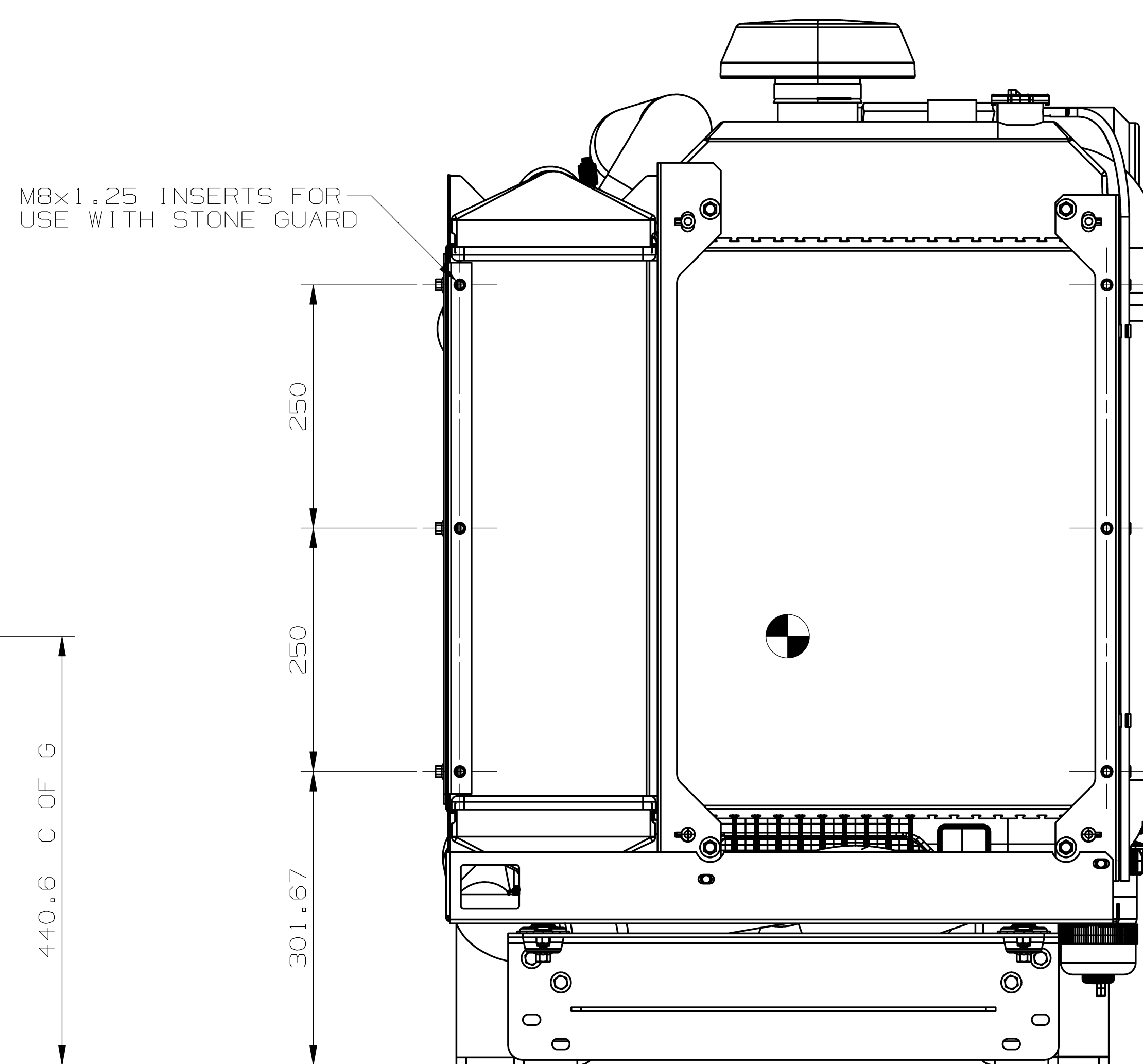
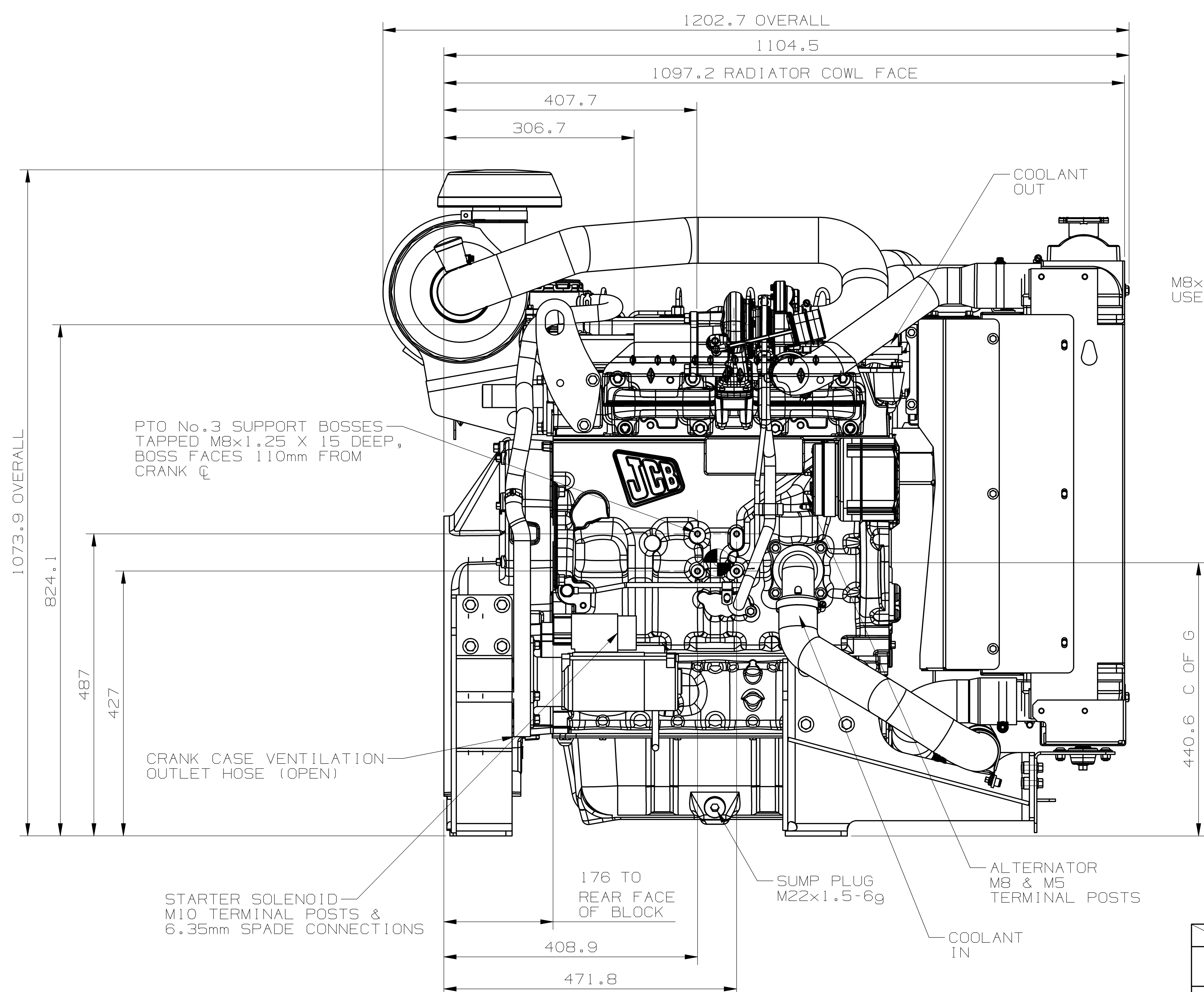
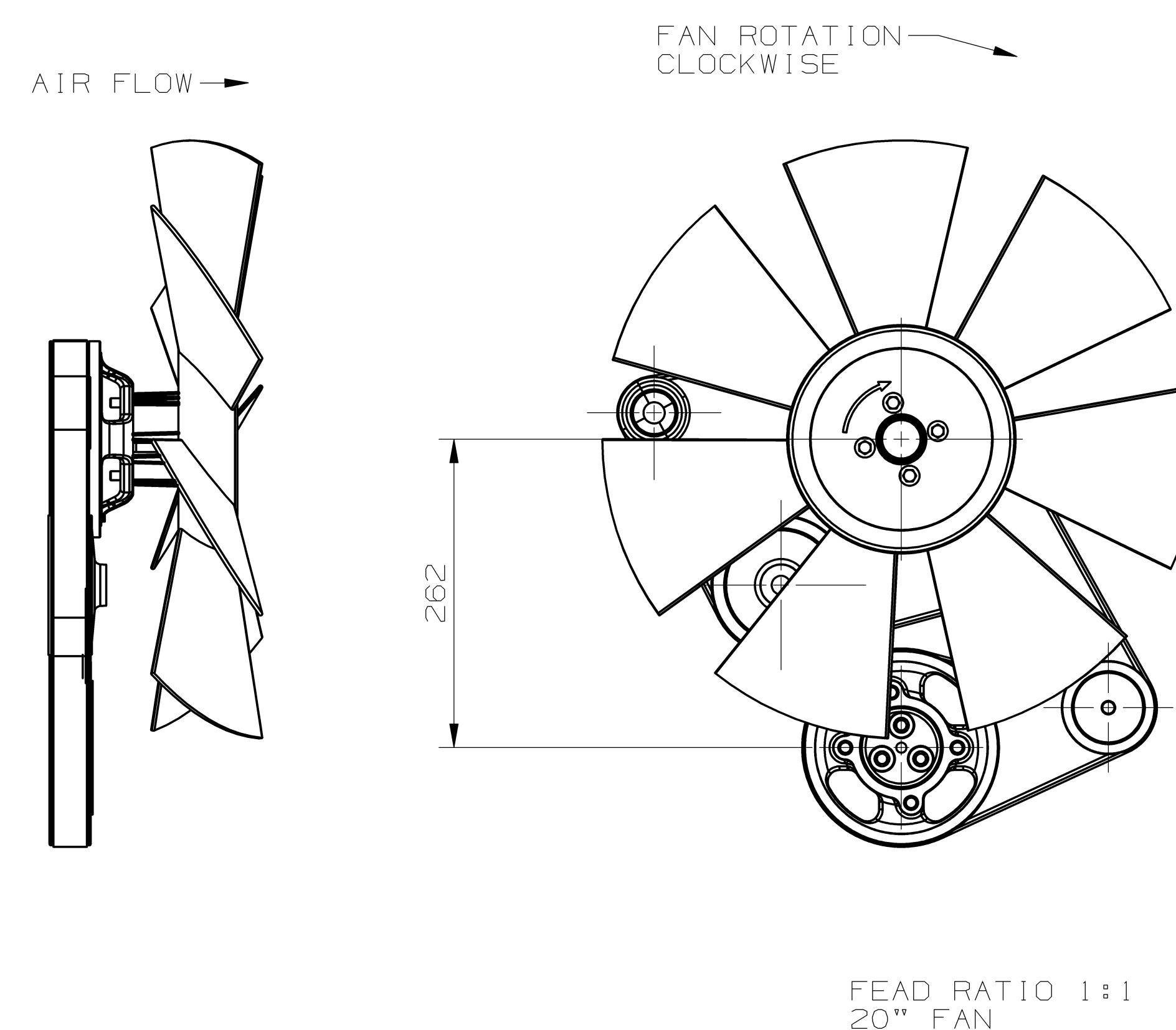
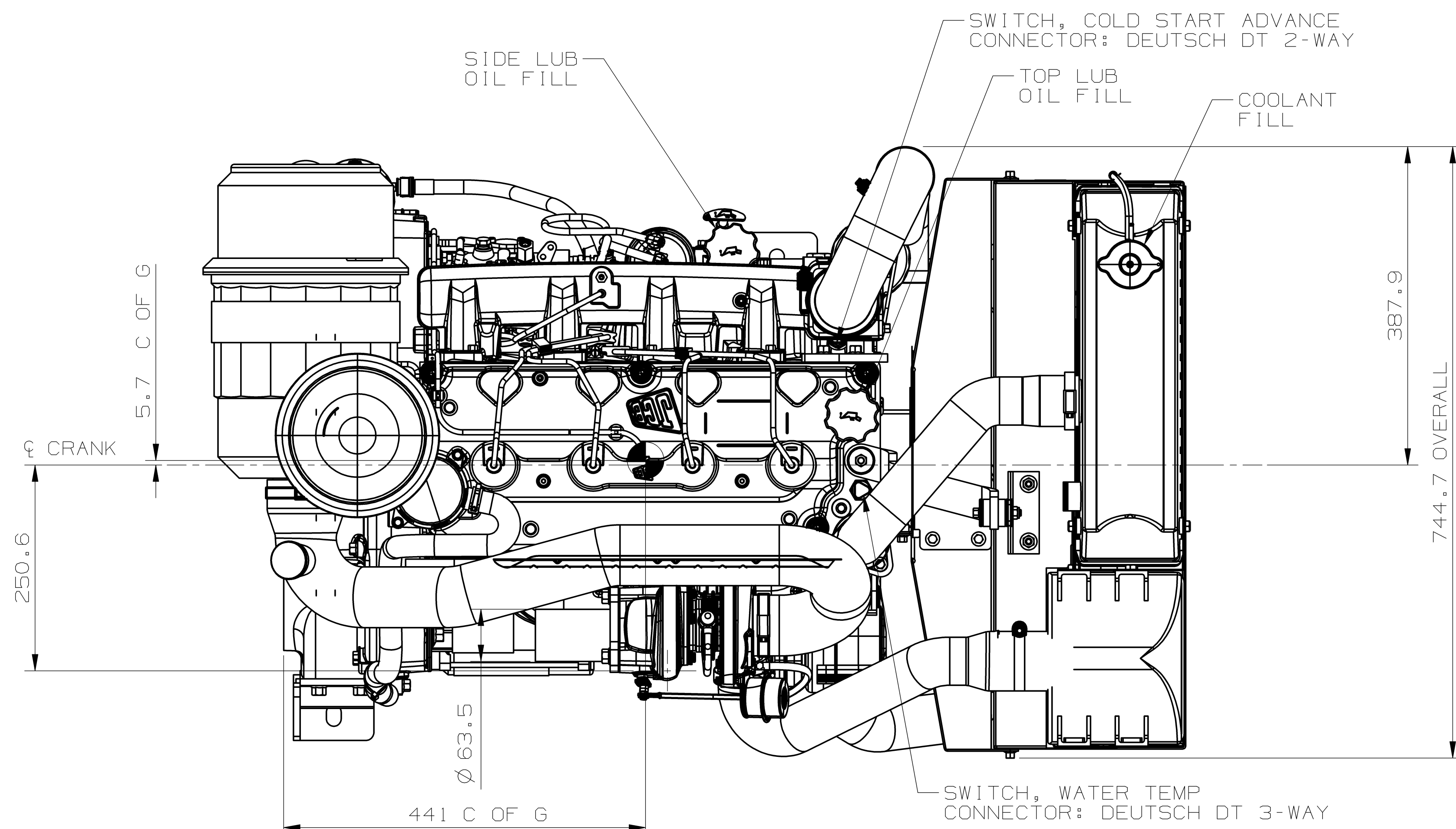


ALL DIMENSIONS IN mm IF IN DOUBT, ASK DO NOT SCALE DRAWING

PI No. C02153_AA
 ISSUE 1 DRAWN J HEALEY DATE 03/08
 PRODUCTION RELEASE



NOTES:
 WEIGHT = 595 KG DRY
 CENTRE OF GRAVITY SHOWN THUS LOCATED:
 X = 265.0
 Y = 5.7
 Z = 150.6
 FROM REAR FACE OF CYLINDER BLOCK, CRANKSHAFT Q

LINEAR DEVIATIONS		PERMISSIBLE DEVIATIONS FOR SIZE RANGE							MATERIAL	
DIMENSION IN mm	0.5 UP TO 3	OVER 3 UP TO 6	OVER 6 UP TO 30	OVER 30 UP TO 120	OVER 120 UP TO 400	OVER 400 UP TO 1000	OVER 1000 UP TO 2000	OVER 2000 UP TO 4000	SEE COMPONENTS	
		±0.5	±1	±1.5	±2.5	±4	±6	±8	FINISH SEE COMPONENTS	
EXTERNAL RADII & CHAMFERS									HEAT TREATMENT	
		±0.4	±1							
ANGULAR DEVIATIONS										
SHORTER SIDE OF ANGLE mm	UP TO 10	OVER 10 UP TO 50	OVER 50 UP TO 120	OVER 120 UP TO 400	OVER 400					
	+3'	+2'	+1'	+0° 30'	+0° 20'					
GEOMETRIC TOLERANCE DEVIATIONS									CIRCULAR RUN-OUT	
	UP TO 10	OVER 10 UP TO 30	OVER 30 UP TO 100	OVER 100 UP TO 300	OVER 300 UP TO 1000	OVER 1000 UP TO 3000				
STRAIGHT/FLAT	0.05	0.1	0.2	0.4	0.6	0.8				
PERPENDICULAR	0.4	0.4	0.4	0.6	0.8	1	0.2			

DRAWN		DATE	BUSINESS UNIT
J HEALEY		03/01/08	Power-Systems
TOLERANCES COMPLY TO STD 00023 VERY COARSE		GEOMETRIC TOLERANCE K	MASS (kg) SEE NOTES

TITLE		
TCA IPU INSTALLATION DETAILS (T3 MECH)		
DRAWING NUMBER	SHEET NUMBER	SCALE
320/00123	1 OF 2	AO 1:4
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