
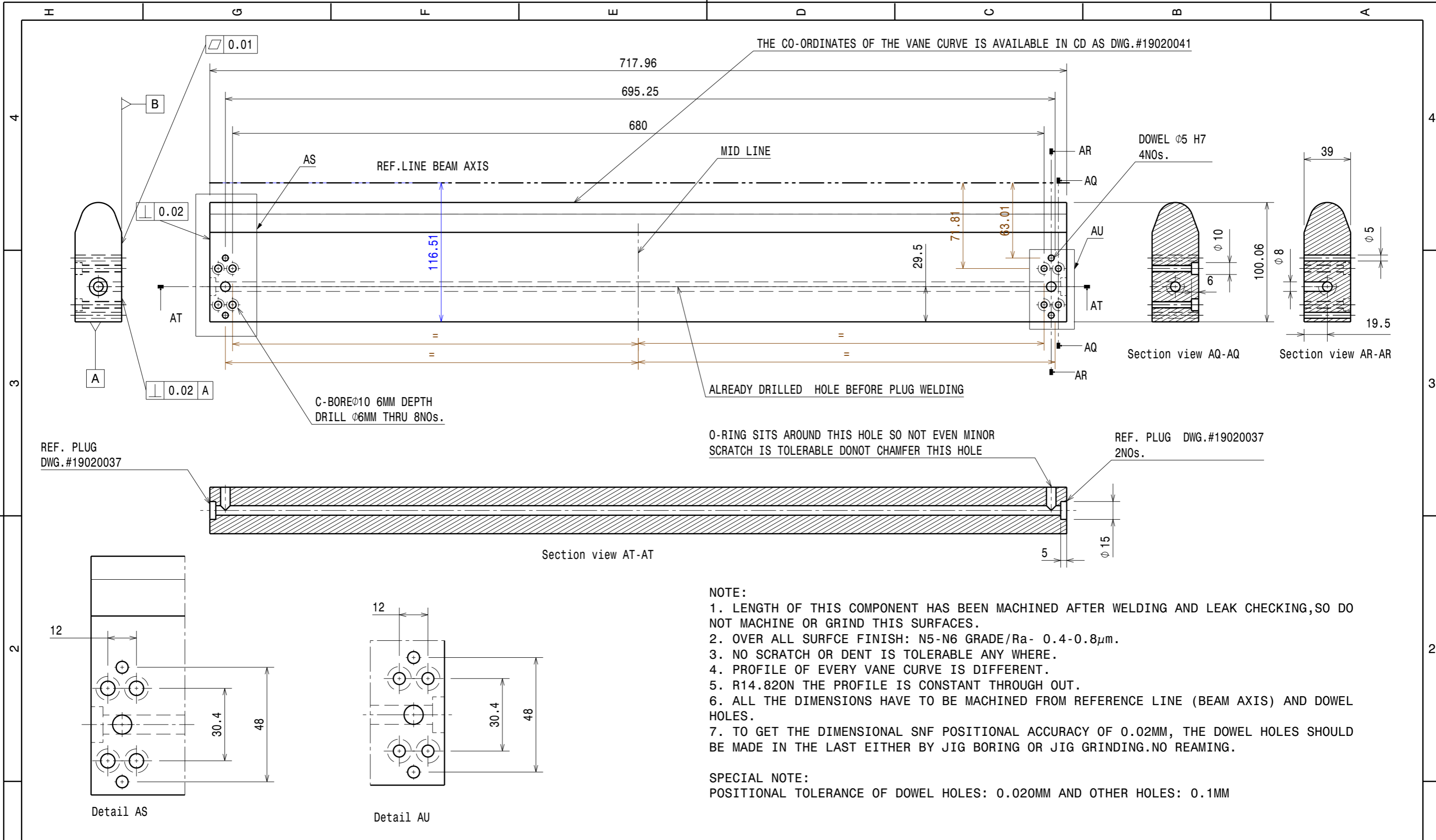


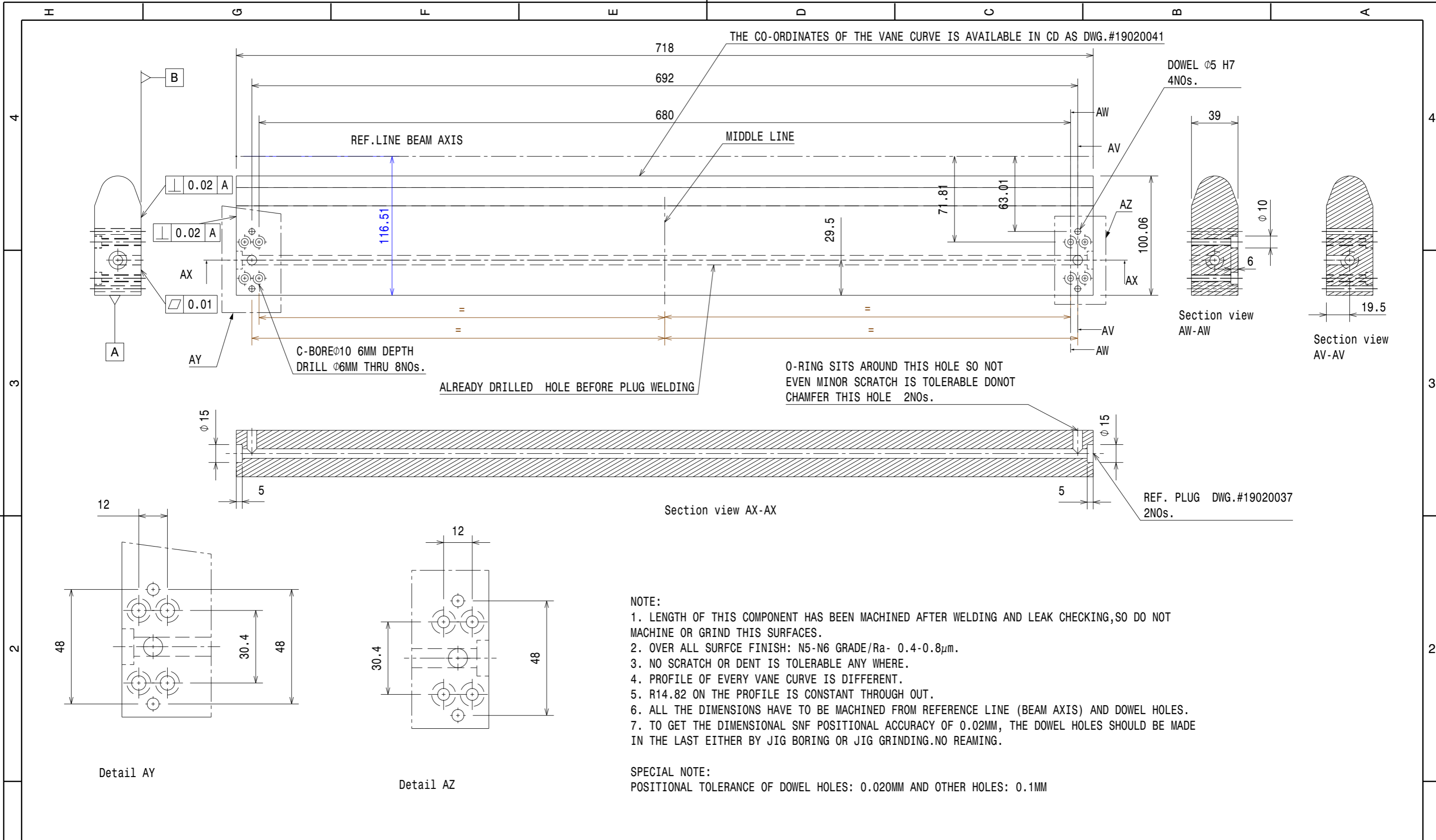
- NOTE:**
1. LENGTH OF THIS COMPONENT HAS BEEN MACHINED AFTER WELDING AND LEAK CHECKING, SO DO NOT MACHINE OR GRIND THIS SURFACES.
 2. OVER ALL SURFCE FINISH: N5-N6 GRADE/Ra- 0.4-0.8 μ m.
 3. NO SCRATCH OR DENT IS TOLERABLE ANY WHERE.
 4. PROFILE OF EVERY VANE CURVE IS DIFFERENT.
 5. R14.82 ON THE PROFILE IS CONSTANT THROUGH OUT.
 6. ALL THE DIMENSIONS HAVE TO BE MACHINED FROM REFERENCE LINE (BEAM AXIS) AND DOWEL HOLES.
 7. TO GET THE DIMENSIONAL SNF POSITIONAL ACCURACY OF 0.02MM, THE DOWEL HOLES SHOULD BE MADE IN THE LAST EITHER BY JIG BORING OR JIG GRINDING.NO REAMING.


SPECIAL NOTE:
 POSITIONAL TOLERANCE OF DOWEL HOLES: 0.020MM AND OTHER HOLES: 0.1MM

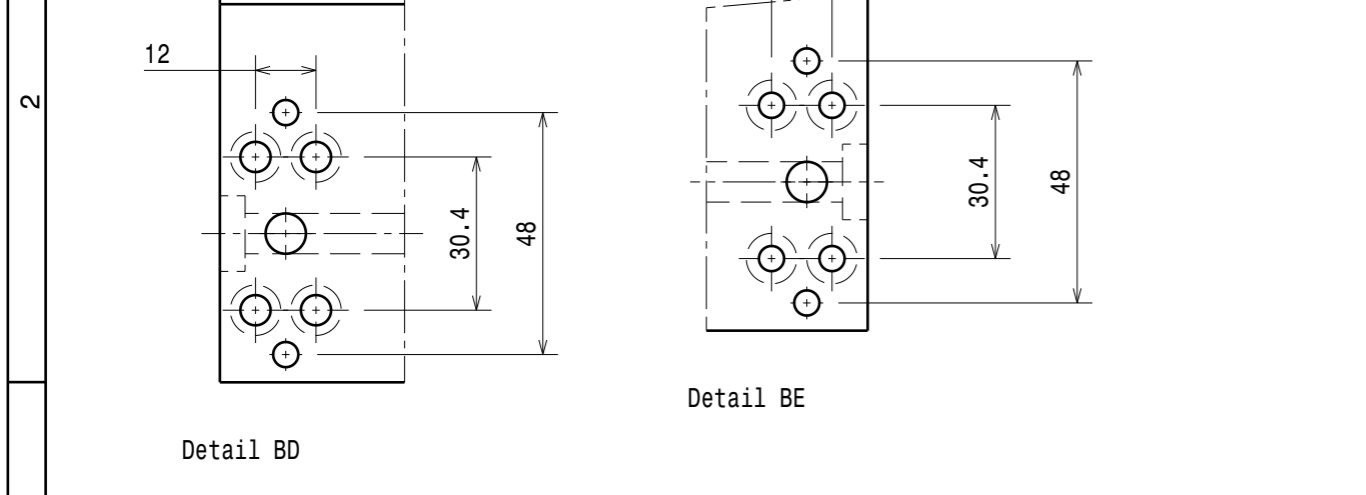
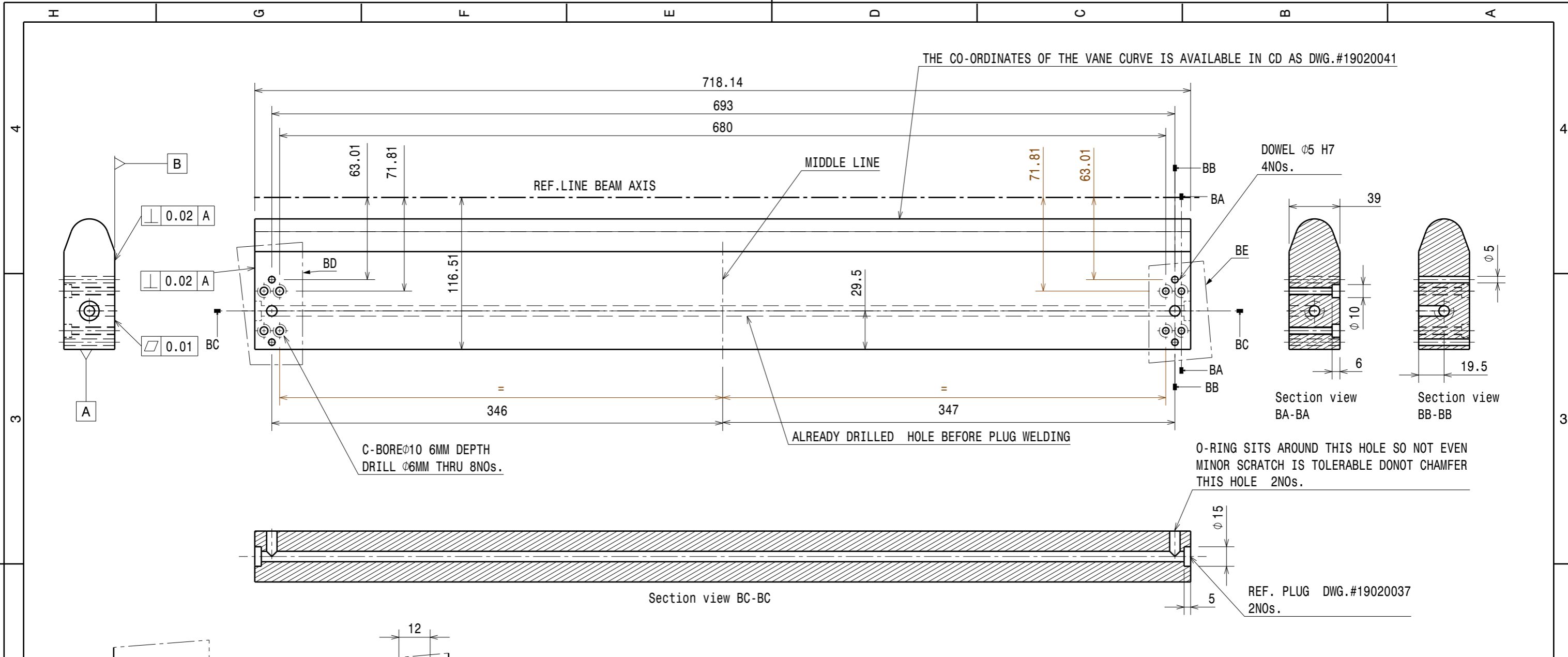
DRG.NO	▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN					RFQ GROUP:		 Institute for Plasma Research प्लाज्मा अनुसंधान संस्थान Bhat, Near Indira Bridge, Gandhinagar 382428, Gujarat (India)			
CO-ORDINATED BY					REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED	ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED				
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS											SCALE	1:1	DATE	TITLE	
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120	120-315			DRAWN	K.R.R.	01.01.18	H ROD LEFT SEGMENT - 2	
UPTO 10	10-50	50-120	OVER 120-400								CHECKED	PKC		REF DRG NO:	REV 0
+1°	+0°-30'	+0°-20'	+0°-10'		+0.1	+0.2	+0.3	+0.5			APPROVED	JMK	DRG.NO	IPR/17/A3/RFQ/19020012	SHEET 1 OF 1



DRG.NO	∇ 8-25	$\nabla\nabla$ 1.6-8	$\nabla\nabla\nabla$ 0.025-1.6	$\nabla\nabla\nabla\nabla$ < 0.025	REVISION COLUMN					RFQ GROUP:		Institute for Plasma Research प्लाज्मा अनुसंधान संस्थान Bhat, Near Indira Bridge, Gandhinagar 382428, Gujarat (India)				
CO-ORDINATED BY					REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED	ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED					
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS											SCALE	1:1	DATE	TITLE		
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120	120-315				DRAWN	K.R.R.	02.01.18	H ROD LEFT SEGMENT-3	
UPTO 10	10-50	50-120	OVER 120-400									CHECKED	PKC		REF DRG NO:	
+1°	+0°-30'	+0°-20'	+0°-10'		+0.1	+0.2	+0.3	+0.5			APPROVED	JMK		DRG.NO	IPR/17/A3/RFQ/19020013	REV 0
												DRG.NO	IPR/17/A3/RFQ/19020013	SHEET 1 OF 1		




DRG.NO	∇ 8-25	$\nabla\nabla$ 1.6-8	$\nabla\nabla\nabla$ 0.025-1.6	$\nabla\nabla\nabla\nabla$ < 0.025	REVISION COLUMN				RFQ GROUP:			 Institute for Plasma Research प्लाज्मा अनुसंधान संस्थान Bhat, Near Indira Bridge, Gandhinagar 382428, Gujarat (India)			
CO-ORDINATED BY					REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED	ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED				
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS											SCALE	1:1	DATE	TITLE	
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120	120-315			DRAWN	K.R.R.	02.01.18	H ROD LEFT SEGMENT - 4	
UPTO 10	10-50	50-120	OVER 120-400								CHECKED	PKC		REF DRG NO:	REV 0
$\pm 1^\circ$	$\pm 0'-30'$	$\pm 0'-20'$	$\pm 0'-10'$		± 0.1	± 0.2	± 0.3	± 0.5			APPROVED	JMK	DRG.NO	I PR/17/A3/RFQ/19020014	SHEET 1 OF 1

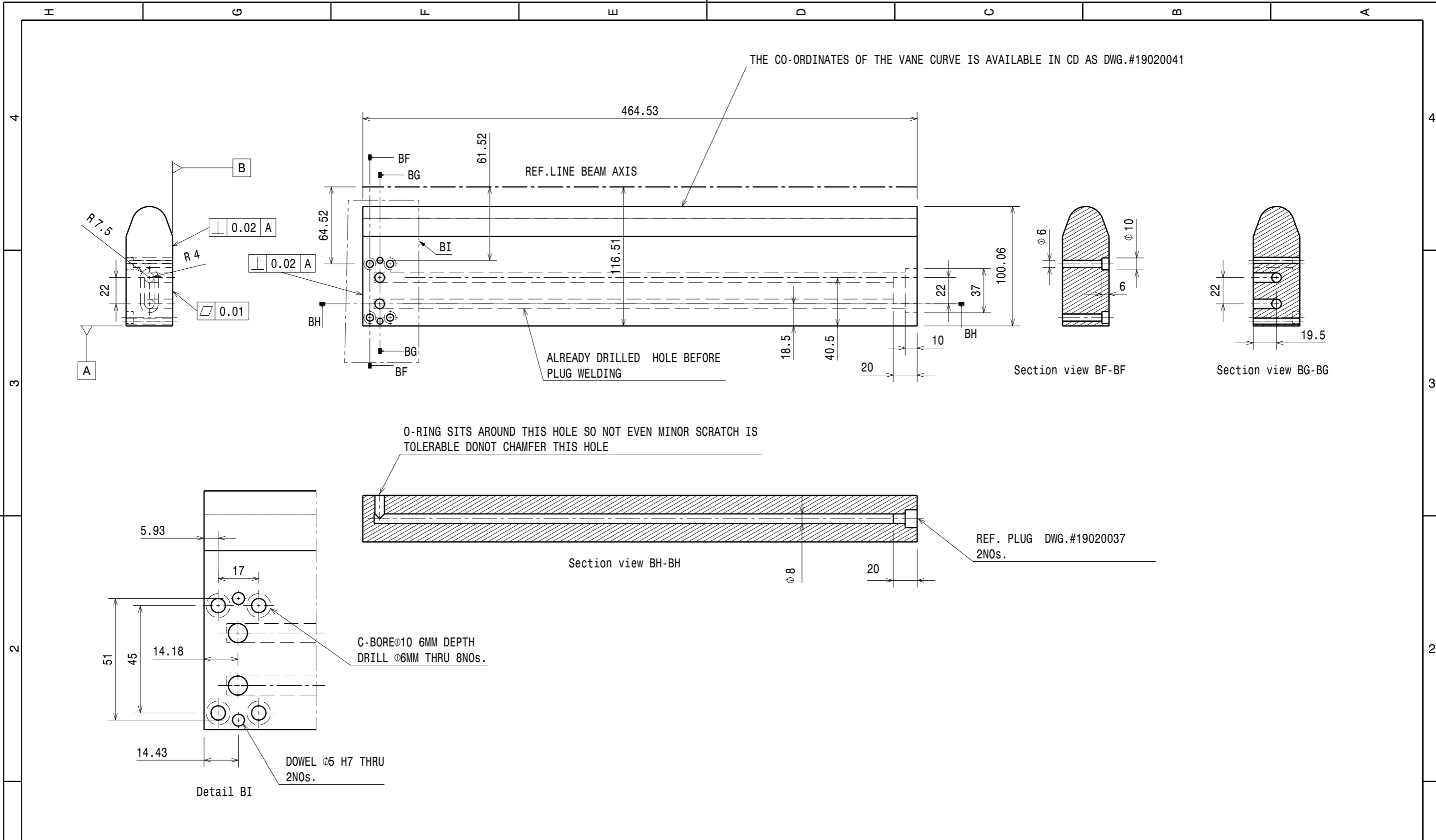



NOTE:

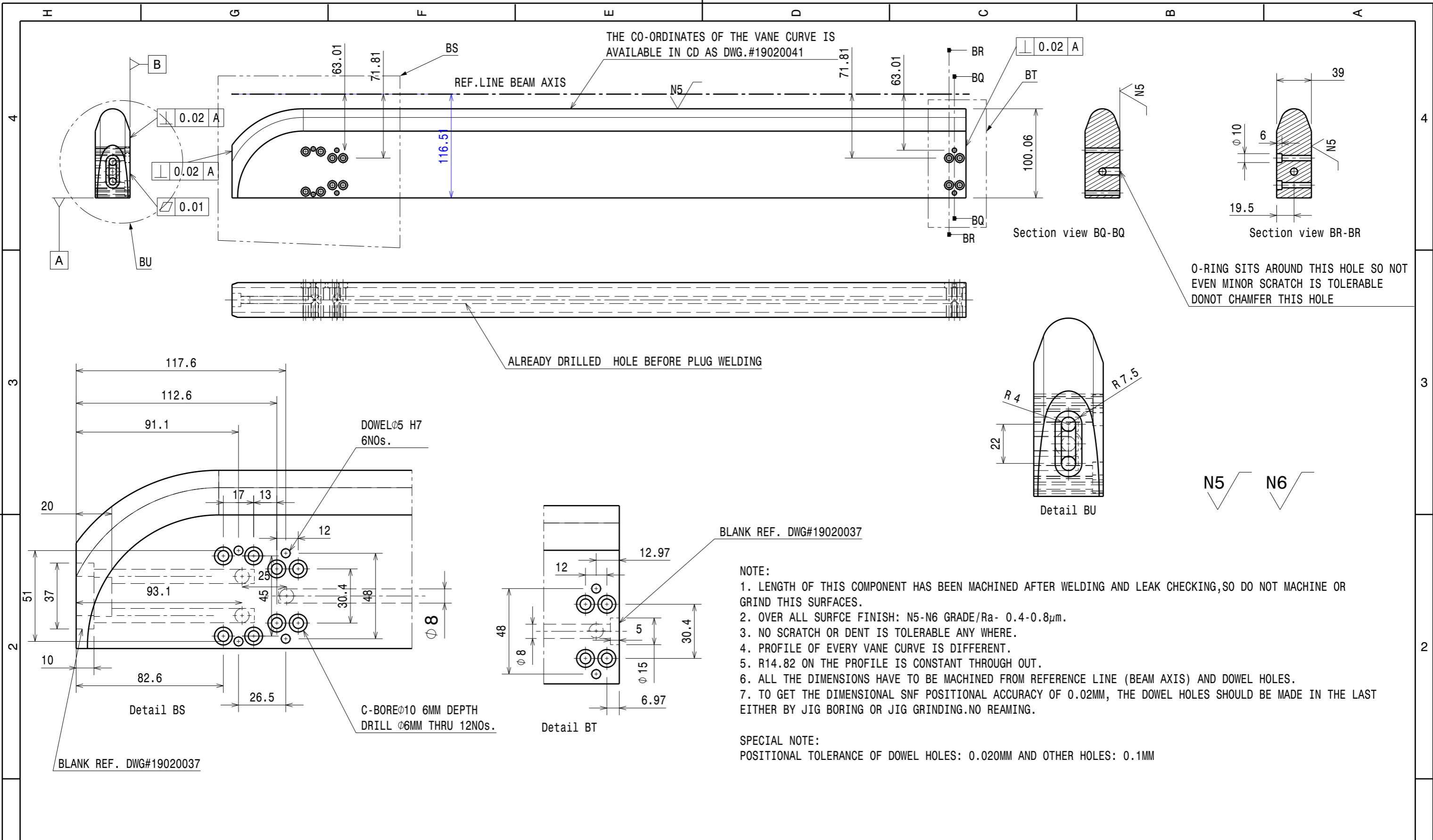
1. LENGTH OF THIS COMPONENT HAS BEEN MACHINED AFTER WELDING AND LEAK CHECKING, SO DO NOT MACHINE OR GRIND THIS SURFACES.
2. OVER ALL SURFACE FINISH: N5-N6 GRADE/Ra- 0.4-0.8 μ m.
3. NO SCRATCH OR DENT IS TOLERABLE ANY WHERE.
4. PROFILE OF EVERY VANE CURVE IS DIFFERENT.
5. R14.82 ON THE PROFILE IS CONSTANT THROUGH OUT.
6. ALL THE DIMENSIONS HAVE TO BE MACHINED FROM REFERENCE LINE (BEAM AXIS) AND DOWEL HOLES.
7. TO GET THE DIMENSIONAL AND POSITIONAL ACCURACY OF 0.02MM, THE DOWEL HOLES SHOULD BE MADE IN THE LAST EITHER BY JIG BORING OR JIG GRINDING. NO REAMING.

SPECIAL NOTE:
POSITIONAL TOLERANCE OF DOWEL HOLES: 0.020MM AND OTHER HOLES: 0.1MM

DRG.NO	▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN				RFQ GROUP:		 Institute for Plasma Research प्लाज्मा अनुसंधान संस्थान Bhat, Near Indira Bridge, Gandhinagar 382428, Gujarat (India)				
CO-ORDINATED BY					REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED		ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED SCALE: 1:1 DATE: 02.01.18 DRAWN: K.R.R. CHECKED: PKC APPROVED: JMK	TITLE	REF DRG NO:	REV 0
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS												H ROD LEFT SEGMENT - 5			
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120	120-315							
UPTO 10	10-50	50-120	OVER 120-400		+0.1	+0.2	+0.3	+0.5							
+1°	+0°-30'	+0°-20'	+0°-10'												
H	G	F	E	D	C	B	A								




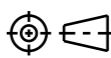
DRG.NO	▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN					RFQ GROUP:			 Institute for Plasma Research प्लाज्मा अनुसंधान संस्थान Bhat, Near Indira Bridge, Gandhinagar 382428, Gujarat (India)			
CO-ORDINATED BY					REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED	ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED					
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS											SCALE	1:1	DATE	TITLE		
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120	120-315				DRAWN	K.R.R.	02.01.17	H ROD LEFT SEGMENT - 6	
UPTO 10	10-50	50-120	OVER 120-400		+0.1	+0.2	+0.3	+0.5				CHECKED	PKC		REF DRG NO:	
+1°	+0°-30'	+0°-20'	+0°-10'								APPROVED	JMK		DRG.NO	IPR/17/A3/RFQ/19020016	REV 0
													DRG.NO	IPR/17/A3/RFQ/19020016	SHEET 1 OF 1	

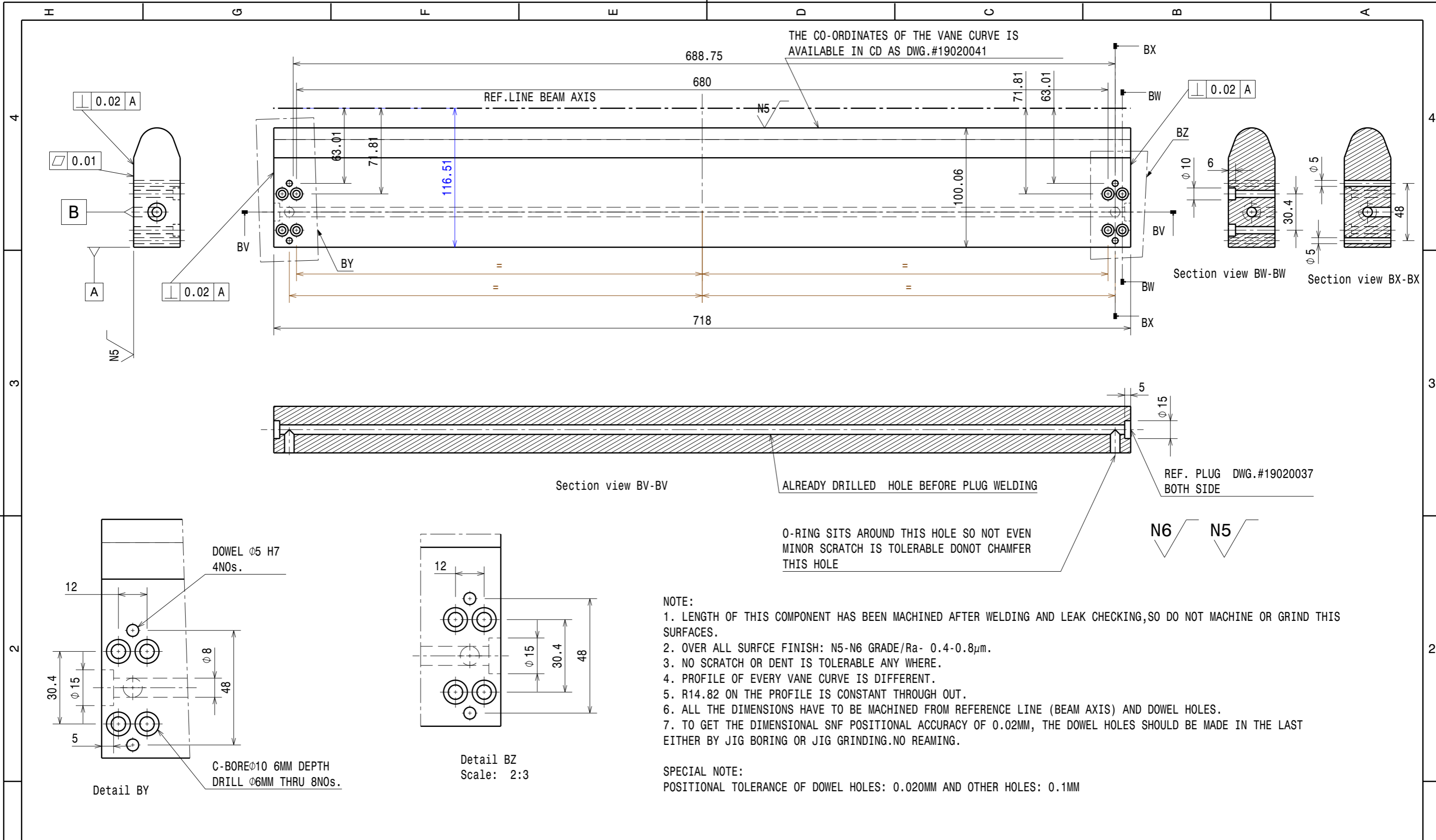


NOTE:

1. LENGTH OF THIS COMPONENT HAS BEEN MACHINED AFTER WELDING AND LEAK CHECKING,SO DO NOT MACHINE OR GRIND THIS SURFACES.
2. OVER ALL SURFACE FINISH: N5-N6 GRADE/Ra- 0.4-0.8μm.
3. NO SCRATCH OR DENT IS TOLERABLE ANY WHERE.
4. PROFILE OF EVERY VANE CURVE IS DIFFERENT.
5. R14.82 ON THE PROFILE IS CONSTANT THROUGH OUT.
6. ALL THE DIMENSIONS HAVE TO BE MACHINED FROM REFERENCE LINE (BEAM AXIS) AND DOWEL HOLES.
7. TO GET THE DIMENSIONAL SNF POSITIONAL ACCURACY OF 0.02MM, THE DOWEL HOLES SHOULD BE MADE IN THE LAST EITHER BY JIG BORING OR JIG GRINDING.NO REAMING.

SPECIAL NOTE:
POSITIONAL TOLERANCE OF DOWEL HOLES: 0.020MM AND OTHER HOLES: 0.1MM


DRG.NO		▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN				RFQ GROUP:		 Institute for Plasma Research प्लाज्मा अनुसंधान संस्थान Bhat, Near Indira Bridge, Gandhinagar 382428, Gujarat (India)							
CO-ORDINATED BY						REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED	ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED							
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS												SCALE	1:1	DATE	TITLE				
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120	120-315							DRAWN	K.R.R.	03.01.18	 H ROD RIGHT SEGMENT - 1	
UPTO 10	10-50	50-120	OVER 120-400		UPTO 6	6-30	30-120	120-315	CHECKED	PKC	REF DRG NO:		REV 0						
+1°	+0°-30'	+0°-20'	+0°-10'	OR DIA	+0.1	+0.2	+0.3	+0.5							APPROVED	JMK	DRG.NO	IPR/17/A3/RFQ/19020017	SHEET 1 OF 1

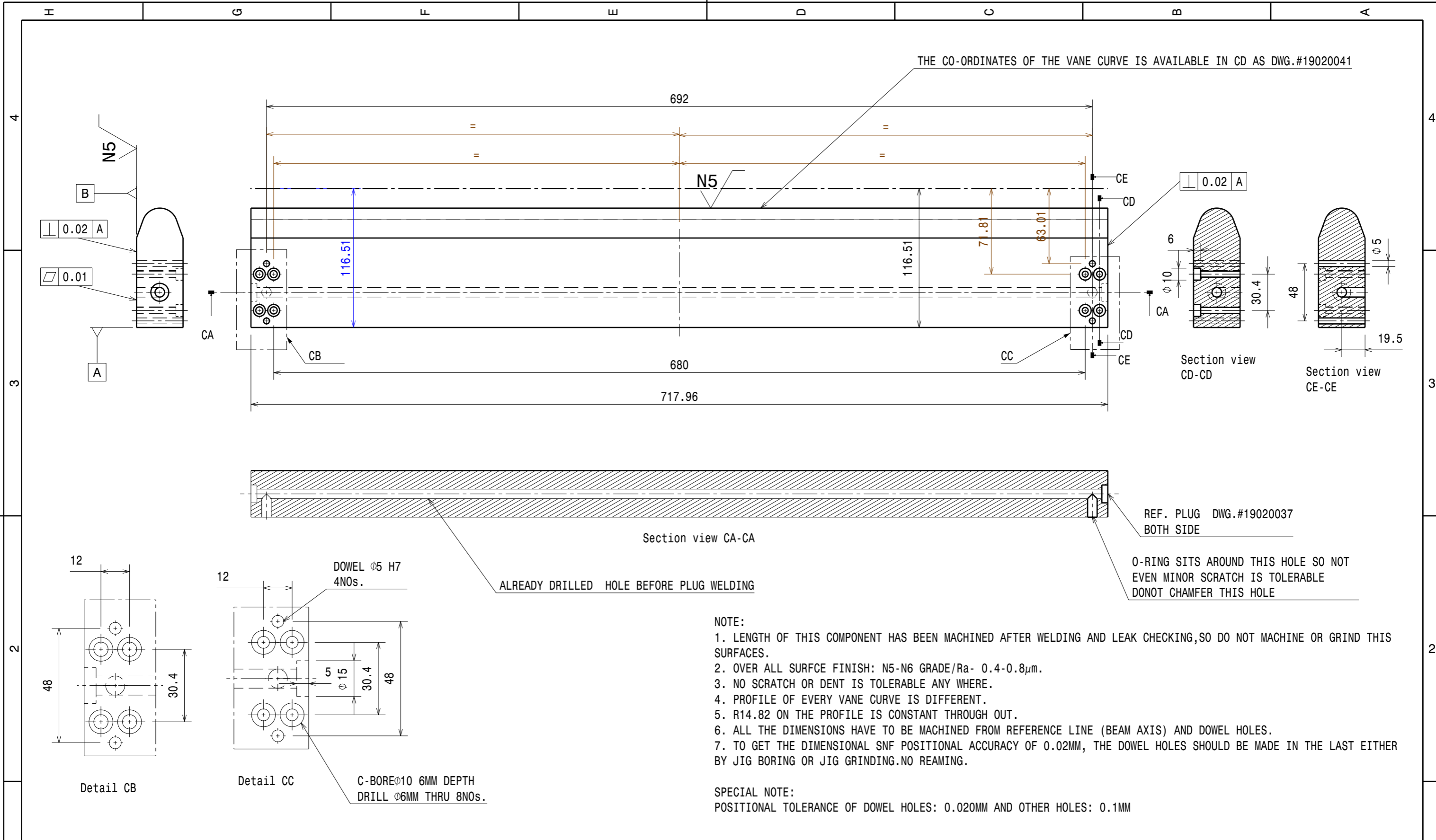


NOTE:

1. LENGTH OF THIS COMPONENT HAS BEEN MACHINED AFTER WELDING AND LEAK CHECKING,SO DO NOT MACHINE OR GRIND THIS SURFACES.
2. OVER ALL SURFCE FINISH: N5-N6 GRADE/Ra- 0.4-0.8 μ m.
3. NO SCRATCH OR DENT IS TOLERABLE ANY WHERE.
4. PROFILE OF EVERY VANE CURVE IS DIFFERENT.
5. R14.82 ON THE PROFILE IS CONSTANT THROUGH OUT.
6. ALL THE DIMENSIONS HAVE TO BE MACHINED FROM REFERENCE LINE (BEAM AXIS) AND DOWEL HOLES.
7. TO GET THE DIMENSIONAL SNF POSITIONAL ACCURACY OF 0.02MM, THE DOWEL HOLES SHOULD BE MADE IN THE LAST EITHER BY JIG BORING OR JIG GRINDING.NO REAMING.


SPECIAL NOTE:
POSITIONAL TOLERANCE OF DOWEL HOLES: 0.020MM AND OTHER HOLES: 0.1MM

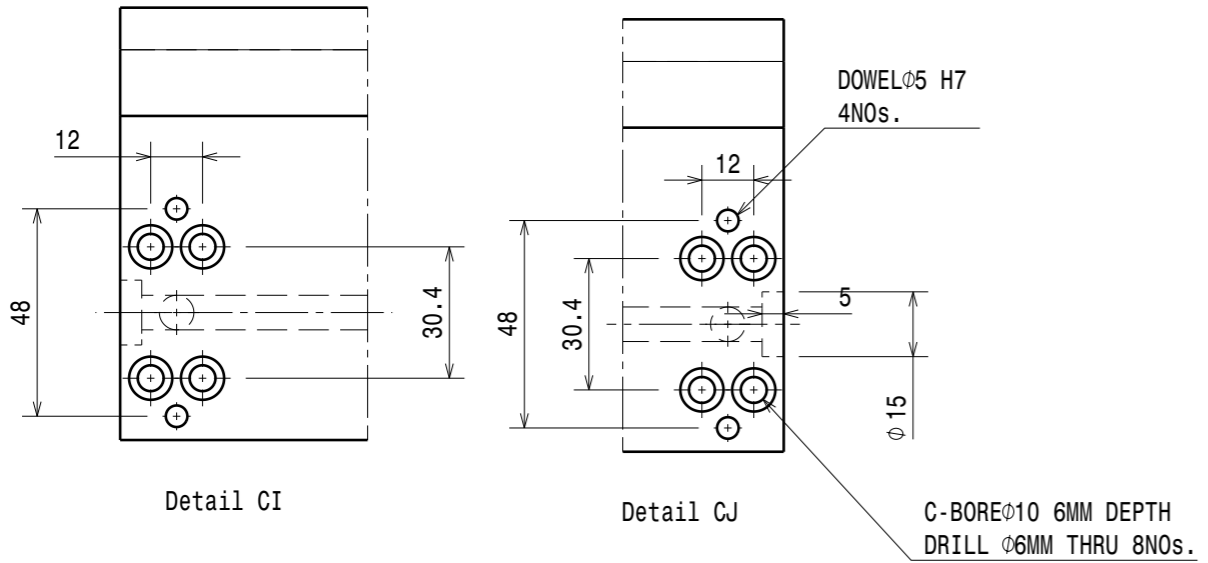
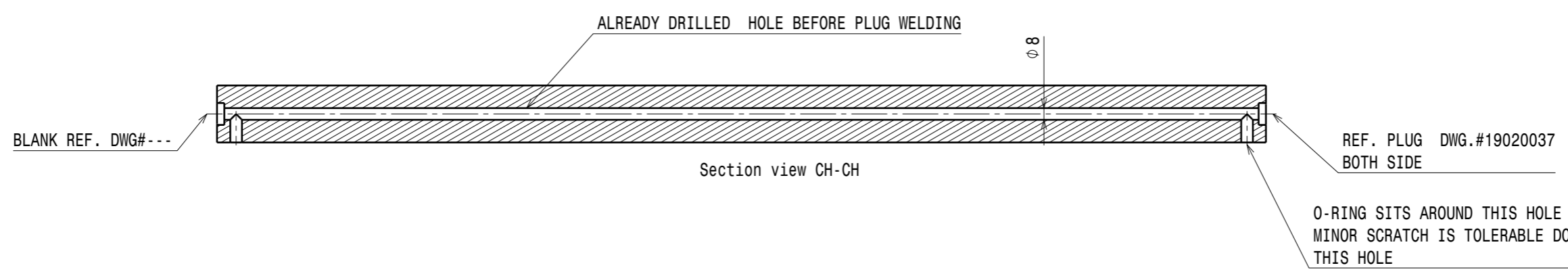
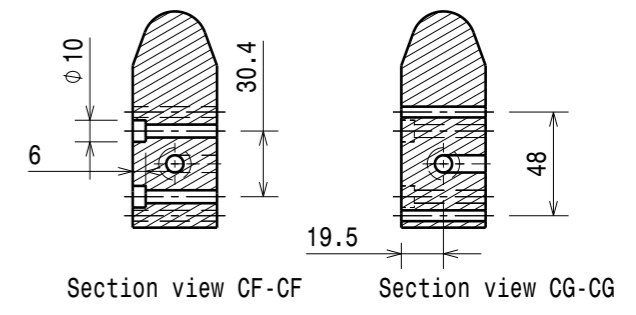
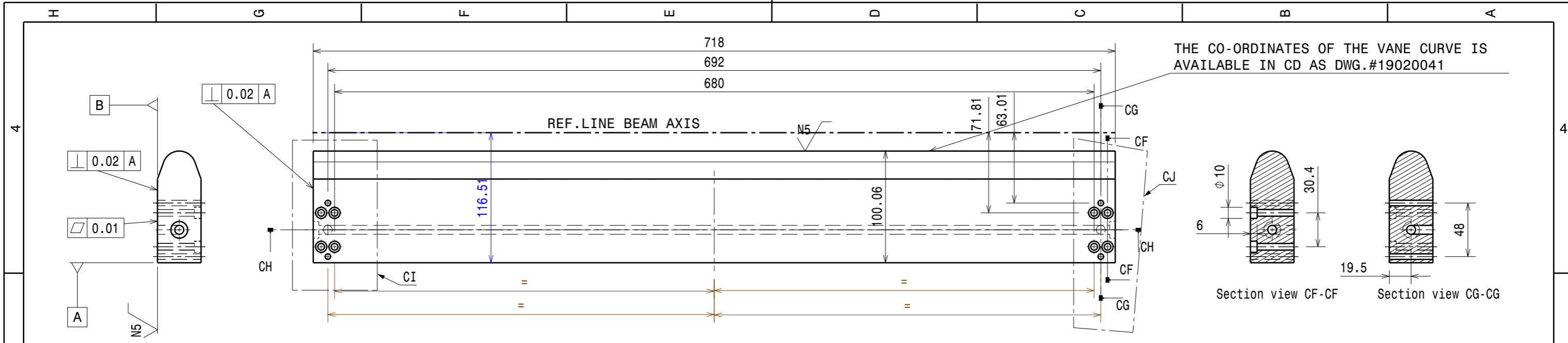
DRG.NO	▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN					RFQ GROUP:			 Institute for Plasma Research प्लाज्मा अनुसंधान संस्थान Bhat, Near Indira Bridge, Gandhinagar 382428, Gujarat (India)	
CO-ORDINATED BY					REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED	ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED			
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS											SCALE	1:1	DATE	TITLE
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120	120-315			DRAWN	K.R.R.	03.02.18	H ROD RIGHT SEGMENT -2
UPTO 10	10-50	50-120	OVER 120-400								CHECKED	PKC		REF DRG NO:
+1°	+0°-30'	+0°-20'	+0°-10'		+0.1	+0.2	+0.3	+0.5			APPROVED	JMK		REV 0
													DRG.NO	IPR/17/A3/RFQ/19020018
														SHEET 1 OF 1



DRG.NO	▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025
CO-ORDINATED BY				
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS				
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH
				OR
				DIA
UPTO 10	10-50	50-120	OVER 120-400	UPTO 6
UPTO 10	10-50	50-120	OVER 120-400	OR DIA
+1°	+0°-30'	+0°-20'	+0°-10'	+0.1
				+0.2
				+0.3
				+0.5

REVISION COLUMN					
REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED


RFQ GROUP:			 Institute for Plasma Research प्लाज्मा अनुसंधान संस्थान Bhat, Near Indira Bridge, Gandhinagar 382428, Gujarat (India)	
ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED			TITLE	
SCALE	1:1	DATE	H ROD RIGHT SEGMENT-3	
DRAWN	K.R.R.	03.01.18	REF DRG NO:	
CHECKED	PKC		REV 0	
APPROVED	JMK		DRG.NO	SHEET 1 OF 1
			IPR/17/A3/RFQ/19020019	

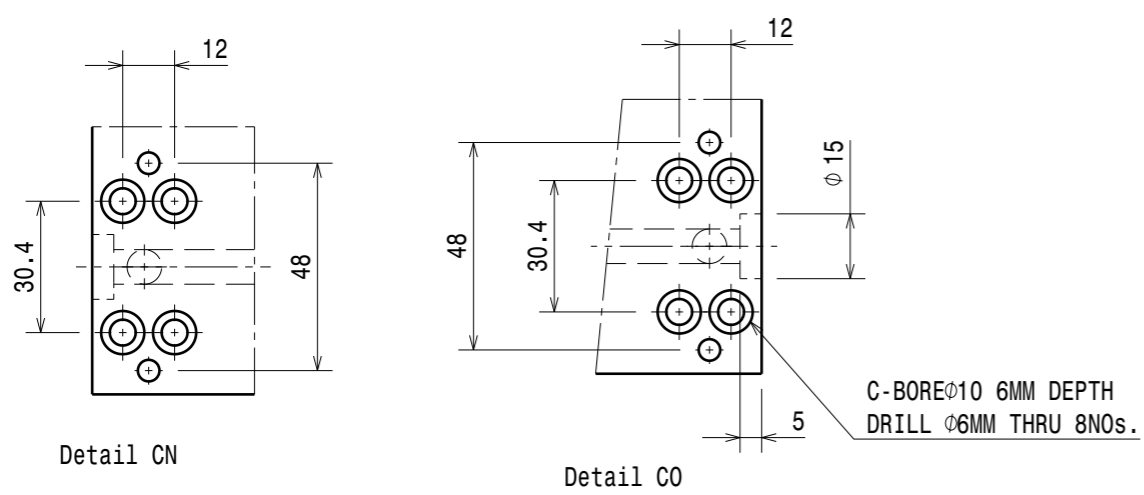
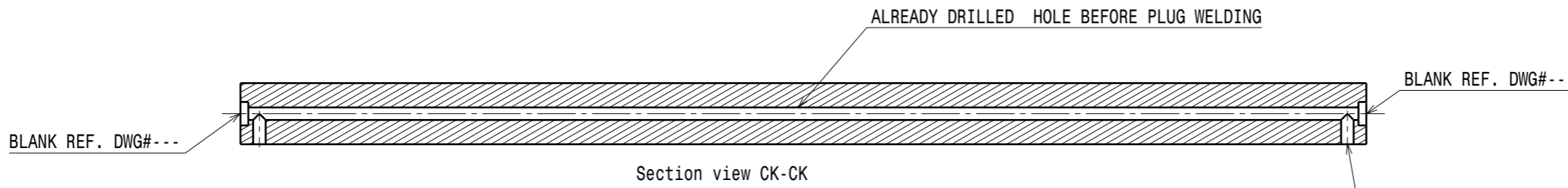
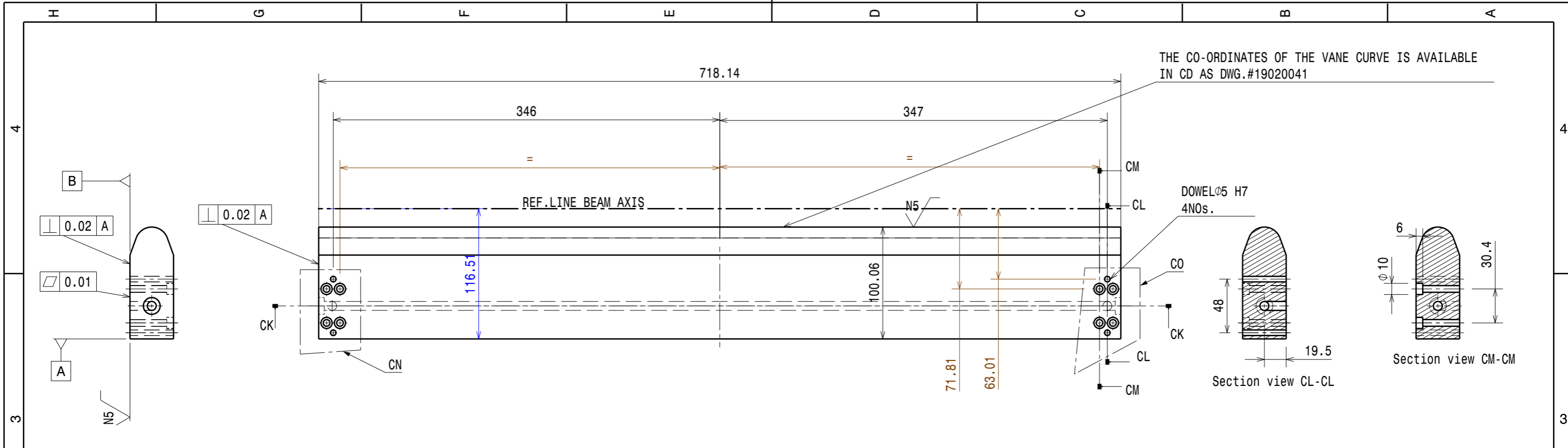


NOTE:

1. LENGTH OF THIS COMPONENT HAS BEEN MACHINED AFTER WELDING AND LEAK CHECKING, SO DO NOT MACHINE OR GRIND THIS SURFACES.
2. OVER ALL SURFACE FINISH: N5-N6 GRADE/Ra- 0.4-0.8 μ m.
3. NO SCRATCH OR DENT IS TOLERABLE ANY WHERE.
4. PROFILE OF EVERY VANE CURVE IS DIFFERENT.
5. R-----ON THE PROFILE IS CONSTANT THROUGH OUT.
6. ALL THE DIMENSIONS HAVE TO BE MACHINED FROM REFERENCE LINE (BEAM AXIS) AND DOWEL HOLES.
7. TO GET THE DIMENSIONAL AND POSITIONAL ACCURACY OF 0.02MM, THE DOWEL HOLES SHOULD BE MADE IN THE LAST EITHER BY JIG BORING OR JIG GRINDING. NO REAMING.


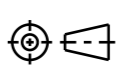
SPECIAL NOTE:
POSITIONAL TOLERANCE OF DOWEL HOLES: 0.020MM AND OTHER HOLES: 0.1MM

DRG.NO	▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN					RFQ GROUP:		 Institute for Plasma Research प्लाज्मा अनुसंधान संस्थान Bhat, Near Indira Bridge, Gandhinagar 382428, Gujarat (India)				
CO-ORDINATED BY					REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED	ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED					
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS											SCALE	1:1	DATE	TITLE		
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120	120-315				DRAWN	K.R.R.	04.01.18	H ROD RIGHT SEGMENT - 4	
UPTO 10	10-50	50-120	OVER 120-400		UPTO 6	6-30	30-120	120-315				CHECKED	PKC		REF DRG NO:	REV 0
+1°	+0°-30'	+0°-20'	+0°-10'		+0.1	+0.2	+0.3	+0.5			APPROVED	JMK		DRG.NO	I PR/17/A3/RFQ/19020020	SHEET 1 OF 1

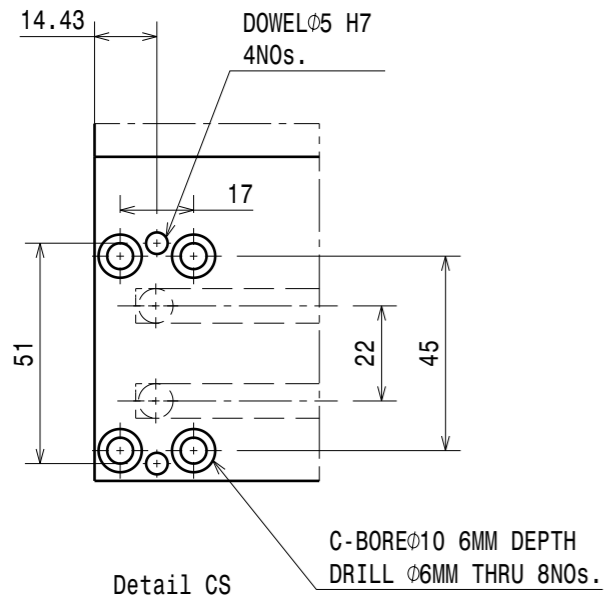
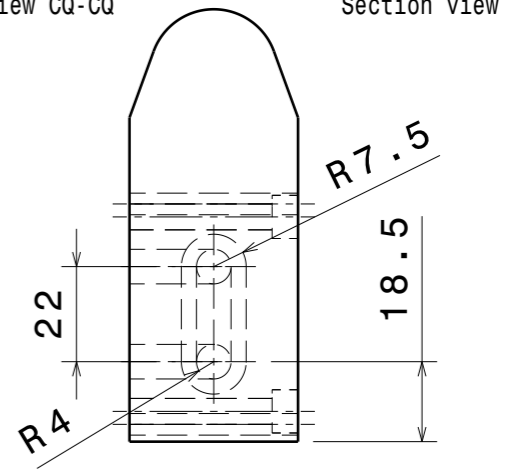
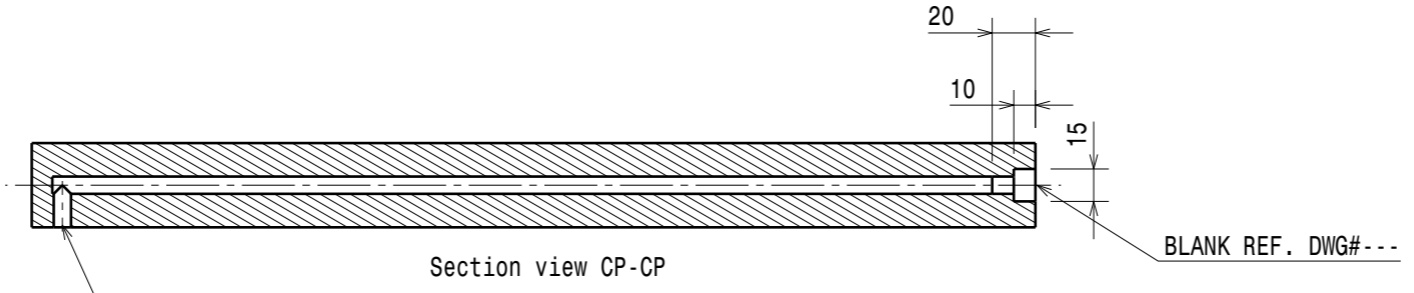
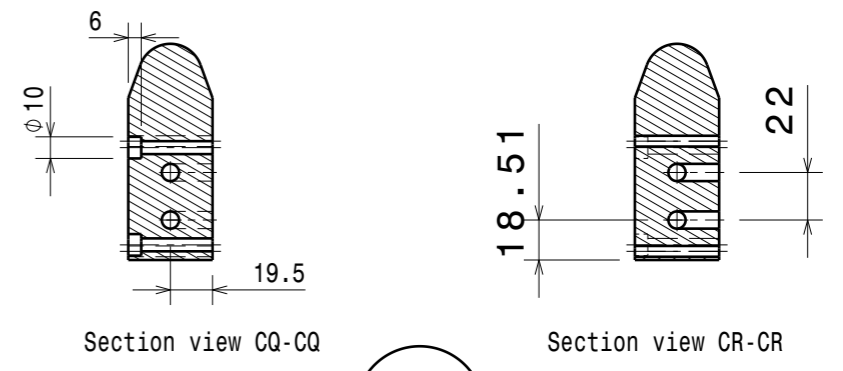
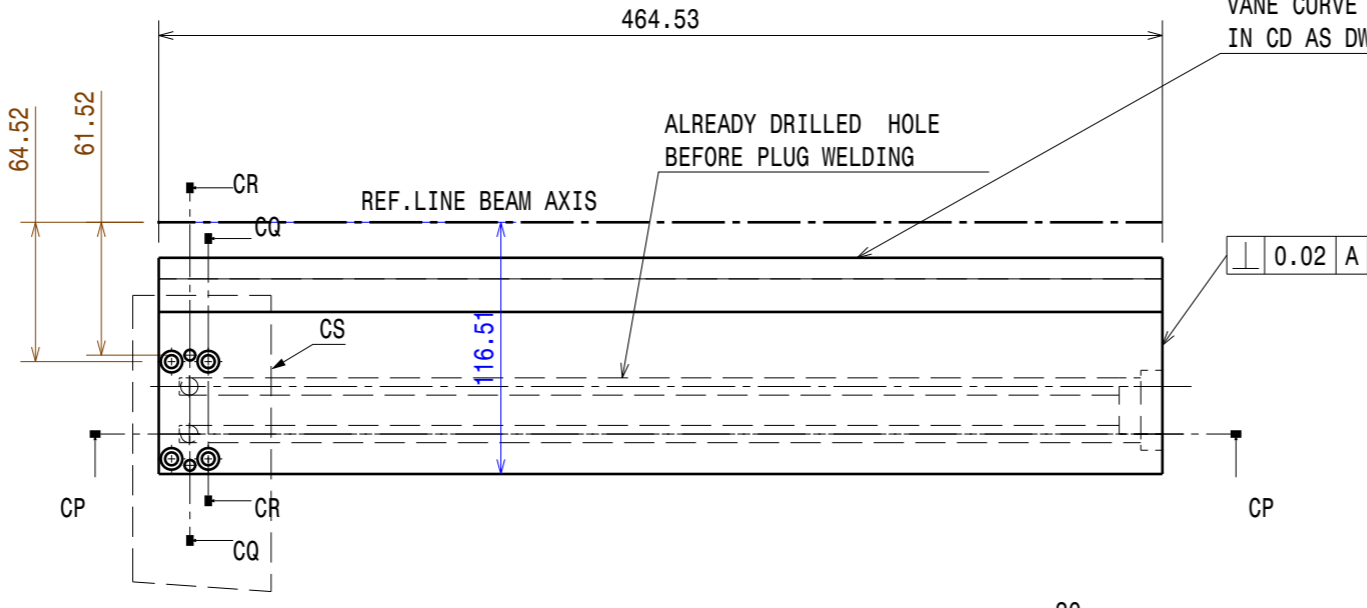
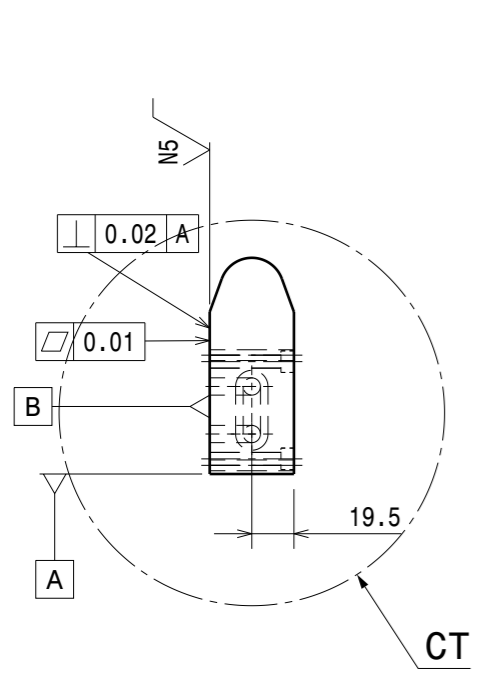


- NOTE:
1. LENGTH OF THIS COMPONENT HAS BEEN MACHINED AFTER WELDING AND LEAK CHECKING, SO DO NOT MACHINE OR GRIND THIS SURFACES.
 2. OVER ALL SURFCE FINISH: N5-N6 GRADE/Ra- 0.4-0.8 μ m.
 3. NO SCRATCH OR DENT IS TOLERABLE ANY WHERE.
 4. PROFILE OF EVERY VANE CURVE IS DIFFERENT.
 5. R-----ON THE PROFILE IS CONSTANT THROUGH OUT.
 6. ALL THE DIMENSIONS HAVE TO BE MACHINED FROM REFERENCE LINE (BEAM AXIS) AND DOWEL HOLES.
 7. TO GET THE DIMENSIONAL SNF POSITIONAL ACCURACY OF 0.02MM, THE DOWEL HOLES SHOULD BE MADE IN THE LAST EITHER BY JIG BORING OR JIG GRINDING.NO REAMING.

SPECIAL NOTE:
POSITIONAL TOLERANCE OF DOWEL HOLES: 0.020MM AND OTHER HOLES: 0.1MM


DRG.NO	▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN					RFQ GROUP:		 Institute for Plasma Research प्लाज्मा अनुसंधान संस्थान Bhat, Near Indira Bridge, Gandhinagar 382428, Gujarat (India)		
CO-ORDINATED BY					REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED	ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED			
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS											SCALE	1:1	DATE	TITLE
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120	120-315			DRAWN	K.R.R.	04.01.18	 H ROD RIGHT SEGMENT - 5
UPTO 10	10-50	50-120	OVER 120-400								CHECKED	PKC		
+1°	+0°-30'	+0°-20'	+0°-10'		+0.1	+0.2	+0.3	+0.5			APPROVED	JMK		REV 0
										DRG.NO	IPR/17/A3/RFQ/19020021		SHEET 1 OF 1	

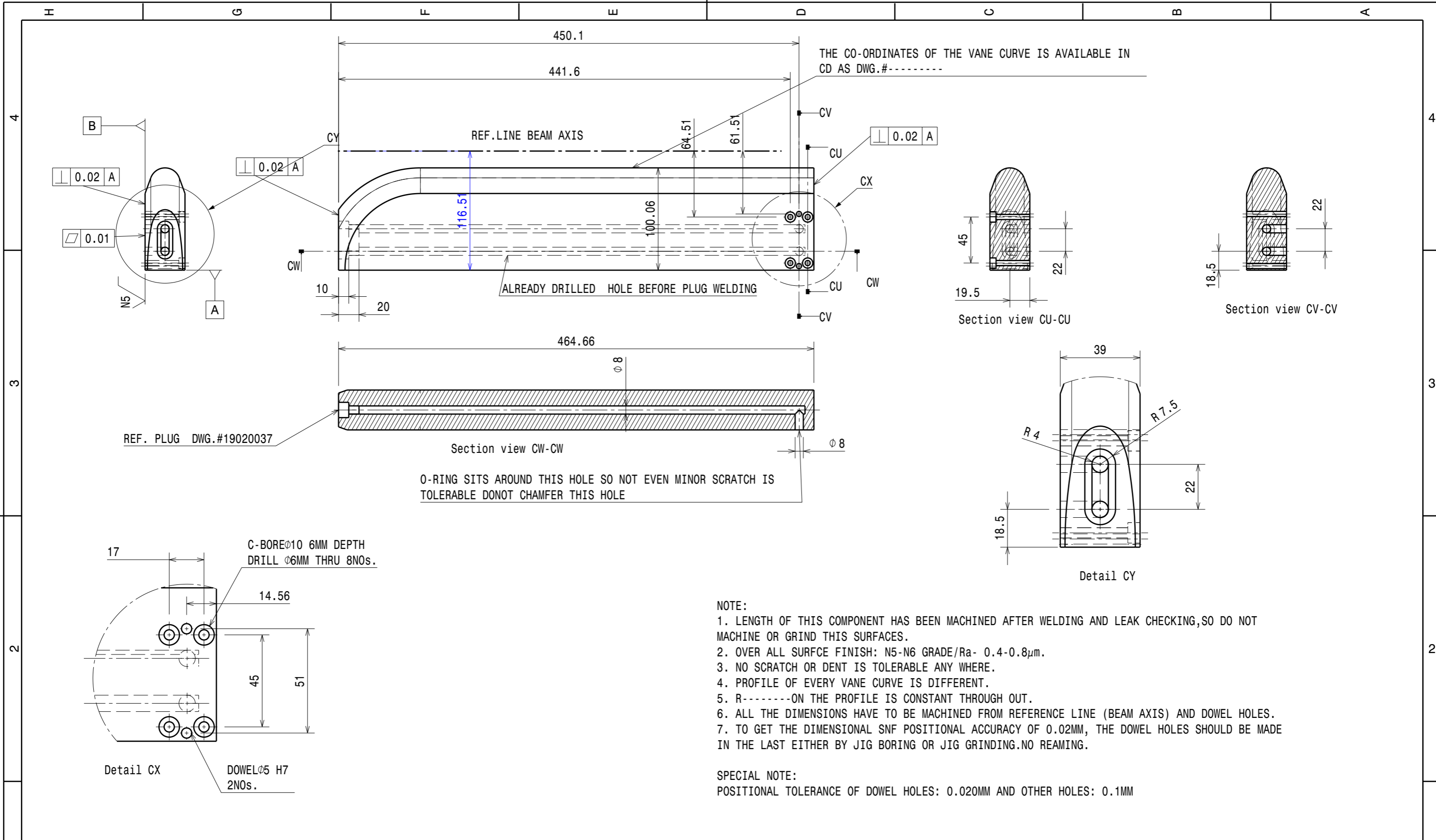
H G F E D C B A



- NOTE:
1. LENGTH OF THIS COMPONENT HAS BEEN MACHINED AFTER WELDING AND LEAK CHECKING, SO DO NOT MACHINE OR GRIND THIS SURFACES.
 2. OVER ALL SURFACE FINISH: N5-N6 GRADE/Ra- 0.4-0.8 μ m.
 3. NO SCRATCH OR DENT IS TOLERABLE ANY WHERE.
 4. PROFILE OF EVERY VANE CURVE IS DIFFERENT.
 5. R-----ON THE PROFILE IS CONSTANT THROUGH OUT.
 6. ALL THE DIMENSIONS HAVE TO BE MACHINED FROM REFERENCE LINE (BEAM AXIS) AND DOWEL HOLES.
 7. TO GET THE DIMENSIONAL AND POSITIONAL ACCURACY OF 0.02MM, THE DOWEL HOLES SHOULD BE MADE IN THE LAST EITHER BY JIG BORING OR JIG GRINDING. NO REAMING.

SPECIAL NOTE:
POSITIONAL TOLERANCE OF DOWEL HOLES: 0.020MM AND OTHER HOLES: 0.1MM


DRG.NO	▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN					RFQ GROUP:			 Institute for Plasma Research प्लाज्मा अनुसंधान संस्थान Bhat, Near Indira Bridge, Gandhinagar 382428, Gujarat (India)		
CO-ORDINATED BY					REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED	ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED			TITLE	
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS											SCALE	1:1	DATE	H ROD RIGHT SEGMENT - 6	
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120	120-315			DRAWN	K.R.R.	04.01.18	REF DRG NO:	REV 0
UPTO 10	10-50	50-120	OVER 120-400		+0.1	+0.2	+0.3	+0.5			CHECKED	PKC		DRG.NO	SHEET 1 OF 1
+1°	+0°-30'	+0°-20'	+0°-10'							APPROVED	JMK		IPR/17/A3/RFQ/19020022		

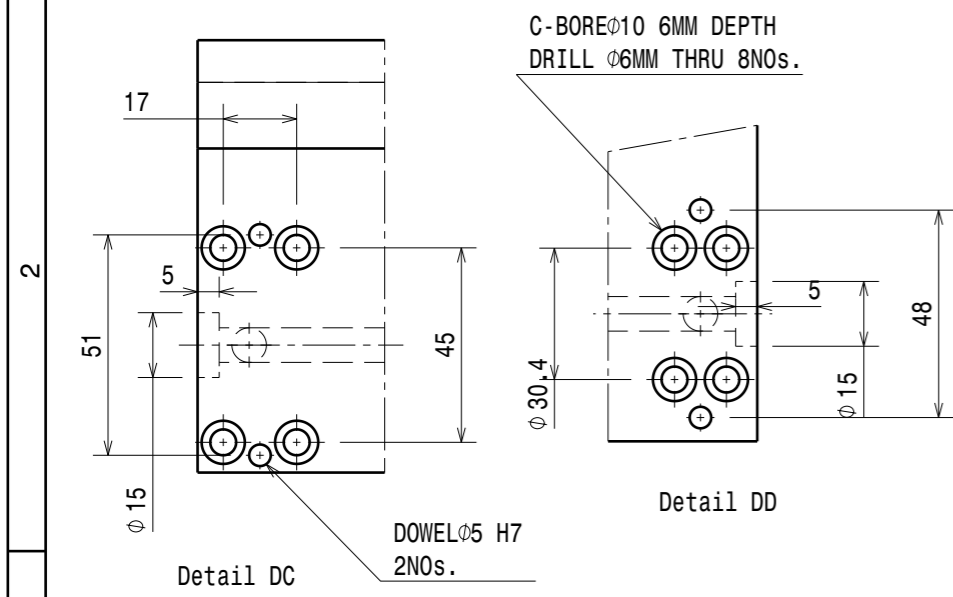
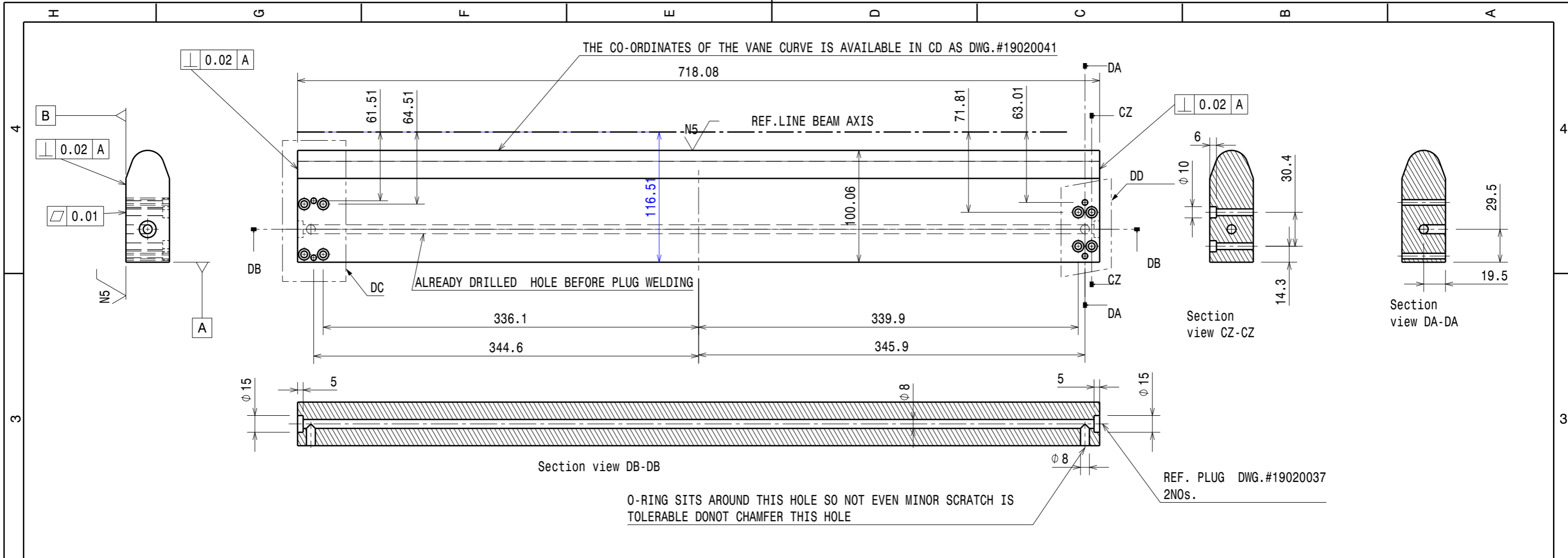


NOTE:

1. LENGTH OF THIS COMPONENT HAS BEEN MACHINED AFTER WELDING AND LEAK CHECKING,SO DO NOT MACHINE OR GRIND THIS SURFACES.
2. OVER ALL SURFCE FINISH: N5-N6 GRADE/Ra- 0.4-0.8 μ m.
3. NO SCRATCH OR DENT IS TOLERABLE ANY WHERE.
4. PROFILE OF EVERY VANE CURVE IS DIFFERENT.
5. R-----ON THE PROFILE IS CONSTANT THROUGH OUT.
6. ALL THE DIMENSIONS HAVE TO BE MACHINED FROM REFERENCE LINE (BEAM AXIS) AND DOWEL HOLES.
7. TO GET THE DIMENSIONAL SNF POSITIONAL ACCURACY OF 0.02MM, THE DOWEL HOLES SHOULD BE MADE IN THE LAST EITHER BY JIG BORING OR JIG GRINDING.NO REAMING.


SPECIAL NOTE:
POSITIONAL TOLERANCE OF DOWEL HOLES: 0.020MM AND OTHER HOLES: 0.1MM

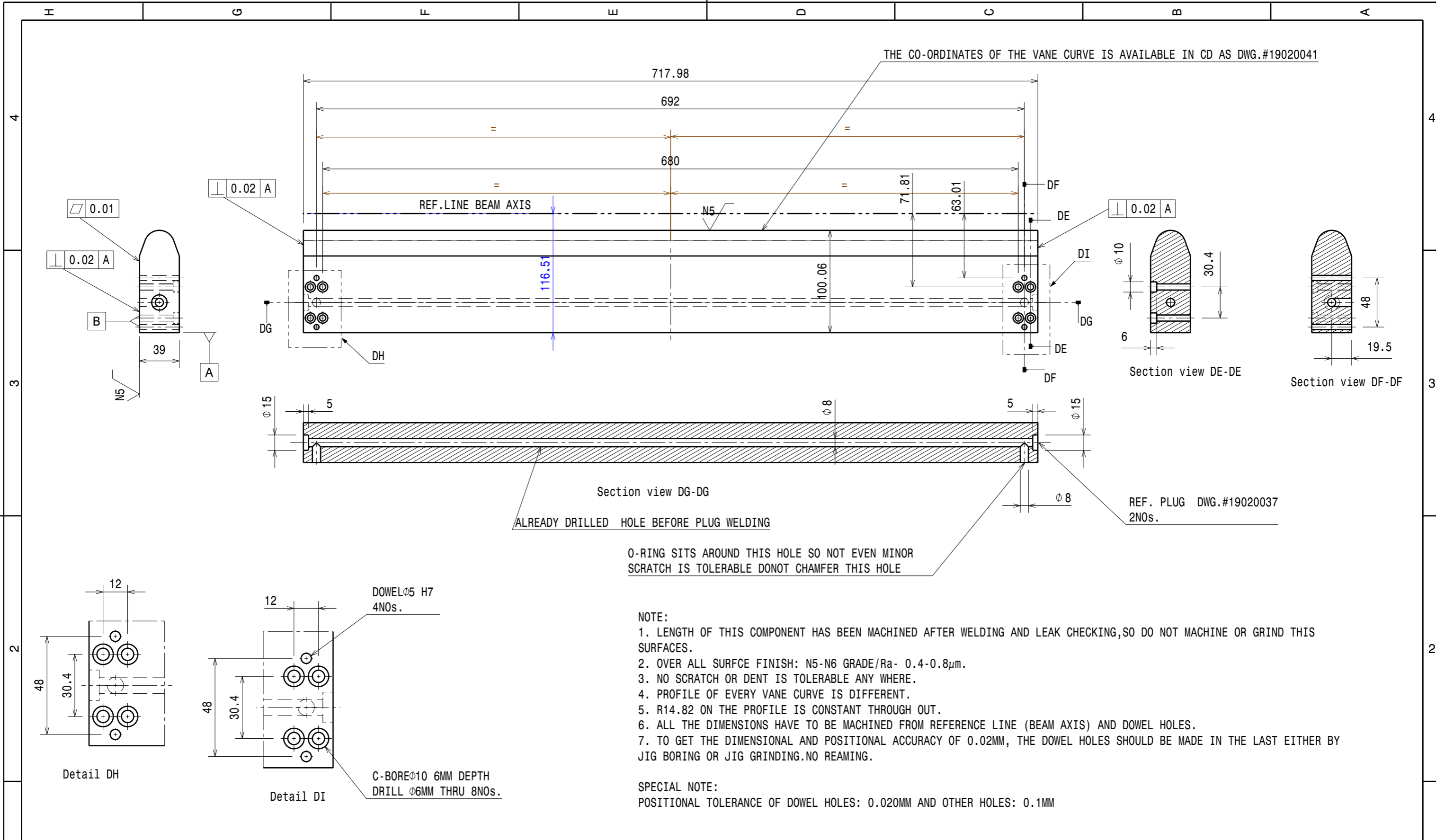
DRG.NO	▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN					RFQ GROUP:		 Institute for Plasma Research प्लाज्मा अनुसंधान संस्थान Bhat, Near Indira Bridge, Gandhinagar 382428, Gujarat (India)				
CO-ORDINATED BY					REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED	ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED					
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS											SCALE	1:1	DATE	TITLE		
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120	120-315				DRAWN	K.R.R.	04.01.18	V ROD LOWER SEGMENT - 1	
UPTO 10	10-50	50-120	OVER 120-400									CHECKED	PKC		REF DRG NO:	
+1°	+0°-30'	+0°-20'	+0°-10'		+0.1	+0.2	+0.3	+0.5			APPROVED	JMK		DRG.NO	IPR/17/A3/RFQ/19020023	REV 0
												DRG.NO	IPR/17/A3/RFQ/19020023	SHEET 1 OF 1		



- NOTE:**
1. LENGTH OF THIS COMPONENT HAS BEEN MACHINED AFTER WELDING AND LEAK CHECKING,SO DO NOT MACHINE OR GRIND THIS SURFACES.
 2. OVER ALL SURFACE FINISH: N5-N6 GRADE/Ra- 0.4-0.8µm.
 3. NO SCRATCH OR DENT IS TOLERABLE ANY WHERE.
 4. PROFILE OF EVERY VANE CURVE IS DIFFERENT.
 5. R14.82 ON THE PROFILE IS CONSTANT THROUGH OUT.
 6. ALL THE DIMENSIONS HAVE TO BE MACHINED FROM REFERENCE LINE (BEAM AXIS) AND DOWEL HOLES.
 7. TO GET THE DIMENSIONAL AND POSITIONAL ACCURACY OF 0.02MM, THE DOWEL HOLES SHOULD BE MADE IN THE LAST EITHER BY JIG BORING OR JIG GRINDING.NO REAMING.

SPECIAL NOTE:
POSITIONAL TOLERANCE OF DOWEL HOLES: 0.020MM AND OTHER HOLES: 0.1MM


DRG.NO	▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN				RFQ GROUP:		 Institute for Plasma Research प्लाज्मा अनुसंधान संस्थान Bhat, Near Indira Bridge, Gandhinagar 382428, Gujarat (India)				
CO-ORDINATED BY					REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED		ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED			
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS											SCALE	1:1	DATE	TITLE	
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120	120-315			DRAWN	K.R.R.	04.01.18	V ROD LOWER SEGMENT -2	
UPTO 10	10-50	50-120	OVER 120-400								CHECKED	PKC		REF DRG NO:	REV 0
+1°	+0°-30'	+0°-20'	+0°-10'		+0.1	+0.2	+0.3	+0.5			APPROVED	JMK	DRG.NO	IPR/17/A3/RFQ/19020024	SHEET 1 OF 1

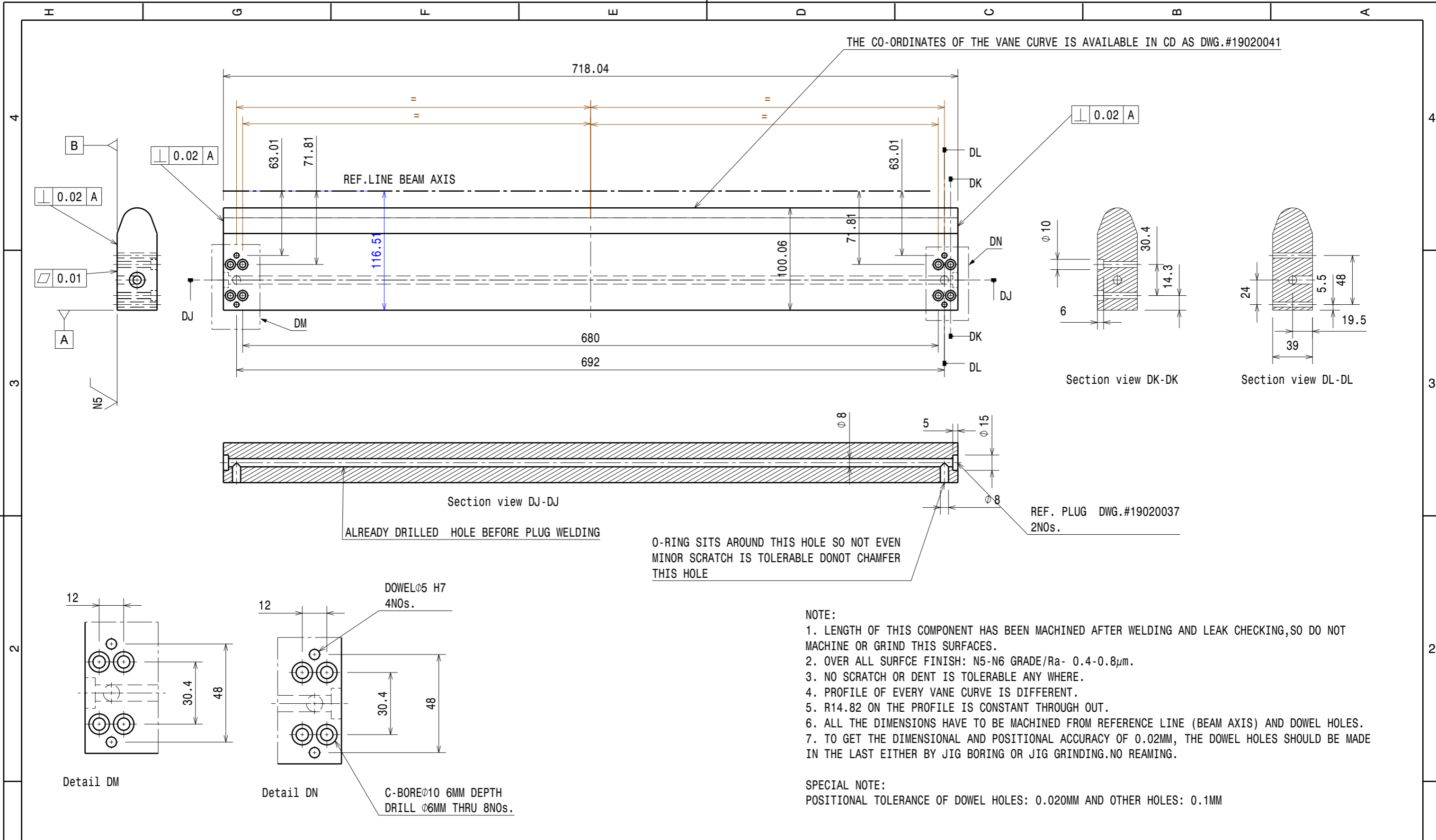



NOTE:

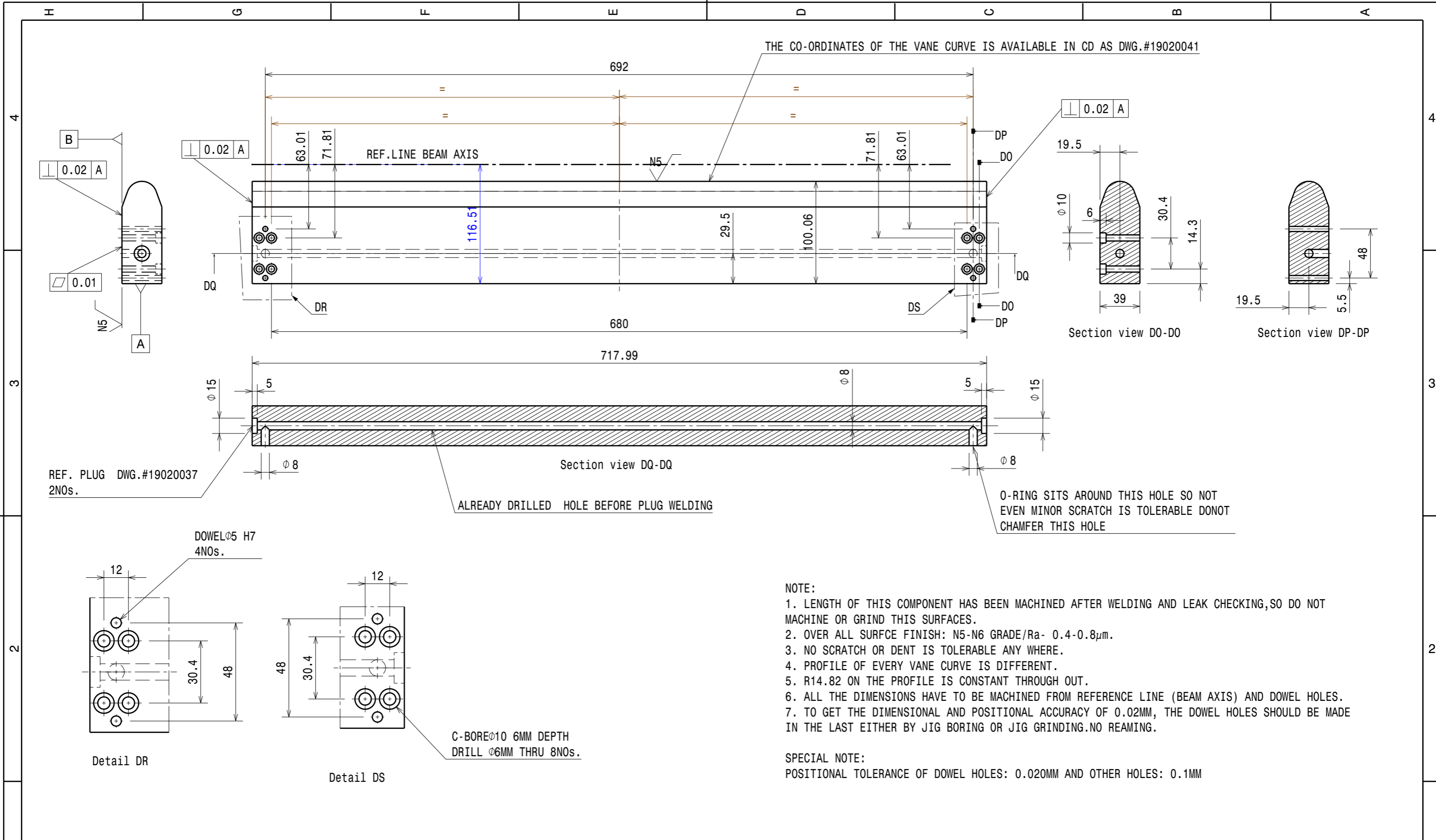
1. LENGTH OF THIS COMPONENT HAS BEEN MACHINED AFTER WELDING AND LEAK CHECKING,SO DO NOT MACHINE OR GRIND THIS SURFACES.
2. OVER ALL SURFCE FINISH: N5-N6 GRADE/Ra- 0.4-0.8 μ m.
3. NO SCRATCH OR DENT IS TOLERABLE ANY WHERE.
4. PROFILE OF EVERY VANE CURVE IS DIFFERENT.
5. R14.82 ON THE PROFILE IS CONSTANT THROUGH OUT.
6. ALL THE DIMENSIONS HAVE TO BE MACHINED FROM REFERENCE LINE (BEAM AXIS) AND DOWEL HOLES.
7. TO GET THE DIMENSIONAL AND POSITIONAL ACCURACY OF 0.02MM, THE DOWEL HOLES SHOULD BE MADE IN THE LAST EITHER BY JIG BORING OR JIG GRINDING.NO REAMING.

SPECIAL NOTE:
POSITIONAL TOLERANCE OF DOWEL HOLES: 0.020MM AND OTHER HOLES: 0.1MM

DRG.NO	▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN					RFQ GROUP:			 Institute for Plasma Research प्लाज्मा अनुसंधान संस्थान Bhat, Near Indira Bridge, Gandhinagar 382428, Gujarat (India)		
CO-ORDINATED BY					REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED	ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED				
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS											SCALE	1:1	DATE	TITLE	
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120	120-315			DRAWN	K.R.R.	04.01.18	V ROD LOWER SEGMENT -3	
UPTO 10	10-50	50-120	OVER 120-400								CHECKED	PKC		REF DRG NO:	REV 0
+1°	+0°-30'	+0°-20'	+0°-10'		+0.1	+0.2	+0.3	+0.5			APPROVED	JMK	DRG.NO	IPR/17/A3/RFQ/19020025	SHEET 1 OF 1



DRG.NO	∇ 8-25	∇ 1.6-8	∇ 0.025-1.6	∇ < 0.025	REVISION COLUMN				RFQ GROUP:		 Institute for Plasma Research प्लाज्मा अनुसंधान संस्थान Bhat, Near Indira Bridge, Gandhinagar 382428, Gujarat (India)			
CO-ORDINATED BY					REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED		ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED		
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS											SCALE	1:1	DATE	TITLE
LENGTH IN mm OF SHORTER SIDE OF ANGLES											DRAWN	K.R.R.	04.01.18	V ROD LOWER SEGMENT -4
LENGTH OR DIA											CHECKED	PKC		REF DRG NO:
UPTO 10											APPROVED	JMK		REV 0
UPTO 10														DRG.NO
UPTO 10														IPR/17/A3/RFQ/19020026
UPTO 10														SHEET 1 OF 1



DRG.NO	▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN					RFQ GROUP:		Institute for Plasma Research प्लाज्मा अनुसंधान संस्थान Bhat, Near Indira Bridge, Gandhinagar 382428, Gujarat (India)				
CO-ORDINATED BY					REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED	ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED					
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS											SCALE	1:1	DATE	TITLE		
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120	120-315				DRAWN	K.R.R.	05.01.18	V ROD LOWER SEGMENT -5	
UPTO 10	10-50	50-120	OVER 120-400									CHECKED	PKC		REF DRG NO:	REV 0
+1°	+0°-30'	+0°-20'	+0°-10'		+0.1	+0.2	+0.3	+0.5			APPROVED	JMK		DRG.NO	IPR/17/A3/RFQ/19020027	SHEET 1 OF 1