



TECHNICAL REQUIREMENTS

1. THE FORGING SHALL BE SUPPLIED EXACTLY IN CONFORMITY WITH THE PURCHASING SPECIFICATION NO. HY 19485.
2. THE FORGING SHALL BE SUPPLIED IN ROUGH MACHINED CONDITION. THE PERMISSIBLE TOLERANCES ON OUTSIDE DIMENSION: $\pm 2\text{mm}$.
3. UNSPECIFIED RADII SHALL BE TAKEN AS R10.
4. BRACKETED DIMENSIONS ARE FOR REFERENCE ONLY.
5. AT THE PLACES MARKED T1 AND T2 SUPPLIER SHALL LOCATE THE TANGENTIAL TEST SAMPLES FOR MECHANICAL TESTING AND GET IT APPROVED FROM BHHEL. PART OF THE TEST SAMPLE SHALL BE LEFT INTEGRAL WITH THE SHAFT FOR RETESTING PURPOSES AT BHHEL.
6. PERMISSIBLE RADIAL RUN OUT OF SHAFT IS 1mm WITH RESPECT TO STEADY REST BEARING. [A] [B].
7. THE IDENTIFICATION NUMBER MUST BE STAMPED AT THE PLACE MARKED IN AND SURROUNDED WITH PAINT. IDENTIFICATION ACCORDING TO ST. 00004.
8. THE AXIAL TREPAN BORE AFTER TESTING SHALL BE PLUGGED BY DETACHABLE PLUG. THE PRESERVATIVE USED FOR PROTECTING THE BORE AGAINST CORROSION MUST BE ABLE TO BE REMOVED BY COLD DEGREASING AGENT.
9. AXIAL TREPAN CORE TESTING SHALL BE AS PER VARIANT-02 OF SHEET 2 OF THIS DRAWING.

FOR TESTING OF AXIAL CORE REFER SHEET NO. 2

ST 351B 50000		HY 19485	
VAR. DO	ITEM NO.	ITEM NO.	ITEM NO.
32	32	32	32
DESCRIPTION		DESCRIPTION	
N30-2x3.2		N30-2x3.2	
TYPE OF PRODUCT		TYPE OF PRODUCT	
OR		OR	
NAME OF CUSTOMER / PROJECT		NAME OF CUSTOMER / PROJECT	
BHARAT HEAVY ELECTRICALS LTD.		BHARAT HEAVY ELECTRICALS LTD.	
HYDERABAD		HYDERABAD	
DATE		DATE	
25.6.82		25.6.82	
REV.		REV.	
1		1	
TITLE		TITLE	
FORGING FOR L.P. TURBINE SHAFT		FORGING FOR L.P. TURBINE SHAFT	
(ROUGH MACHINED)		(ROUGH MACHINED)	
DRAWING NO.		DRAWING NO.	
1-103-01-62901		1-103-01-62901	
SHEET NO.		SHEET NO.	
1		1	
NO. OF SHEETS		NO. OF SHEETS	
2		2	

REV	DATE	ALT	CHD	LD	REV	DATE	ALT	CHD	LD
06	16.7.03	END	DIR	LD	02	26.10.82	CHD	N	LD
TR-1 SPEC. WAS HW19367 REV. 12.29					TR-1 SPEC. WAS HW19367 REV. 12.29				
TITLE: MAIL CODE WAS HW19367					TITLE: MAIL CODE WAS HW19367				
TR-1 Modified					TR-1 Modified				
Dim 1253 was 1253					Dim 1253 was 1253				
Dim 160 & 124 were 184 and 124					Dim 160 & 124 were 184 and 124				
Dim 160 was 180					Dim 160 was 180				
Dim 428 was 448					Dim 428 was 448				
Dim 806 was 786					Dim 806 was 786				