Required bought out parts for assembly

<table>
<thead>
<tr>
<th>Item no</th>
<th>Part name</th>
<th>Description</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>socket head M6x25</td>
<td>to connect caster wheel to Base support</td>
<td>24</td>
</tr>
<tr>
<td>2</td>
<td>socket head M6x40</td>
<td>to connect screw jack to Base support</td>
<td>24</td>
</tr>
<tr>
<td>3</td>
<td>socket head M6x25</td>
<td>to connect mirror positioning to base support</td>
<td>12</td>
</tr>
<tr>
<td>4</td>
<td>M6 washer &amp; Nut</td>
<td>To connect Dwg.No 0007 &amp; 0008 to Base support</td>
<td>60</td>
</tr>
<tr>
<td>5</td>
<td>M8 Nut</td>
<td>To connect Dwg.No 0007 &amp; 0008 to Base support</td>
<td>6</td>
</tr>
</tbody>
</table>

Mass with out segment = 140655g (140.65kg) (Information only)
NOTE: Unless otherwise specified
1. All dimensions are in mm.

Drill center hole dia 8 first with respect to the center of fixture and than three holes to be drilled from the center taking the reference.

3. Parts shall be free of scratches, dents and gouges after all machining

4. For further details refer 3d model

5. All welds shall be blended smooth.

6. All sharp edges should be round off

7. Finish machined surface shall be given a coat of rust preventive or oil/grease during storage till assembly (Painting)

8. The component shall be Stress relieved @600°c for 1 hour after all welding before machining

9. All unmachined surfaces shall be cleaned free of rust, scale, dreg etc and painted as per specifications.

10. Total component shall be blast cleaned on all unmachined surface after stress relief & given a coat of zinc oxide yellow primer.
SECTION A-A
SHEET 2, ZONE D6 SCALE 1:2

SECTION S-S
SHEET 2, ZONE D4 SCALE 1:2

2x 4.50 at 6 places
4 Nos TAP DRILL $\phi$ 10 FOR HELICOIL INSERT M4x0.7x1.5 D LONG FROM BOTTOM SIDE

3 Nos TAP DRILL THROUGH ALL FOR HELICOIL INSERT M6x1.0x1.5D LONG

$\phi$ 80

2x [86.34]

2x [266.2]

2x [26.66]

547.3

5.2731

30.20

2x [10]

2x [80]

6 Nos TAP DRILL $\phi$ 10 FOR HELICOIL INSERT M4x0.7x1.5 D LONG

NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining
3. For further details refer 3D model
4. All sharp edges should be round off
5. Install helicoil threaded inserts per manufacture instructions after Alodining
6. Gold chemical conversion coat (e.g. Alodine) apply by immersion

Mass = 1240.17 g (information only)

DETAIL B

SCALE 2:1

R0.25 Max

0.50 x 45°

0.050 A

SECTION B-B

SCALE 1:2

INDIA TMT COORDINATE CENTER

DEEP DRAWING MANUFACTURING

MATERIAL: Al Alloy
QUANTITY: 8

SIZE - A3

SEG POL - BS WA - 0005

REV 000

SHEET OF 15
4Nos TAP DRILL THROUGH ALL FOR HELICOIL INSERT M4x0.7x1.5 D LONG

TAP DRILL THROUGH ALL FOR HELICOIL INSERT M4x0.7x1.5 D LONG

11

SECTION C-C
SCALE 1:2

NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining.
3. For further details refer 3D model.
4. All sharp edges should be rounded off.
5. Install helicoidal threaded inserts per manufacture instructions after Alodining.
6. Gold chemical conversion coat (e.g. Alodine) apply by immersion.
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gauges after all machining.
3. For further details refer 3D model.
4. All sharp edges should be round off.
5. Install helicoil threaded inserts per manufacture instructions after Alodining.
6. Gold chemical conversion coat (e.g. Alodine) apply by immersion.

Mass = 797.22 g (Information only)
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining.
3. For further details refer 3D model.
4. All sharp edges should be round off.

Material: STAINLESS STEEL
Quantity: 3

Mass = 21.87g (Information only)

Material: STAINLESS STEEL
Quantity: 3

Mass = 21.87g (Information only)
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining
3. For further details refer 3D model
4. All sharp edges should be round off

Material: STAINLESS STEEL
Quantity: 3

Mass = 20.61 g (Information only)
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining
3. For further details refer 3D model
4. All sharp edges should be round off

MATERIAL: STAINLESS STEEL
QUANTITY: 9

Mass = 13.88g (Information only)
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining
3. For further details refer 3D model
4. All sharp edges should be round off

INNER TRIANGLE HORIZONTAL ALIGNMENT PIN

MATERIAL: STAINLESS STEEL
QUANTITY: 6

Mass = 6.98g (Information only)
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining.
3. For further details refer 3D model.
4. All sharp edges should be round off.

MATERIAL: STAINLESS STEEL
QUANTITY: 16

Mass = 7.27g (Information only)
MATERIAL: STAINLESS STEEL
QUANTITY: 3

SECTION B-B SCALE 5:1

Load cell spacer

MATERIAL: STAINLESS STEEL
QUANTITY: 3

NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents, and gouges after all machining.
3. For further details, refer 3D model.
4. All sharp corners should be chamfered 0.3X45°.

Mass = 19.97g (Information only)

INDIA TMT COORDINATE CENTER
Viswanatha.N
Viswanatha.N
Sudharsan.K

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN MILLIMETERS
Decimals x.x  -  0.3
x.xx  -  0.100
x.xxx - 0.050

SCALE 5:1
SECTION B-B
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining.
3. For further details refer 3D model.
4. All sharp corners should be chamfered 0.3X45°

MATERIAL: STAINLESS STEEL
QUANTITY: 3

Mass = 24.72g (Information only)
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining
3. All sharp corners should be chamfered 0.3X45°

MATERIAL: STAINLESS STEEL
QUANTITY: 3

Mass = 1.56g (Information only)
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining.
3. All sharp corners should be chamfered 0.3x45°

MATERIAL: Derlin/Aluminium
QUANTITY: 18
Mass = 0.20g (Information only)

DIMENSIONS ARE IN MILLIMETERS
Decimals
Angular = +/– 30°
0.3  -  0.100
0.1  -  0.050

INDIA TMT COORDINATE CENTER
Viswanatha N
Sudharsan K

C B A
F E D
8 7 6 5 4 3 2 1
NOTE:
1. All dimensions are in mm
2. Shims had given with different dimensions
3. Quantity of each shim 20 Nos

MATERIAL: Aluminium
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining
3. All sharp corners should be chamfered 0.3X45°

MATERIAL: Derlin/Aluminium
QUANTITY: 15
Mass = 0.28g (Information only)
NOTE:
1. All dimensions are in mm
2. Shims had given with different dimensions
3. Quantity of each shim 20 Nos

MATERIAL: Aluminium
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining
3. All sharp corners should be chamfered 0.3X45°

MATERIAL: Derlin/Aluminium
QUANTITY: 6

Mass = 0.81g (Information only)

ISOMETRIC VIEW

3.70
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining.
3. All sharp corners should be chamfered 0.3X45°

Mass = 0.30g (Information only)

Washer D

MATERIAL: Delrin/Aluminium

QUANITITY: 6
<table>
<thead>
<tr>
<th>ITEM NO.</th>
<th>PART NUMBER</th>
<th>DESCRIPTION</th>
<th>QTY.</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>SEG POL_I - BSWA - 0021</td>
<td>Derlin bush</td>
<td>1</td>
</tr>
<tr>
<td>2</td>
<td>SEG POL_I - BSWA - 0022</td>
<td>Bush support pin</td>
<td>1</td>
</tr>
<tr>
<td>3</td>
<td>Boug out (SMALL SPHERICAL BALL BEARING)</td>
<td>GLRWS 4</td>
<td>1</td>
</tr>
<tr>
<td>4</td>
<td>SEG POL_I - BSWA - 0024</td>
<td>Small bearing support spacer</td>
<td>1</td>
</tr>
</tbody>
</table>

Mass = 14.53g (Information only)
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining.
3. For further details refer 3D model.
4. All sharp corners should be chamfered 0.5X45°

Mass = 3.77g (Information only)

INDIA TMT COORDINATE CENTER

Derlin bush

SECTION C-C
NOTE: Unless otherwise specified:
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining.
3. For further details refer 3D model.
4. All sharp edges should be rounded off.
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining.
3. All sharp edges should be round off.

MATERIAL: Derlin/Aluminium
QUANTITY: 27

Mass = 0.28g (Information only)
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining
3. All sharp edges should be round off

MATERIAL: STAINLESS STEEL
QUANTITY: 3

Mass = 8.23g (Information only)

INDIA TMT COORDINATE CENTER
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining.
3. All sharp edges should be round off.

MATERIAL: STAINLESS STEEL
QUANTITY: 3
Mass = 4.90g (Information only)

INDIA TMT COORDINATE CENTER

WHIFFFLITFLEETHECTURE [MATERIAL: strip A]

SEG POL. I - BSWA - 0025
SIZE: A3
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining.
3. All sharp edges should be round off.

MATERIAL: STAINLESS STEEL 304
QUANTITY: 6

Mass = 7.59g (Information only)
**Mass = 5369.20g (Information only)**

**QUANTITY: 3**

<table>
<thead>
<tr>
<th>QUANITY</th>
<th>ITEM</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Wheel shaft</td>
<td>SEG POL I - BSMA - 0028</td>
</tr>
<tr>
<td>2</td>
<td>WASHER M12</td>
<td>Std (BOUGHT OUT)</td>
</tr>
<tr>
<td>3</td>
<td>WHEEL</td>
<td>SEG POL I - BSMA - 0030</td>
</tr>
<tr>
<td>4</td>
<td>CIRCLIP DIA 11</td>
<td>Std (BOUGHT OUT)</td>
</tr>
<tr>
<td>5</td>
<td>Wheel shaft support (weldment)</td>
<td>SEG POL I - BSMA - 0029</td>
</tr>
</tbody>
</table>

**QUANTITY: 3**

<table>
<thead>
<tr>
<th>QUANITY</th>
<th>ITEM</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>socket head M6x40</td>
<td>To connect wheel shaft to base wheel shaft support</td>
</tr>
<tr>
<td>2</td>
<td>M6 WASHER &amp; Nut6</td>
<td>Std (BOUGHT OUT)</td>
</tr>
<tr>
<td>3</td>
<td>WHEEL SEG POL I - BSMA - 0030</td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>CIRCLIP DIA 11</td>
<td>Std (BOUGHT OUT)</td>
</tr>
<tr>
<td>5</td>
<td>Wheel shaft support (weldment)</td>
<td>SEG POL I - BSMA - 0029</td>
</tr>
</tbody>
</table>

**INDIA TMT COORDINATE CENTER**

**Mirror support & Aresting Mechanism**

**Title**

**Date**

**Drawing No.**

**Sheet No.**

**Dimension**

**Drawing Scale**

**Drawing revision**

**Approval by**

**Checked by**

**Designed by**

**Prepared by**

**Drawn by**

**Controlled by**
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining.
3. For further details refer 3D model.
4. All sharp edges should be round off.

MATERIAL: STAINLESS STEEL
QUANTITY: 3
Mass = 3782.65g (Information only)

<table>
<thead>
<tr>
<th>ITEM NO.</th>
<th>QTY.</th>
<th>DESCRIPTION</th>
<th>LENGTH</th>
</tr>
</thead>
<tbody>
<tr>
<td>11</td>
<td>1</td>
<td>Base plate</td>
<td></td>
</tr>
<tr>
<td>21</td>
<td>1</td>
<td>C channel 125X65X6X8</td>
<td>4.19</td>
</tr>
<tr>
<td>31</td>
<td>1</td>
<td>Top plate</td>
<td></td>
</tr>
</tbody>
</table>
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining.
3. For further details refer 3D model.
4. All sharp edges should be round off.

ISOMETRIC VIEW

Wheel shaft

MATERIAL: STAINLESS STEEL
QUANTITY: 3

Mass = 1249.79g (Information only)
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining.
3. All sharp edges should be rounded off.

MATERIAL: Nylon/PU
QUANTITY: 6
Mass = 163.88g (Information only)
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining.
3. For further details refer 3D model.
4. All sharp edges should be round off.

QUANTITY: 3

INDIA TMT COORDINATE CENTER

Caster wheel

DWG NO. SEG POL_I - BSCWA - 003 SIZE - A3

1. Socket head bolt M6x18 to connect caster wheel support to base support 12
2. M6 Washer & Nut 12

15 INCH CASTER WHEEL Std. Bought out 1
2 Caster wheel support SEG POL_I - BSCWA - 0032 1
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining
3. For further details refer 3D model
4. All sharp edges should be round off

MATERIAL: MILD STEEL
QUANTITY: 3

INDIA TMT COORDINATE CENTER
Caster wheel support (weldment)

<table>
<thead>
<tr>
<th>ITEM NO.</th>
<th>QTY.</th>
<th>DESCRIPTION</th>
<th>LENGTH</th>
</tr>
</thead>
<tbody>
<tr>
<td>12</td>
<td>2</td>
<td>Support plate</td>
<td></td>
</tr>
<tr>
<td>21</td>
<td>3</td>
<td>Std. rec tube 50x50x525</td>
<td></td>
</tr>
</tbody>
</table>

ISOMETRIC VIEW
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining.
3. For further details refer 3D model.
4. All sharp edges should be round off.

ITEM NO./PART NO./DESCRIPTION/QUANTITY

<table>
<thead>
<tr>
<th>ITEM NO.</th>
<th>PART NO.</th>
<th>DESCRIPTION</th>
<th>QTY.</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>SEG POL_I - BSMS - 0035</td>
<td>Cylindrical bar</td>
<td>1</td>
</tr>
<tr>
<td>2</td>
<td>SEG POL_I - BSMS - 0034</td>
<td>Jack Cup</td>
<td>1</td>
</tr>
<tr>
<td>3</td>
<td>SEG POL_I - BSMS - 0036</td>
<td>Base</td>
<td>1</td>
</tr>
<tr>
<td>4</td>
<td>SEG POL_I - BSMS - 0037</td>
<td>Handle</td>
<td>1</td>
</tr>
<tr>
<td>5</td>
<td>Std. (Bought out)</td>
<td>Top washer - washer M10</td>
<td>1</td>
</tr>
<tr>
<td>6</td>
<td>Std. (Bought out)</td>
<td>M20 Lock nut</td>
<td>1</td>
</tr>
<tr>
<td>7</td>
<td>Std. (or) SEG POL_I - BSMS - 0040</td>
<td>Washer M6</td>
<td>1</td>
</tr>
<tr>
<td>8</td>
<td>Std. (Bought out)</td>
<td>Socket head bolt M6x12</td>
<td>1</td>
</tr>
</tbody>
</table>

Mass = 1703.07g (Information only)
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining.
3. For further details refer 3D model.
4. All sharp edges should be round off.

MATERIAL: MILD STEEL
QUANTITY: 6
Mass = 567.17g (Information only)

ISOMETRIC VIEW

Cylindrical Bar

SEG POL I - BSMS - 0034
SIZE - A3
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining.
3. For further details refer 3D model.
4. All sharp edges should be round off.

MATERIAL: MILD STEEL
QUANTITY: 6

Mass = 508.47g (Information only)
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining.
3. For further details refer 3D model.
4. All sharp edges should be rounded off.

MATERIAL: MILD STEEL
QUANTITY: 6
Mass = 589.07g (Information only)
VIEW CV
SCALE 2:1

MATERIAL: MILD STEEL
QUANTITY: 6

Mass = 20.98g (Information only)

HANDLE

CV

scale 2:1
MATERIAL: MILD STEEL
QUANTITY: 6
Mass = 3.55g (Information only)

Top washer (or) washer M10

DEVICES: Axial length +/±0.100
Angular = +/±30'

DIMENSIONS ARE IN MILLIMETERS

20
10.5

MATERIAL: MILD STEEL
QUANTITY: 6
Mass = 3.55g (Information only)
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining.
3. For further details refer 3D model.
4. All sharp edges should be round off.

MATERIAL: STAINLESS STEEL
QUANTITY: 6

Mass = 9.95g (Information only)
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining.
3. All sharp edges should be round off.

MATERIAL: Derlin/Aluminium
QUANTITY: 18
Mass = 0.20g (Information only)

INDIA TMT COORDINATE CENTER
TITLE: Washer M4

DRAWN BY: Viswanatha.N
CHECKED BY: Sudharsan.K
DATE: 01/01/2020

Sheet 35 of 35
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining.
3. All sharp edges should be round off.

MATERIAL: Derlin/Aluminium

QUANTITY: 9
Mass = 0.34g (Information only)

ISO VIEW
Mass = 1.70g (Information only)

NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining
3. All sharp edges should be round off
NOTE: Unless otherwise specified
1. All dimensions are in mm.
2. Parts shall be free of scratches, dents and gouges after all machining
3. For further details refer 3D model
4. All sharp edges should be round off

MATERIAL: BRASS/STAINLESS STEEL
QUANTITY: 3

Mass = 413.12g (Information only)