























SR NO. DRAWING DESCRIPTION DRAWING NO. SHEET NO. 01 RFG ASSEMBLY 19010001 01 OF 01 07 01 0	SR NO. DRAWING DESCRIPTION	1																	1	Ω	
01   RFD ASSEMILY   19010001   01   0F   01   01   01   02   02   03   05   05   05   05   05   05   05	101   RFQ ASSEMBLY   19010001   01   07   01   01   01   01   0										<u>'</u>				I						
01 RFQ ASSEMILY 10010001 01 07 01 02 01 02 02 03 01 07 01 02 03 08 05 05 04 05 05 05 05 05 05 05 05 05 05 05 05 05	101   RFQ ASSEMBLY   19010001   01   07   01   01   01   01   0																				
01 RPC ASSEMBLY 19010001 01 07 01 01 02 02 RBOSTEM BASE PLATE ASSEMBLY 19020004 01 07 07 01 03 BASE PLATE ASSEMBLY 19020007 03 STEEL 1 19020007 03 STEEL 1 19020007 03 STEEL 1 19020007 05 STEEL 1 19020007 07 STEEL 1 19020007 07 STEEL 1 19020008 05 STEEL 1 19020008 05 STEEL 1 19020008 07 STEEL 1 19020008 07 STEEL 1 19020009 07 STEEL 1 19020008 07 STEEL 1 19020009 07 STEEL 1 1902009 07 STEEL 1 1902009 07 STEEL 1 19020009 07 STEEL 1 1902009 07 STEEL 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	01   RFD ASSEMBLY   19020001   01   0F 01   01   02   03   05   05   05   05   05   05   05	NO. DRAWI	NG DESCRIPTION				DRAWING	NO.			SHEET NO.	SR NO	. DR	RAWING	DESCRIPT	ION			DRA	WING NO.	SHEET
20   ROD STEM BASE PLATE -1   19020004   01 0F 01	02   00 STEM BASE PLATE   19020001   01 OF 01   03   BASE PLATE   19020003   01 OF 01   04   BASE PLATE   19020003   01 OF 01   05   STEM -2   19020003   01 OF 01   06   STEM -1   19020003   01 OF 01   07   STEM -1   19020005   19020007   3 SMETS   08   STEM -2   19020008   3 SMETS   09   STEM -2   19020008   3 SMETS   09   STEM -3   19020009   2 SMETS   09   HORIZONTAL ROD LEFT SEGMENT (1 TO 6)   19020017   19020002   01 OF 01   09   VERTICAL ROD LOWER SEGMENT (1 TO 6)   19020017   19020022   01 OF 01   10   VERTICAL ROD LOWER SEGMENT (1 TO 6)   19020023   10 19020022   01 OF 01   11   RFOASSEMBLY PROTOTYPE   19020003   01 OF 01   12   VANE STEM BASE PLATE ASSEMBLY PROTOTYPE   19020003   01 OF 01   13   VERTICAL ROD LOWER SEGMENT (1 TO 6)   19020002   01 OF 01   14   VERTICAL ROD LOWER SEGMENT (1 TO 6)   19020002   01 OF 01   15   VACUUM CHANGER ASSEMBLY PROTOTYPE   19020003   01 OF 01   16   VACUUM CHANGER ASSEMBLY PROTOTYPE   19020003   01 OF 01   17   VACUUM CHANGER ASSEMBLY PROTOTYPE   19020003   01 OF 01   18   ROM FLANGE COVER -2   19030001   01 OF 01   19   RIM FLANGE COVER -1   19030000   01 OF 01   19   RIM FLANGE COVER -1   19030000   01 OF 01   10   RIM FLANGE COVER -1   19030000   01 OF 01   11   VACUUM CHANGER ASSEMBLY PROTOTYPE   19030000   01 OF 01   12   ROM FLANGE COVER -1   19030000   01 OF 01   13   ROM FLANGE COVER -1   19030000   01 OF 01   14   VACUUM CHANGER ASSEMBLY PROTOTYPE   19030000   01 OF 01   15   VACUUM CHANGER ASSEMBLY PROTOTYPE   19030000   01 OF 01   16   ROM FLANGE COVER -1   19030000   01 OF 01   17   VACUUM CHANGER ASSEMBLY PROTOTYPE   19030000   01 OF 01   18   ROM FLANGE COVER -1   19030000   01 OF 01   19   RIM FLANGE COVER -1   19030000   01 OF 01   19   RIM FLANGE COVER -1   19030000   01 OF 01   19   RIM FLANGE COVER -1   19030000   01 OF 01   19   RIM FLANGE COVER -1   19030000   01 OF 01   19   RIM FLANGE COVER -1   19030000   01 OF 01   19   RIM FLANGE COVER -1   19030000   01 OF 01   19   RIM FLANGE COVER -1   19030000   01 OF 01   20   RIM FLANGE COVER -1   19						19010001						_			1011					
BASE PLATE-1	BASE PLATE-1	ROD S	TEM BASE PLATE A	SSEMBLY									_			1					
BASE PLATE - 2	BASE PLATE - 2											-	_								
STEH-1	STEM-1						-									_					
DECEMBER 2   19020008   3 SHETS   19020008   3 SHETS   19020009   2 SHETS   19020001   10 P O1   10	STEM-2												_								
	STEM - 3															т					
APRIZONTAL ROD LEFT SEGMENT(1 TO 6)   19020017 TO 19020016   01 0F 01	NORIZONTAL ROD LEFT SEGMENT(1 TO 6)   19020011 TO 190200228											1.4									
DB	D8			EGMENT (1	TO 6)			TO 1	902001	16											
Vertical Rod Lower Segment(1 TO 6)	Vertical Rod Lower Segment(1 To 6)					)							_								
VERTICAL ROD UPPER SEGMENT (1 TO 6)	10			•	,							-	_			FNT-1 PI	ROTOTVE	)F			
11	11											F									
12   VANE STEM BASE PLATE ASSEMBLY PROTOTYPE   19020002   01 0F 01   13   VERTICAL ROD LOWER SEGMENT-5   PROTOTYPE   19020026   01 0F 01   14   VERTICAL ROD LOWER SEGMENT-5   PROTOTYPE   19020035   01 0F 01   15   VACUUM CHAMBER ASSEMBLY   19030001   01 0F 01   16   VACUUM CHAMBER ASSEMBLY   19030002   01 0F 01   16   VACUUM CHAMBER-1 ASSEMBLY   19030002   01 0F 01   18   END FLANGE -2 ASSEMBLY   19030003   01 0F 01   19   19   19   19   19   19   19	12   VANE STEM BASE PLATE ASSEMBLY PROTOTYPE   19020002				,								_				1010111				
13 VERTICAL ROD LOWER SEGMENT-5 PROTOTYPE 19020028 01 0F 01 14 VERTICAL ROD UPPER SEGMENT-5 PROTOTYPE 19020035 01 0F 01 15 VACUUM CHAMBER ASSEMBLY 19030001 16 VACUUM CHAMBER -1 ASSEMBLY 19030002 01 0F 01 17 VACUUM CHAMBER-1 ASSEMBLY 19030003 01 0F 01 18 END FLANGE-1 19030005 10 0F 01 19 END FLANGE-2 19030006 01 0F 01 20 END FLANGE COVER-1 19030007 01 0F 01 21 END FLANGE COVER-PROTOTYPE 19030008 01 0F 01 22 END FLANGE COVER-PROTOTYPE 19030009 01 0F 01 23 0 RING-1 19030009 01 0F 01 24 0 RING-2 19030010 01 0F 01 25 0 RING-3 19030011 01 0F 01 26 0 RING-3 19030011 01 0F 01 27 0 RING-5 19020005 01 0F 01 30 BOTTOM PLATE-1 19030012 01 0F 01 31 SIDE PLATE-1 19030015 01 0F 01 32 SIDE PLATE-2 19030016 01 0F 01 33 SIDE PLATE-2 19030016 01 0F 01 48 STEM SLOT COVER FOR PROTOTYPE 19020040 01 0F 01 49 0D FOR VANE PROFILE DATA 19020040 01 0F 01 50 BILL OF MATERIAL 19030032 01 0F 01 51 DRAWING LIST OF RFQ 19030032 01 0F 01 52 DRAWING LIST OF RFQ 19030032 01 0F 01 53 DRAWING LIST OF RFQ 19030032 01 0F 01 54 DRAWING LIST OF RFQ 19030032 01 0F 01 55 DRAWING LIST OF R	13				PROTOT	ГҮРЕ							_				G FOR \	/ANES			
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MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS  MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS  TITLE  LIST OF DRAWINGS FOR	MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS  MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS  SCALE 1:1 DATE  TITLE  LIST OF DRAWINGS FOR RI	1		LENGTH		3-30	30-120   120-	315	$\perp$	-			-				-	11.01.18	<u> </u>		1
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS  MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS  SCALE 1:1 DATE  ORAWN K.R.R. 11.01.18  LENGTH 6 6 30 30-120 120-315	MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS  MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS  SCALE 1:1 DATE  DRAWN K.R.R. 11.01.18  LENGTH 6 6-30 30-120 120-315	10-50	50-120 OVER 120-400		+0.1		10.2									CHECKED	PKC		REF DRG N	0:	
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS  MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS  SCALE 1:1 DATE  DRAWN K.R.R. 11.01.18  TITLE  LIST OF DRAWINGS FOR  OTO 10 10-50 50-120 OVER 120-400 OR  TO 10 10-50 50-120 OVER 120-400 OR  THE VIOLE Block I I I DATE  DRAWN K.R.R. 11.01.18  CHECKED PKC REF DRG NO:	MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS  MACHINING ATTROVED UNLESS OTHERWISE STATED  Bhat, Near Indira Bridge, Gandhinagar 382428, Gujara  TITLE  LIST OF DRAWINGS FOR RI  TO 10 10-50 50-120 OVER 120-400 OVER 120-400 OR  CHECKED PKC REF DRG NO:  REF DRG NO:	+0°-30'	+0°-10'	DIA	±0.1   ±	±0.2	+0.3   +0	.5								APPROVED	JMK		DRG.NO	IPR/17/A3/RFQ/19	9030032
34		IDI	STEM- STEM- STEM- STEM- HORIZ VERTI VERTI RFQ A VANE VERTI VERTI VACUU VACUU VACUU VACUU END F END F END F END F END F SIDE SIDE SIDE SIDE SIDE SIDE	STEM-1 STEM-2 STEM-3 HORIZONTAL ROD LEFT SI HORIZONTAL ROD LOWER SEI VERTICAL ROD LOWER SEI VERTICAL ROD UPPER SEI RFQ ASSEMBLY PROTOTYPH VANE STEM BASE PLATE A VERTICAL ROD LOWER SEI VACUUM CHAMBER ASSEMBH VACUUM CHAMBER-1 ASSEMBH VACUUM CHAMBER-2 ASSEMBH VACUUM CHAMBER-2 ASSEMBH VACUUM CHAMBER-2 ASSEMBH VACUUM CHAMBER-1 ASSEMBH VACUUM CHAMBER-2 ASSEMBH VACUUM CHAMBER-2 ASSEMBH VACUUM CHAMBER-2 ASSEMBH VACUUM CHAMBER-1 ASSEMBH VACUUM CHAMBER-2 ASSEMBH VACUUM CHAMBER-1 ASSEMBH VACUUM CHAMBER	STEM-1 STEM-2 STEM-3 HORIZONTAL ROD LEFT SEGMENT(1 HORIZONTAL ROD RIGHT SEGMENT(1 VERTICAL ROD LOWER SEGMENT(1 VERTICAL ROD LOWER SEGMENT(1 RFQ ASSEMBLY PROTOTYPE VANE STEM BASE PLATE ASSEMBLY VERTICAL ROD LOWER SEGMENT-5 VERTICAL ROD UPPER SEGMENT-5 VACUUM CHAMBER ASSEMBLY VACUUM CHAMBER-1 ASSEMBLY VACUUM CHAMBER-2 ASSEMBLY END FLANGE-1 END FLANGE-2 END FLANGE COVER-1 END FLANGE COVER-2 END FLANGE COVER-PROTOTYPE O RING-1 O RING-2 O RING-3 O RING-4 O RING-5 O RING-6 BOTTOM PLATE-1 BOTTOM PLATE-1 SIDE PLATE-1 SIDE PLATE-2 SIDE PLATE-3 SIDE PLATE-3 SIDE PLATE-4  VACUUM CHAMBER-1  SIDE PLATE-4  INATED BY MACHINING DEVIATIONS FOR NON-TOLERANCED D  N mm OF SHORTER SIDE OF ANGLES LENGTH DIA  LENGTH	STEM-1 STEM-2 STEM-3 HORIZONTAL ROD LEFT SEGMENT(1 TO 6) HORIZONTAL ROD RIGHT SEGMENT(1 TO 6) VERTICAL ROD LOWER SEGMENT(1 TO 6) VERTICAL ROD UPPER SEGMENT(1 TO 6) VERTICAL ROD UPPER SEGMENT(1 TO 6) RFQ ASSEMBLY PROTOTYPE VANE STEM BASE PLATE ASSEMBLY PROTOTIVE VERTICAL ROD LOWER SEGMENT-5 PROTOTIVE VACUUM CHAMBER ASSEMBLY VACUUM CHAMBER ASSEMBLY VACUUM CHAMBER-1 ASSEMBLY VACUUM CHAMBER-2 ASSEMBLY END FLANGE-1 END FLANGE-2 END FLANGE COVER-1 END FLANGE COVER-2 END FLANGE COVER-2 END FLANGE COVER-PROTOTYPE O RING-1 O RING-3 O RING-4 O RING-5 O RING-6 BOTTOM PLATE-1 BOTTOM PLATE-1 SIDE PLATE-1 SIDE PLATE-2 SIDE PLATE-3 SIDE PLATE-3 SIDE PLATE-3 SIDE PLATE-4  WACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS N mm OF SHORTER SIDE OF ANGLES  LENGTH  10-50 50-120 OVER 120-400  DIA +0.1	STEM-1 STEM-2 STEM-3 HORIZONTAL ROD LEFT SEGMENT(1 TO 6) HORIZONTAL ROD RIGHT SEGMENT(1 TO 6) VERTICAL ROD LOWER SEGMENT(1 TO 6) VERTICAL ROD LOWER SEGMENT(1 TO 6) RFQ ASSEMBLY PROTOTYPE VANE STEM BASE PLATE ASSEMBLY PROTOTYPE VERTICAL ROD LOWER SEGMENT-5 PROTOTYPE VERTICAL ROD LOWER SEGMENT-5 PROTOTYPE VERTICAL ROD UPPER SEGMENT-5 PROTOTYPE VACUUM CHAMBER ASSEMBLY VACUUM CHAMBER-1 ASSEMBLY VACUUM CHAMBER-2 ASSEMBLY END FLANGE-1 END FLANGE-2 END FLANGE COVER-1 END FLANGE COVER-1 END FLANGE COVER-2 END FLANGE COVER-2 O RING-3 O RING-4 O RING-5 O RING-6 BOTTOM PLATE-1 BOTTOM PLATE-1 SIDE PLATE-1 SIDE PLATE-3 SIDE PLATE-3 SIDE PLATE-3 SIDE PLATE-4  V 8-25 VV 1.6-8 VVV 0.025-1.6  INATED BY MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS N mm OF SHORTER SIDE OF ANGLES  LENGTH 6 BOTA BOTTOM BOTA BOTTOM BOTA BOTA BOTTOM BOTA BOTTOM BOTA BOTTOM BOTT	STEM-1	STEM-1	STEM-1	STEM-1	STEM-1	STEM-1	STEM-1	STEM-1	STEM-1	STEM-1	STEM_1	STEM-1	STEM-1	STEM-1