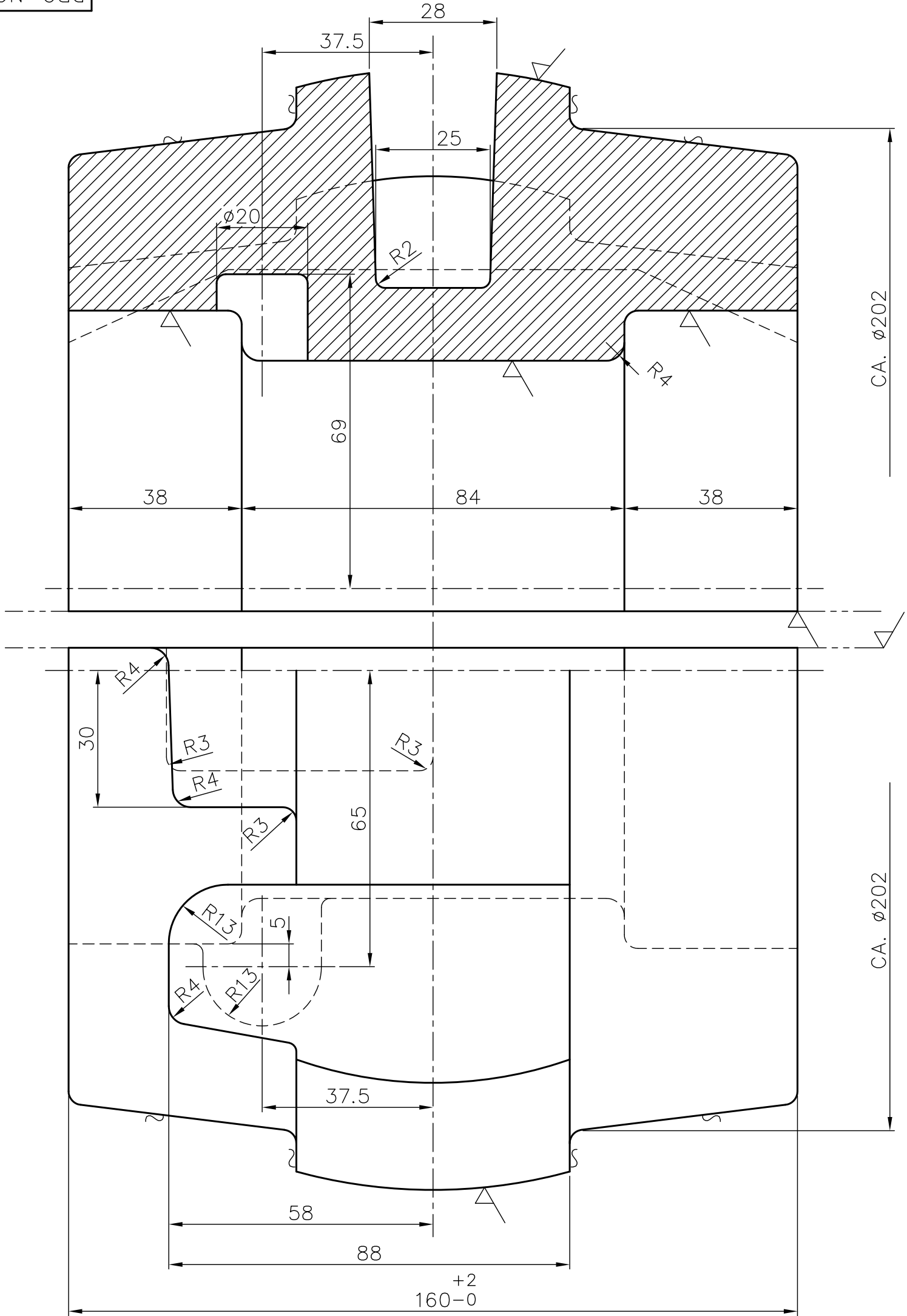
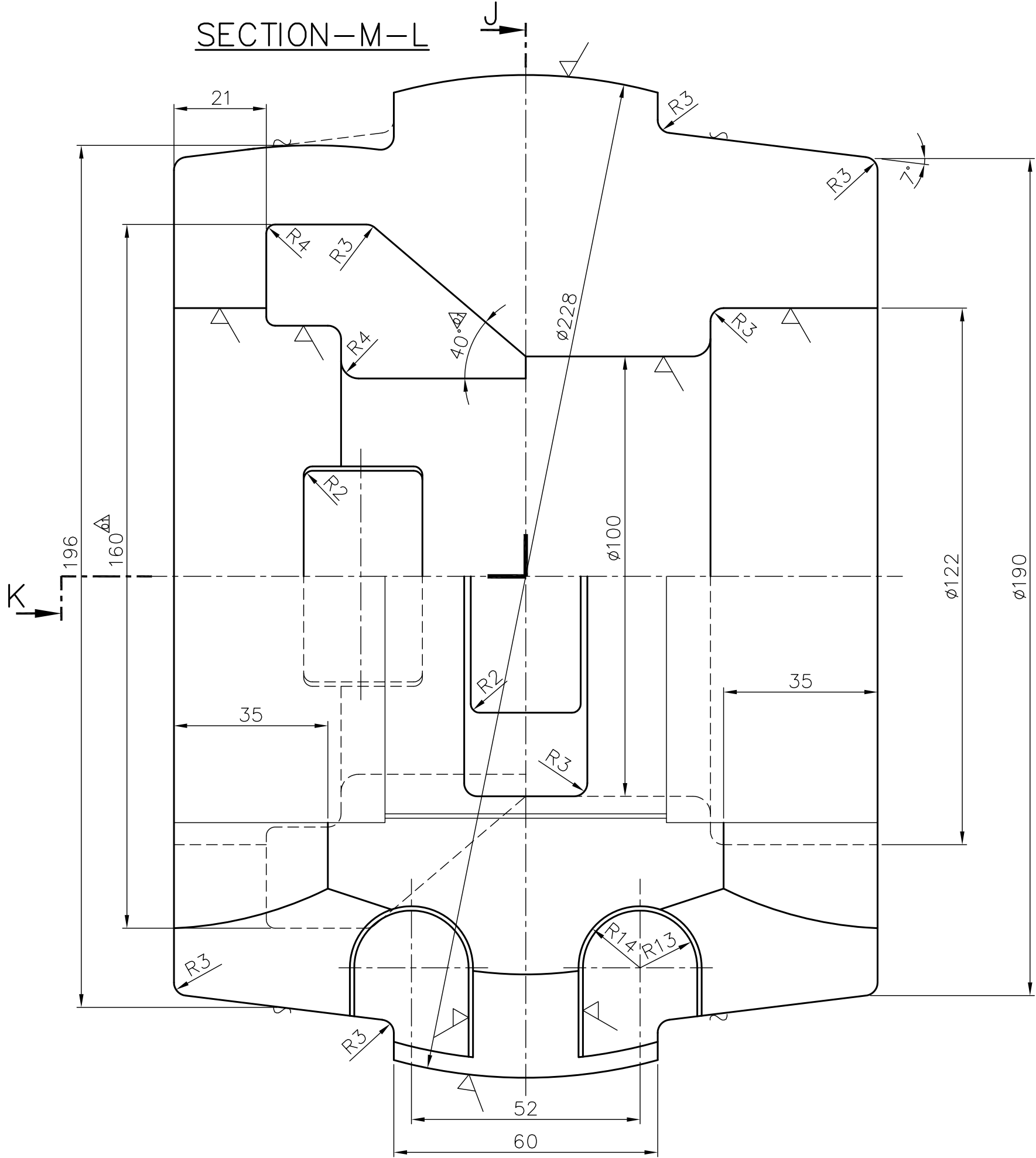


1-142-14-30500/02
DRG. NO.

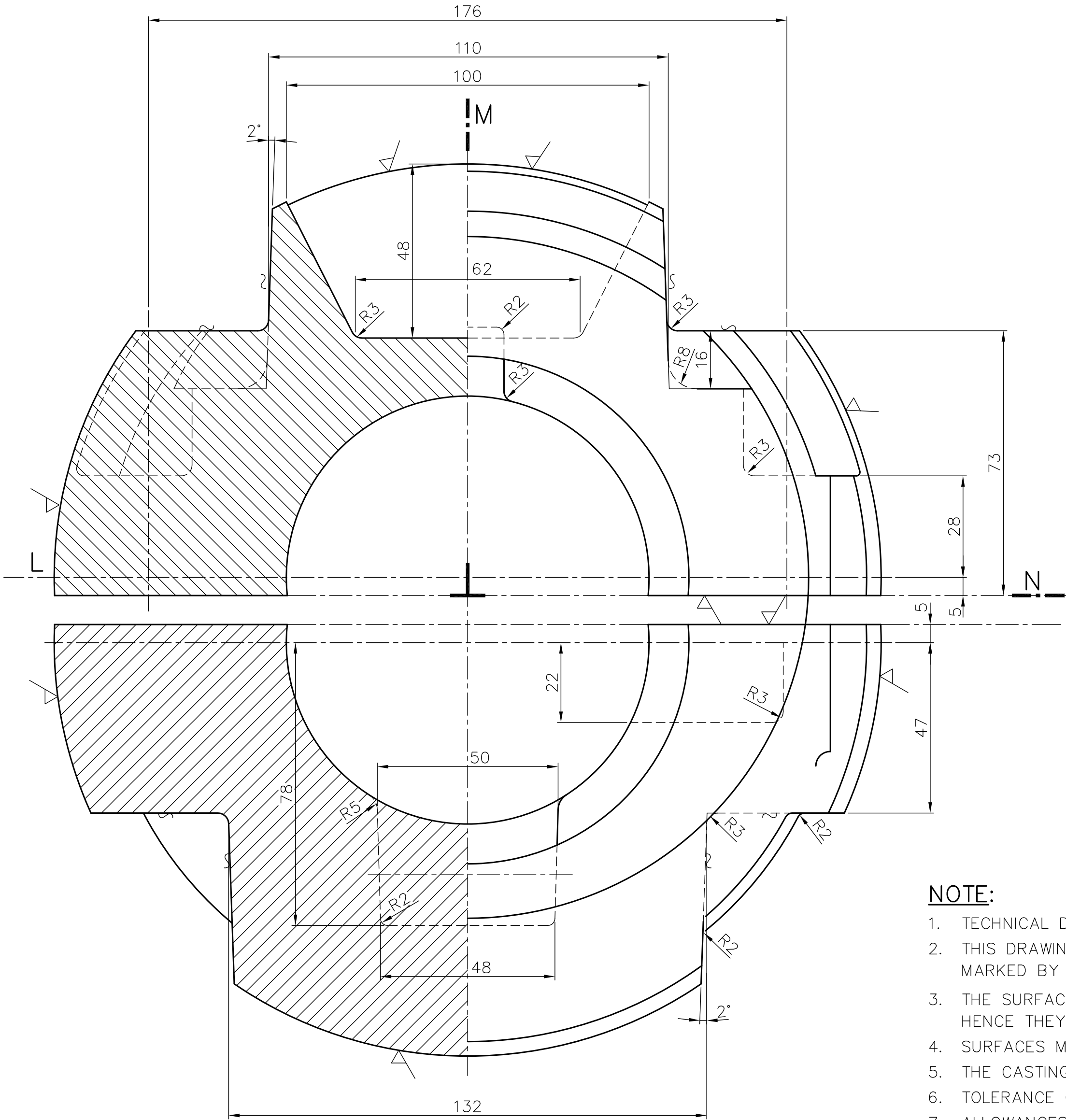
SECTION-M-N



SECTION-M-L



SECTION-J-K



NOTE:

1. TECHNICAL DELIVERY CONDITIONS APPLICABLE AS PER CLAUSE-3, OF AA19521.
2. THIS DRAWINGS IS OF ROUGH CASTING TO BE PROOF MACHINED AT FOUNDRY ON THE SURFACE MARKED BY LINE () TO THE DIMENSIONS SHOWN ON THE DRG.
3. THE SURFACE MARKED (~) ARE AS CAST SURFACE WHICH ARE NOT GOING TO BE MACHINED. HENCE THEY SHOULD BE FREE FROM FOUNDRY DEFECTS REFER CLAUSE 9 OF AA19521.
4. SURFACES MARKED (✓) TO BE MACHINED AT B.H.E.L.
5. THE CASTING SHALL BE SUPPLIED IN THE NORMALISED CONDITION AS PER CLAUSE 7 OF AA19521.
6. TOLERANCE ON PROOF MACHINED SURFACES ±1.
7. ALLOWANCES ON "AS CAST" SURFACES AS PER CLAUSE 5 OF AA 19521.
8. THE NECESSARY FINISH MACHINING ALLOWANCES ARE ALREADY INCLUDED IN THE DIMENSIONS, EXTRA ALLOWANCES ARE NOT REQUIRED.
9. MECHANICAL TESTS SHALL BE CARRIED OUT AS PER CLAUSE 9 OF AA19521 FROM SEPARATELY CAST KEEL BLOCK FOR EACH MELT AS PER CLAUSE 11.4 OF AA19521.
10. THE CASTING ARE TO BE SUPPLIED R/M CONDITION AS PER DRG. DIMENSIONS WITH 12.5 SURFACE FINISH.
11. CASTING SHALL BE DELIVERED TO MEET THE REQUIREMENTS OF AA.19521.
12. M.P.I AND U.T. SHALL BE CARRIED OUT AS PER SPEC. AA0850134 AND AA0850104 TO QUALITY LEVEL 11
13. DIMENSIONAL TOLERANCES ON UNMACHINED SURFACE SHALL BE AS PER CLASS 4 OF ACCURACY AS PER SPEC.AA023042
14. DRG. NO. AND SUPPLIER'S EMBLEM SHALL BE PUNCHED ON THE SURFACE.
15. DEHYDROGENATION ANNEALING TO BE CARRIED OUT AT 650±10 FOR 24hrs.

DRAWING
REDRAWN

					TG9212153216	31	
						1	
ITEM NO.	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG. NO. OR FORGING DRG. NO.	MATERIAL CODE	NET WT.	GROSS WT.
					MATERIAL SPECN.	QUANTITY	

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE SPECIFIED...							
1. REF. TO HY0230261 FOR TOLERANCES.							
2. CHAMFER M/CD SHARP EDGES 1.2 TO 1.0 AT 45°.							
3. INTERNAL M/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 B.L.EXC. TYPE ELR 44/22-30/6-3 OR NAME OF CUSTOMER/PROJECT							
BHARAT HEAVY ELECTRICALS LTD. HYDERABAD							
DEPT.	EME	SCALE	WEIGHT (KG)	REF. TO ASSY DRG.	ITEM NO.	NO. OF ITEMS	NO. OF VAR.
CODE	425	NTS	31.00	N.A	N.A	N.A	N.A
TITLE BEARING SHELL CASTING				DRAWING NO. 1-142-14-30500			
				REV. 02			

REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED
		CHECKED	02	19.11.19	CHECKED	01	22.7.95	CHECKED
			R NARASING					
			CHECKED MNVSP			APPD. KKROY		
			ZONE			ZONE		
			DIMENSIONS 170 & 45° CHANGED TO 160 & 40° RESPECTIVELY.			TOLERANCE FOR LENGTH GIVEN.		