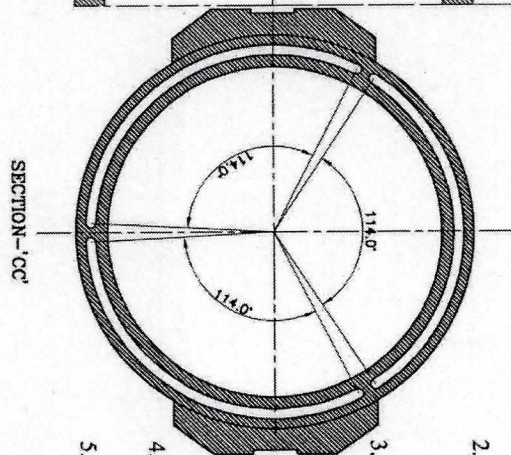
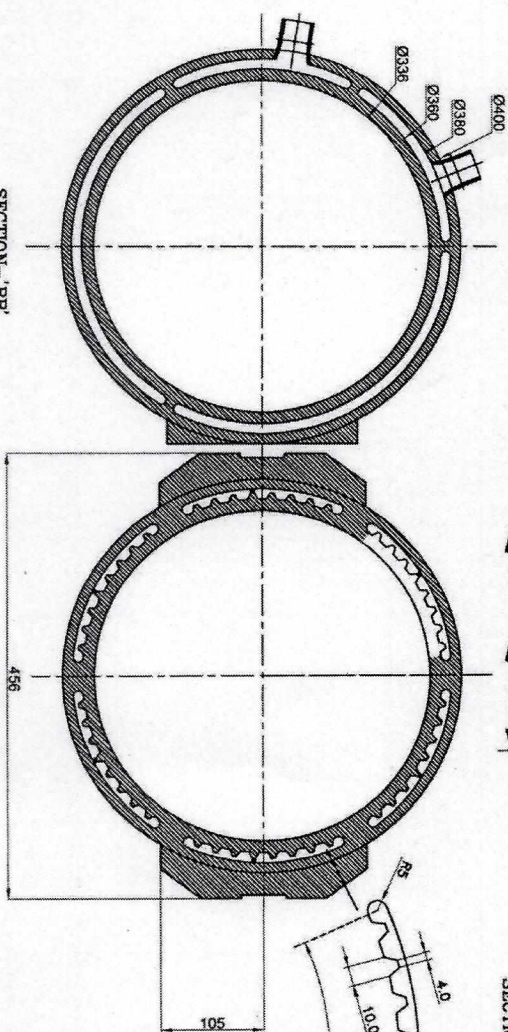


<small>0001-1980</small>	<small>1981-1990</small>	<small>1991-PRESENT</small>
INVENTORY NO.	REF.DRG.NO.	COMP. FILE NAME

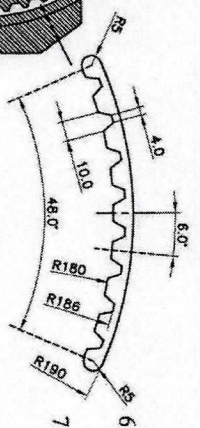


SECTION--'CC'



SECTION--'BB

SECTION-'AA



1. The Casting to be manufactured with Pressure Die Casting process only.
2. Aluminium Alloy AlSi10Mg-T6 as per DIN (LM-9) grade material to be used for Casting.
3. The castings shall be T6 Solution heat treated and age hardened to get the desired mechanical properties as mentioned below.
 - a) Ultimate tensile strength > 275 MPa
 - b) Yield strength (0.2 % proof stress) of > 220 MPa.
4. The Castings shall also be stress relieved as they will be machined subsequently.
5. Radiography inspection to be carried out on the Castings for detecting any internal damages etc. Acceptance of the inspection shall be as per Class-2 / Level-2 or better of ASTM E155.
6. Pressure leak test to be carried out at 6 Bar Pressure.
7. Casting to be sand blasted for removing any projections and unwanted deposits and to be supplied in Rough machined as per drawing.
8. Suitable primer to be applied on the casting.
9. Approximate weight of the casting will be 30 kgs (for indicative only).

[illegible]

Stator Frame Casting
(Unmachined)

DRAWING NO.
SKETCH 1

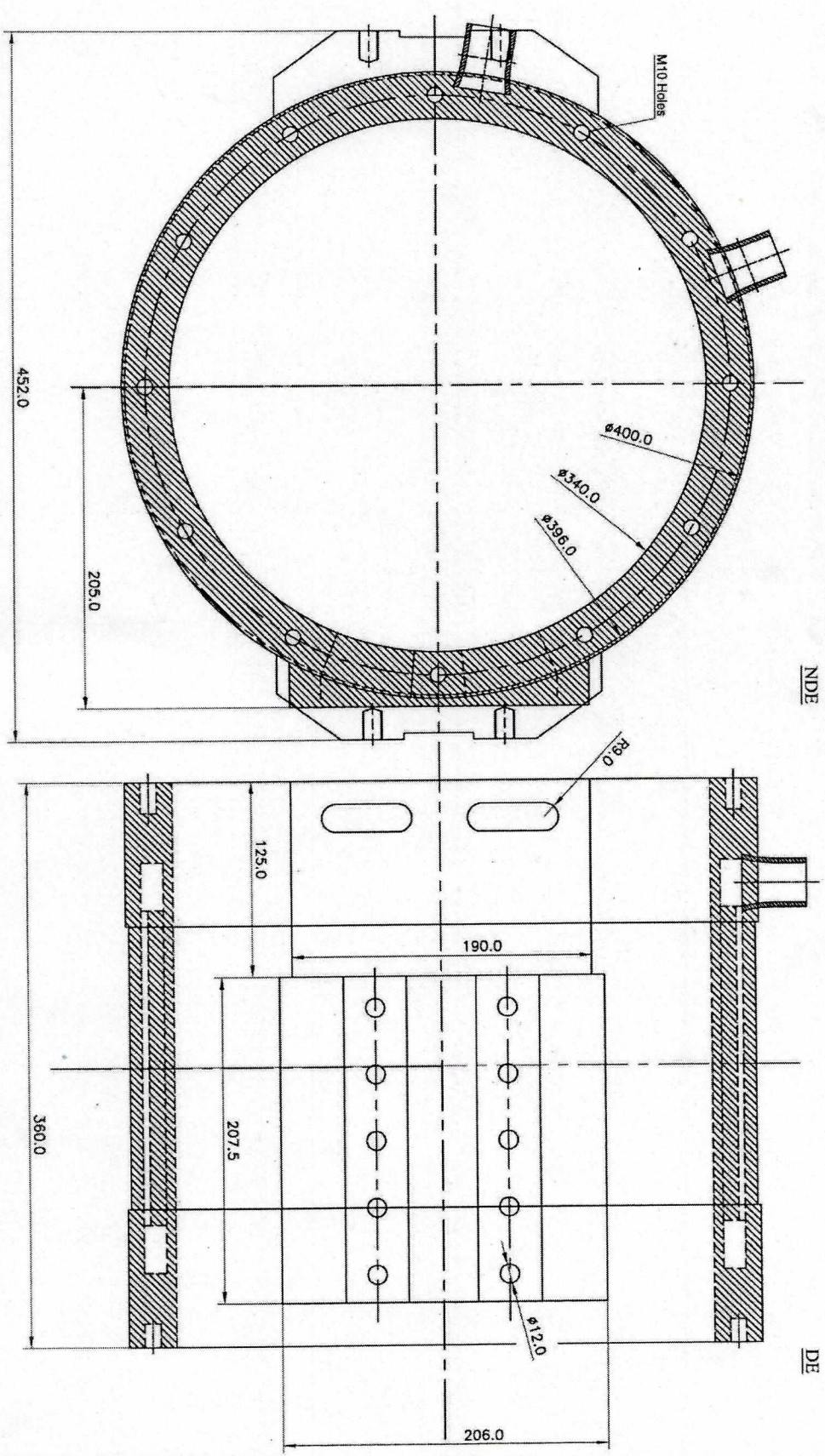
2

SHEET NO.	NO OF SHEETS
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2

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

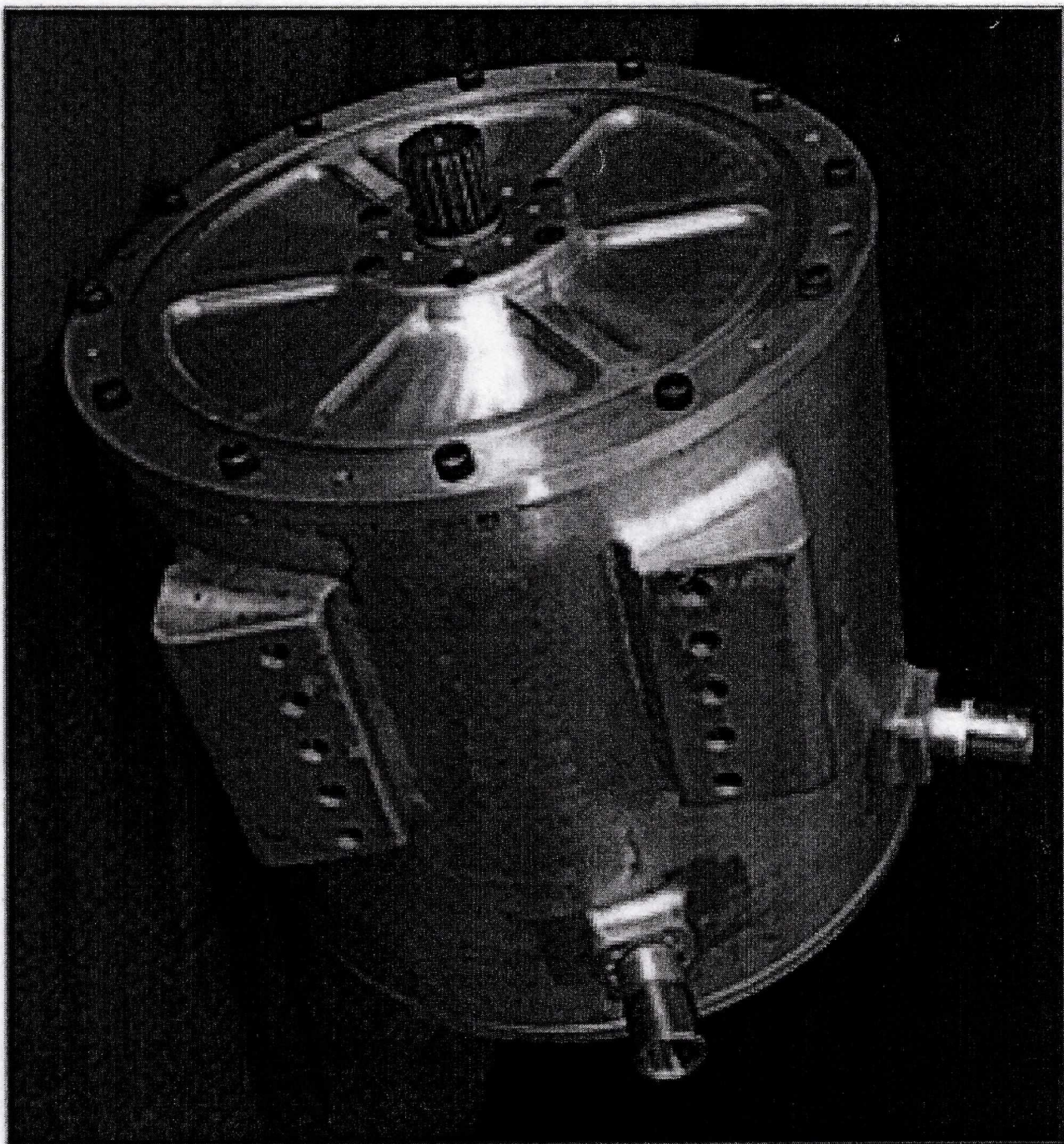


- Technical Requirements:
1. Stator frame facing and Tapped holes as indicated in the drawings should match with those on the End Covers.
 2. Stator frame ID machining to be done for press fitting the Wound core capsule. Tolerances are -0.018 to -0.02
 3. Holes for fixing terminal box to be drilled in line with those on the Box. Refer Terminal Box drawing.
 3. Tolerances on OD, width are $+/-0.10$ mm.

INVENTORY NO. REF. DRG. NO. COMP. FILE NAME THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

REV.	DATE	ALTERED	CHECKED	APPRO.	REV.	DATE	ALTERED	CHECKED	APPRO.	REV.	DATE	ALTERED	CHECKED	APPRO.	REV.	DATE	ALTERED	CHECKED	APPRO.
ZONE					ZONE					ZONE					ZONE				

TITLE		DRAWING NO.		REV.	
Stator Frame Machining		SKETCH-2		00	
SHEET NO.		NO OF SHEETS			
8		8			



Snapshot of motor
for Vendor's reference
purpose only.

2/22/11
J. S. J.