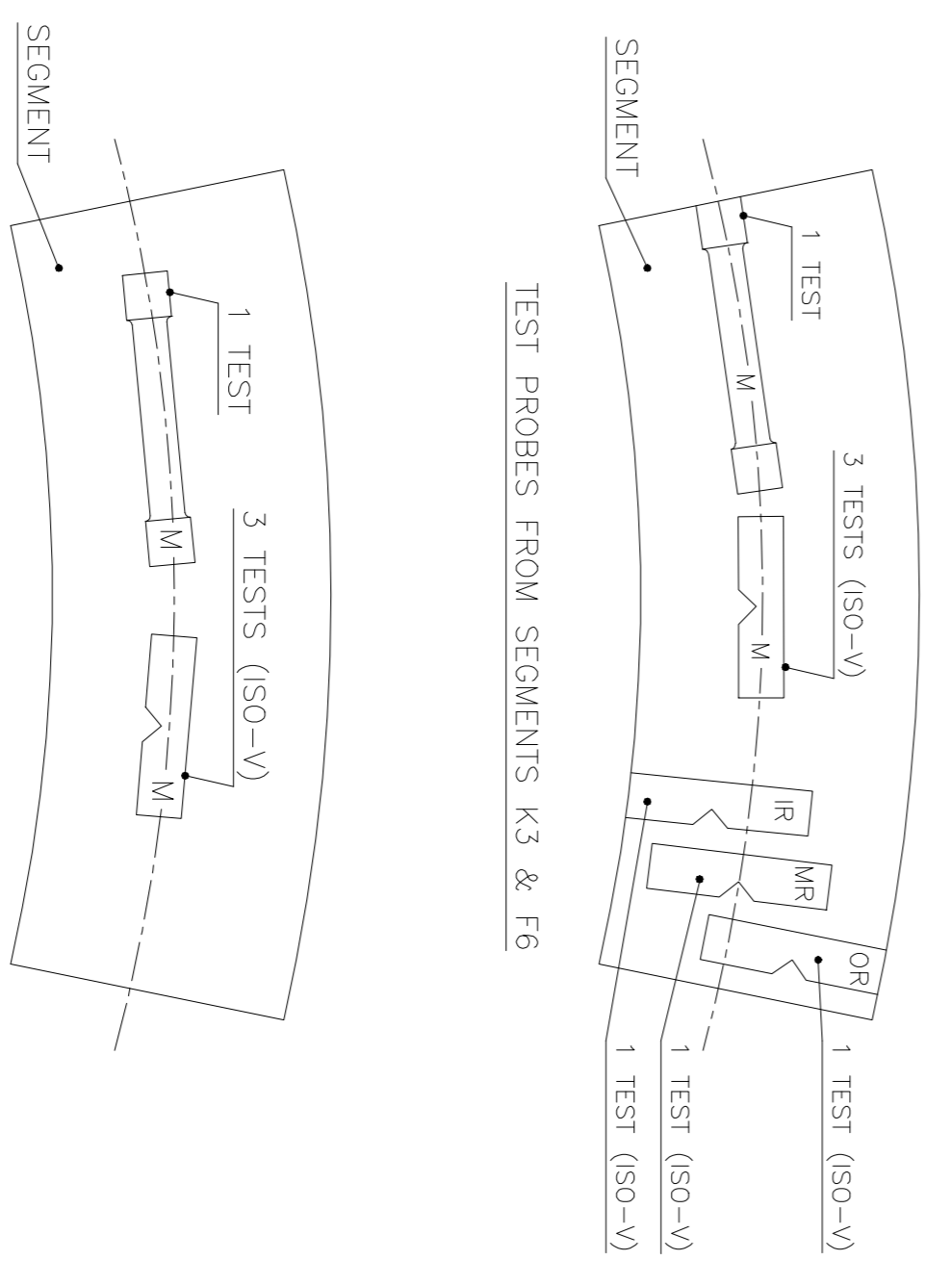
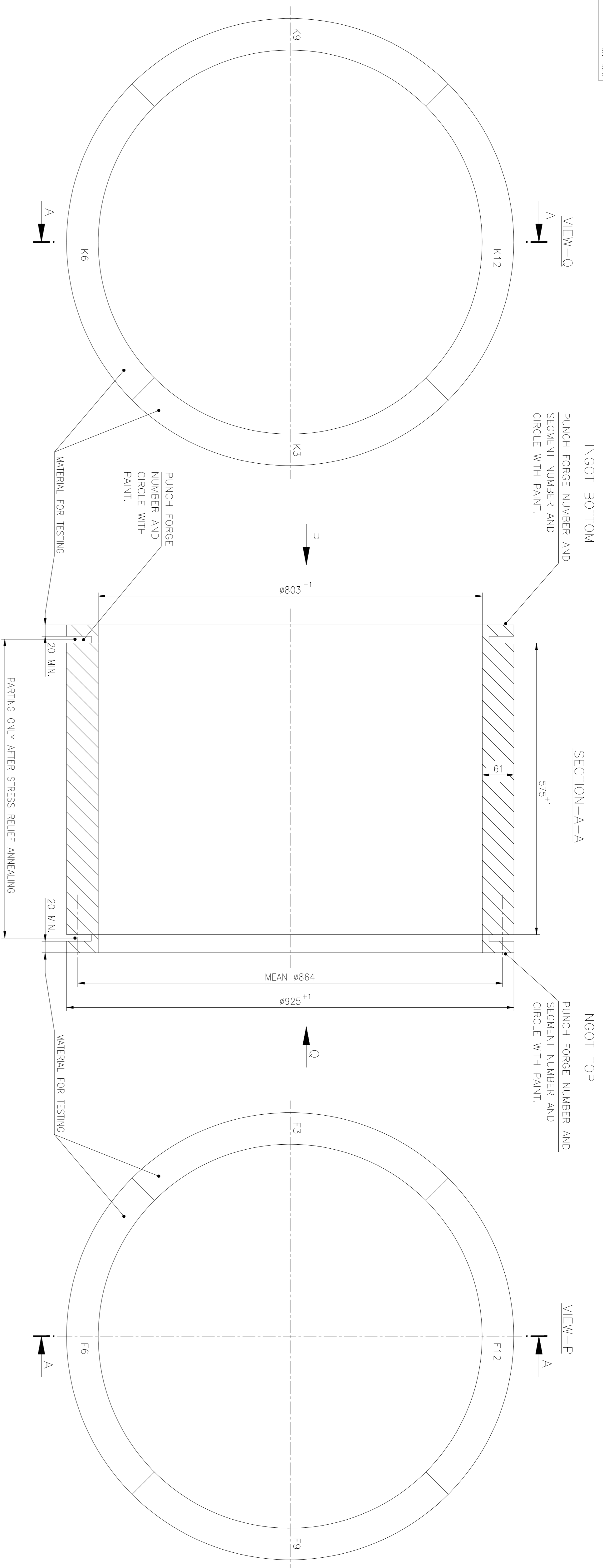


10/6503-90-921-1
CN 984

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)



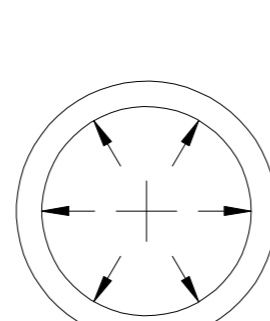
M : MEAN DIA
IR : INNER RADIAL
OR : OUTER RADIAL

R : RADIAL
MR : MEAN RADIAL

REV.	DATE	ALTERED	REV.	DATE	ALTERED
01	09.06.04	CHD./APPD.	01	09.06.04	CHD./APPD.

STRENGTH GRADE CHANGED FROM VAR.08 TO VAR.10 OF CLAUSE 12.1 OF SPECIFICATION HY19372 REV.01. DRAWING REDRAWN.

ITEM NO.	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG. NO. OR FORGING DRG. NO.	MATERIAL CODE	NET WT.	GROSS WT.	QUANTITY
001	RETAINING RING FORGING-ROUGH MACHINED	1-136-06-30529	01	FORGING	TG9517250274 HY19372	703	2	NA



- REMARK:**
1. MATERIAL OF THE FORGING: X8 Cr Mn N18 18K.
 2. SPECIFICATION: HY 19372 (VAR 10.)
 3. SURFACE FINISH OF THE FORGING: $3\frac{1}{2}$ (MICRONS C.L.A.)
 4. THE DRAWING REFERS TO ROUGH MACHINED RETAINING RING FORGING. NO ADDITIONAL ALLOWANCES NEED BE GIVEN OVER THOSE SHOWN ABOVE.
 5. THE RING WILL BE SUBJECTED TO THE FOLLOWING TYPE OF LOAD.

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED....

1. REF. TO HG028281 FOR UNSPECIFIED TOLERANCES.
2. CHAMFER W/CD. SHARP EDGES 1.2 TO 1.0 AT 45°.
3. INTERNAL W/CD. CORNER RADI 1 TO 0.7
4. THE SURFACE ROUGHNESS WHEREVER NOT SHOWN SHALL BE TAKEN FROM THE SURFACE ROUGHNESS SHOWN OUT SIDE BACK SLASHES GIVEN AT THE TOP MOST RIGHT CORNER OF THE DRG.

TYPE OF PRODUCT: TARI 860-24P
NAME OF CUSTOMER/PROJECT: BHARAT HEAVY ELECTRICALS LIMITED HYDERABAD

DEPT. CODE	UNIT. DMS. OR	SCALE	WEIGHT (KG)	DRAWING NO.	CARD CODE
425	g/m ³	NTS	703	2-136-06-31145	01

TITLE: RETAINING RING FORGING

NAME	SIGN.	DATE	NO. OF
K C PANDA	[Signature]	19.5.04	VAR.
U SRINIVAR	[Signature]	19.5.04	NA

SHEET NO. 1 OF 12