

13
16

4. Procedure for fixing pivot support sub – assembly with modified motor support as per CLW drawing No. 1209-01.412-187:-

> Pivot support sub assembly with in-built welded pivot pin will be welded with transom after locating its position using tack welding fixture, maintaining distance shown in Fig 4.

1. X dir. 64.5 mm
2. Y dir. 1155 mm (35+1120)
3. Z dir. (Z1= 284 mm & Z2 = 163 mm) as shown in fig-4
4. Sequential Mig welding will be carried out slowly to avoid distortion during welding process to maintain dimensional accuracy with centre line in X, Y, Z, direction.

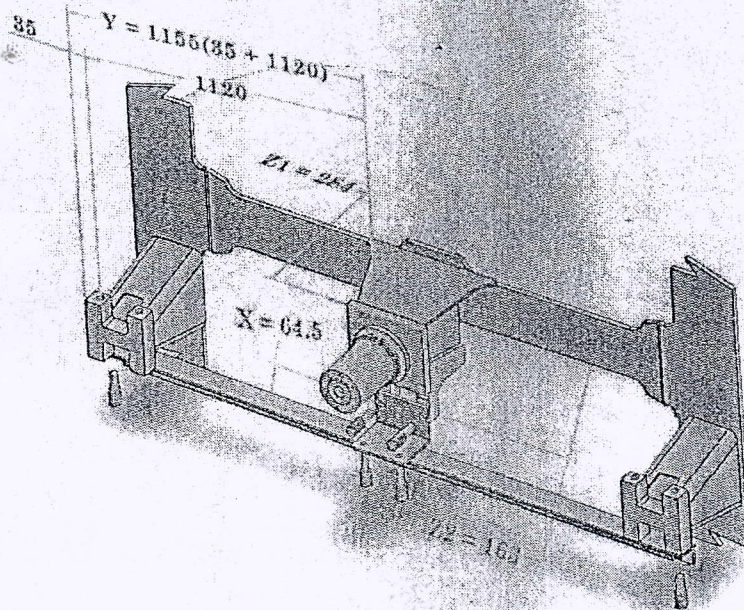


Fig-4

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