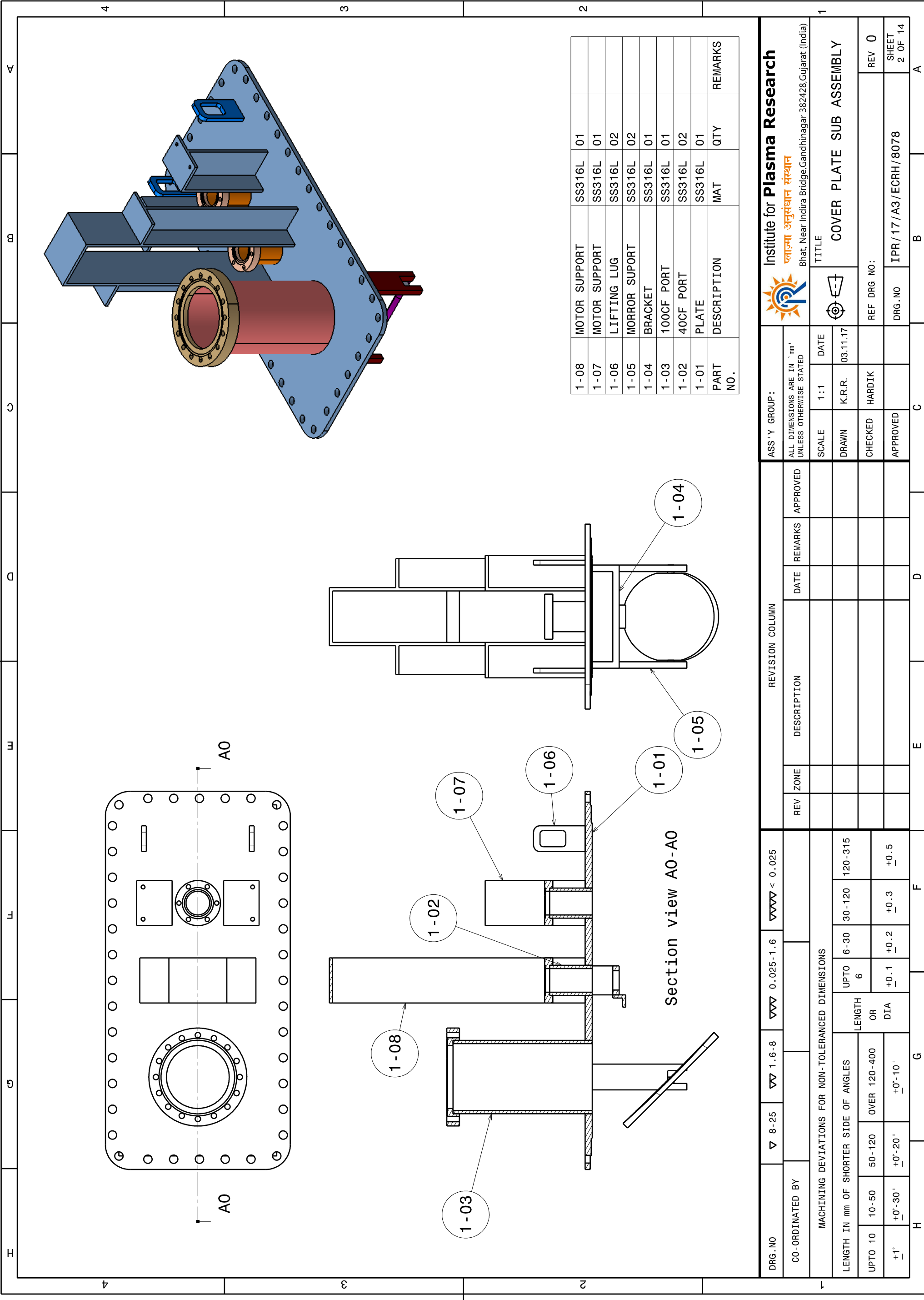


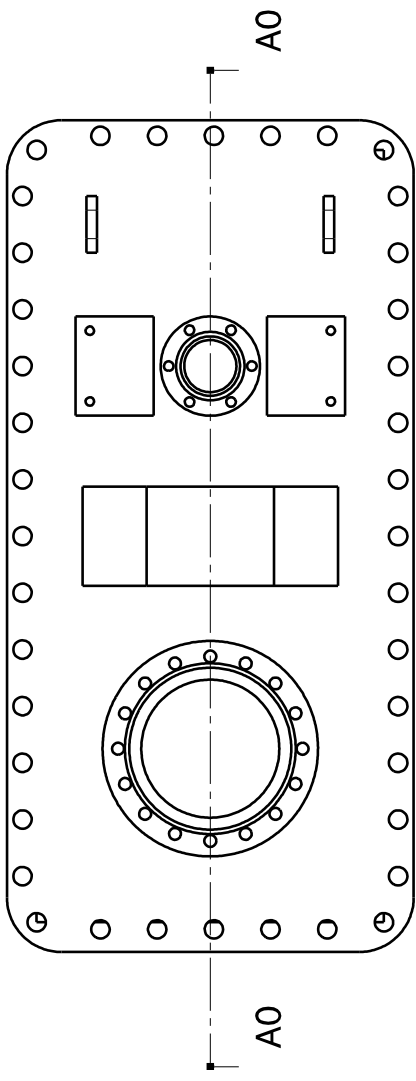
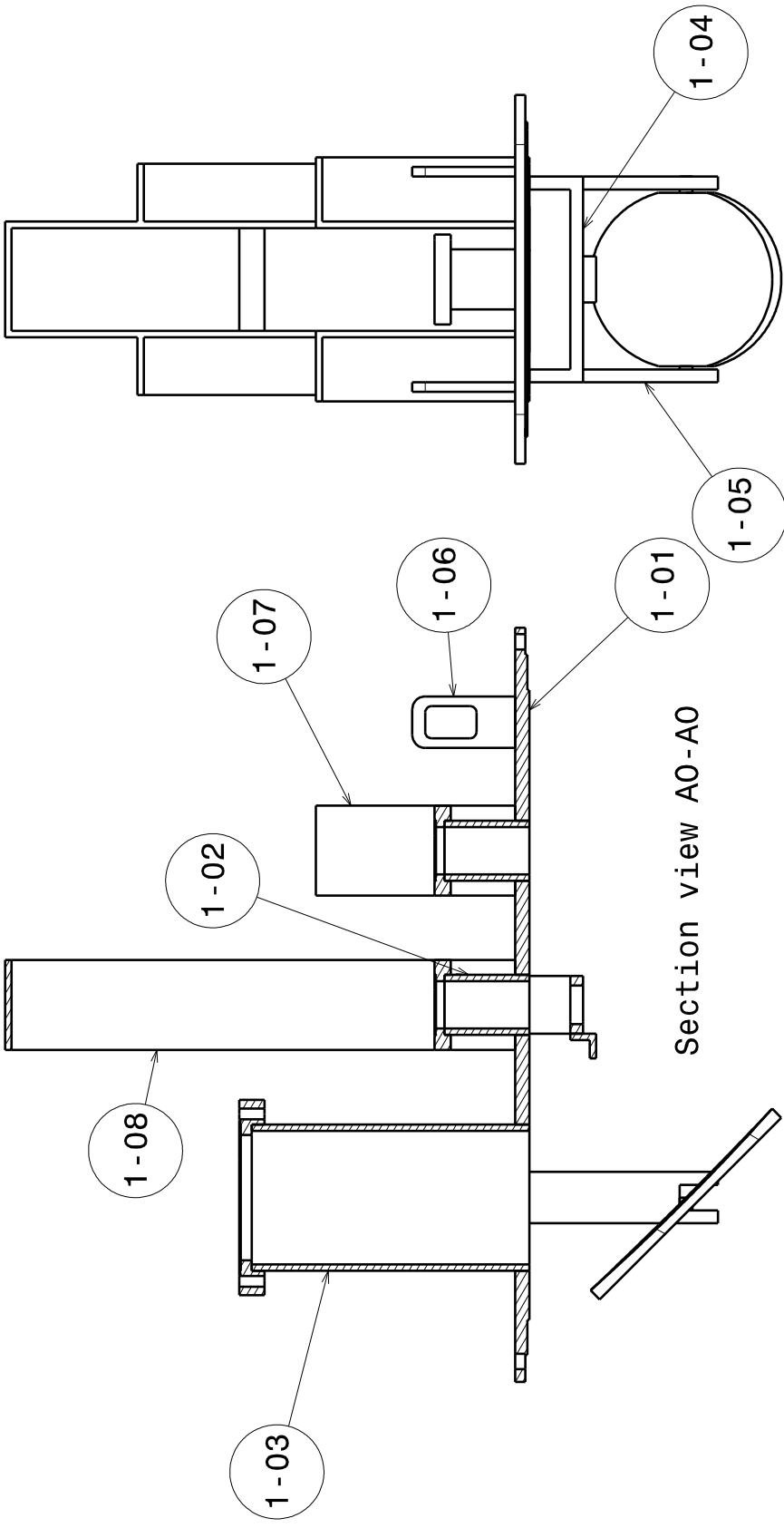
PART NO.	DESCRIPTION	QTY	MAT	REMARKS
21	FOCUSING MIRROR	01	SS316L	
20	ENCODER SCALE	02		AS PER SPEC.
19	ENCODER READ HEAD	02	-	AS PER SPEC.
18	COUPLING	02	-	AS PER SPEC.
17	M4X16 SCREW	01	SS316L/304L	
16	BALL SCREW ASSLY	01		
15	VACUUM CHAMBER SUB ASSLY	01		
14	M4 HEX NUT	02	SS316L/304L	
13	BUSH	01	CERAMIC	
12	CERAMIC BEARING	04		AS PER SPEC.
11	MOTOR-2			AS PER SPEC.
10	MOTOR-1	01		AS PER SPEC.
9	MOTOR SUPPORT	01	SS316L	
8	SPUR GEAR	02	-	AS PER SPEC.
7	LINK	01	SS316L	
6	REFLECTING MIRROR	01	SS316L	
5	BRACKET	01	SS316L	
4	PUSH POLE ROD SUB ASSLY	01		
3	ROTOR FEEDTHROUGH	01		AS PER SPEC.
2	BELLOW	01		AS PER SPEC.
1	COVER PLATE SUB ASSLY	01		

DRG.NO		▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN		ASS'Y GROUP:		Institute for Plasma Research પ્લાઝ્મા અભ્યુસંધાન સંસ્થાન Bhat, Near Indira Bridge, Gandhinagar, 382428, Gujarat (India)	
CO-ORDINATED BY						REV ZONE	DESCRIPTION	DATE	REMARKS	APPROVED	TITLE
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS											LAUNCHER ASSEMBLY
LENGTH IN mm OF SHORTER SIDE OF ANGLES											REF DRG NO:
UPTO 10	10-50	50-120	OVER 120-400								REV 0
+1°	+0°-30'	+0°-20'	+0°-10'								SHEET 1 OF 14
											DRG.NO IPR/17/A3/ECRH/8078
											SCALE 1:1
											DATE 03.11.17
											K.R.R.

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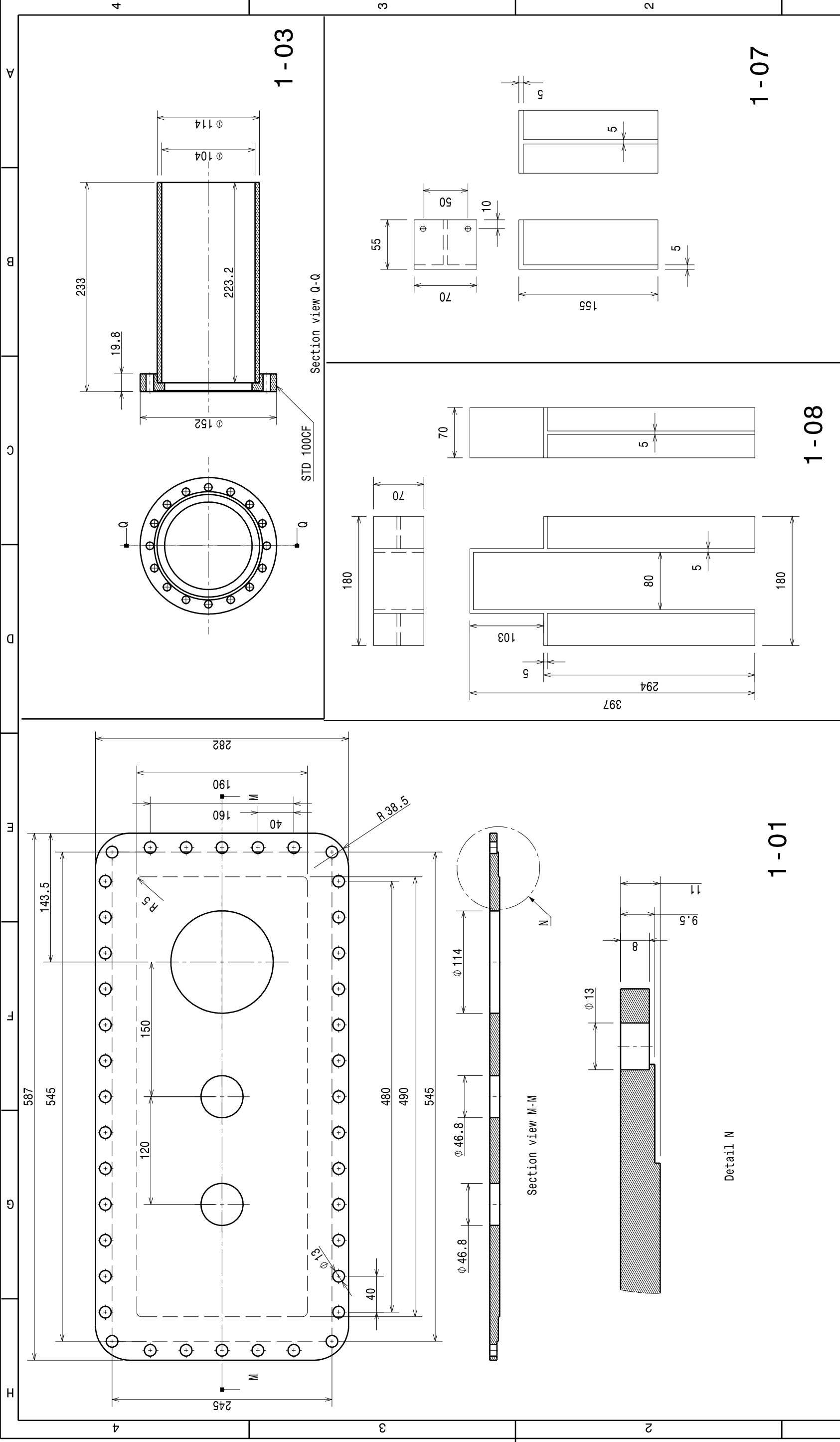


PART NO.	DESCRIPTION	MAT	QTY	REMARKS
1-08	MOTOR SUPPORT	SS316L	01	
1-07	MOTOR SUPPORT	SS316L	01	
1-06	LIFTING LUG	SS316L	02	
1-05	MORROR SUPORT	SS316L	02	
1-04	BRACKET	SS316L	01	
1-03	100CF PORT	SS316L	01	
1-02	40CF PORT	SS316L	02	
1-01	PLATE	SS316L	01	



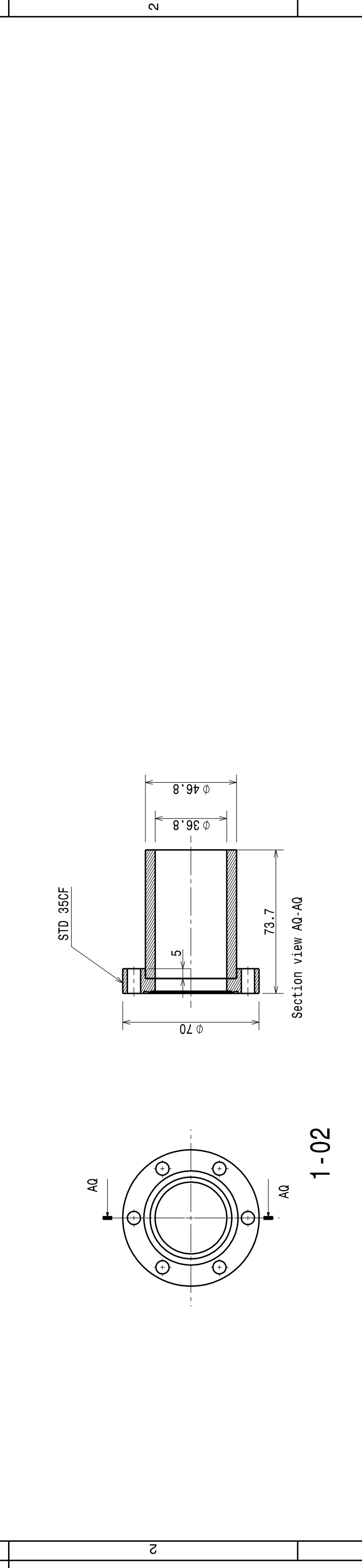
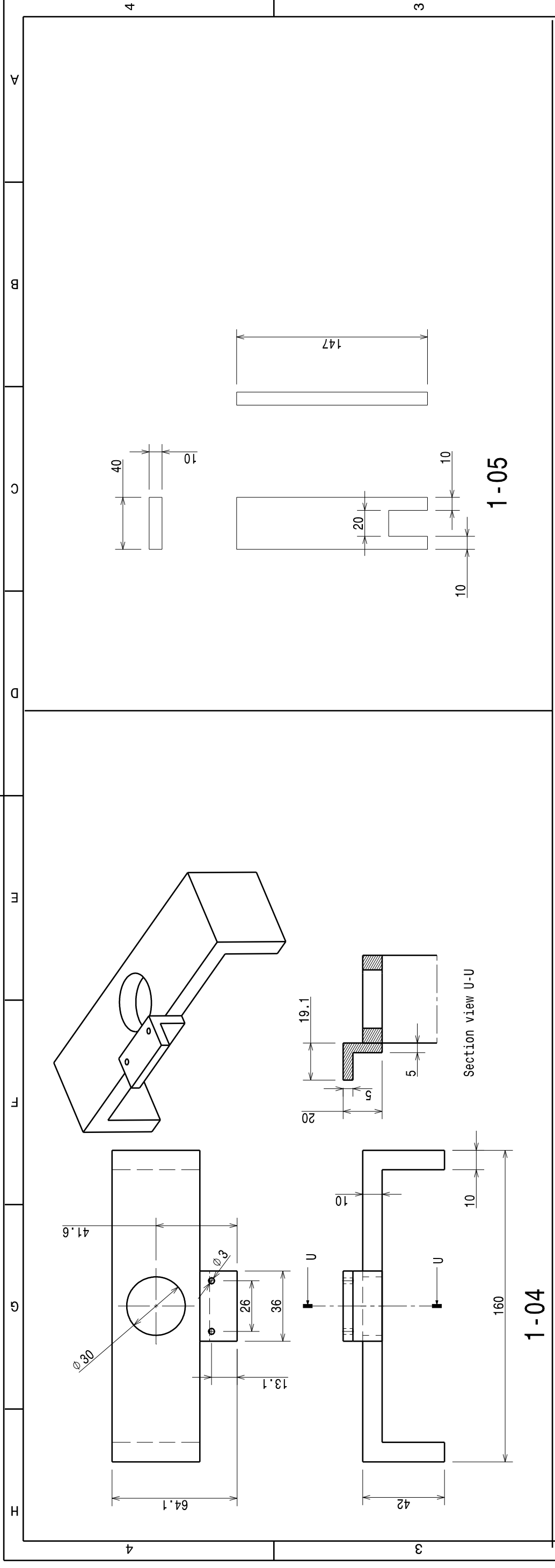
DRG. NO	CO-ORDINATED BY	▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN	ASS'Y GROUP:
						REV ZONE	ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED
						DATE	SCALE 1:1
						DESCRIPTION	DATE 03.11.17
						REMARKS	TITLE COVER PLATE SUB ASSEMBLY
						APPROVED	REF DRG NO:
						APPROVED	DRG. NO
						APPROVED	REV 0
						APPROVED	SHEET 2 OF 14

Institute for Plasma Research
 ભાતમાં અણુસંશ્લેષણ સંસ્થા
 Bhat, Near Indira Bridge, Gandhinagar 382428, Gujarat (India)



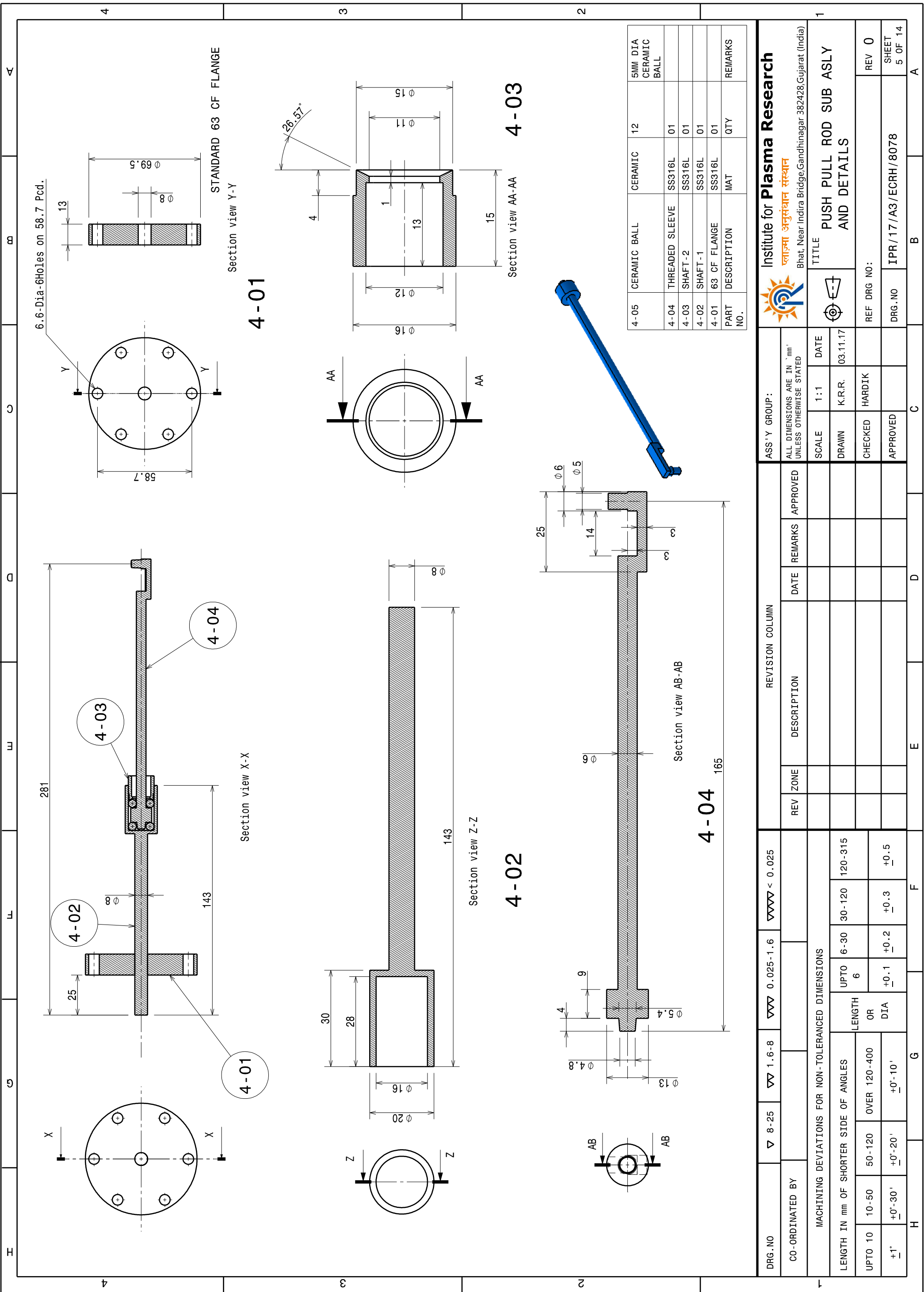
DRG. NO	▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN		ASS'Y GROUP:		Institute for Plasma Research ભાવનગર અણુસંશોધન સંસ્થા Bhat, Near Indira Bridge, Gandhinagar, 382428, Gujarat (India)				
CO-ORDINATED BY					REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED	ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED		
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS LENGTH IN mm OF SHORTER SIDE OF ANGLES					UPTO	6	6-30	30-120	120-315	SCALE	1:1	DATE	01/08/17
					10	50-120	OVER 120-400	OR	DIA	LENGTH	DRAWN	K.R.R.	CHECKED
+1	+0'-30'	+0'-20'	+0'-10'	+0'-10'	+0.1	+0.2	+0.3	+0.5		APPROVED	DRG. NO	IPR/17/A3/ECRH/8078	REV 0
											TITLE COVER PLATE DETAILS		SHEET 3 OF 14

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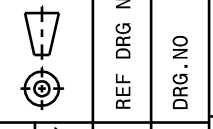


DRG.NO		CO-ORDINATED BY		▽ 8-25		▽ 1.6-8		▽ 0.025-1.6		▽▽▽ < 0.025		REVISION COLUMN		ASS'Y GROUP:		Institute for Plasma Research ભાટ નીચે અમુરસદાપ સંસ્થા Bhat, Near Indira Bridge, Gandhinagar 382428, Gujarat (India)		TITLE		COVER PLATE SUB. ASLY DETAILS			
LENGTH IN mm OF SHORTER SIDE OF ANGLES		LENGTH OR DIA		UPTO 6		6-30		30-120		120-315		REV		DATE		SCALE		DRAWN		CHECKED		APPROVED	
UPTO 10		10-50		50-120		OVER 120-400		+0.1		+0.2		+0.3		+0.5		1:1		K.R.R.		HARDIK		REF DRG NO:	
+1'		+0'-30'		+0'-20'		+0'-10'																IPR/17/A3/ECRH/8078	
+1'		+0'-30'		+0'-20'		+0'-10'																REV 0	
																						SHEET 4 OF 14	

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 Bhat, Near Indira Bridge, Gandhinagar 382428, Gujarat (India)



TITLE
PUSH PULL ROD SUB ASLY AND DETAILS

REF DRG NO:
 IPR/17/A3/ECRH/8078

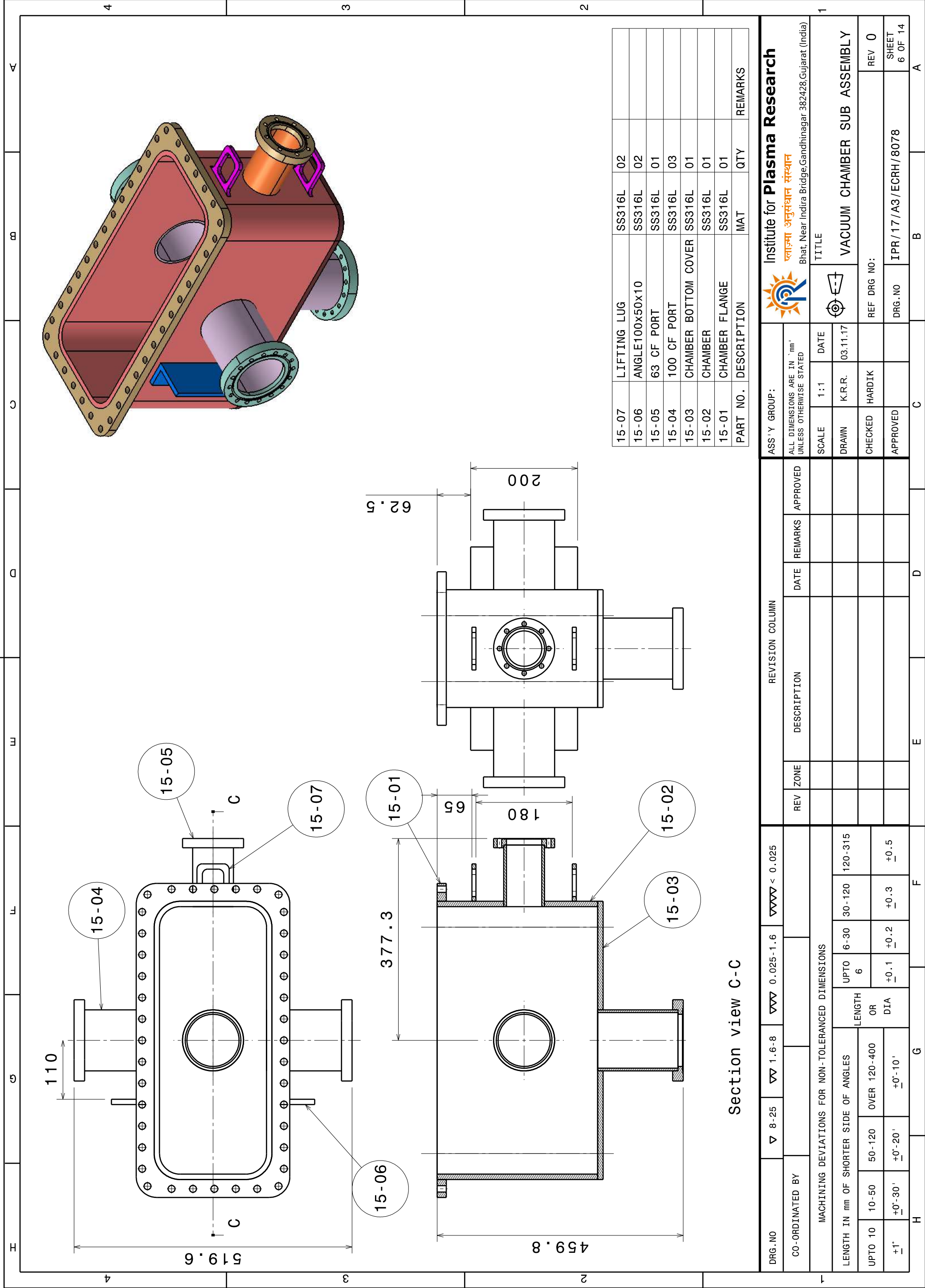
REV 0
 SHEET 5 OF 14

ASS'Y GROUP:		ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED	
SCALE	1:1	DATE	03.11.17
DRAWN	K.R.R.	CHECKED	HARDIK
APPROVED			

REVISION COLUMN		DATE	REMARKS	APPROVED
REV	ZONE	DESCRIPTION		

DRG. NO	CO-ORDINATED BY	▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	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	6-30	30-120	120-315	
+1°	+0°-30'	+0°-20'	+0°-10'			+0.1	+0.2	+0.3	+0.5	

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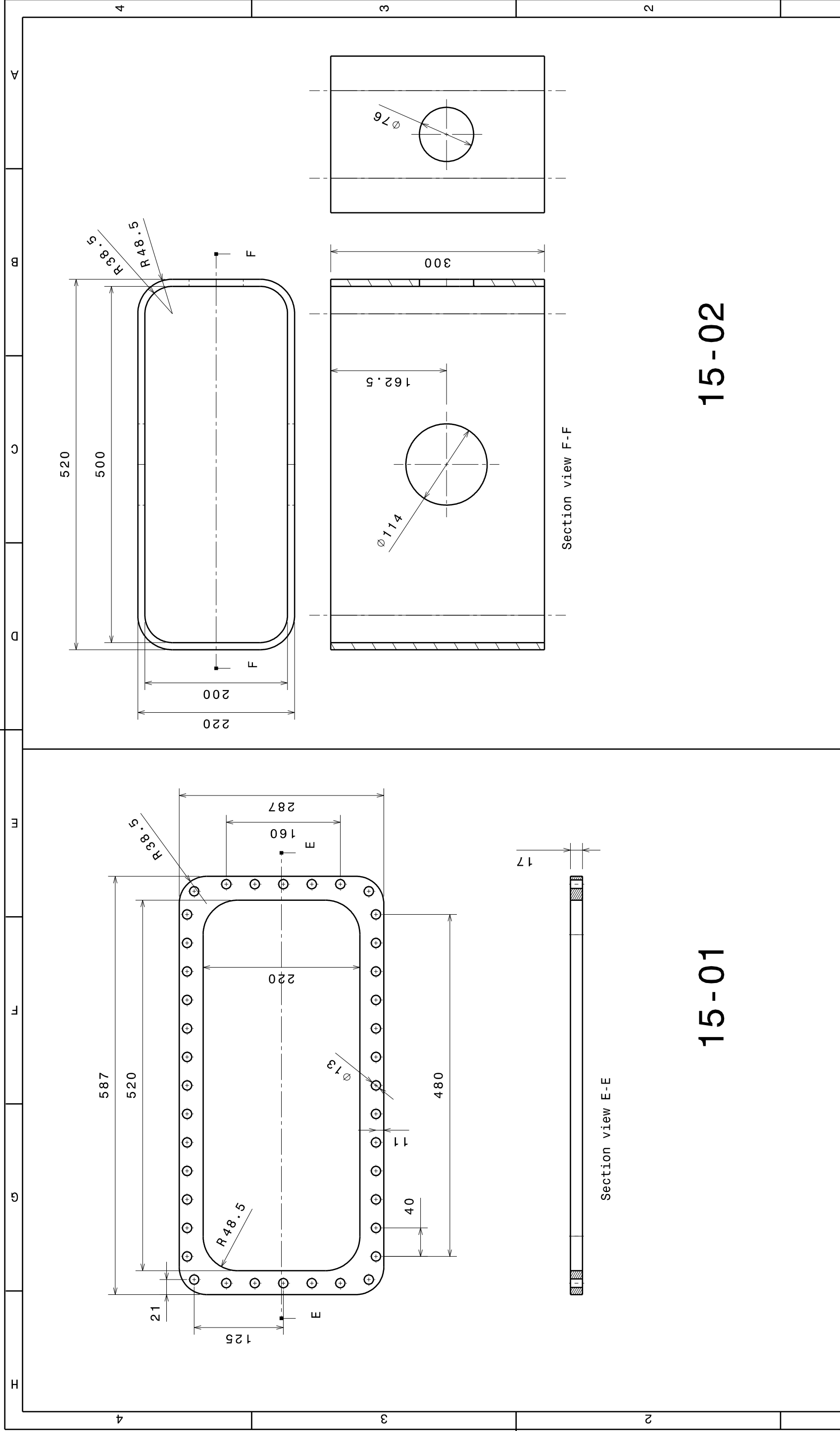
Section view C-C

PART NO.	DESCRIPTION	MAT	QTY	REMARKS
15-07	LIFTING LUG	SS316L	02	
15-06	ANGLE100X50X10	SS316L	02	
15-05	63 CF PORT	SS316L	01	
15-04	100 CF PORT	SS316L	03	
15-03	CHAMBER BOTTOM COVER	SS316L	01	
15-02	CHAMBER	SS316L	01	
15-01	CHAMBER FLANGE	SS316L	01	
		MAT		

DRG. NO	CO-ORDINATED BY	▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN				ASS'Y GROUP:					
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS						REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED	ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED			
LENGTH IN mm OF SHORTER SIDE OF ANGLES		LENGTH OR DIA		TOLERANCE		SCALE	1:1	DATE	DRAWN		K.R.R.		DATE		
UPTO 10	10-50	50-120	OVER 120-400	+0'-30'	+0'-20'	+0'-10'	UPTO 6	6-30	30-120	120-315	120-315	1:1	03.11.17		
+1'							+0.1	+0.2	+0.3	+0.5		CHECKED	HARDIK	REF DRG NO:	
												APPROVED		DRG.-NO	
														IPR/17/A3/ECRH/8078	
														REV 0	
														SHEET 6 OF 14	

Institute for Plasma Research
 ભાવનગર અણુસંશોધન સંસ્થા
 Bhat, Near Indira Bridge, Gandhinagar, 382428, Gujarat (India)

TITLE
VACUUM CHAMBER SUB ASSEMBLY

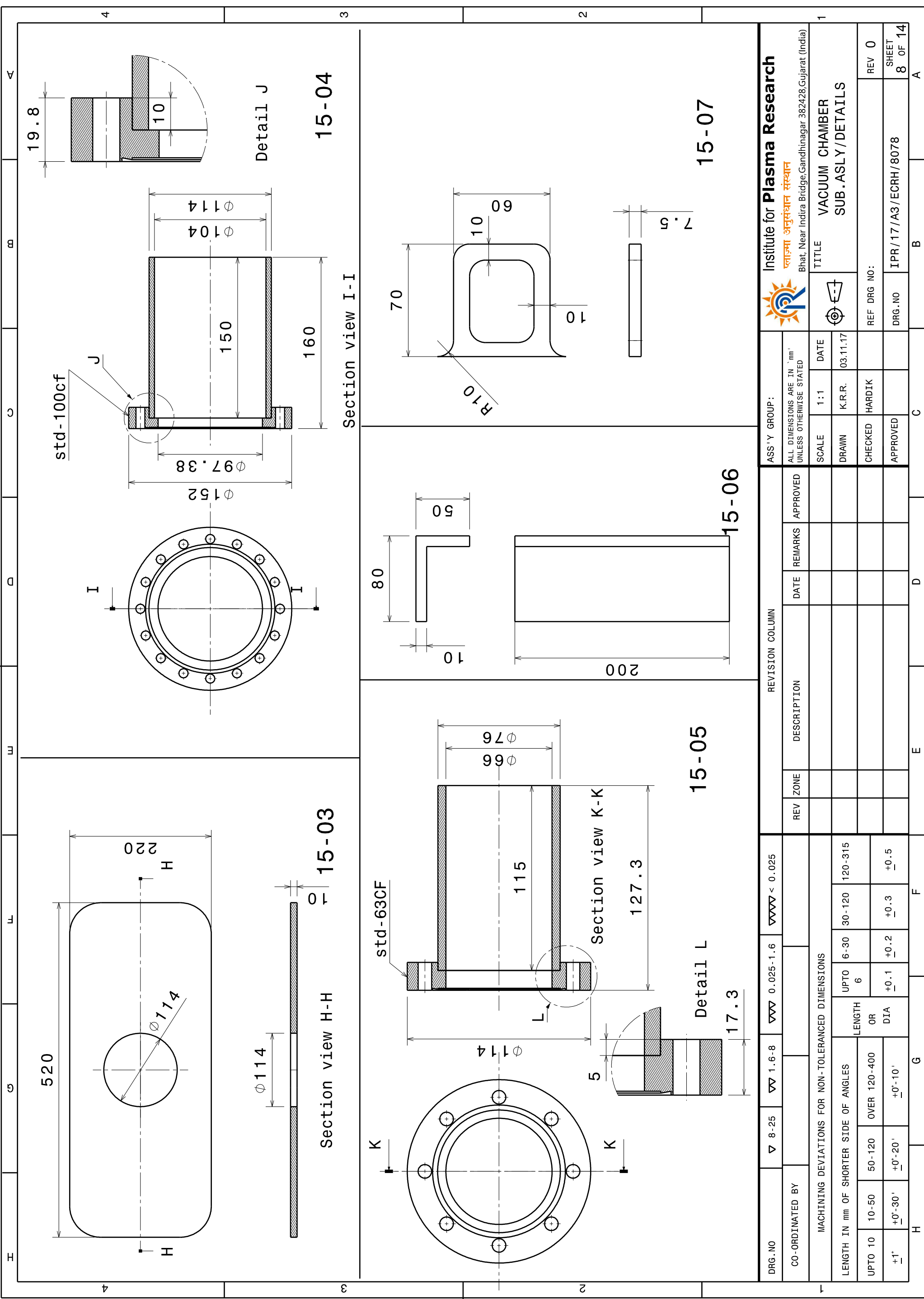


15-01

15-02

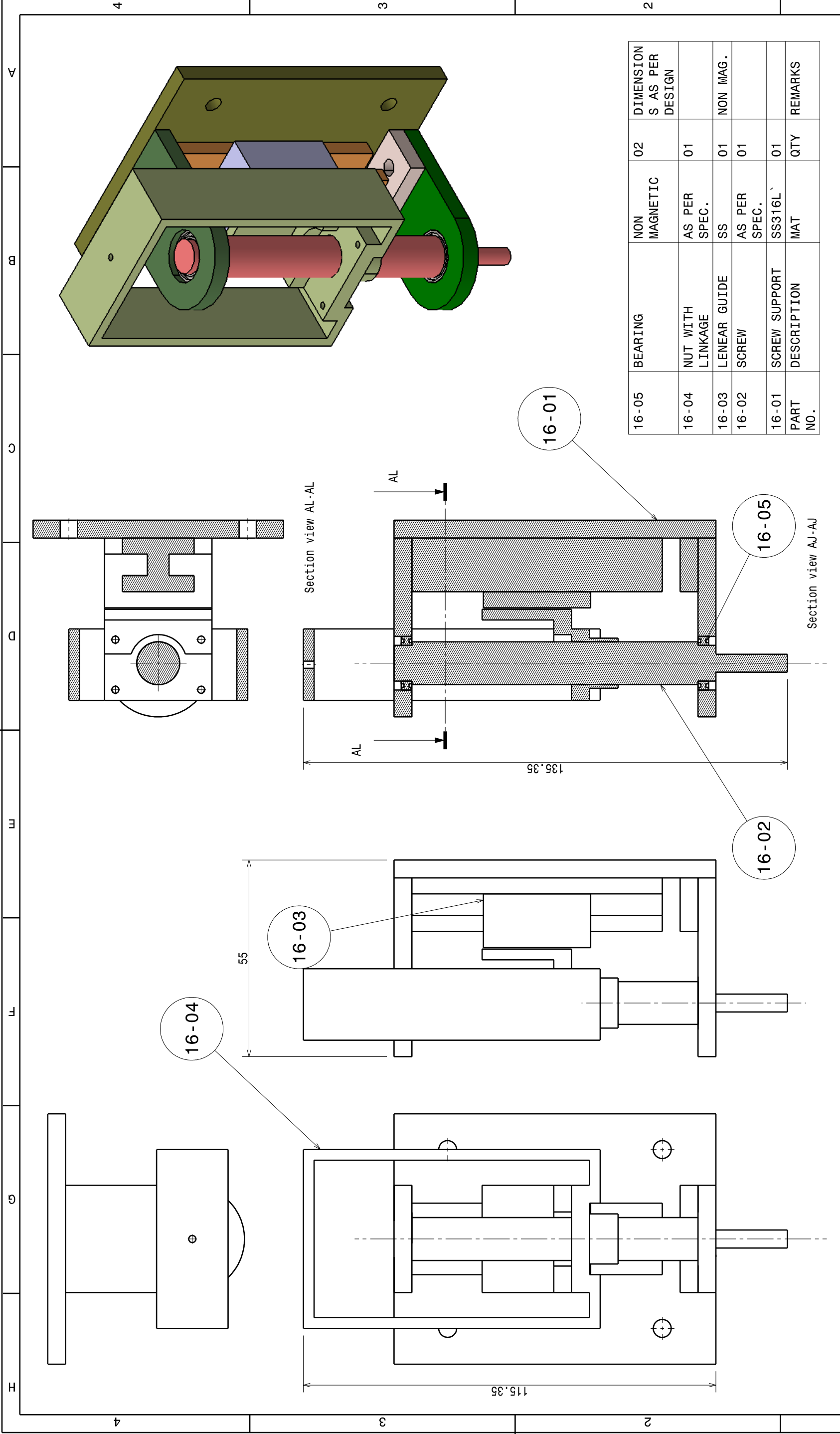
DRG.NO	▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN		ASS'Y GROUP:		Institute for Plasma Research Institute for Plasma Research Bhat, Near Indira Bridge, Gandhinagar 382428, Gujarat (India)		TITLE VACUUM CHAMBER SUB-ASLY/DETAILS		
CO-ORDINATED BY					REV ZONE	DESCRIPTION	DATE	REMARKS	APPROVED	SCALE	DATE	REF DRG NO:	
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS										1:1	03.11.17		
LENGTH IN mm OF SHORTER SIDE OF ANGLES					UPTO 6	30-120	120-315			DRAWN	K.R.R.		REV 0
UPTO 10	10-50	50-120	OVER 120-400		LENGTH OR DIA					CHECKED	HARDIK		SHEET 7 OF 14
+1*	+0*-30'	+0*-20'	+0*-10'							APPROVED		IPR/17/A3/ECRH/8078	
					E		D		C		B		A

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DRG. NO	CO-ORDINATED BY	▽ 8-25	▽ 1.6-8	▽ 0.025-1.6	▽ 0.025	REVISION COLUMN	ASS'Y GROUP:
						REV ZONE	ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED
						DESCRIPTION	SCALE 1:1
						DATE	DATE 03.11.17
						REMARKS	DRAWN K.R.R.
						APPROVED	CHECKED HARDIK
							APPROVED
							REF DRG NO:
							DRG.NO IPR/17/A3/ECRH/8078
							TITLE VACUUM CHAMBER SUB.ASLY/DETAILS
							REV 0
							SHEET 8 OF 14

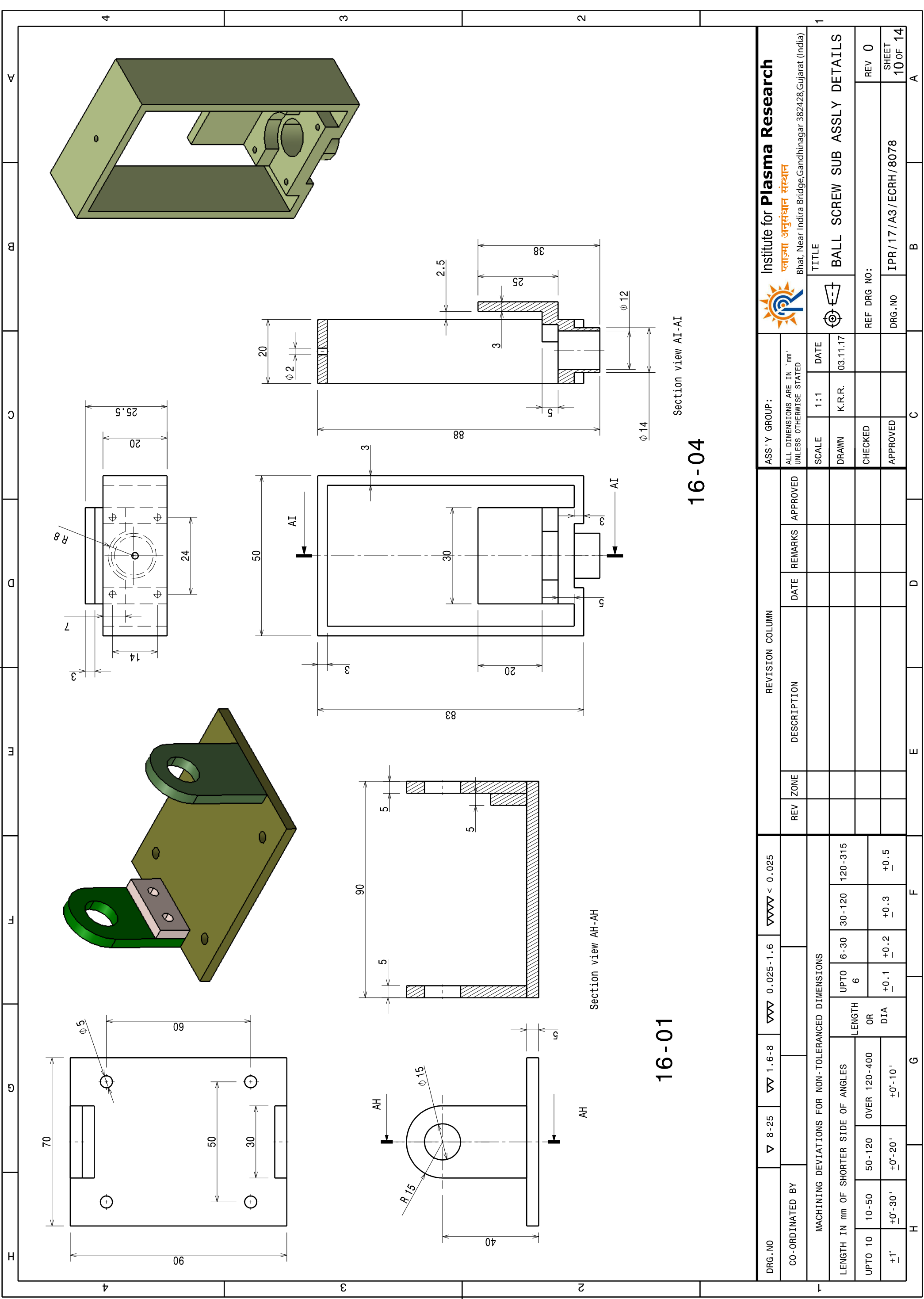
Institute for Plasma Research
 વ્યાજ્ઞા અનુસંધાન સંસ્થા
 Bhat, Near Indira Bridge, Gandhinagar, 382428, Gujarat (India)



PART NO.	DESCRIPTION	MAT	QTY	REMARKS
16-05	BEARING	NON MAGNETIC	02	DIMENSION S AS PER DESIGN
16-04	NUT WITH LINKAGE	AS PER SPEC.	01	
16-03	LENEAR GUIDE	SS	01	NON MAG.
16-02	SCREW	AS PER SPEC.	01	
16-01	SCREW SUPPORT	SS316L	01	

DRG.NO	CO-ORDINATED BY	▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN	ASS'Y GROUP:
						REV ZONE	ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED
						DESCRIPTION	SCALE 1:1
						DATE	DATE 03.11.17
						REMARKS	TITLE BALL SCREW SUB ASLY
						APPROVED	REF DRG NO:
						CHECKED	DRG.NO IPR/17/A3/ECRH/8078
						APPROVED	REV 0
							SHEET 9 OF 14

Institute for Plasma Research
 Institute for Plasma Research
 Bhat, Near Indira Bridge, Gandhinagar, 382428, Gujarat (India)



Section view AI-AI

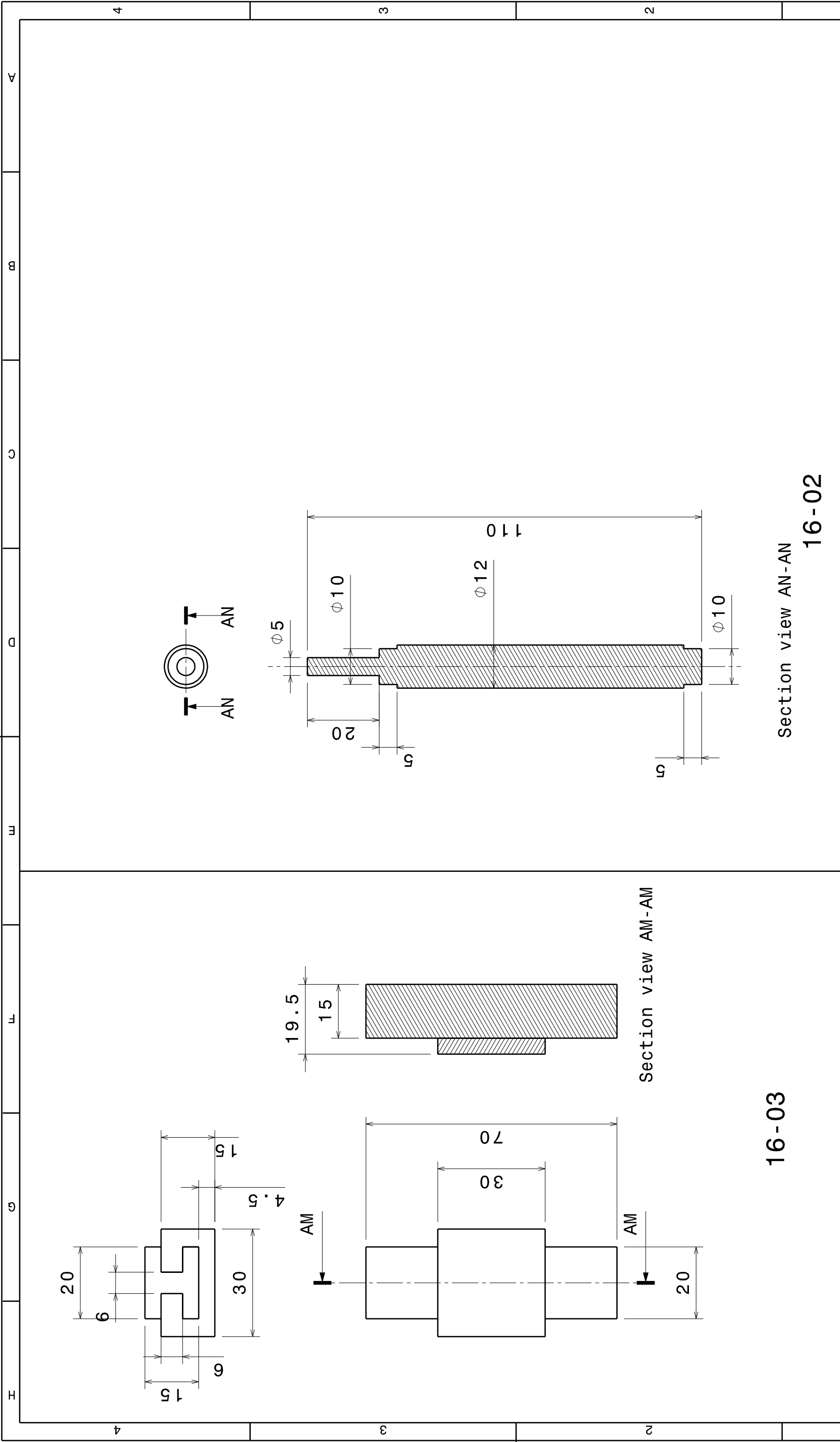
16-04

Section view AH-AH

16-01


DRG. NO	▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN		ASS'Y GROUP:		Institute for Plasma Research પ્લાઝ્મા અનુસંધાન સંસ્થા Bhat, Near Indira Bridge, Gandhinagar 382428, Gujarat (India)		TITLE BALL SCREW SUB ASSLY DETAILS		REV 0	SHEET 10 OF 14	
CO-ORDINATED BY					REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED	SCALE	DATE	REF DRG NO:		
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS											1:1	03.11.17			
LENGTH IN mm OF SHORTER SIDE OF ANGLES		LENGTH OR DIA		TOLERANCE											
UPTO 10	10-50	50-120	OVER 120-400	UPTO 6	6-30	30-120	120-315								
+1°	+0°-30'	+0°-20'	+0°-10'	+0.1	+0.2	+0.3	+0.5								
								APPROVED					IPR/17/A3/ECRH/8078		

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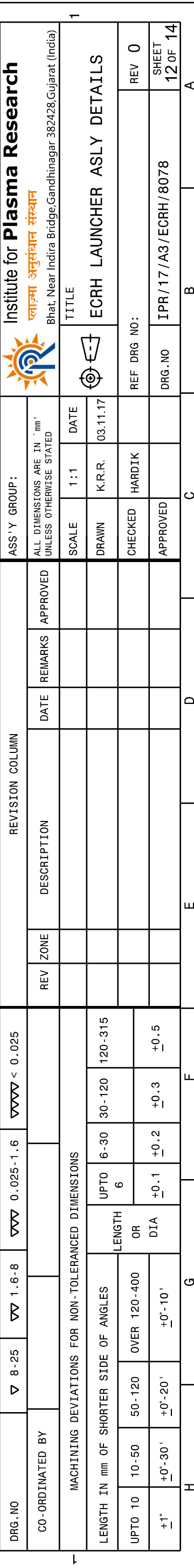
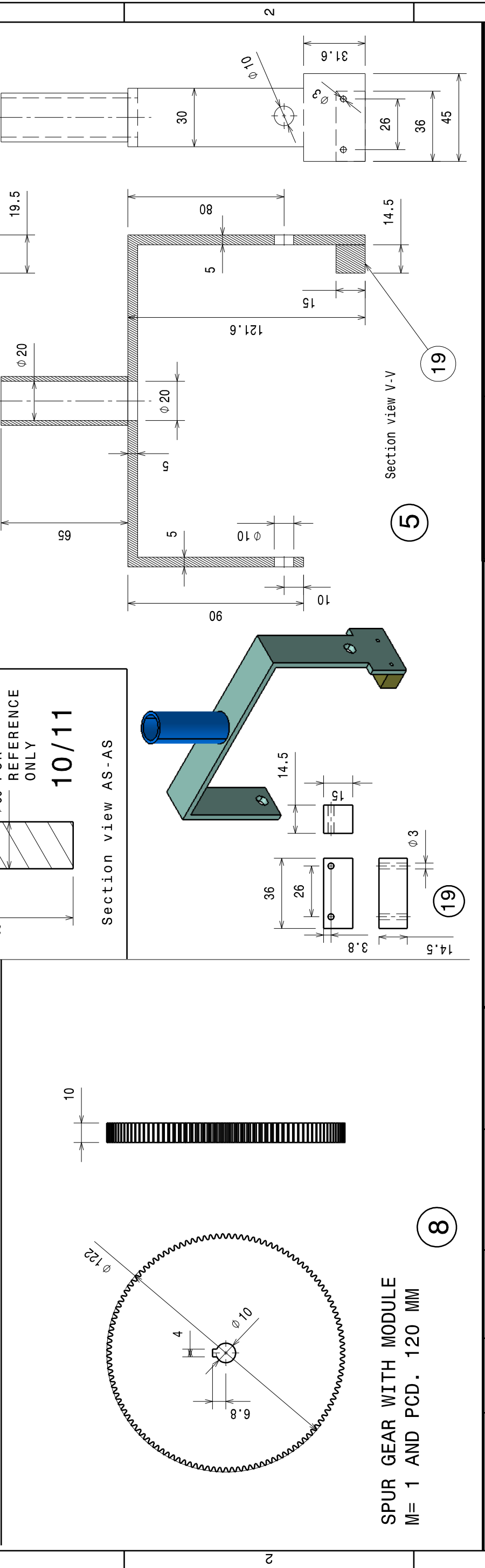
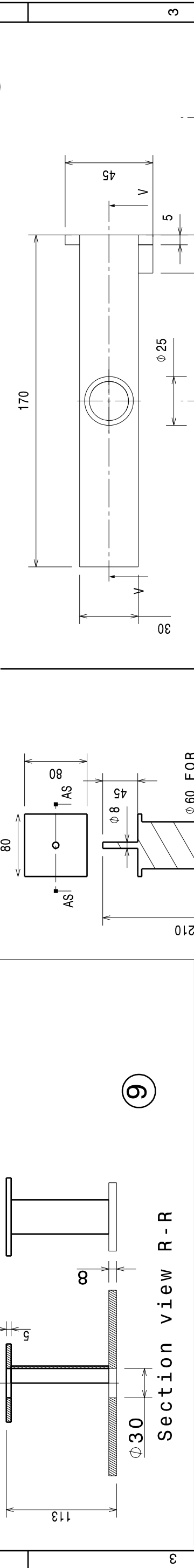
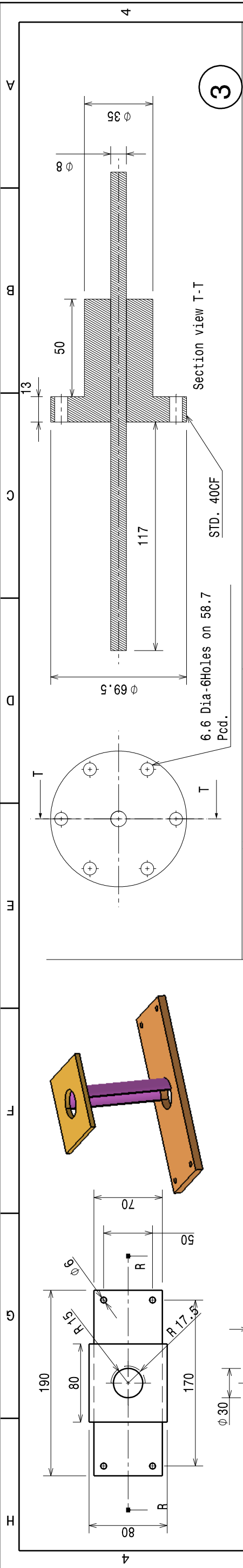


Section view AN-AN
16-02

16-03

DRG.NO	▽ 8-25	▽ 1.6-8	▽ 0.025-1.6	▽ 0.025 < 0.025	REVISION COLUMN		ASS'Y GROUP:		 Institute for Plasma Research ભાતપ્લાઝ્મા અભ્યાસ સંસ્થા Bhat, Near Indira Bridge, Gandhinagar 382428, Gujarat (India)		
CO-ORDINATED BY					REV ZONE	DESCRIPTION	DATE	REMARKS		APPROVED	
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS					REV					ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED	
LENGTH IN mm OF SHORTER SIDE OF ANGLES					UPTO 6	6-30	30-120	120-315	SCALE	1:1	DATE
UPTO 10	10-50	50-120	OVER 120-400		LENGTH			DRAWN	K.R.R.	03.11.17	
+1'	+0'-30'	+0'-20'	+0'-10'		DIA	+0.1	+0.2	CHECKED			TITLE
								APPROVED			BALL SCREW SUB ASSLY DETAILS
											REF DRG NO:
											IPR/17/A3/ECRH/8078
											DRG.NO
											REV 0
											SHEET 11 OF 14
											A

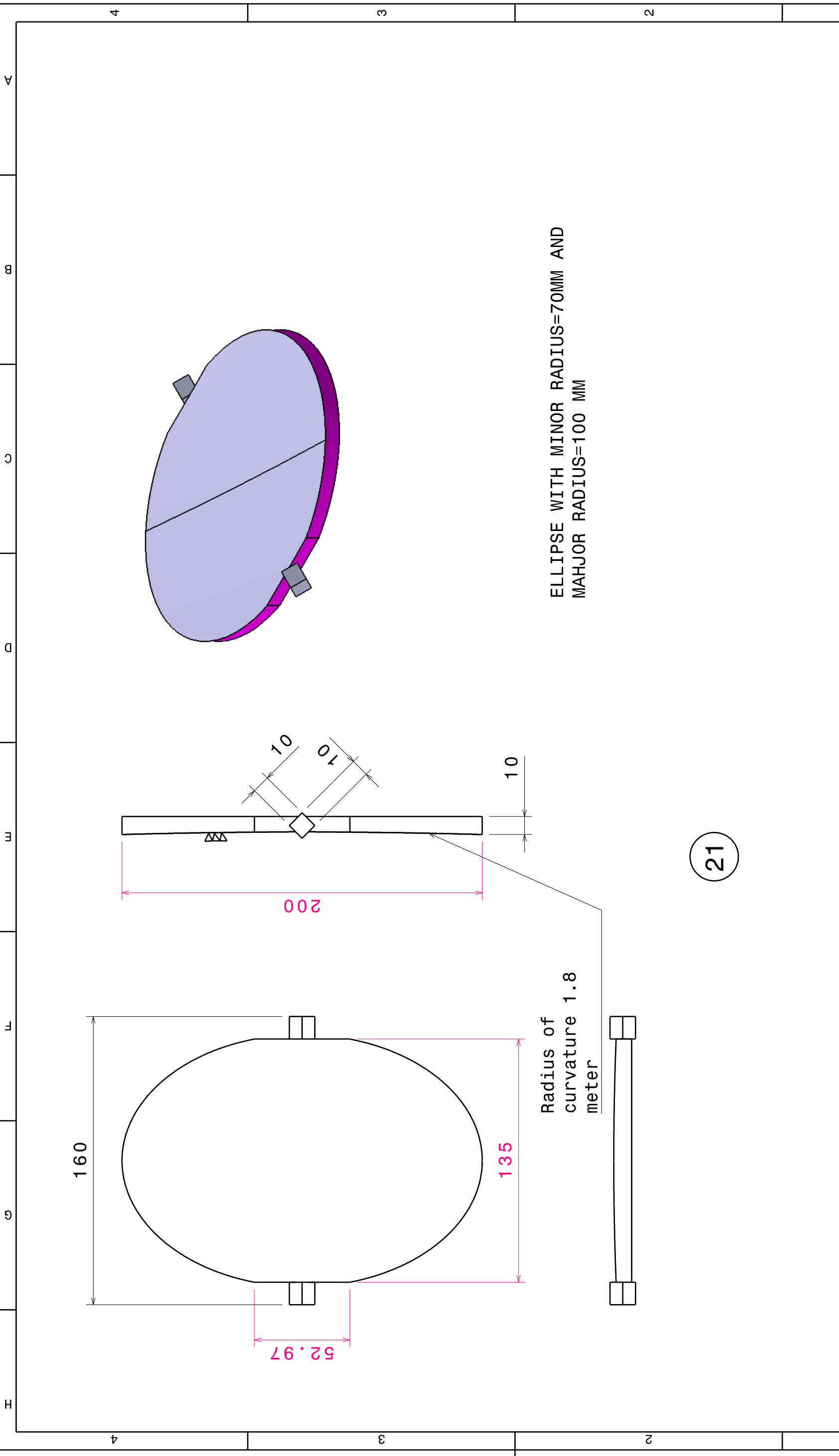
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DRG. NO	CO-ORDINATED BY	▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REV ZONE	DESCRIPTION	DATE	REMARKS	APPROVED

MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS			
LENGTH IN mm OF SHORTER SIDE OF ANGLES	UP TO 6	OR DIA	LENGTH
			UPTO 10
+1'	+0'-30'	+0'-20'	+0'-10'

ASS'Y GROUP:		ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED	
SCALE	DATE	DRAWN	CHECKED
1:1	03.11.17	K.R.R.	HARDIK
TITLE		REF DRG NO:	
ECRH LAUNCHER ASLY DETAILS		IPR/17/A3/ECRH/8078	
DRG. NO		REV 0	
SHEET		12 OF 14	



ELLIPSE WITH MINOR RADIUS=70MM AND MAHJOR RADIUS=100 MM

Radius of curvature 1.8 meter

21

DRG. NO	▽ 8-25	▽ 1.6-8	▽ 0.025-1.6	▽ 0.025 < 0.025	REVISION COLUMN		ASS'Y GROUP:		Institute for Plasma Research प्लाज्मा अनुसंधान संस्थान Bhat, Near Indira Bridge, Gandhinagar, 382428, Gujarat (India)		
CO-ORDINATED BY	MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS				REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED	TITLE LAUNCHER ASSEMBLY DETAILS
LENGTH IN mm OF SHORTER SIDE OF ANGLES	UPTO 10	10-50	50-120	OVER 120-400	LENGTH	OR	DIA	UPTO 6	6-30	30-120	120-315
UPTO 10	+0'-30'	+0'-20'	+0'-10'	+0'-10'							
+1'											
					DATE	SCALE	1:1	DATE	REF DRG NO: IPR/17/A3/ECRH/8078		
					DATE	SCALE	1:1	DATE	DRG. NO IPR/17/A3/ECRH/8078		
					DATE	SCALE	1:1	DATE	SHEET 14 OF 14		