	-0,050
φ55h6	-0,000
	-0,019
16 p9	-0,018
18 p9	-0,061



CHAMFER SHARP CORNERS TO 1/45°

		3M-CQ45 45CB				1.M.02f-0804		5	
NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET WT(KG)	GROSS WT(KG)	DRAWING NO.	ITEM NO.
REMARKS			TOTAL NET wt (kg) CC:01/ EC 14						
SCALE 1:2	DRAWN	V. H. B. Samy.		REFERENCE	ALTERATIONS		DATE	SIGNATURE	INDEX
	CHECKED				DIMENSION ALTERED		12-6-75		②
	APPROVED	<i>[Signature]</i>							
	STDS. OFFICER								
DATE		19.11.1974							
MACHINE		PINCH ROLL			TYPE: PRG		INV. NO.		
TITLE:		SHAFT			DRAWING NO.		4-M-02f-12815		
NO. OF SHEETS					SHEET NO.				

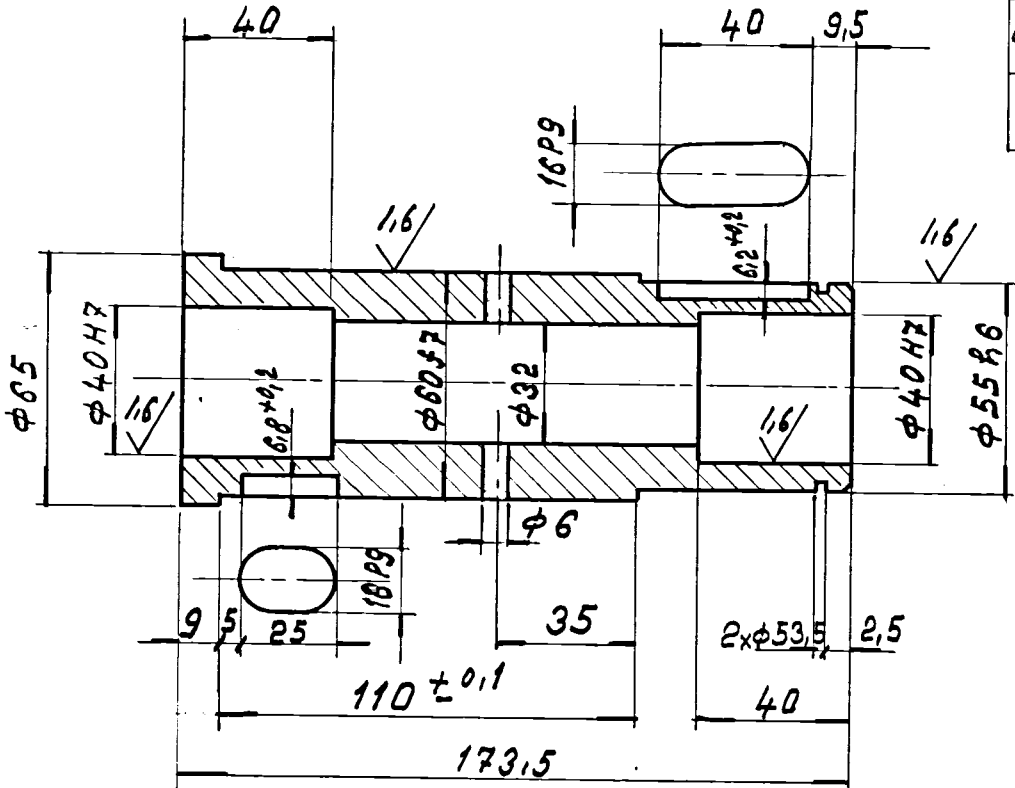


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TIRUCHIRAPALLI-14

3,2 / 1,5 /

φ60 f7	-0,030
	-0,060
φ55 h6	-0,000
	-0,019
φ40 H7	+0,025
	+0,000
16 P9	-0,018
18 P9	-0,061



CHAMFER SHARP CORNERS TO 1/45°

1			BM-C 30	45 CB IS:7283				1.M.02f.0804 7	
NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING NO.	ITEM NO.
REMARKS				TOTAL NET WT (kg)		CC:30	EC:14		
SCALE	DRAWN	REFERENCE	ALTERATIONS		DATE	SIGNATURE	INDEX		
1:2	K. U. B. Sanyal								
	CHECKED								
	APPROVED								
	STDS. OFFICER								
	DATE	19.11.1974							
MACHINE			TYPE:		INV. NO.				
TITLE:			DRAWING NO.						
PINCH ROLL			PRG						
SLEEVE			4.M.02f.12817 ¹⁴						
NO. OF SHEETS			SHEET NO.						

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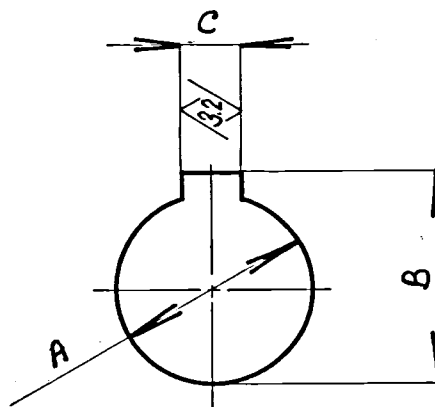
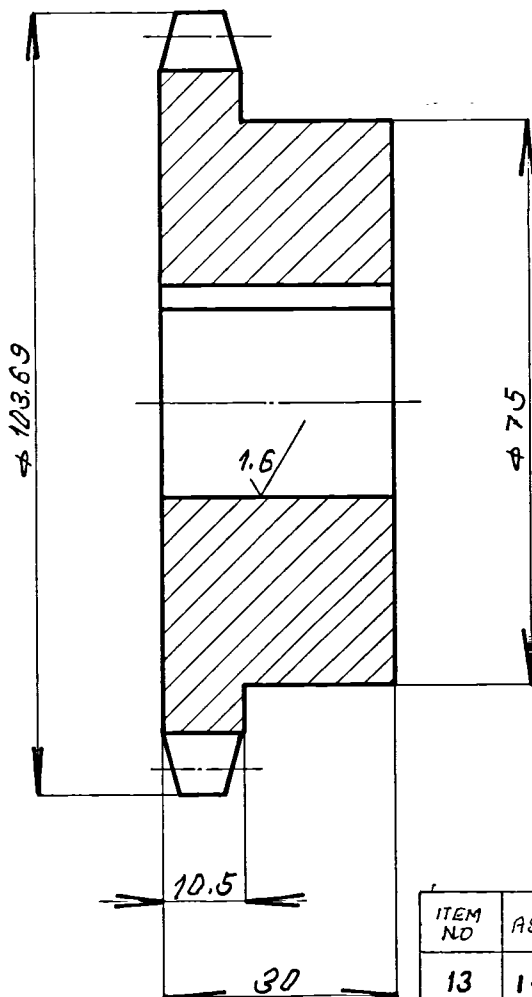
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6.3 / 3.2 / 1.6

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±25H7	+0.021
	+0.000
8P9	-0.015
10P9	-0.051
±32H7	+0.025
	+0.000



NO. OF TEETH 16
 PITCH (3/4") 19.05
 ROLLER DIA 12.07

ITEM NO	ASSY DRG. NO	'A'	'B'	'C'	Qty.
13	1-M-02f-0804	±25H7	27.9 ^{+0.2}	8P9	1
11	1-M-02f-2049	±32H7	35.3 ^{+0.4}	10P9	3
19	2-M-02f-3485	±25H7	27.9 ^{+0.2}	8P9	1

BM-C45

4-11-02f-S377

NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING NO.	ITEM NO.

REMARKS				TOTAL NET WT (kg)		CC: 22 / EC: 14	
SCALE	DRAWN	REFERENCE	ALTERATIONS	DATE	SIGNATURE	INDEX	
1:1	<i>Jayashree</i>						
	CHECKED						
	APPROVED	<i>byz...</i>					
	STDS. OFFICER						
	DATE	19.11.1974					

MACHINE PINCH ROLLER

TYPE: PRG

INV. NO.

TITLE:

DRAWING NO.



SPROCKET
 16T/3/4" P

4.M-02f-12819

NO. OF SHEETS

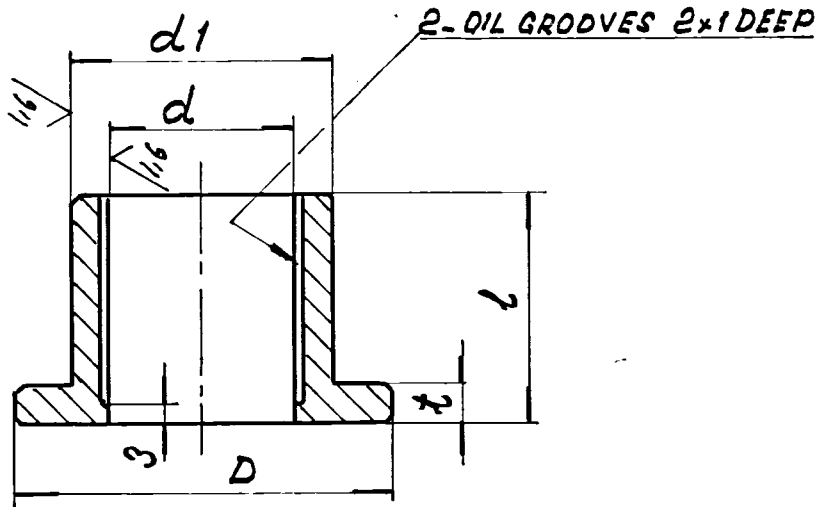
SHEET NO.

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 TIRUCHIRAPALLI-14

3.2 / 1.6

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D	d ϕ 7	d ϕ 6	l	t	NOS.	RED	ITEM NO.	wt.
70	50	60	30	5	1		26	0,26
50	25	35	20	5	2		25	0,114
80	60	70	30	5	4		24	0,075
55	35	45	40	5	4		22	0,26

CHAMFER SHARP CORNERS TO $1/45^\circ$

26
25
24
22

		BH-CA3		PCUSN7 IS:28				1.M.02f.0804	
NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET WI(KG)	GROSS WI(KG)	DRAWING NO.	ITEM NO.
REMARKS				TOTAL NET WI(KG) 66.17-66.01					
SCALE 1:1	DRAWN	K. U. B. Samy.		REFERENCE	ALTERATIONS	DCN	DATE	SIGNATURE	INDEX
	CHECKED								
	APPROVED	<i>[Signature]</i>							
	STDS. OFFICER	<i>[Signature]</i>							
DATE		19.11.1974							
MACHINE		PINCH ROLL		TYPE: PRG		INV. NO.			
TITLE:		BUSH		DRAWING NO.		14 4.M.02F.12820			
NO. OF SHEETS				SHEET NO.					



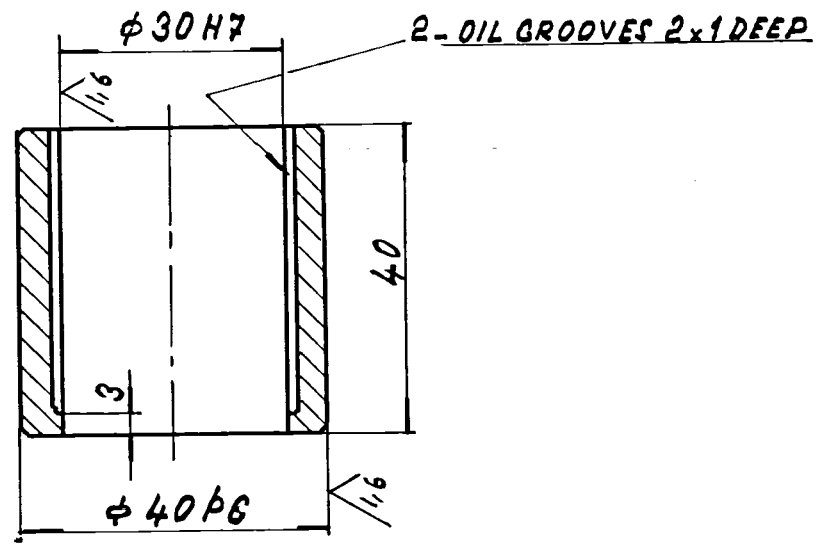
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3.2 / 1.5 /

φ30H7	+0,021
	+0,000
40p6	+0,042
	+0,026

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CHAMFER SHARP CORNERS TO 1/45°

2			BN-CA3	PCUSn7 IS:28				1.M.02f-0804	23
NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET WT (KG)	GROSS WT (KG)	DRAWING I.O.	ITEM NO.
REMARKS				TOTAL NET WT (KG)		00.17	EC:14		
SCALE	DRAWN	REFERENCE	ALTERATIONS		DATE	SIGNATURE	INDEX		
1:1	K. U. B. Samy.								
	CHECKED								
	APPROVED								
	STDS. OFFICER								
	DATE	19.11.1974							
MACHINE PINCH ROLL			TYPE: PRG		INV. NO.				
TITLE: BUSH			DRAWING NO. 4.M.02f.12821		14				
NO. OF SHEETS			SHEET NO.						



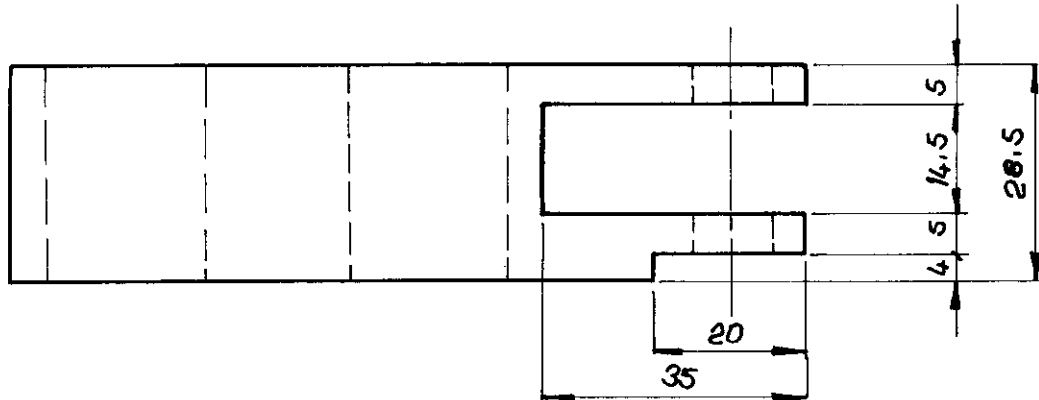
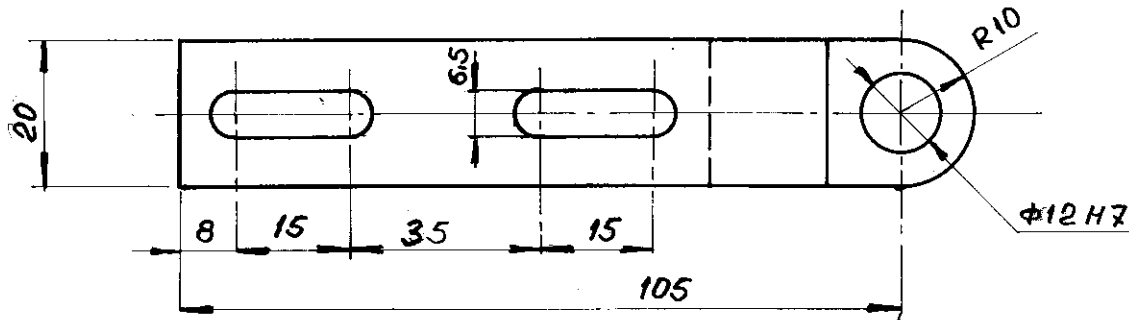
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 TIRUCHIRAPALLI-14

3/2

Φ12H7	+0.018
	+0.000

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1	pl. 125x35x25t		BM-C30					3-M-02f-6504	2
NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET Wt(kg)	GROSS Wt(kg)	DRAWING NO.	ITEM NO.
REMARKS				TOTAL NET wt (kg) EC: 27					
SCALE 1:1	DRAWN	<i>M. Jayaraman</i>		REFERENCE	ALTERATIONS		DATE	SIGNATURE	INDEX
	CHECKED	<i>Rama Sany</i>							
	APPROVED	<i>Rama Sany</i>							
	STDS. OFFICER	<i>Rama Sany</i>							
	DATE	28-6-77							
MACHINE PINCH ROLL		TYPE: PR6		INV. NO.					
TITLE: HOLDER		DRAWING NO. 4-M-02f-16836		NO. OF SHEETS					
SHEET NO.									



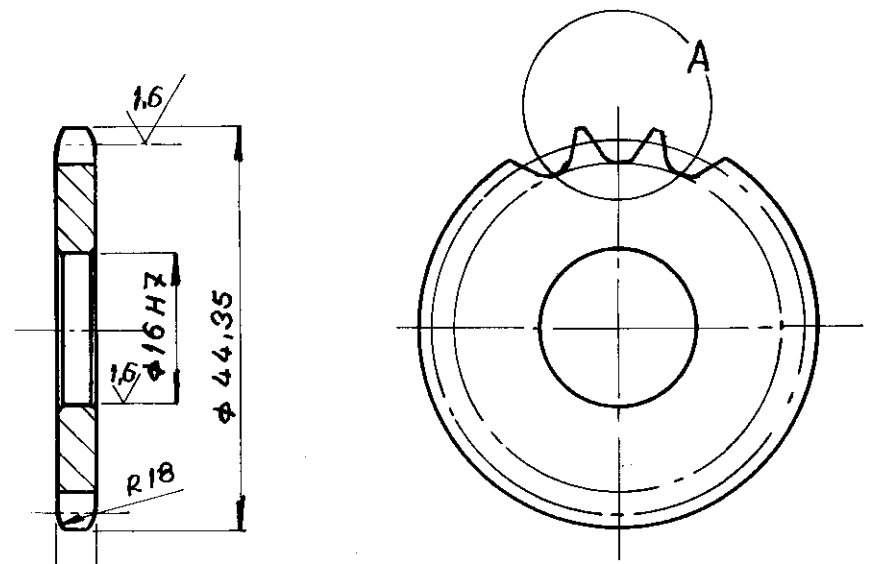
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3,2 / 1,6

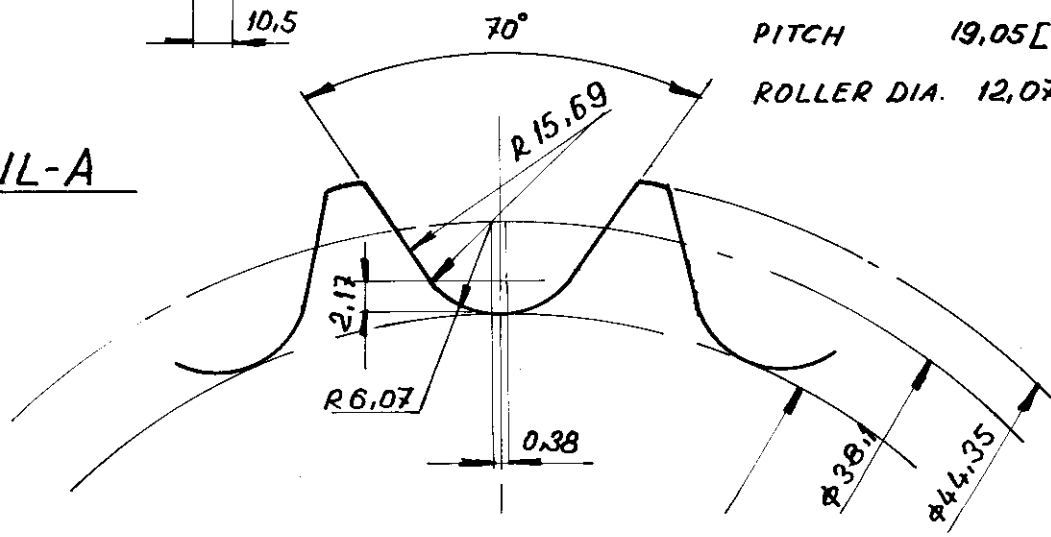
φ16 H7	+0.018
	+0.000

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NO. OF TEETH 6
 PITCH 19.05 [3/4"]
 ROLLER DIA. 12.07

DETAIL-A



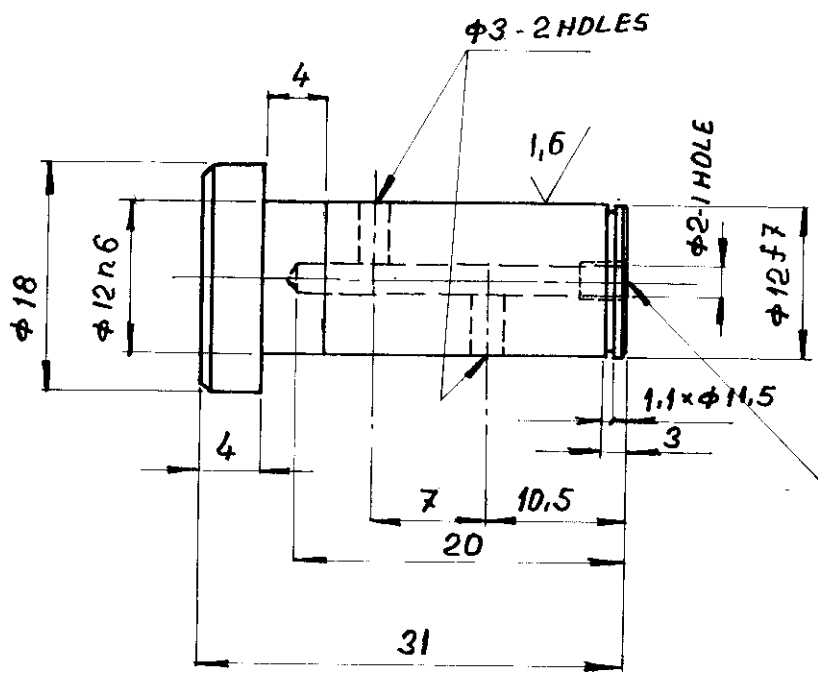
			BM-C65					3M-02f-6506	3
NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET Wt(kg)	GROSS Wt(kg)	DRAWING NO.	ITEM NO.
REMARKS				TOTAL NET Wt (kg) EC: 27					
SCALE	DRAWN		REFERENCE	ALTERATIONS		DATE	SIGNATURE	INDEX	
	CHECKED								
	APPROVED								
	STDS. OFFICER								
	DATE	28.6.77							
MACHINE PINCH ROLL		TYPE: PRG		INV. NO.					
TITLE:		DRAWING NO.							
SPROCKET 6T/3/4" P		4-M-02f-16837							
NO. OF SHEETS		SHEET NO.							

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3,2 / 1,6

φ12f7	-0,016
	-0,036
φ12n6	+0,023
	+0,012



THD. HOLE FOR 1/4" B.S.W. STRAIGHT GREASE NIPPLE x 10 DEEP.

1	ROD φ20x40		BM-C45					3-M-02f-6504	4
NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET wt(kg)	GROSS wt(kg)	DRAWING NO.	ITEM NO.
REMARKS				TOTAL NET wt (kg) - EC: 27					
SCALE 2:1	DRAWN	<i>M. Langbourn</i>		REFERENCE	ALTERATIONS		DATE	SIGNATURE	INDEX
	CHECKED	<i>Rama Roy</i>							
	APPROVED								
	STDS. OFFICER								
DATE		28.6.77							
MACHINE		RD PINCH ROLL		TYPE: PRG		INV. NO.			
TITLE:		PIN		DRAWING NO.		4-M-02f-16838 ²⁷			
NO. OF SHEETS				NO. OF SHEETS		SHEET NO.			

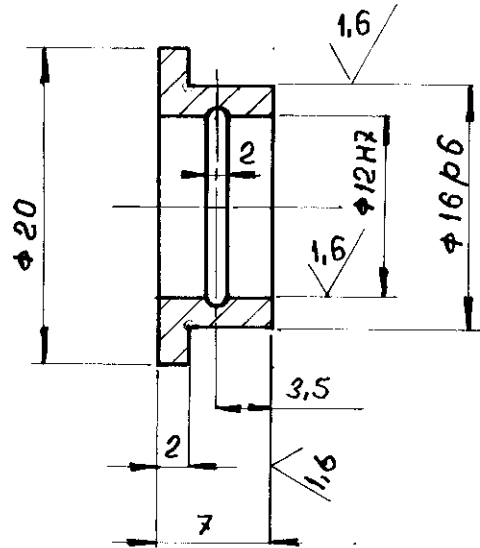


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TIRUCHIRAPALLI-14

3,2 / 1,6

φ12 H7	+0,018
	+0,000
φ16 p6	+0,029
	+0,018



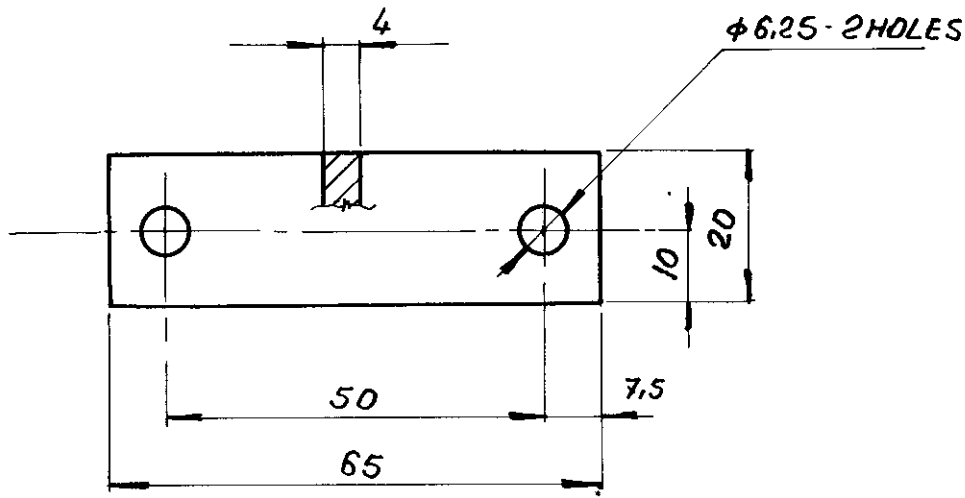
2	ROD φ30×15		BN-CA3					3-M-02f-6504	5
NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET wt(kg)	GROSS wt(kg)	DRAWING NO.	ITEM NO.
REMARKS				TOTAL NET wt (kg) EC: 27					
SCALE 2:1	DRAWN	<i>M. Sankaranarayanan</i>	REFERENCE	ALTERATIONS			DATE	SIGNATURE	INDEX
	CHECKED	<i>Ramalingam</i>							
	APPROVED	<i>M. Sankaranarayanan</i>							
	STDS. OFFICER								
DATE	28-6-77								
	MACHINE	PINCH ROLL		TYPE:	PRG		INV. NO.		
	TITLE:	BUSH		DRAWING NO.	4-M-02f-16839²⁷				
				NO. OF SHEETS	SHEET NO.				

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TIRUCHIRAPALLI-14

3,2

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1	Pl. 4 ^t x 65 x 20		BM-C3D					3-M-02f-6504	9
NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET WT (KG)	GROSS WT (KG)	DRAWING NO.	ITEM NO.
REMARKS				TOTAL NET wt (kg) EC: 27					
SCALE 1:1	DRAWN	<i>M. S. S. S.</i>		REFERENCE	ALTERATIONS		DATE	SIGNATURE	INDEX
	CHECKED	<i>Rama Sany.</i>							
	APPROVED	<i>Rama Sany.</i>							
	STDS. OFFICER	<i>Rama Sany.</i>							
	DATE	16.7.77							
MACHINE PINCH ROLL			TYPE: PRG		INV. NO.				
TITLE: WASHER			DRAWING NO. 4-M-02f-16925²⁷						
NO. OF SHEETS			SHEET NO.						



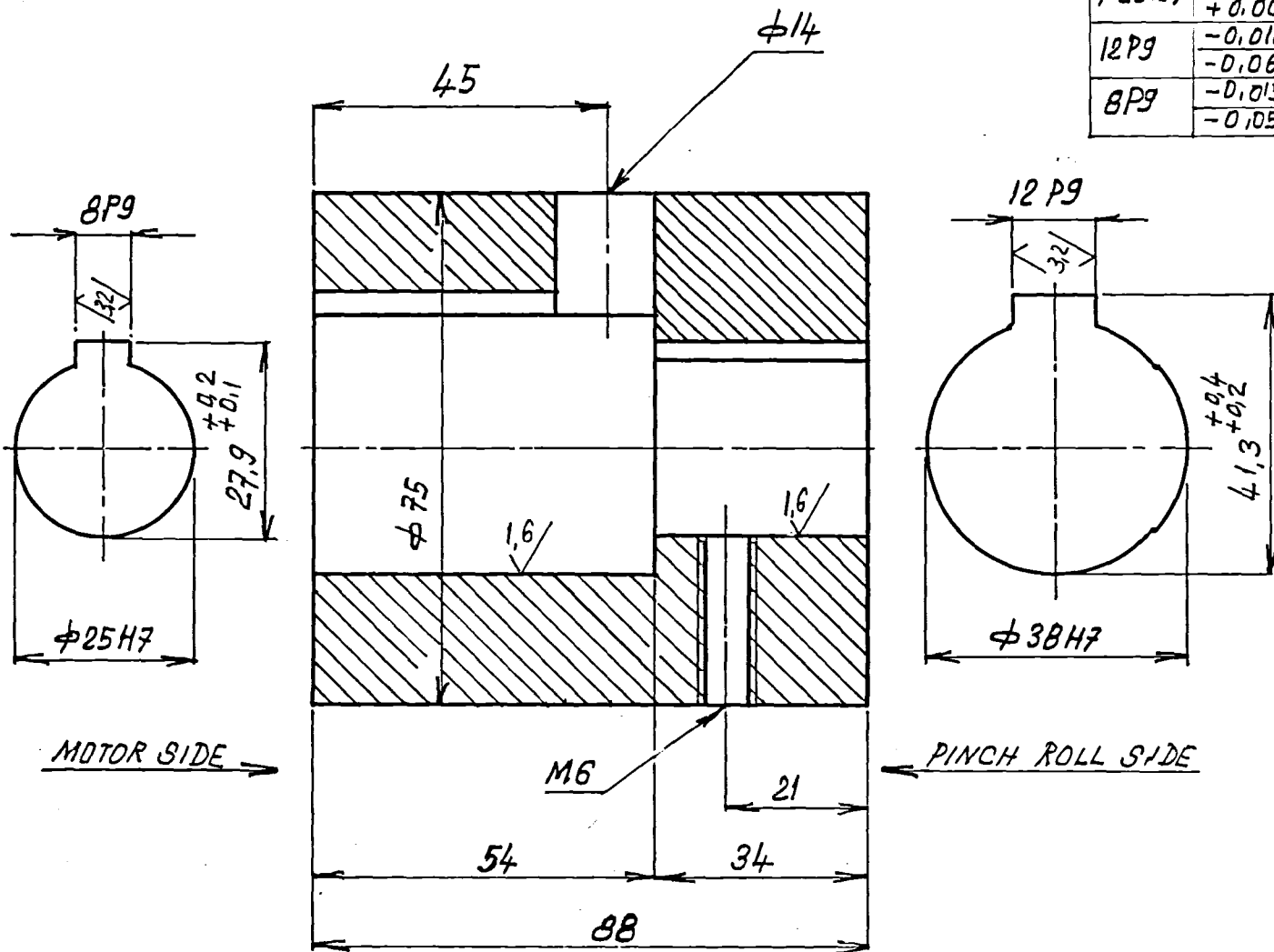
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 TIRUCHIRAPALLI-14

12.6 / 1.6 / 32

φ3BH7	+0,025
	+0,000
φ25H7	+0,021
	+0,000
12P9	-0,018
	-0,061
8P9	-0,015
	-0,051

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1	ROD φ 50x100L	BM-03D	4508	25:7283				1.M.02f.0604	11
NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET WT(kg)	GROSS WT(kg)	DRAWING NO.	ITEM NO.
REMARKS					TOTAL NET WT (kg) EC: 14				
SCALE	DRAWN	REFERENCE	ALTERATIONS		DATE	SIGNATURE	INDEX		
/	Checked								
	APPROVED								
	STDS. OFFICER								
	DATE	10-3-80							
MACHINE PINCH ROLL		TYPE: PRG		INV. NO.					
TITLE: COUPLING		DRAWING NO. 27		4-M.02f.16929					
NO. OF SHEETS		SHEET NO.							