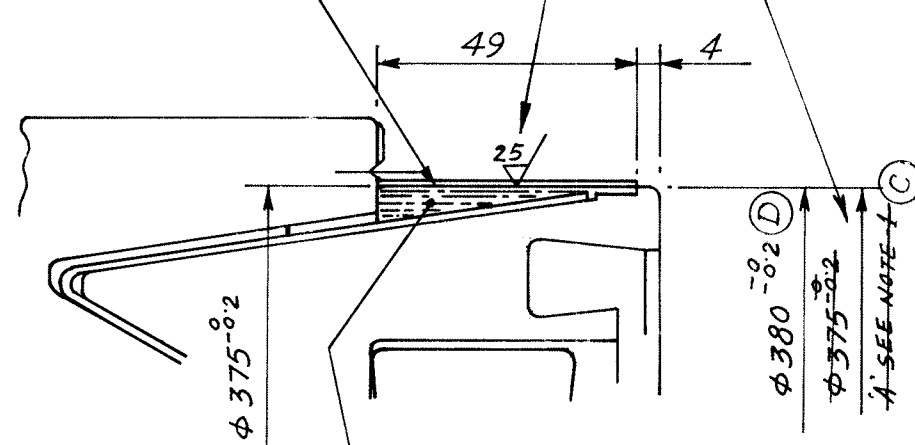


SYM.	DWG. ZONE	REVISIONS	DATE	REV.	CHKD.	RE. DWG.	MTR.	RE. MTR.
D	-	NOTE-1 DELETED AND DIMENSION INCORPORATED. REF: L/NO. EL/TM/2013, DATED- 26-9-98.	13-10-98	BY:CEE/TMD.	-	-	-	-
E	-	NOTE-2 ADDED AND FOR INSERTION OF TEFLON RING MODIFIED. REF: L/NO. EL/TM/2013 Dt. 27.8.01.	29.08.01	BY:CEE/TMD.	-	-	-	-
F	-	NOTE - 3 ADDED REF: L/NO. EL/TM/2013 Dt 29.8.2002	04-9-02	BY:CEE/TMD.	-	-	-	-

MACHINE THE SURFACE OF GLASS-BIND, AND THEN
ROUGHEN THE MACHINED SURFACE WITH EMERY
CLOTH (GRAIN SIZE: # 320)

EVENLY APPLY ADHESIVES
(VARNISH HEW 502N) TO
SLEEVE INSULATION



WIND THE GLASS-BIND UNTIL GETTING STRAIGHT
SURFACE FROM END OF BAR TO V-RING.
THEN CURE THE GLASS BIND (CURING = 130°C x 12 HR)

FIG-4

- E 1. THE SUPPLIER SHALL INDICATE THE THICKER END OF THE RING BY (COLOURED/BLACK BASED) ADHESIVE STICKER ON GLOSSY (NON-ETCHED) SURFACE.
2. INSERT THE TEFLON RING FROM THICKER SIDE
3. AFTER INSERTION THE ADHESIVE STICKER IS TO BE REMOVED.

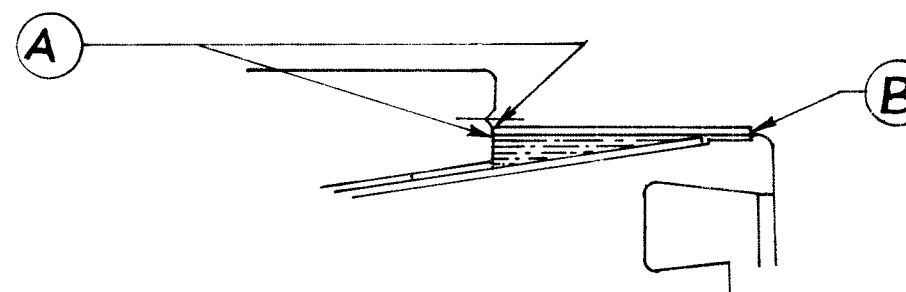
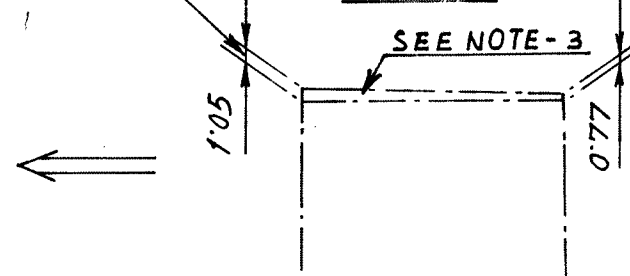


FIG-5

DELIVER THE SHAPED TEFLON RING BENDING INSERTED TO PVC
TUBE TO PREVENT THE INNER DIAMETER FROM BEING CONTRACTED.

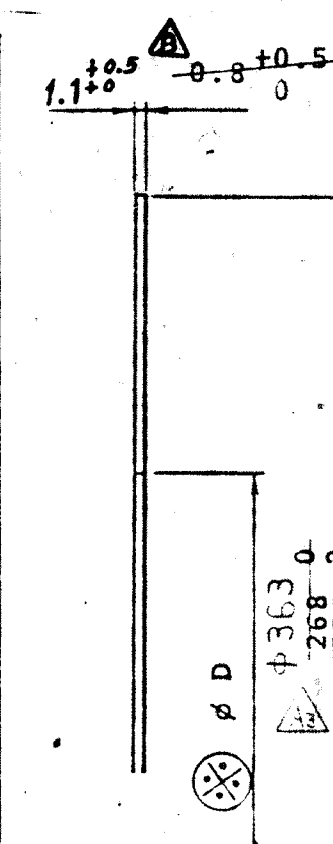


FIG-1 MATERIAL DRAWING

MAKE SURE TO KEEP THIS TOLERANCE

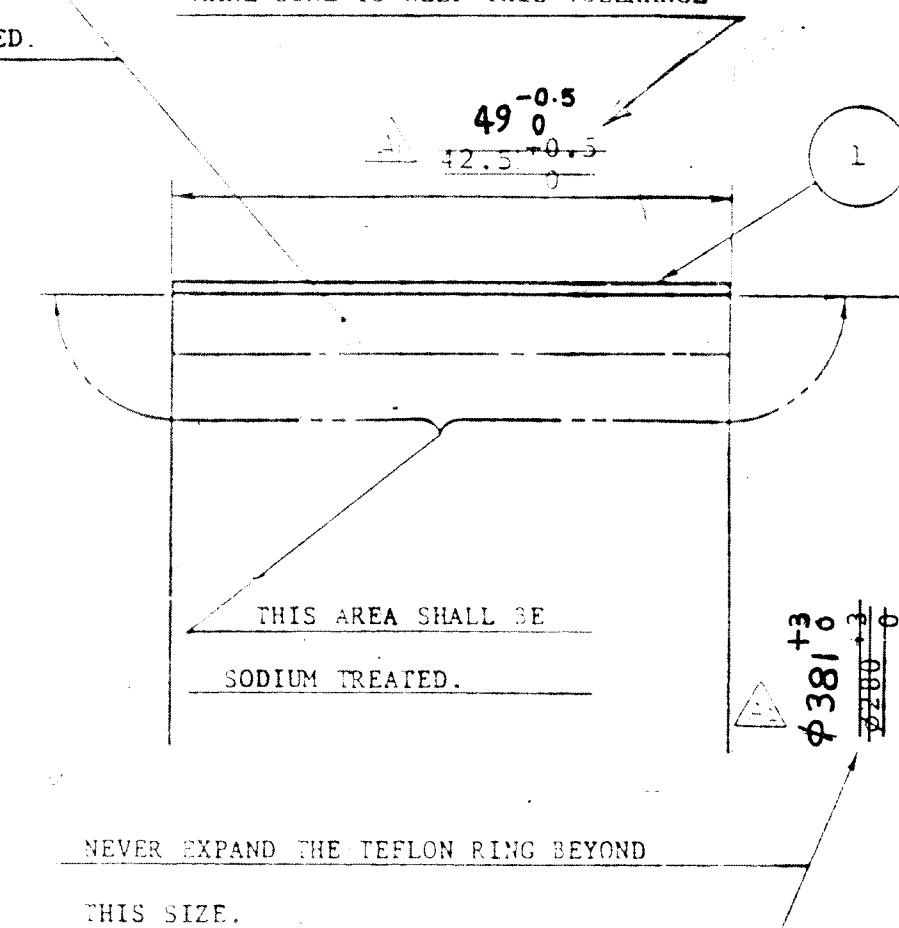
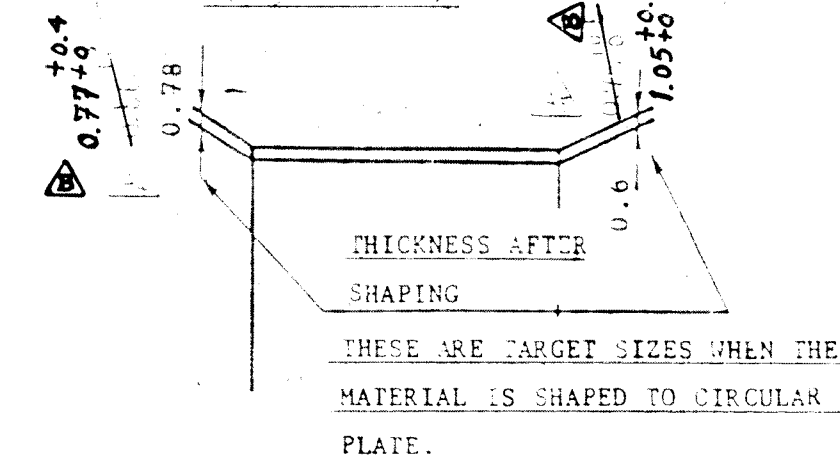
FIG-2 SHAPE DRAWING OF TEFLON RING
(AS DELIVERED)

FIG-3

INSTRUCTIONS FOR TEFLON RING INSERTION

- AS SHOWN ABOVE, LAP THE TAPE (EGT 0.18 x 19) WHILE APPLYING ADHESIVES (VARNISH HEW 502N). CARE SHALL BE TAKEN TO MINIMIZE SURFACE ROUGHNESS. BEFORE FITTING TEFLON RING, WORK THE SURFACE OF GLASS-BIND (FIG-4).
- COMPLETELY DECREASE SURFACES TO WHICH TEFLON RING IS ADHERED AND SURFACES WHICH ARE SODIUM TREATED
- EVENLY APPLY ADHESIVES (VARNISH HEW 502N) TO SLEEVE INSULATION AND INNER SURFACE OF TEFLON RING PARTS.
- REMOVE THE TEFLON RING FROM PVC TUBE, AND INSERT IT INTO COMMUTATOR SLEEVE INSULATION PART.
- HEAT EVENLY AROUND OUTER CIRCUMFERENCE OF TEFLON RING TO SHRINK IT BY HEAT.
- STOP HEATING WHEN THE TEFLON RING SHRINKS COMPLETELY AROUND THE SLEEVE INSULATION PART.
- CURE ADHESIVES (VARNISH HEW 502N) (VARNISH CURING: 130°C x 12HR). AFTER THE ADHESIVE HAS HARDENED, CHECK VISUALY ADHESION OF TEFLON RING.
- CHECK IF THERE IS NO OPENING AT BOTH ENDS OF TEFLON RING (PARTS (A) AND (B)). PARTICULARLY, CHECK PART (A) CAREFULLY. SHOULD ANY OPENING BE FOUND, FILL IT WITH VARNISH (HEW 502N).
- ALTHOUGH THE TEFLON RING IS SHIPPED AS INSERTED TO PVC TUBE, REMOVE THE TEFLON RING FROM THE TUBE IMMEDIATELY BEFORE INSERTING INTO THE SLEEVE INSULATION PARTS SINCE THE RING CONTRACTS IN RADIUS DIRECTION.

NOTE :-

- D C 1. DIMENSION 'A' SHOULD BE i) 375-0.2 FOR COMMUTATOR ASSLY TO DRG NO. 100745-376
ii) 380-0.2 FOR COMMUTATOR ASSLY TO DRG NO. 2740-095-051
- E 2. THE SUPPLIER SHALL INDICATE THE THICKER END OF THE RING BY (COLOURED/BLACK BASED) ADHESIVE STICKER ON GLOSSY (NON-ETCHED) SURFACE
- F 3. MANUFACTURERS IDENTIFICATION TO BE STAMPED AT THE LOCATION SHOWN.

INSTRUCTIONS TO PROCESS THE TEFLON RING (BY MANUFACTURER)

- EXPAND A CIRCULAR SHAPED TEFLON RING (BY MANUFACTURER) SHOWN IN FIG. 1 MATERIAL DRAWING (* 3D SHALL BE DETERMINED BY THE MANUFACTURER) TO THE SHAPE SHOWN IN FIG. 2. DELIVER IT AS BEING INSERTED TO PVC TUBE.
- THROUGHLY ROUGHEN THE INNER CIRCUMFERENCE OF TEFLON RING AND SODIUM TREAT IT.
- SODIUM TREATMENT SHALL BE APPLIED EVENLY. CARE SHALL BE TAKEN NOT TO HAVE GREASE OR DUST ON SODIUM TREATED SURFACE.
- WHILE PACKING AND HANDLING, CARE SHALL BE TAKEN NO TO DAMAGE ANY SURFACE OF TEFLON RING.
- THE TEFLON RING SHALL BE STORED AND HANDLED WITH CARE NOT TO EXPOSE IT TO ULTRAVIOLET RAYS WHICH WILL DETRIORATE THE SODIUM TREATED SURFACE.
- SINCE THE PRODUCT IS SHAPED FROM THE CIRCULAR SHAPE SHOWN IN FIG. 1 TO THE ONE IN FIG. 2, THICKNESS OF THE TEFLON RING VARIES ON BOTH SIDES. MAKE SURE TO ATTAIN TARGET SIZES IN FIG. 3.

TEFLON RING		PT.FE		(POLY-TETRA FLUORO ETHYLENE RESIN)	
PARTS NAME		NO. OF SAME JPT. RAW		SPECIFI- RAW FINISHED	
MATERIAL		MATERIAL		WEIGHT OF MATERIAL	
DWN. J. Nemo		86.12.25		THIRD	
CHKD. M. Alakuma		87.01.09		ANG. PROJ.	
APPD. J. Nemo		87.01.09		SCALE 1:1	
Hitachi, Ltd. Tokyo Japan				HITACHI WORKS DWG. NO. 10R812-076	
				REV'D 1/8	