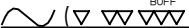






Technical drawing of a vertical component. The drawing shows a long, narrow rectangular part with several features and dimensions:

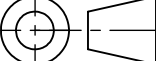
- Top Dimension:** A horizontal dimension line at the top indicates a width of 100 ± 0.1 .
- Surface Finish Symbols:** Five circular symbols with a triangle and the number '5' inside are distributed along the vertical surfaces, indicating specific surface finish requirements.
- Internal Features:** The component has internal rectangular cavities. One cavity near the top contains three small circular features (possibly holes or pins). Another cavity near the bottom contains two small circular features.
- Bottom Dimensions:** At the bottom, two horizontal dimension lines indicate a width of 10 on each side of the central part.
- Sectional View:** A small section of the component is shown on the right side, with a vertical dimension line indicating a height of 5.


BUFF

SURFACE FINISH SYMBOLS			
	UNMACHINED		
	12.5µm-25µm (Ra)		
	1.6µm-6.3µm (Ra)		
	0.2µm-0.8µm (Ra)		
GENERAL TOL.			
MACHINING SIZE OF HOLE POS.	ABOVE 1 - 10	±0.10	
	ABOVE 10 - 100	±0.15	
	ABOVE 100 - 500	±0.25	
	ABOVE 500 -	±0.50	
	ANGLE	±1°30'	
MACHINING SIZE OF SHAFT HOLE POS.		HOLE	SHAFT
	ABOVE 1 - 10	+0.2 0.0	0.0 -0.2
	ABOVE 10 - 100	+0.3 0.0	0.0 -0.3
	ABOVE 100 - 500	+0.5 0.0	0.0 -0.5
	ABOVE 500 -	+1.0 0.0	0.0 -1.0
WELDING	ABOVE 1 - 100	±2.5	
	ABOVE 150	±2.5	

1. All the tubes and plates will be welded using MIG welding. Plate A, B, C & D should be welded continuously.
2. Thickness of all the top and bottom plates will be 12mm, after machining it will be 10mm
3. After welding, machining should be done on both sides in single setting.
4. All the drills are to be done by VMC only in single setting.

5. Debur all corners unless specified.
4. Tappings should be masked before coating.
3. Mark each part with its drawing number.
2. Specified tolerances are to be maintained after coating.
1. Stress relieving to be done after welding/before machining.

DWG NO. MS01A0101001FR00		DRAWN BY CKY		SIGN.		STAMP (APP. AUTH.)		DATE OF ISSUE 01/11/2020	
REF. ASSLY. MAIN ASSEMBLY		CHKD BY RDS		SIGN.				DRAWN DATE 01/11/2020	
PART NAME MOTHER SHUTTLE FRAME		APPD BY BKS		SIGN.				PROJECT CODE -	
MATERIAL MS		HEAT TREATMENT							
QTY. 1		WEIGHT 216 <small>Nos</small> Kg		COATING POWDER RAL 7024		COATING THICKNESS 60-80 <small>μm</small>		SCALE NTS	
								SHEET NO. 01 OF 12	
								SIZE A3	
								REV. 00	
Addverb Technologies		This drawing is a business secret of Addverb Tech. Pvt. Ltd. and/or the company herein, and any act to copy, use or transfer this drawing without prior approval is illegal misconduct.							

GENERAL TOLERANCES FOR DIMENSIONS (REF. ISO 2768mk)															
	DEVIATIONS FOR LINEAR DIMENSIONS						DEVIATIONS FOR ANGULAR DIMENSIONS				DEVIATIONS FOR RADII & CHAMFERS				
	RANGE OF NOMINAL DIMENSIONS						NOMINAL DIMENSIONS OF SHORTER SIDE				RANGE OF NOMINAL DIMENSIONS				
ABOVE	0.5	6	30	120	400	1000	-	10	50	120	0.5	3	6	30	120
UPTO	6	30	120	400	1000	2000	10	50	120	-	3	6	30	120	315
TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±1°	±30'	±20'	±10'	±0.2	±0.5	±1	±2	±4

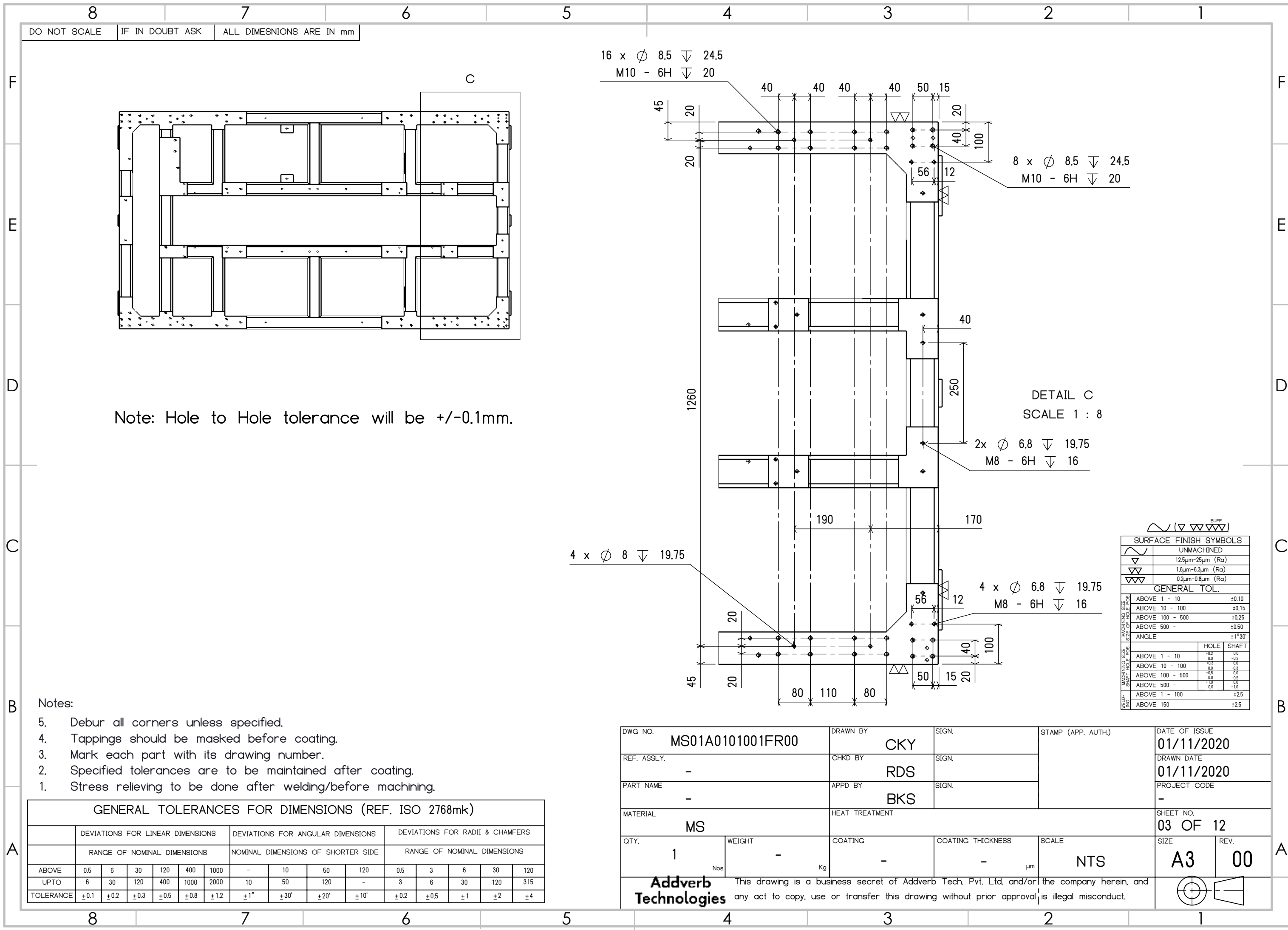


A

A






- A

AA

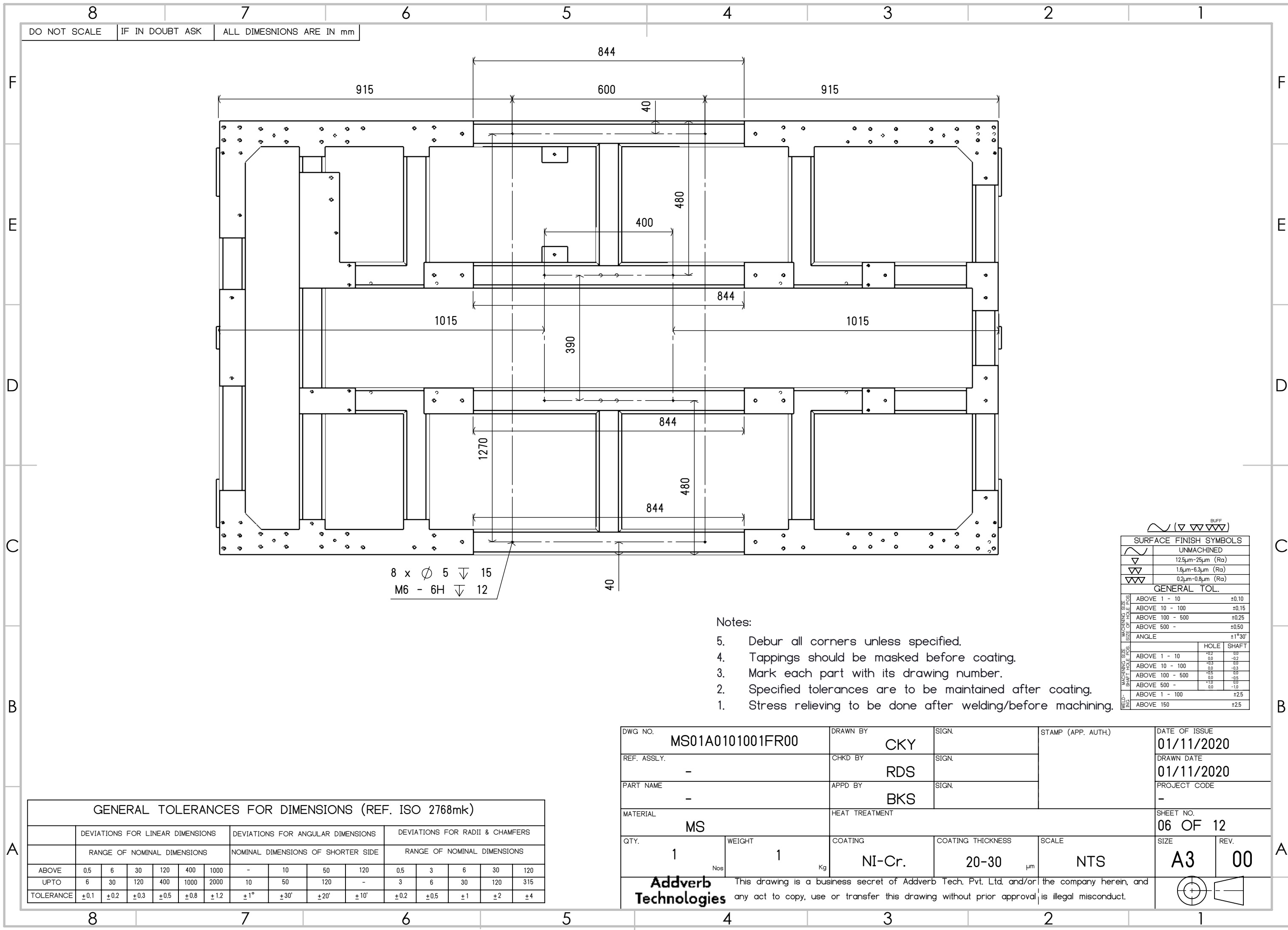









5. Debur all corners unless specified.
4. Tappings should be masked before coating.
3. Mark each part with its drawing number.
2. Specified tolerances are to be maintained after coating.
1. Stress relieving to be done after welding/before machining.

		
SURFACE FINISH SYMBOLS		
	UNMACHINED	
	12.5µm-25µm (Ra)	
	1.6µm-6.3µm (Ra)	
	0.2µm-0.8µm (Ra)	
GENERAL TOL.		
TOLERANCE SIZE TOLERANCE SIZE TOLERANCE SIZE	TOLERANCE SIZE TOLERANCE SIZE TOLERANCE SIZE	TOLERANCE SIZE TOLERANCE SIZE TOLERANCE SIZE
ABOVE 1 - 10		±0.10
ABOVE 10 - 100		±0.15
ABOVE 100 - 500		±0.25
ABOVE 500 -		±0.50
ANGLE		±1°30'
HOLE		SHAFT
ABOVE 1 - 10	±0.2 0.0	±0.2 -0.2
ABOVE 10 - 100	±0.3 0.0	±0.3 -0.3
ABOVE 100 - 500	±0.5 0.0	±0.5 -0.5
ABOVE 500 -	±1.0 0.0	±1.0 -1.0
ABOVE 1 - 100		±2.5
ABOVE 150		±2.5

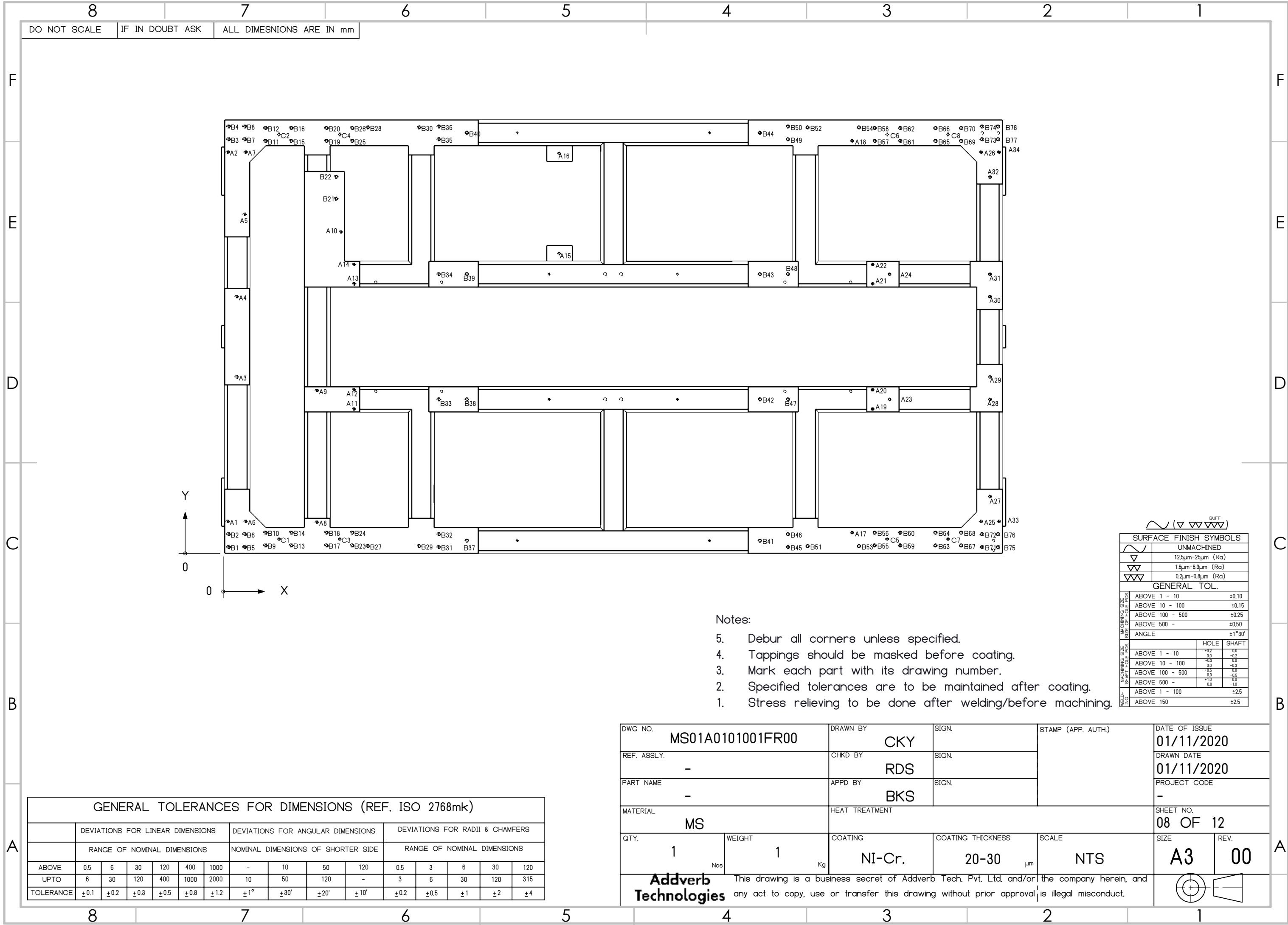
A





 BUFF		
SURFACE FINISH SYMBOLS		
	UNMACHINED	
	12.5μm-25μm (Ra)	
	1.6μm-6.3μm (Ra)	
	0.2μm-0.8μm (Ra)	
GENERAL TOL.		
TOLERANCE SIZE TOLERANCE Ranges TOLERANCE POSITION	ABOVE 1 - 10	±0.10
	ABOVE 10 - 100	±0.15
	ABOVE 100 - 500	±0.25
	ABOVE 500 -	±0.50
	ANGLE	±1°30'
TOLERANCE SIZE TOLERANCE Ranges TOLERANCE POSITION		HOLE SHAFT
	ABOVE 1 - 10	+0.2 0.0 0.0 -0.2
	ABOVE 10 - 100	+0.3 0.0 0.0 -0.3
	ABOVE 100 - 500	+0.5 0.0 0.0 -0.5
	ABOVE 500 -	+1.0 0.0 0.0 -1.0
TOLERANCE SIZE TOLERANCE Ranges TOLERANCE POSITION	ABOVE 1 - 100	±2.5
	ABOVE 150	±2.5

DWG. NO. MS01A0101001FR00		DRAWN BY CKY	SIGN.	STAMP (APP. AUTH.)	DATE OF ISSUE 01/11/2020	
REF. ASSLY. -		CHKD BY RDS	SIGN.		DRAWN DATE 01/11/2020	
PART NAME -		APPD BY BKS	SIGN.		PROJECT CODE -	
MATERIAL MS		HEAT TREATMENT			SHEET NO. 07 OF 12	
QTY. 1 <small>Nos</small>	WEIGHT 1 <small>Kg</small>	COATING NI-Cr.	COATING THICKNESS 20-30 <small>µm</small>	SCALE NTS	SIZE A3	REV. 00
Addverb Technologies					This drawing is a business secret of Addverb Tech. Pvt. Ltd. and/or the company herein, and any act to copy, use or transfer this drawing without prior approval is illegal misconduct.	



GENERAL TOLERANCES FOR DIMENSIONS (REF. ISO 2768mk)															
	DEVIATIONS FOR LINEAR DIMENSIONS						DEVIATIONS FOR ANGULAR DIMENSIONS				DEVIATIONS FOR RADII & CHAMFERS				
	RANGE OF NOMINAL DIMENSIONS						NOMINAL DIMENSIONS OF SHORTER SIDE				RANGE OF NOMINAL DIMENSIONS				
ABOVE	0.5	6	30	120	400	1000	-	10	50	120	0.5	3	6	30	120
UPTO	6	30	120	400	1000	2000	10	50	120	-	3	6	30	120	315
TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±1°	±30'	±20'	±10'	±0.2	±0.5	±1	±2	±4

- Notes:
1. Stress relieving to be done after welding/before machining.
 2. Specified tolerances are to be maintained after coating.
 3. Mark each part with its drawing number.
 4. Tappings should be masked before coating.
 5. Debur all corners unless specified.

DWG NO.		MS01A0101001FR00		DRAWN BY		CKY		SIGN.		STAMP (APP. AUTH.)		DATE OF ISSUE		01/11/2020													
REF. ASSLY.		-		CHKD BY		RDS		SIGN.				DRAWN DATE		01/11/2020													
PART NAME		-		APPD BY		BKS		SIGN.				PROJECT CODE		-													
MATERIAL				MS				HEAT TREATMENT				SHEET NO.				08 OF 12											
QTY.		1		WEIGHT		1		COATING		NI-Cr.		COATING THICKNESS		20-30		SCALE		NTS		SIZE		A3		REV.		00	
		Nos				Kg								µm													
<div><div>Addverb Technologies</div><div>This drawing is a business secret of Addverb Tech. Pvt. Ltd. and/or the company herein, and any act to copy, use or transfer this drawing without prior approval is illegal misconduct.</div></div>																											

8	7	6	5	4	3	2	1
DO NOT SCALE	IF IN DOUBT ASK	ALL DIMENSIONS ARE IN mm					







TAG	X LOC	Y LOC	SIZE
A1	12	100	$\varnothing 6.8 \downarrow 19.75$ M8 - 6H $\downarrow 16$
A2	12	1250	$\varnothing 6.8 \downarrow 19.75$ M8 - 6H $\downarrow 16$
A3	40	550	$\varnothing 6.8 \downarrow 19.75$ M8 - 6H $\downarrow 16$
A4	40	800	$\varnothing 6.8 \downarrow 19.75$ M8 - 6H $\downarrow 16$
A5	65	1056.50	$\varnothing 6.8 \downarrow 19.75$ M8 - 6H $\downarrow 16$
A6	68	100	$\varnothing 6.8 \downarrow 19.75$ M8 - 6H $\downarrow 16$
A7	68	1250	$\varnothing 6.8 \downarrow 19.75$ M8 - 6H $\downarrow 16$
A8	290	97.50	$\varnothing 6.8 \downarrow 19.75$ M8 - 6H $\downarrow 16$
A9	290	507.50	$\varnothing 6.8 \downarrow 19.75$ M8 - 6H $\downarrow 16$
A10	365	1001.50	$\varnothing 6.8 \downarrow 19.75$ M8 - 6H $\downarrow 16$
A11	406	450	$\varnothing 6.8 \downarrow 19.75$ M8 - 6H $\downarrow 16$
A12	406	510	$\varnothing 6.8 \downarrow 19.75$ M8 - 6H $\downarrow 16$
A13	406	840	$\varnothing 6.8 \downarrow 19.75$ M8 - 6H $\downarrow 16$
A14	406	900	$\varnothing 6.8 \downarrow 19.75$ M8 - 6H $\downarrow 16$
A15	1045.85	934	$\varnothing 6.8 \downarrow 19.75$ M8 - 6H $\downarrow 16$


TAG	X LOC	Y LOC	SIZE
A16	1045.85	1246	$\varnothing 6.8 \nabla 19.75$ M8 - 6H $\nabla 16$
A17	1960	65	$\varnothing 6.8 \nabla 19.75$ M8 - 6H $\nabla 16$
A18	1960	1285	$\varnothing 6.8 \nabla 19.75$ M8 - 6H $\nabla 16$
A19	2024	450	$\varnothing 6.8 \nabla 19.75$ M8 - 6H $\nabla 16$
A20	2024	510	$\varnothing 6.8 \nabla 19.75$ M8 - 6H $\nabla 16$
A21	2024	840	$\varnothing 6.8 \nabla 19.75$ M8 - 6H $\nabla 16$
A22	2024	900	$\varnothing 6.8 \nabla 19.75$ M8 - 6H $\nabla 16$
A23	2076.50	480	$\varnothing 6.8 \nabla 19.75$ M8 - 6H $\nabla 16$
A24	2076.50	870	$\varnothing 6.8 \nabla 19.75$ M8 - 6H $\nabla 16$
A25	2362	100	$\varnothing 6.8 \nabla 19.75$ M8 - 6H $\nabla 16$
A26	2362	1250	$\varnothing 6.8 \nabla 19.75$ M8 - 6H $\nabla 16$
A27	2390	177.50	$\varnothing 6.8 \nabla 19.75$ M8 - 6H $\nabla 16$
A28	2390	480	$\varnothing 6.8 \nabla 19.75$ M8 - 6H $\nabla 16$
A29	2390	550	$\varnothing 6.8 \nabla 19.75$ M8 - 6H $\nabla 16$
A30	2390	800	$\varnothing 6.8 \nabla 19.75$ M8 - 6H $\nabla 16$

Notes:

5. Debur all corners unless specified.
4. Tappings should be masked before coating.
3. Mark each part with its drawing number.
2. Specified tolerances are to be maintained after coating.
1. Stress relieving to be done after welding/before machining.

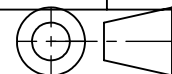
GENERAL TOLERANCES FOR DIMENSIONS (REF. ISO 2768mk)																
	DEVIATIONS FOR LINEAR DIMENSIONS						DEVIATIONS FOR ANGULAR DIMENSIONS				DEVIATIONS FOR RADII & CHAMFERS					
	RANGE OF NOMINAL DIMENSIONS						NOMINAL DIMENSIONS OF SHORTER SIDE				RANGE OF NOMINAL DIMENSIONS					
ABOVE	0.5	6	30	120	400	1000	-	10	50	120	0.5	3	6	30	120	
UPTO	6	30	120	400	1000	2000	10	50	120	-	3	6	30	120	315	
TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±1°	±30'	±20'	±10'	±0.2	±0.5	±1	±2	±4	

			BUFF
SURFACE FINISH SYMBOLS			
	UNMACHINED		
	12.5µm-25µm (Ra)		
	1.6µm-6.3µm (Ra)		
	0.2µm-0.8µm (Ra)		
GENERAL TOL.			
MACHINING SIZE SURFACE TOL.	ABOVE 1 - 10	±0.10	
	ABOVE 10 - 100	±0.15	
	ABOVE 100 - 500	±0.25	
	ABOVE 500 -	±0.50	
	ANGLE	±1°30'	
MACHINING SIZE SURFACE TOL.		HOLE	SHAFT
	ABOVE 1 - 10	+0.2 0.0	0.0 -0.2
	ABOVE 10 - 100	+0.3 0.0	0.0 -0.3
	ABOVE 100 - 500	+0.5 0.0	0.0 -0.5
	ABOVE 500 -	+1.0 0.0	0.0 -1.0
WELD- ING	ABOVE 1 - 100	±2.5	
	ABOVE 150	±2.5	

DWG NO. MS01A0101001FR00		DRAWN BY CKY		SIGN.		STAMP (APP. AUTH.)		DATE OF ISSUE 01/11/2020	
REF. ASSLY. -		CHKD BY RDS		SIGN.				DRAWN DATE 01/11/2020	
PART NAME -		APPD BY BKS		SIGN.				PROJECT CODE -	
MATERIAL MS		HEAT TREATMENT						SHEET NO. 09 OF 12	
QTY. 1 Nos	WEIGHT 1 Kg	COATING NI-Cr.		COATING THICKNESS 20-30 µm		SCALE NTS		SIZE A3	REV. 00
Addverb Technologies		This drawing is a business secret of Addverb Tech. Pvt. Ltd. and/or the company herein, and any act to copy, use or transfer this drawing without prior approval is illegal misconduct.							

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TAG	X LOC	Y LOC	SIZE
A31	2390	870	\varnothing 6.8 ∇ 19.75 M8 - 6H ∇ 16
A32	2390	1172.50	\varnothing 6.8 ∇ 19.75 M8 - 6H ∇ 16
A33	2418	100	\varnothing 6.8 ∇ 19.75 M8 - 6H ∇ 16
A34	2418	1250	\varnothing 6.8 ∇ 19.75 M8 - 6H ∇ 16
B1	15	20	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20
B2	15	60	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20
B3	15	1290	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20
B4	15	1330	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20
B5	65	20	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20
B6	65	60	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20
B7	65	1290	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20
B8	65	1330	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20
B9	130	25	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20
B10	130	65	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20
B11	130	1285	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20

Notes:

- Debur all corners unless specified.
- Tappings should be masked before coating.
- Mark each part with its drawing number.
- Specified tolerances are to be maintained after coating.
- Stress relieving to be done after welding/before machining.

GENERAL TOLERANCES FOR DIMENSIONS (REF. ISO 2768mk)															
	DEVIATIONS FOR LINEAR DIMENSIONS						DEVIATIONS FOR ANGULAR DIMENSIONS				DEVIATIONS FOR RADII & CHAMFERS				
	RANGE OF NOMINAL DIMENSIONS						NOMINAL DIMENSIONS OF SHORTER SIDE				RANGE OF NOMINAL DIMENSIONS				
ABOVE	0.5	6	30	120	400	1000	-	10	50	120	0.5	3	6	30	120
UPTO	6	30	120	400	1000	2000	10	50	120	-	3	6	30	120	315
TOLERANCE	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±1°	±30'	±20'	±10'	±0.2	±0.5	±1	±2	±4

TAG	X LOC	Y LOC	SIZE
B12	130	1325	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20
B13	210	25	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20
B14	210	65	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20
B15	210	1285	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20
B16	210	1325	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20
B17	320	25	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20
B18	320	65	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20
B19	320	1285	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20
B20	320	1325	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20
B21	350.21	1104.75	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20
B22	350.21	1173.25	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20
B23	400	25	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20
B24	400	65	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20
B25	400	1285	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20
B26	400	1325	\varnothing 8.5 ∇ 24.5 M10 - 6H ∇ 20

BUFF

SURFACE FINISH SYMBOLS			
	UNMACHINED		
	12.5µm-25µm (Ra)		
	1.6µm-6.3µm (Ra)		
	0.2µm-0.8µm (Ra)		
GENERAL TOL.			
ABOVE 1 - 10			±0.10
ABOVE 10 - 100			±0.15
ABOVE 100 - 500			±0.25
ABOVE 500 -			±0.50
ANGLE			±1°30'
MACHINING SIZE HOLE	HOLE		SHAFT
ABOVE 1 - 10	±0.2 0.0		0.0 -0.2
ABOVE 10 - 100	±0.3 0.0		0.0 -0.3
ABOVE 100 - 500	±0.5 0.0		0.0 -0.5
ABOVE 500 -	±1.0 0.0		0.0 -1.0
WELD- ING	ABOVE 1 - 100		±2.5
	ABOVE 150		±2.5

DWG NO.	MS01A0101001FR00	DRAWN BY	CKY	SIGN.	STAMP (APP. AUTH.)	DATE OF ISSUE	01/11/2020
REF. ASSLY.	-	CHKD BY	RDS	SIGN.		DRAWN DATE	01/11/2020
PART NAME	-	APPD BY	BKS	SIGN.		PROJECT CODE	-
MATERIAL	MS	HEAT TREATMENT				SHEET NO.	10 OF 12
QTY.	1	WEIGHT	1	COATING	NI-Cr.	COATING THICKNESS	20-30
	Nos		Kg			SCALE	NTS
Addverb Technologies						This drawing is a business secret of Addverb Tech. Pvt. Ltd. and/or the company herein, and any act to copy, use or transfer this drawing without prior approval is illegal misconduct.	

