

Changes made in EX200 INFRA Cabin

CONTENT

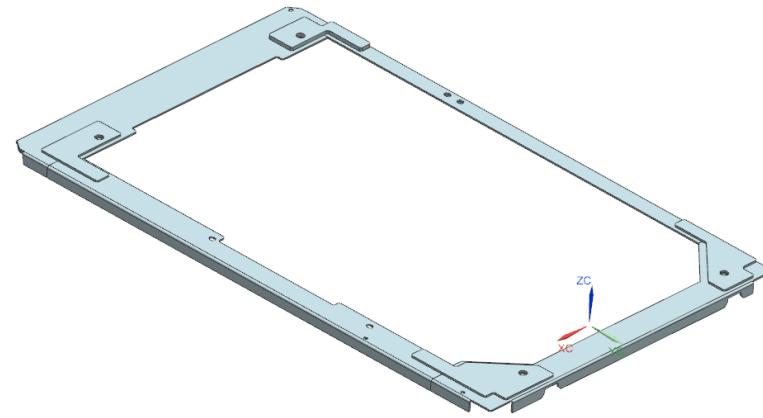
1. Changes in Floorplate
2. Changes in Cabin assembly

Changes in Floorplate

TATA HITACHI

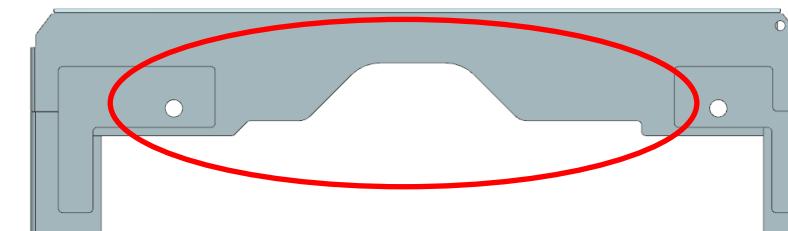
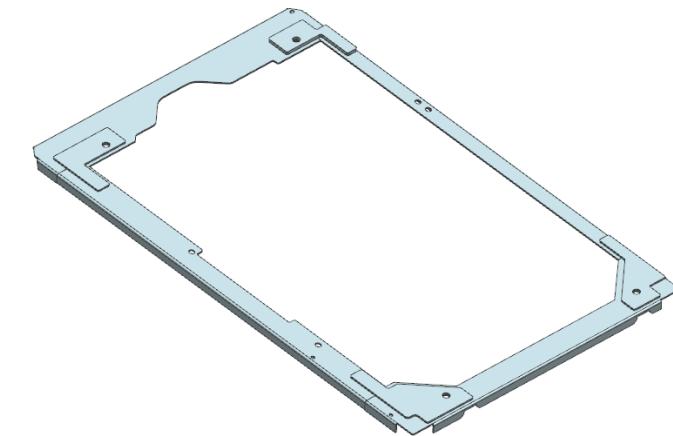
Reliable solutions

Before



TC21199 – Floor Plate

After

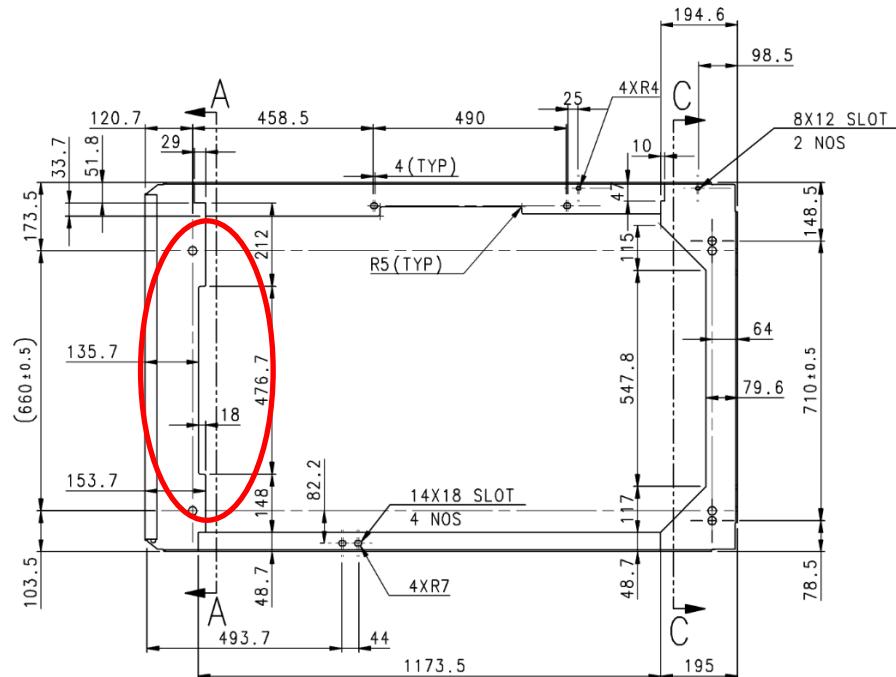


TC21199 – Floor Plate

Cut out added in floorplate due to travel lever fouling with floorplate during assembly

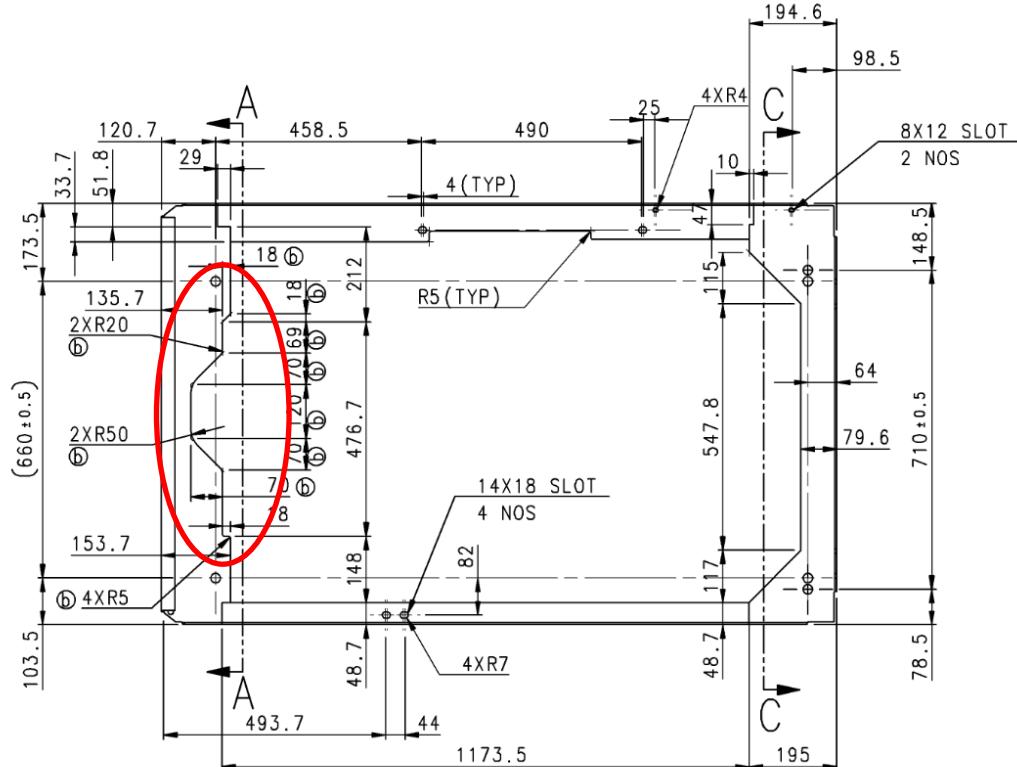
Changes in Floorplate

Before



TC21199 – Floor Plate

After



TC21199 – Floor Plate

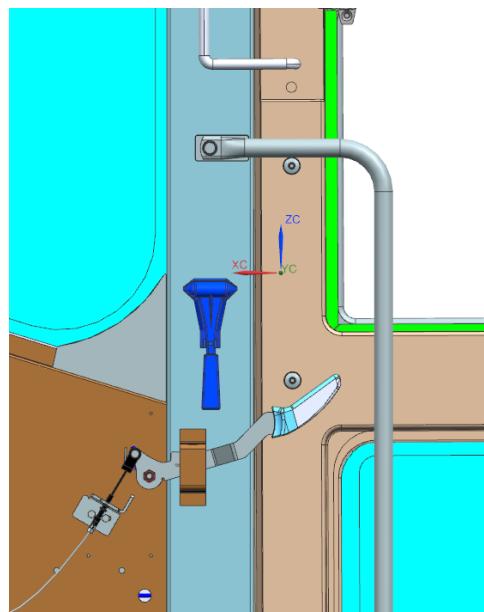
Cut out added in floorplate due to travel lever fouling with floorplate during assembly

Changes in Cabin assembly

TATA HITACHI

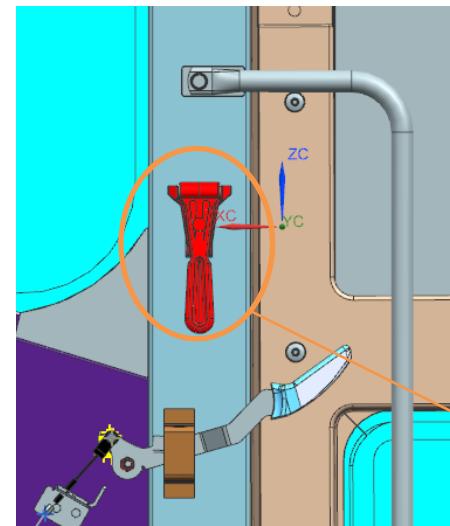
Reliable solutions

Before

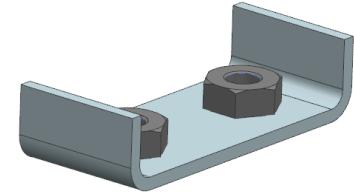


TA12476 – Cabin

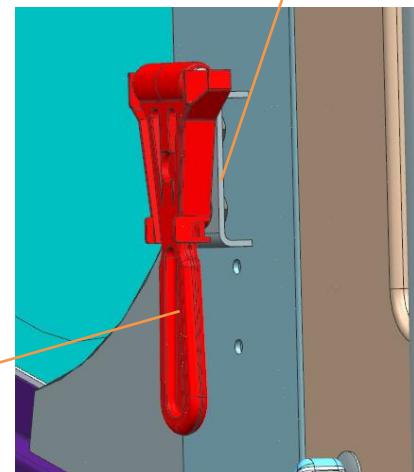
After



TD25374 – Hammer



TE42177 - Bracket



TA12476 – Cabin

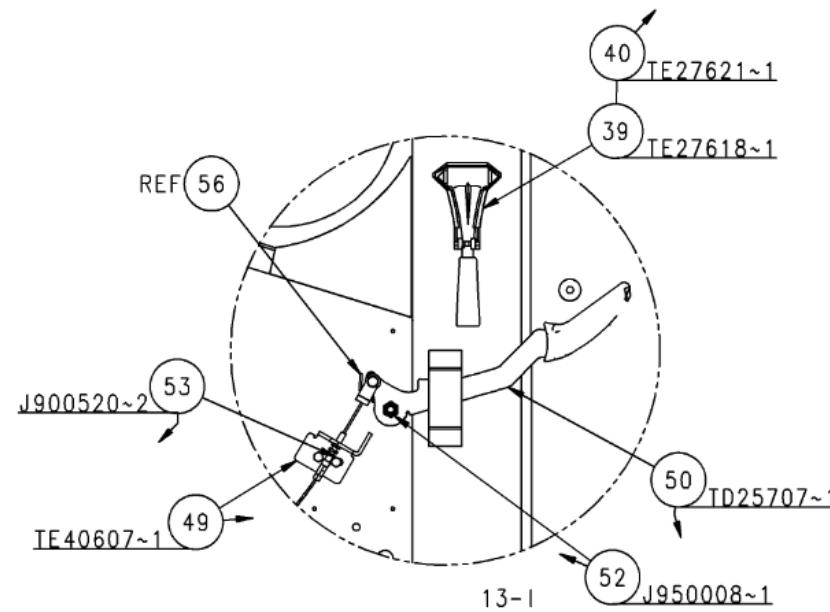
Emergency glass breaking hammer is changed to 'Pacoline hammer' as a cost reduction idea

Changes in Cabin assembly

TATA HITACHI

Reliable solutions

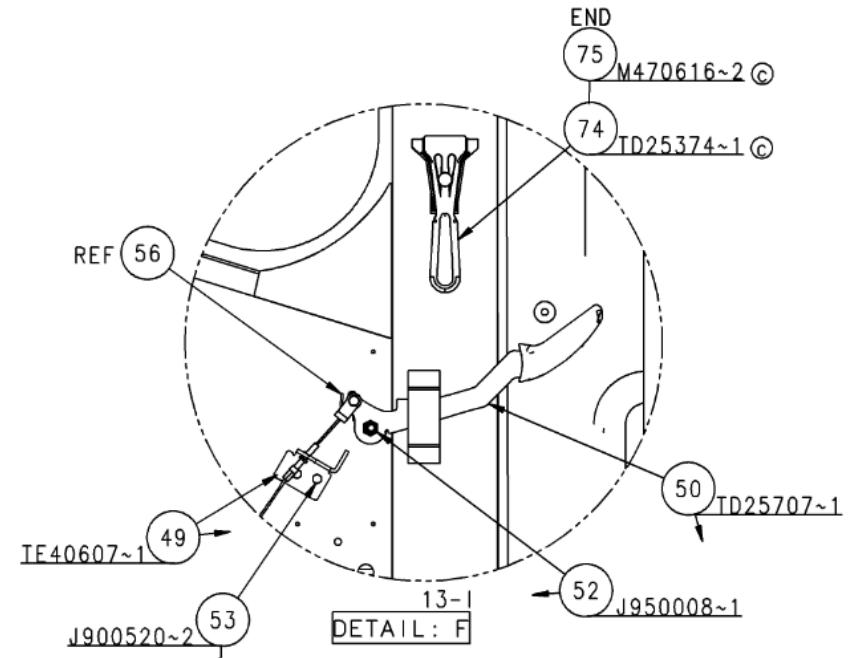
Before



SCALE 1:5

TA12476 – Cabin

After



SCALE 1:5

TA12476 – Cabin

Emergency glass breaking hammer is changed to 'Pacoline hammer' as a cost reduction idea

THANK YOU

TE42177

DO NOT SCALE; IF IN DOUBT, ASK

Date	Mod.No	Zone	Modification	Drn.	Chd.
14.03.23	(C)		DRG. INTRODUCED, ECN NO S200-2351	VIGNESH	VARMA

Tolerance For Fabrication

Nominal Dimension	Tolerance
<6	± 0.5
6≤	± 1.0
30≤	± 1.5
63≤	± 2.0
125≤	± 2.5
250≤	± 3.15
500≤	± 4.0
1000≤	± 5.0
2000≤	± 6.3
4000≤	± 8.0
8000≤	± 10.0

Machining Process

Nominal Dimension	Tolerance
≤4	± 0.1
4<	± 0.2
16<	± 0.3
63<	± 0.5
250<	± 0.8
1000<	± 1.25

Angular Tolerance

Nominal Dimension	Tolerance
≤10	$\pm 1^\circ$
10<	$\pm 30'$
50<	$\pm 20'$
120<	$\pm 10'$
400<	$\pm 5'$

Lesser Cutting & Bending Process

Nominal Dimension	Die Cutting Tol.	Drawing Process Tol.
≤6	± 0.3	± 0.5
6<	± 0.5	± 1.0
30<	± 0.8	± 1.5
120<	± 1.2	± 2.5
400<	± 2.0	± 4.0
1000<	± 3.0	± 6.0

Pressing Process

Nominal Dimension	Die Cutting Tol.	Drawing Process Tol.
≤6	± 0.1	± 0.3
6<	± 0.2	± 0.5
30<	± 0.3	± 0.8
120<	± 0.5	± 1.2
400<	± 0.8	± 2.0
1000<	± 1.2	± 3.0

2.5 (THK)

15

R3 (TYP.)

2X Ø8

2X

2

M650006~2

= 26 =

= 32 =

= 62 =

(15)

(26)

SH 2.5x26x82~1
IS 5986-235(DD/FE 360)

This drg. is the sole property of Tata Hitachi. It should not be copied or communicated to any person without the written approval of Tata Hitachi.



Tata Hitachi Construction Machinery Co. Pvt. Ltd.
Kharagpur

2023	Sign	Date	Weld Quality	Gen.Roughness	Material Description, Size, Spec., Std. No.
Drn. VIGNESH		14.03			
Chd. VARMA		14.03			Fin. Mass (kg): 0.05
Appd. ARUN		14.03			Replaces Drg.: -
					Ref. Drg. No.: -
					Drg./ Part No.
					TE42177
					Sheet No. 1 of 1 Sheets

BRACKET

TC21199

DO NOT SCALE; IF IN DOUBT, ASK

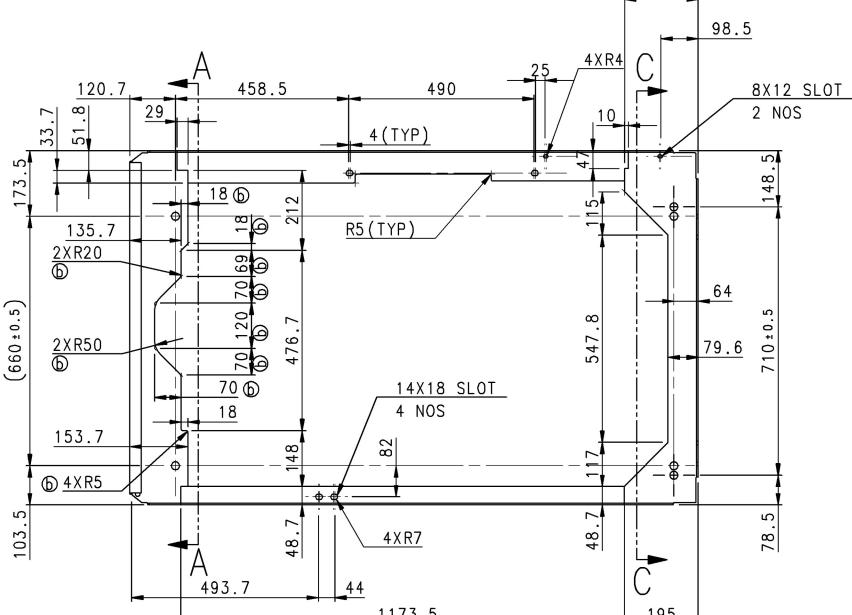
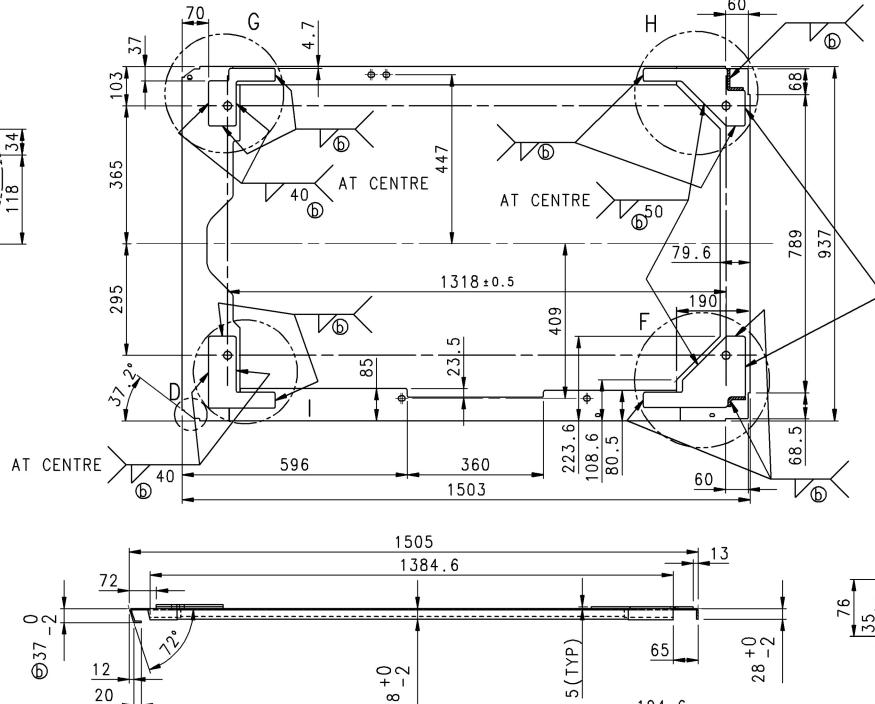
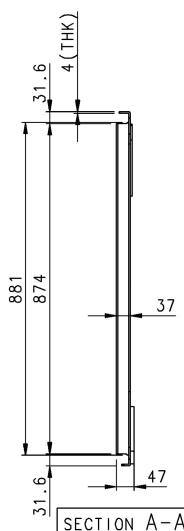
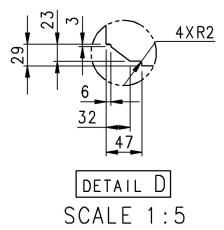
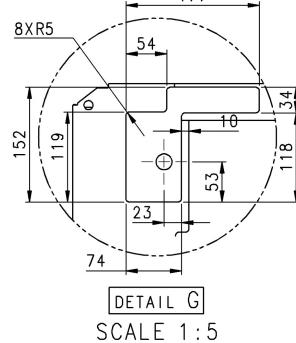
Drgr. / Part No.

DRG. INTRODUCED, ECN NO S200-2312.

IT-1,2,6 MODIFIED, DIM 37 WAS 28, DIMS 18,69,70,120,R5,R20,

R50 ADDED, WELDING MODIFIED FOR IT-1,2,4 & 5, ECN NO S200-2351.

Date	Mod. No	Zone	Modification	Drn.	Chd.
15.11.22	(A)		DRG. INTRODUCED, ECN NO S200-2312.	VIGNESH	SHRUTI
13.03.23	(B)		IT-1,2,6 MODIFIED, DIM 37 WAS 28, DIMS 18,69,70,120,R5,R20, R50 ADDED, WELDING MODIFIED FOR IT-1,2,4 & 5, ECN NO S200-2351.	SHRUTI	ARUN



GEN.TOL. FOR MACHINING GEN.TOLERANCE FOR WELDING
 LENGTH DEVIATION LENGTH DEVIATION
 $L \leq 4$ ± 0.1 $L < 63$ ± 1.6
 $4 < L \leq 16$ ± 0.2 $63 \leq L < 125$ ± 2.0
 $16 < L \leq 63$ ± 0.3 $125 \leq L < 250$ ± 2.5
 $63 < L \leq 250$ ± 0.5 $250 \leq L < 500$ ± 3.0
 $250 \leq L < 1000$ ± 0.8 $500 \leq L < 1000$ ± 4.0
 $1000 \leq L \leq 4000$ ± 1.25 $1000 \leq L < 2000$ ± 5.0
 COMPLY WITH STD. IES 900-025 $2000 \leq L < 4000$ ± 6.3
 DON'T USE PROHIBITED CHEMICALS $4000 \leq L < 8000$ ± 8.0
 (REF DRG. NO. 9964633) IN SUPPLIES $8000 \leq L < 16000$ ± 10.0

This drg. is the sole property of Toto Hitachi.
 It should not be copied or communicated to any person without the written approval of Toto Hitachi.
 Drn. VIGNESH 15.11 Project Name EX200Super
 Chd. SHRUTI 15.11
 Apd. ARUN 15.11 Projection DIMS ARE IN mm
 Scale:- 1 : 10 TOL. AS PER STD. ISO 286-2
 Drg./ Part Designation Ref. Drg. No.: TC20366
 Toto Hitachi Construction Machinery Co. Pvt. Ltd.
 Kharagpur

FLOOR PLATE ASSY
 Sheet No. 1 of 1 Sheets

2022	Sign	Date	Weld Quality	Gen.Roughness	Material Description, Size, Spec., Std. No.
Drn. VIGNESH		15.11			ASSY
Chd. SHRUTI		15.11			Fin. Mass (kg): 18.5 (B)
Apd. ARUN		15.11			Project Name Replicates Org.:
Scale:- 1 : 10					EX200Super
Drg./ Part Designation					Ref. Drg. No.: TC20366
					Drg./ Part No.
					TC21199
					Sheet No. 1 of 1 Sheets

