

**SPECIFICATIONS:**

**“ANODIZINGPLANT”**

**Qty. – 01Set.**

**CodeNo.** \_\_\_\_\_

**Scope:** Design, fabrication, manufacturing, supply, installation & commissioning of anodizing plant with prove-out of plant capacity.

**Purpose:** To perform Anodizing on different parts used in mobility aids e.g. Axilla, Walking stick, Tri-pod, Tetra Pod, etc.

S.No.	Description of requirement	Required		
1	Components	Aluminum Parts of Walking Aids like Axilla, Walking stick, Tri-pod, Tetra Pod, etc.		
2	Dimensions of largest component	As per attached drawing, (Max. length of 1300 mm approx.)		
3	Surface Area of Largest component (axilla: side tube)	As per attached drawings		
4	Output Desired	Total 72,000 Components (All sizes) per year i.e. 6000 Nos. per month i.e. 250 Nos. per day.		
5	No. of Parts / Batch	50 Nos.		
6	Tank Section (in mm) (Internal dimension/working area)	Min. 1000W x 1800 L x 1200 H (Single Carrier Bar) at least accommodate 50 nos. largest size parts		
7	Available Floor Space	Max. 23m x 6m		
8	Method of Handling	Component jugged, suspended on Carrier Bar (with GM ‘V’ Blocks) which is carried with help of manually operated Motorized mono-rail crane with ON/OFF switch, forward, reverse, up-down operation		
10	Process Sequence	<b>Process sequence</b>	<b>Temp. (in °C)</b>	<b>Tank MOC</b>
		Load / Unload	-	Steel channel/angles
		Hot soak Degreasing	75-80	SS 316L (thickness : 3.0mm)
		Single Water Rinse	RT	PP Thickness : 20mm(min.)
		Caustic Etching	50	Base material MS thickness: 5mm Fibre glass coating of 3.0mm(min)
		C.F. Rinse	RT	PP Thickness : 20mm(min.)
		De-oxidation	RT	PP Thickness : 20mm(min.)
		C.F. Rinse	RT	PP Thickness : 20mm(min.)
		Anodizing	Below 8 °C	A. Base material : MS thickness : 5mm, Lead lining (inside) thickness : 5mm, FRP(outside) Thickness : 3.0mm Insulation (outside) with Rockwool of thickness : 50mm (density-60kg/m3) B. Cooling Coil (all around except bottom) made of Titanium OD-25.4mm x thickness 0.9mm(min)

		C.F. Rinse	RT
		Nickel Acetate sealing	85-90°C
		Boiling Water Sealing	98-100°C
		Hot air drying	100°C
			PP Thickness : 20mm(min.)
			SS 304 thickness : 3.0 mm
			SS 304 thickness : 3.0 mm
			SS 304 thickness : 3.0 mm
11	Load / Unload stand with 'V' location saddles	Min.1 set (on each tank)	
12	Process tanks made of MS, SS, and PP complete with essential fittings such as thermal insulation, water inlet, drain outlet, overflow/scum chamber/lip type exhaust ducting, 'V' location saddles, anode/cathode supportbars, air agitation coils, heaters, thermocouple.	1 Lot	
12.1	<u>Reinforcement to avoid bulging of tank:-</u> (i) PP Tank:- suitable reinforcement (min.50X 25 mm thick support rib at a distance of maximum 450mm) (ii) MS & SS Tank:- suitable reinforcement (min. 50 X 50 X5 mm thick support rib at a distance of maximum 450mm)	Confirm	
13	<b>COOLING SYSTEM</b>		
13.1	Min.15TR capacity chilling unit (forcoolingand maintaining the temperature of anodizing bath.) The compressor unit shall have 02 years warranty plus 03 years minimum extended warranty.	1 Set	
	A. Both Heat Exchanger & pump (Min. 2 H.P.) is made up of acid resistant materialspecifically <b>SS316L</b> . B. Piping for all connections from tank outlet to chiller unit is made up ofPVC.		
14	Rectifiers: Make: Kraft Powercon/ Munk Rectifier/ Italteco/Jindal	Confirm	
14.1	IGBT solid state rectifier with digital type ammeter, voltmeter & Amp-Min / Amp-Hr. meter, PLC communication air cooled design with AC cooling and remote operated pendant, with PLC hook up facility and voltage ramping profile programmer. Capacity Min. 30Volts / 1000Amps.	1 Set	
15	<b>FILTRATION</b>		
15.1	PP body, plate type filtration units with seal-less magnetic pump, complete with inlet/outlet hoses, pressure gauge, pressure switch for auto cut off, carbon treatment chamber, PP ball valves and PP	1 Set	

	strainer etc. Capacity: 6000 LPH	
16	FUME EXTRACTION SYSTEM	
16.1	Fume Extraction unit fitted with Lip Duct, V belt Driven by 7.5 HP, 3 phase dynamically balanced impeller complete standard unit of capacity for 4500CFM(min) makes: Crompton/ Bharat Bijlee/ Siemens / HindustanPP/FRP water washed Fume Scrubber complete with water spray nozzles, circulation pump, pall Rings, mistelminator and centrifugal seal-less pump. The chimney height should be 15 meter form the ground	1 Set
18	MATERIAL HANDLING SYSTEM	
18.1	Single Work Carrier Bar. DC current with Cu Alloy, 'V' block and lifting arms suitable to operate with monorailon fully automatic operations.	6 Nos.
18.2	Monorail operated Crane 250 kg capacity.	1 No.
18.3	Floor Mounted Structure for above Crane.	1 Lot
18.4	Centralized Control Panel to monitor and control accessories, such as heaters, digital temperature controllers, complete with overload contactors, relay, indicating lamps, ON/OFF switch, starters etc for all items of supply.	1 No.
18.5	Work Platform with FRP gratings with MS strip of 25x5mm thick(min)	1 Lot
19	Post Coating Cleaning	Confirm
20	OTHER REQUIREMENTS	
20.1	Electrical system to be designed for following	
20.1.1	Electrical System: 415 V, 3Phase, 50 Hz supply	Confirm
20.1.2	Protection level: IP 54 or better	Confirm
20.1.3	Complete system to be tropicalized for Indian conditions (up to 50°C and RH 100%)	Confirm
20.2	DM Plant complete with mixed-2500litre per change, TDS less than 1	Confirm
20.3	All civil work / foundation, details and drawings will be required from tenderer within 15 days from the release of PO/WO	Confirm
20.4	ALIMCO will provide power supply till mains panel in the work center, rest all work will be in the scope of tenderer (including panels and cabling for all processes)	Confirm
20.5	Chemicals and consumables required for all processes: for initial make-up and three months maintenance. Chemical's preferred makes: CMP Pvt. Ltd./ Atotech/ Coventya (India)/ Grauer & Weil (I) Ltd./ Artek/ chemetall Rai	Confirm
20.6	Vendor to provide detail of power & air requirement	Confirm
21	ACCESSORIES	

21.1	Turbine Blower (Min. 5 HP, 3 Phase, energy efficient) (For supply of dust & oil free air for agitation in all tanks).	1 Set
21.2	Oil Skimmer (for removal of oil/skim from Degreasing Bath).	Min.1 Set
21.3	Pneumatically operated top cover Lids for Sealing & Drying Tanks.	Min.3 Set
21.4	Hot Air Blower / Radiator (3 Phase, energy efficient) for Drying Tank	Min. 1 Set
21.5	Titanium Jigs (for various components to be anodized).	Min. 20 Nos.
22	SERVICES LINE	
22.1	PP/PVC piping for plain water supply.	1 Lot
22.2	PP/PVC piping for DM water supply.	1 Lot
22.3	PP/PVC piping for chilled water circulation.	1 Lot
22.4	PP/PVC piping for air supply.	1 Lot
22.5	PP/PVC piping for drains & overflows.(min 50 each connecting to 150 mm final drain pipe)	1 Lot
22.6	AC field cabling from Monorail Hoist with cable track / trolley.	1 Lot
22.7	AC field cabling/wiring from control panel to all electrical machines of supply. (with cable tray & support structure)	1 Lot
22.8	Conductive Copper bus bar or cable connections between rectifiers & process tanks with support structure.	1 Lot
22.9	PP/FRP connecting ducts from lip ducts on tanks to Scrubber to Exhaust fans (with support structure).	1 Lot
22.10	PP/FRP chimney with weather cowl (with support structure) 3mtrs. Above factory shed	1 Lot
22.11	Erection & assembly of plant at site.	1 Lot
22.12	Chemical Commissioning with approved sample trials for 7 days of Plant operation.	Confirm
22.13	Vendor has to successfully prove out 5 cycles of Anodizing plating at ALIMCO premises during prove-out. Same shall be verified by ALIMCO.	Confirm
23	For Commissioning of the Plant (preparation of chemical baths & process trials), Vendor shall depute expert chemist to guide operators for min. 2 weeks.	Confirm
24	Operation and Maintenance training at site, after successful installation and commissioning of plant	Min. 15 days
25	Chemicals / Consumables (for Initial Makeup & 3 Months Maintenance)	Confirm
26	Spares for 1 Year Maintenance	
26.1	Monorail Crane	1 Lot
26.2	Process Tank Heaters	1 Lot
26.3	PT-100 Rated Sensor	1 Lot
26.4	Pneumatic Accessories	1 Lot
26.5	Control Panel	1 Lot
26.6	Filter Unit.	1 Lot
26.7	Centrifugal Exhaust Fan & Scrubber	1 Lot
26.8	Turbine Blower	1 Lot
26.9	Chilling Unit	1 Lot
26.10	Rectifier	1 Lot
26.11	Spares for Oil Skimmer	1 Lot
27	Service	
27.1	The authorized Service Partner (Name & Address) must be certified by manufacturer and shown in the quotation	Confirm

28	Vendor to include all items even if not mentioned above for necessary successful operation of plant on turnkeybasis as per design.	Confirm.
29	Drawing of component (maximum size) is attached with the tender document. To get clarity on variety of components to be plated, tenderer to visit ALIMCO Kanpur site and obtain acknowledgement certificate /slip for same, from competent authority.	Confirm.
30	Drawing Design with complete layout and all electrical diagram/drawing (03 sets)to be provided by the party	confirm

**DELIVERY PERIOD INCLUDING INSTALLATION & COMMISSIONING:**

The delivery period including installation & commissioning of anodizing plant at the destination mentioned in Para 1 on page no. 02 of the tender documents will be 04 months from the date of placement of Purchase Order/workcontract.

**WARRANTY:**

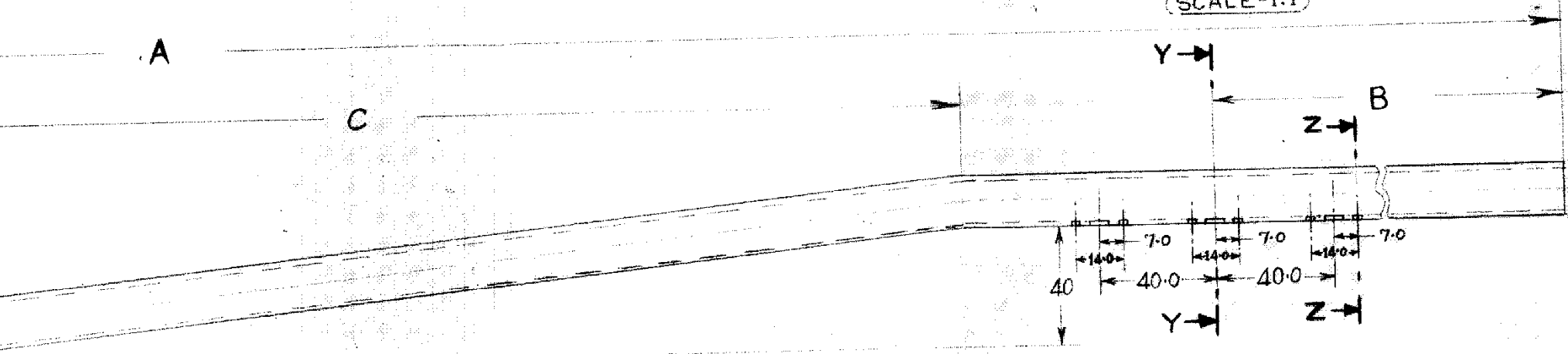
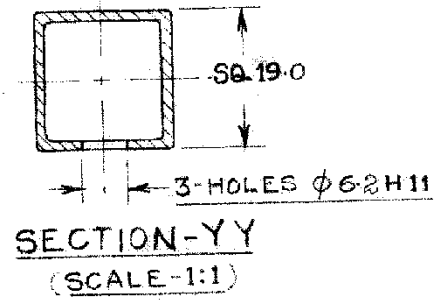
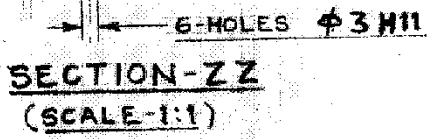
The entire plant inclusive of all system/accessories should be covered under warranty for a period of 24 months from the date of commissioning. The compressor unit for chilling unit shall have 02 years warranty plus 03 years minimum extended warranty.

Note:- To cover the extended warranty of 03 years on Compressor unit of chilling unit, Tenderer has to submit an undertaking to submit the Performance Bank Guarantee of 5% of total Order value for 03 years.

**Note:**

1. Sketch/figure of tank attached at enclosure-A & B are indicative and for reference purpose only. Vendor has to fabricate & supply as per their design.
2. Items/Machine shall be supplied with 3 sets of comprehensive operation and maintenance manual.
3. Breakdown calls to be attended within 48hrs.
4. Supply to be done on Turnkey Basis. ALIMCO shall provide electrical supply point near to the place of installation.
5. Civil foundation details and drawings with specifications to be provided by the tenderer.
6. Total power consumption (in KW) to be provided by the tenderer.
7. Abbreviations:
 

RT	-	Room temperature MOC
	-	Material of construction
MS	-	Mild steel
SS	-	Stainless steel
PVC	-	Polyvinylchloride
PP	-	Polypropylene
FRP	-	Fibre reinforced plastic



MTL.:-  
 EXTRUDED SQUARE TUBE AL. ALLOY HV9 OR HV20.  
 SIZE 19X1.2 mm THICK IS:1285 (A Q 68)  
 OR  
 AL. EXTRUDED SQUARE TUBE 19X1.6 mm THK. (EQUVALENT  
 TO HINDALCO SECTION No. TU-169 ) (A Q 69).

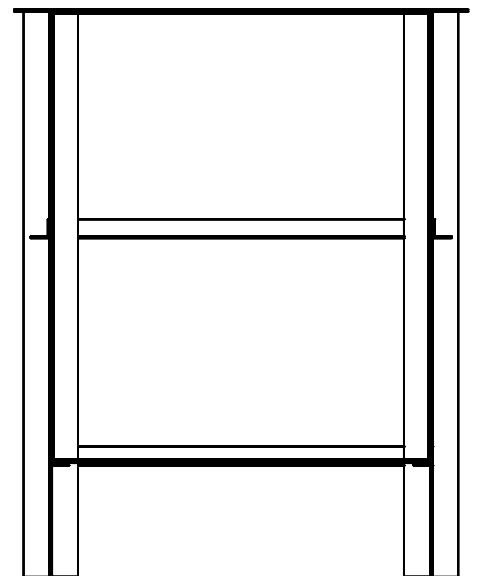
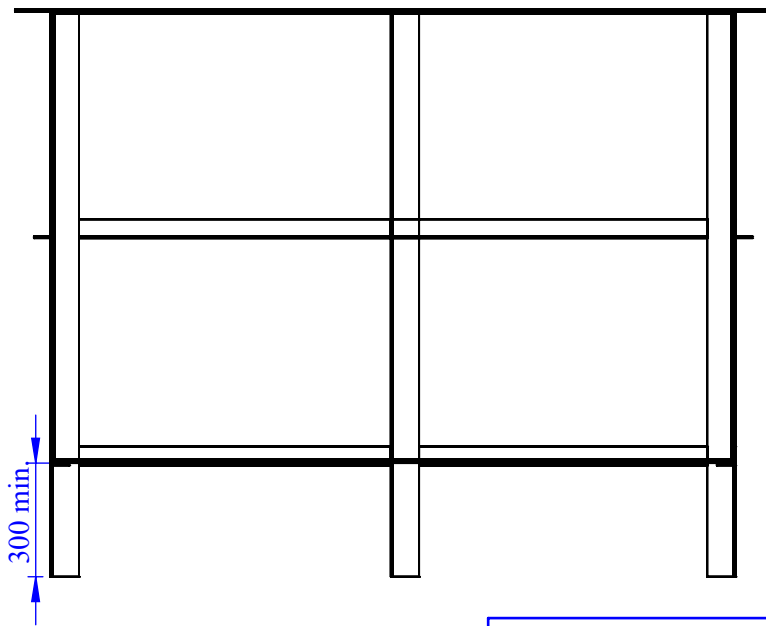
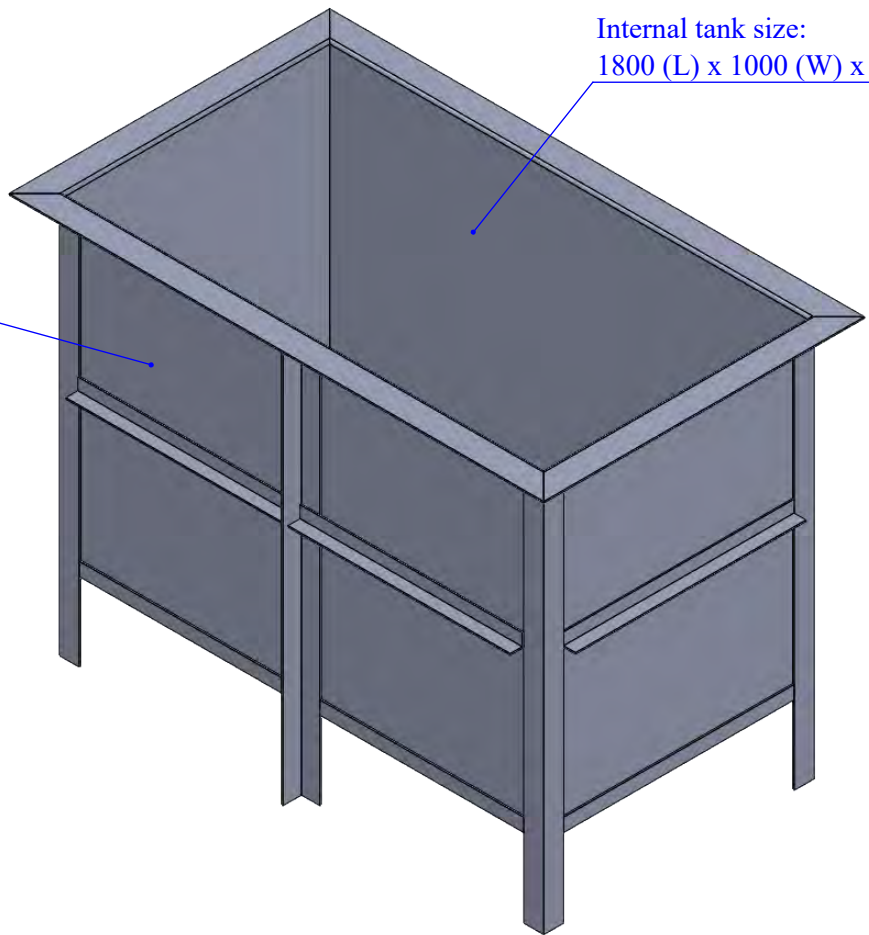
4	B-G	MTL. CODE No. A Q 69 ADDED AS ALTERNATE	24.11.86	<i>Phle</i>
3	E-3, G-9	DIMS. 7.0, 14.0 WERE 8.0, 16.0 AND 2-HOLES THROUGH $\phi 6.2$ H11 WAS 2-HOLES THROUGH $\phi 6.5$	1-8-88	<i>Phle</i>
2	E-3, G-2	DIM. 20, 155 & 'A' WERE DIM. 40, 175 & 'A'- 975, 1100 & 1225	30-6-86	<i>Phle</i>
1	G-5	6-HOLES $\phi 3$ H11 WAS $\phi 2.3$ H11	19-5-84	<i>Phle</i>

S.No.	REGION	REVISION	DATE	SIG.
<b>R E V I S I O N S</b>				
<b>ARTIFICIAL LIMBS MANUFACTURING CORPN. OF INDIA KANPUR</b>				
DGN.	<i>Qu. binistara</i>	NOM.	SIDE TUBE	
DRN.	<i>K. S. Brown</i>			

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MS/SS Tank

Internal tank size:  
1800 (L) x 1000 (W) x 1200 (H)



NOTE:

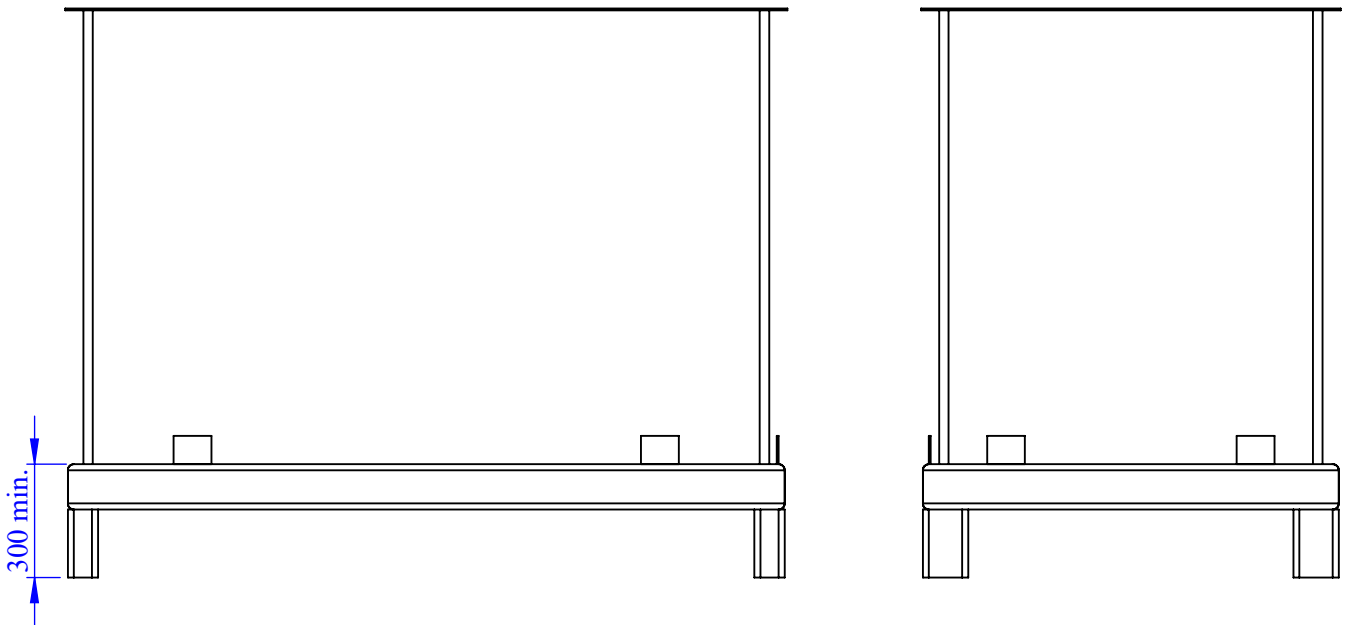
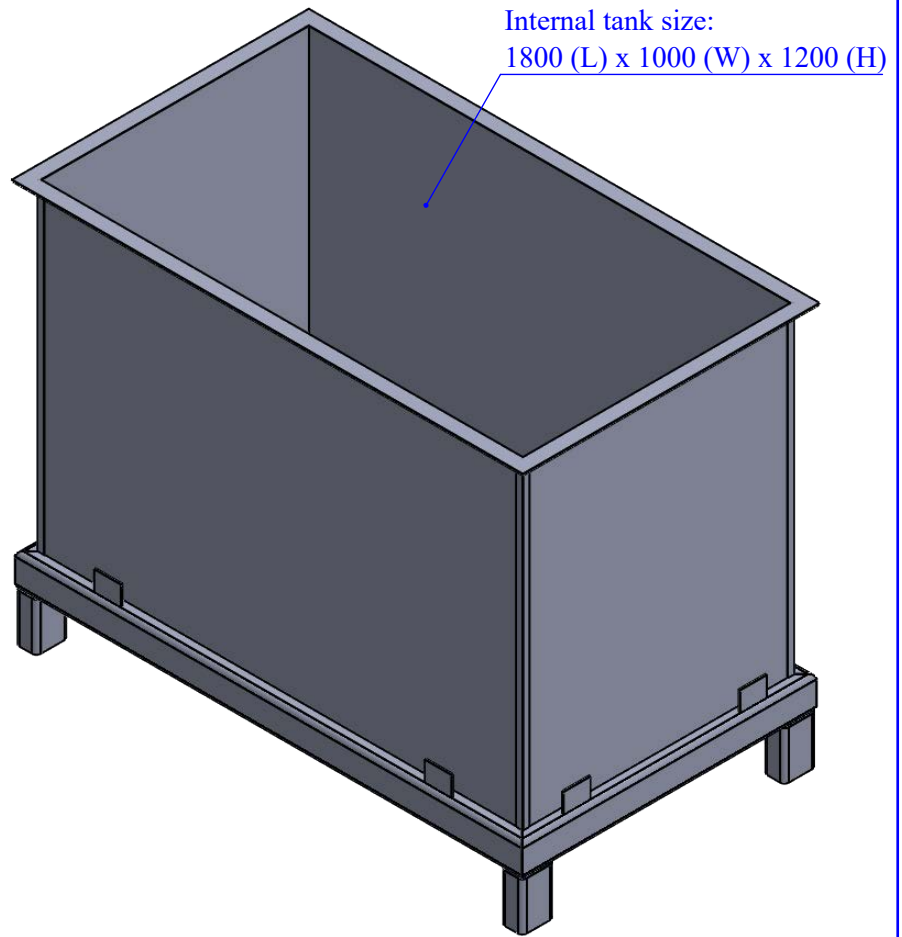
1. This drawing is for reference only



**ARTIFICIAL LIMBS MANUFACTURING CORPORATION OF INDIA (ALIMCO)**

DRN BY		DT		MATERIAL	
CHKD BY		DT		HEAT TRT.	
APPD BY		DT		SUR. TRT.	
	IS: 2102		DEBURR ALL SHARP EDGES 0.5x45°		
	ISO: 2768-mK				
WEIGHT		<b>NOM.</b>		MS/SS Tank	
SCALE		<b>DRG NO.</b>			
SHEET					
REV. NO.					

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Note:

1. Tank should be designed in such a way that the ground clearance of tank will be at least 300 mm
2. This drawing is for reference only

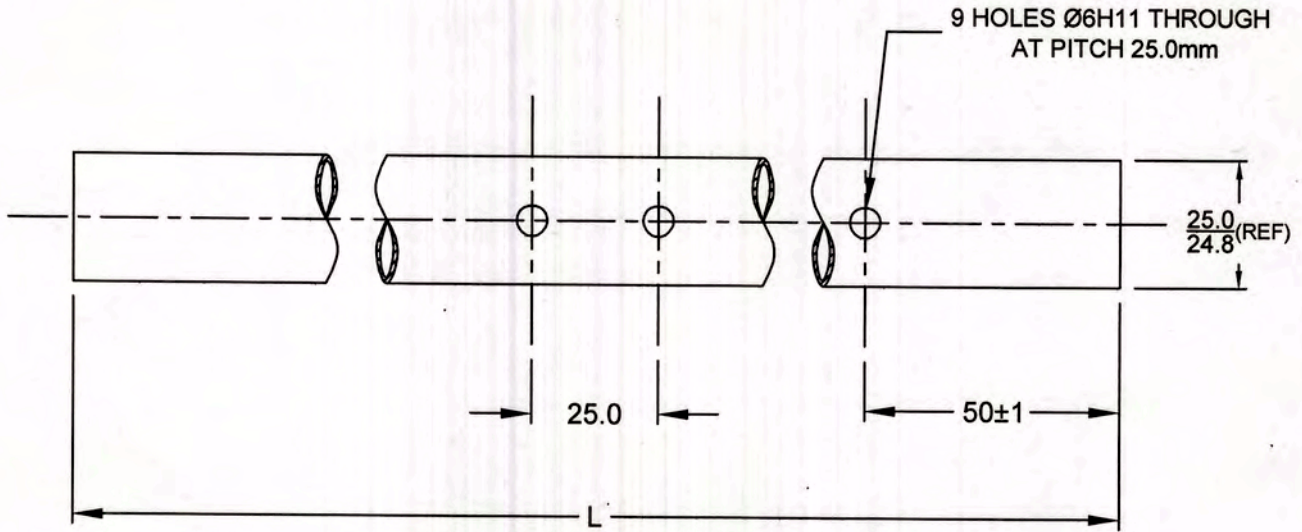


## ARTIFICIAL LIMBS MANUFACTURING CORPORATION OF INDIA (ALIMCO)

DRN BY		DT		MATERIAL	
CHKD BY		DT		HEAT TRT.	
APPD BY		DT		SUR. TRT.	
	IS: 2102		DEBURR ALL SHARP EDGES 0.5x45°		
	ISO: 2768-mK				
WEIGHT		<b>NOM.</b>  <b>DRG NO.</b>		<b>PP TANK</b>	
SCALE					
SHEET					
REV. NO.					



SL No.	DRG No.	L ± 1
1	TD 1 N 23 0 02	365
2	TD 1 N 24 0 02	465



**MTL:-**

EXTRUDED TUBE AL.ALLOY HV 9 (63400)  
COMMERCIAL QUALITY OD 25.0/24.8,  
ID 22.5/22.3, IS:1285 (AQ 67)

OR

EXTRUDED TUBE AL.ALLOY & TEMPER  
6063-T6 CONFORMING TO 63400 WP,  
ID 22.93/22.63 X 1.25mm WALL THICKNESS,  
IS:1285 (AQ 79)

**NOTE:-**

1. REMOVE SHARP EDGES & CORNERS.

**TOLERANCE:-**

DEVIATION FOR NON TOLERANCED DIMENSIONS  
(ISI:2102 MEDIUM)

DIAMETER & LENGTHS BETWEEN	LENGTH IN MM OF SHORTER SIDE OF ANGLE UPTO & INCL.	TOLERANCE
0.5 up to 6	Up to 10	±0.1
Over 6 up to 30	Over 10 upto 50	±0.2
Over 30 up to 120	Over 50 upto 120	±0.3
Over 120 up to 315	Over 120 upto 400	±0.5
Over 315 up to 1000		±0.8
Over 1000 up to 2000		±1.2
Over 2000 up to 4000		±2.0

MACHINING FINISH IN MICRONS  
▽ 8 - 25   ▽▽ 1.6 - 8   ▽▽▽ 0.025 - 1.6   ▽▽▽▽ <0.025

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4	C - 5	MTL AQ 79 ADDED AS AN ALTERNATE	27.09.18	
SNNo.	REGION	REVISION	DATE	SIGN

**REVISIONS**

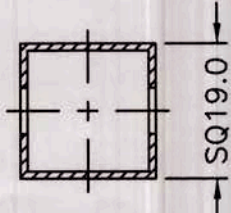
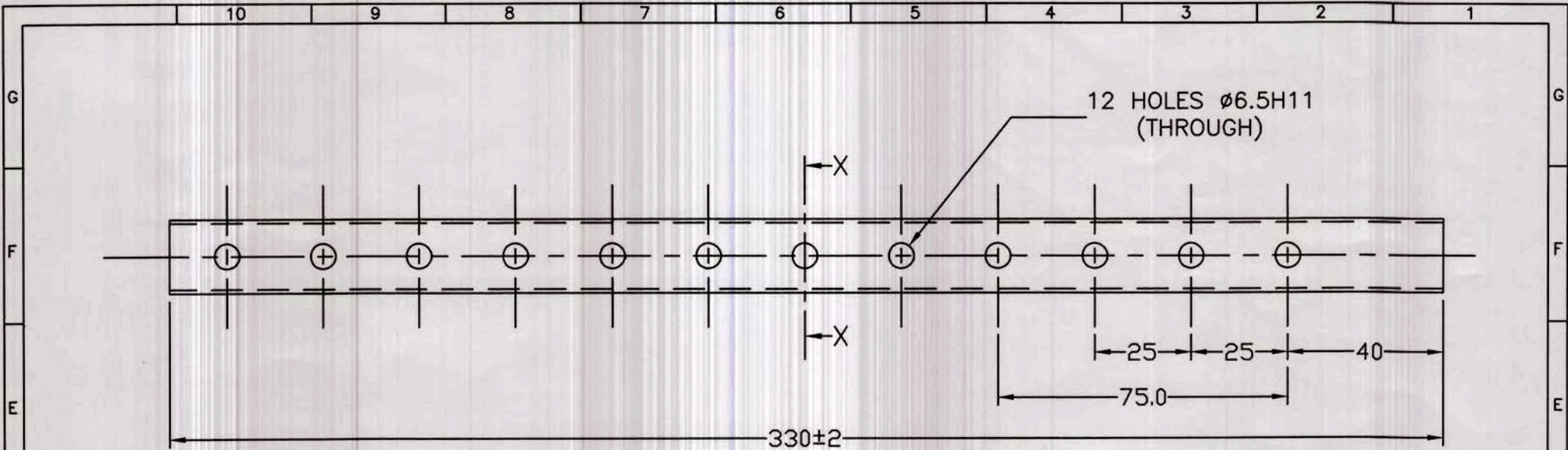
ARTIFICIAL LIMBS  
MANUFACTURING CORPORATION  
OF INDIA  
KANPUR



DGN	Abhishek	NOM	LEG TUBE	
DRN		MTL	INDICATED	
CHD	R. D. Singh	HEAT TREATMENT	—	
DIM	IN mm	SURFACE TREATMENT	POWDER COATING COLOUR - WHITE ALTERNATE ANODIZE Gd AC 10, IS:1868	
SCALE	NTS	DRG No:-	TD 1 N 23 0 02	REV SHEET
APP	Sd/DDI		TD 1 N 24 0 02	4 10F1
DATE	15.10.1982			

5

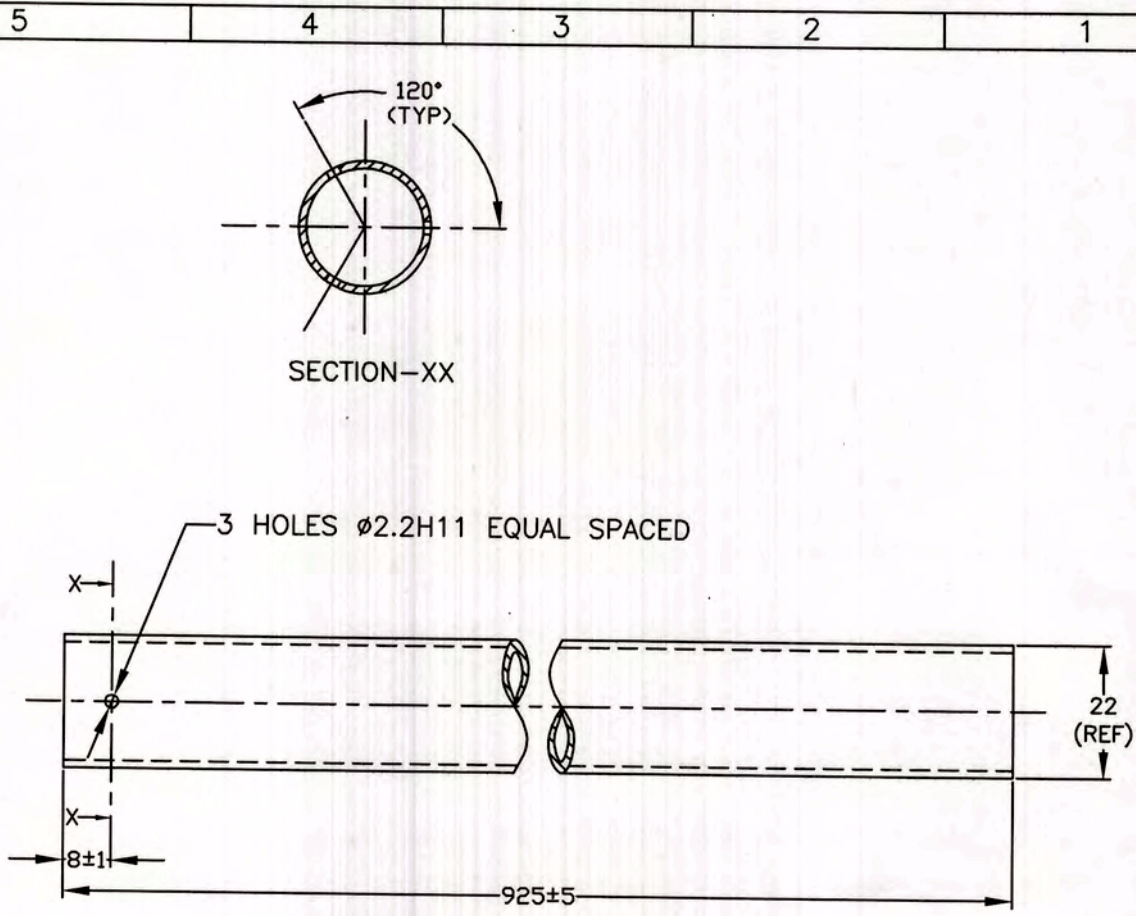
4



SECTION -XX

MATERIAL:- (AQ 69)  
 EXTRUDED SQ. TUBE AL. ALLOY  
 19x19x1.6mm THICK, IS:1285  
 (EQUI. HINDALCO SECTION No.TU-169)

5	E - 2	DIM 40mm WAS 50mm	04.07.18	
4	—	DRAWING REDRAWN	16.05.17	
SNo.	REGION	REVISION	DATE	SIGN
REVISIONS				
ARTIFICIAL LIMBS MANUFACTURING CORPORATION OF INDIA KANPUR				
DGN	<i>Ashish</i>	NOM	EXTENSION TUBE	
DRN	<i>Raw</i>	MTL	INDICATED	
CHD		TOL	INTEGER ONLY ±0.500 mm UNLESS SPECIFIED ONE PLACE DECIMAL ±0.250 mm TWO PLACE DECIMAL ±0.125 mm	
DIM	IN mm	FIN	ANODIZE Gd.A C 10, IS:1868	
SCALE	NTS			
APP	<i>ce/DD</i>			
DATE	12.02.1987	DRG No:-	TD 1N 37 0 02	REV 5 SHEET 10F1



NOTE:-

- 1. REMOVE SHARP EDGES & CORNERS.

TOLERANCE:-

DEVIATION FOR NON TOLERANCED DIMENSIONS (ISI:2102 MEDIUM)

DIAMETER & LENGTHS BETWEEN	TOLERANCE	LENGTH IN MM OF SHORTER SIDE OF ANGLE UPTO & INCL.	TOLERANCE
0.5 up to 6	±0.1	Up to 10	±1°00'
Over 6 up to 30	±0.2	Over 10 upto 50	±0°30'
Over 30 up to 120	±0.3	Over 50 upto 120	±0°20'
Over 120 up to 315	±0.5	Over 120 upto 400	±0°10'
Over 315 up to 1000	±0.8		
Over 1000 up to 2000	±1.2		
Over 2000 up to 4000	±2.0		

MACHINING FINISH IN MICRONS  
 ▽ 8 - 25 ▽▽ 1.6 - 8 ▽▽▽ 0.025 - 1.6 ▽▽▽▽ <0.025

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6	A - 2	MTL AQ 80 WAS AQ 57	27.09.18	<i>[Signature]</i>
SNNo.	REGION	REVISION	DATE	SIGN

REVISIONS

ARTIFICIAL LIMBS  
MANUFACTURING CORPORATION  
OF INDIA  
KANPUR

DGN	<i>Abhishek</i>	NOM	TUBE
DRN	<i>Abhishek</i>	MTL	EXTRUDED TUBE AL ALLOY & TEMPER 6063-T6 CONFORMING TO 63400 WP OD 22.2 x 1.6mm WALL THICKNESS, IS:1285 (AQ 80)
CHD	<i>Abhishek</i>	HEAT TREATMENT	—
DIM	IN mm	SURFACE TREATMENT	POWDER COATING COLOUR - WHITE ALTERNATE ANODIZE Gd AC 10, IS:1868
SCALE	NTS	DRG No:-	TD 1 N 61 0 01
APP	<i>Sd/BDI</i>	REV	6
DATE	24.06.1988	SHEET	10F1

5 4 3 2 1

G

F

E

D

C

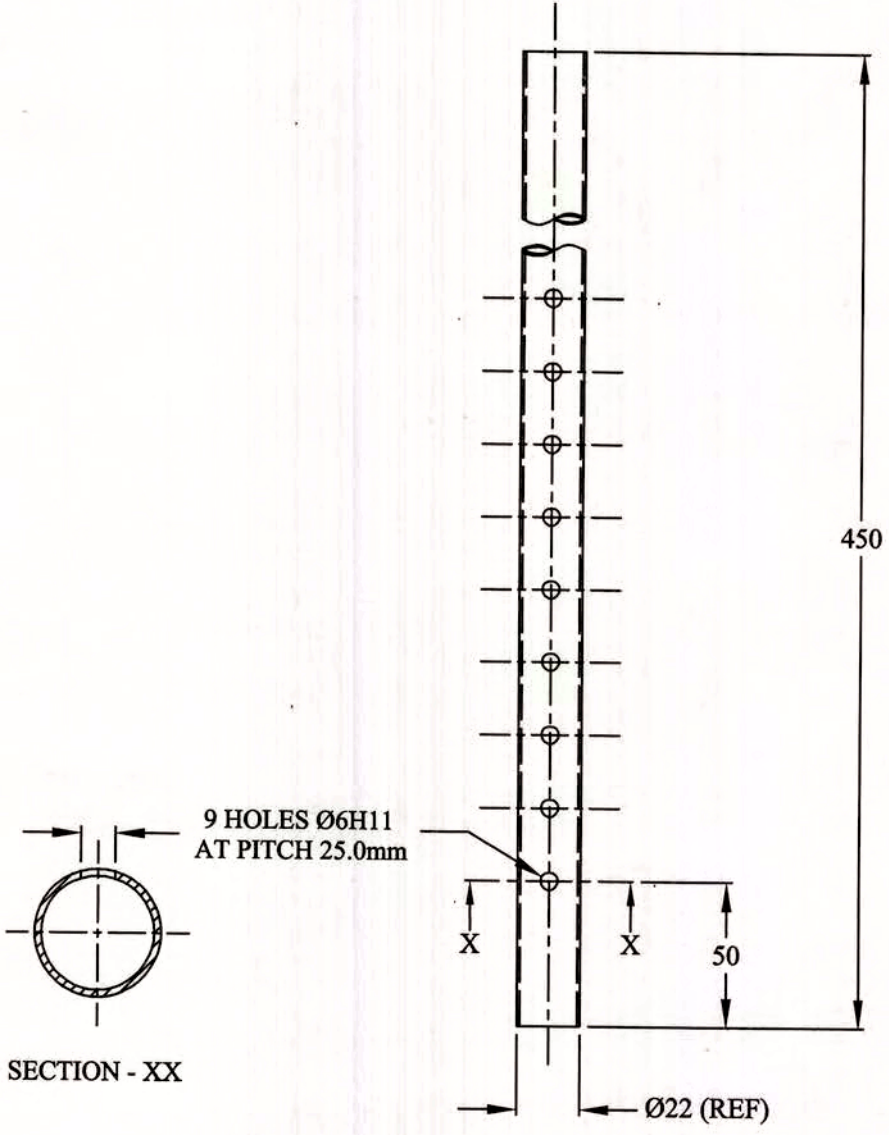
G

F

E

D

C



9 HOLES Ø6H11  
AT PITCH 25.0mm

SECTION - XX

**NOTE:-**

1.REMOVE SHARP EDGES & CORNERS.

**TOLERANCE:-**

DEVIATION FOR NON TOLERANCED DIMENSIONS  
(ISI:2102 MEDIUM)

DIAMETER & LENGTHS BETWEEN	TOLERANCE	LENGTH IN MM OF SHORTER SIDE OF ANGLE UPTO & INCL.	TOLERANCE
0.5 up to 6	±0.1	Up to 10	±1°00'
Over 6 up to 30	±0.2	Over 10 upto 50	±0°30'
Over 30 up to 120	±0.3	Over 50 upto 120	±0°20'
Over 120 up to 315	±0.5	Over 120 upto 400	±0°10'
Over 315 up to 1000	±0.8		
Over 1000 up to 2000	±1.2		
Over 2000 up to 4000	±2.0		

MACHINING FINISH IN MICRONS  
▽ 8 - 25 ▽▽ 1.6 - 8 ▽▽▽ 0.025 - 1.6 ▽▽▽▽ <0.025

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1	E-2	DIMENSION 450mm & MTL AQ 80 WERE 465mm & MTL AQ 57	09.10.18	
SNNo.	REGION	REVISION	DATE	SIGN

**R E V I S I O N S**

**ARTIFICIAL LIMBS  
MANUFACTURING CORPORATION  
OF INDIA  
KANPUR**

DGN		NOM	EXTENSION TUBE
DRN		MTL	EXTRUDED TUBE AL ALLOY & TEMPER 6063-T6 CONFORMING TO 63400 WP OD 22.2 x 1.6mm, WALL THICKNESS, IS:1285 (AQ 80)
CHD		HEAT TREATMENT	—
DIM	IN mm	SURFACE TREATMENT	ANODIZE Gd AC10, IS:1868
SCALE	NTS	DRG No:- TD 2 P 02 0 0 1	REV 1
APP		DATE	07.02.2017
DATE	07.02.2017		SHEET 1 OF 1

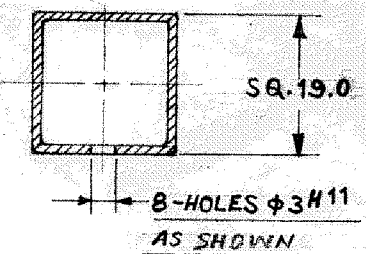
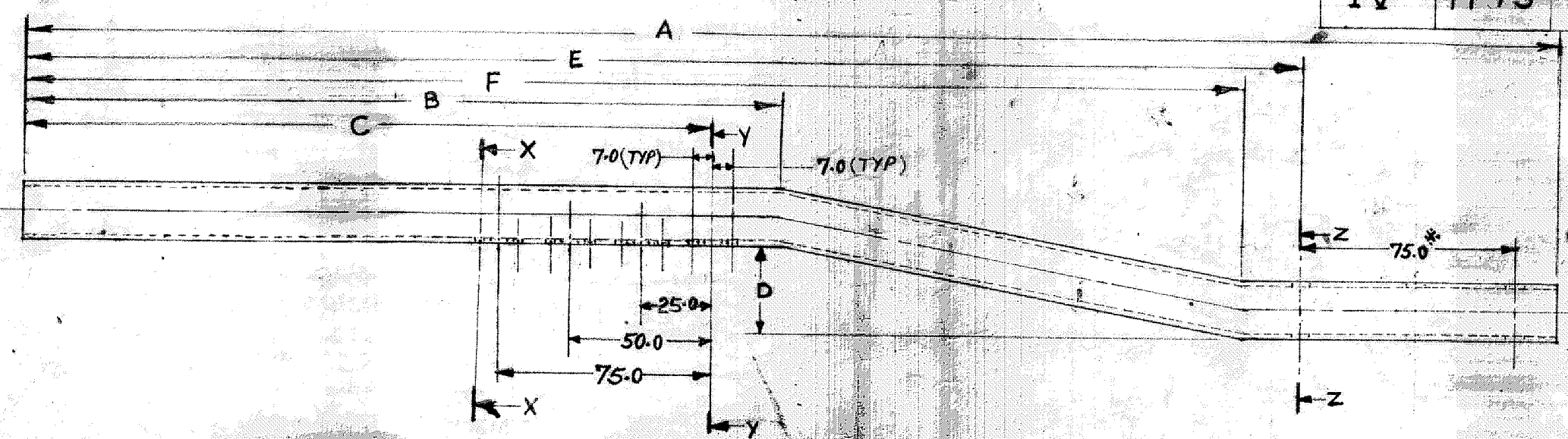
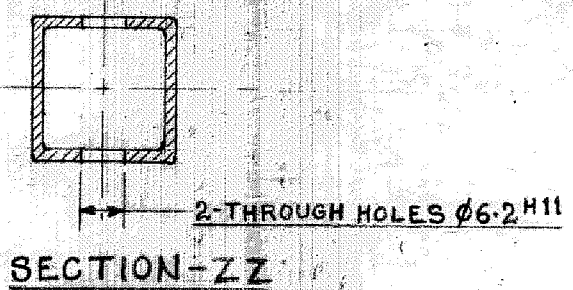
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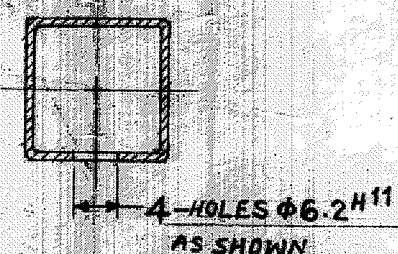
B

A

SIZE	A±2	B±2	C±2	D±1	E±1	F±1
I	520	265	242	30	430	410
II	745	340	317	30	655	635
III	950	395	375	40	860	840
IV	1175	470	450	40	1085	1065



SECTION-XX  
SCALE-1:1



SECTION-YY  
SCALE-1:1

**NOTE:**  
1. \* CRS OF THESE HOLES TO MATCH WITH \* CRS OF TD 1N 37 0 02

MTL:

AL EXTRUDED SQUARE TUBE 19X1.6mm THK.  
(EQUVALENT TO HINDALCO SECTION No. TU-169)  
(AB 69).

SIZE	DRG.No.
I	TD 1 N 37 0 01
II	TD 1 N 38 0 01
III	TD 1 N 39 0 01
IV	TD 1 N 40 0 01

OLG 2 184

10	E-9	2-HOLES Ø 3.2 H11 & DIMS 58, 31.0 - SECTION-WW DELETED.	28.12.84	RPS
9	E, G-8	2-HOLES Ø3.2H11 WAS 3H11 AT SECTION-WW	11.10.95	QWS
8	E-8, 9	2-HOLES Ø3H11 DIMS. 58, 31.0 - SECTION-WW ADDED TO LOCATE "LABEL IS: 5143"	12-8-95	QWS
7	E-8	ISI MARK & DIM 55 ADDED	3.5.95	QWS
6	A-2	FIN-POWDER COATING DELETED	21.9.93	QWS
5	A-2	FIN-POWDER COATING ADDED MTL-A Q 68 DELETED	7.7.93	QWS
4	E-7	DIM 'C' OF SIZE-I & II, PITCH DIMS & 4-HOLES Ø6.2H11 WERE DIM 'C'-24.5, 32.0, PITCH DIMS. 14.0, 28.0, 42.0, 56.0, 70.0, 84.0 & 7-HOLES Ø6.2H11	13.7.90	QWS
3	F&E-4, E-3, 2	DIMS. E & F ADDED DIMS. 110, 15 DELETED.	26.5.90	QWS
2	D7, 6	IN SECTION-XX 8 HOLES WERE 6 & SECTION-YY 7 HOLES WAS 3	29.3.90	QWS
1	E-7	DIM 4.0.0 WAS 35.0	7.3.87	QWS

S.No.	REGION	REVISION	DATE	SIG.
<b>REVISIONS</b>				
<b>ARTIFICIAL LIMBS MANUFACTURING CORPN. OF INDIA KANPUR</b>				
DCN.	DESCRIPTION	NON.	SIDE TUBE	
ORN.		MTL.	INDICATED	
CHD.		TOL.	INTEGER ONLY ±0.500 mm ONE PLACE DECIMAL ±0.250 mm TWO PLACE DECIMAL ±0.125 mm UNLESS SPECIFIED	
SCALE	1:2	FIN.	ANODIZE Gd. AC10, IS:1868	
APP.		DATE	12-2-87	DRG.NO. INDICATED