FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

DRG. NO. 1-61-110-01564

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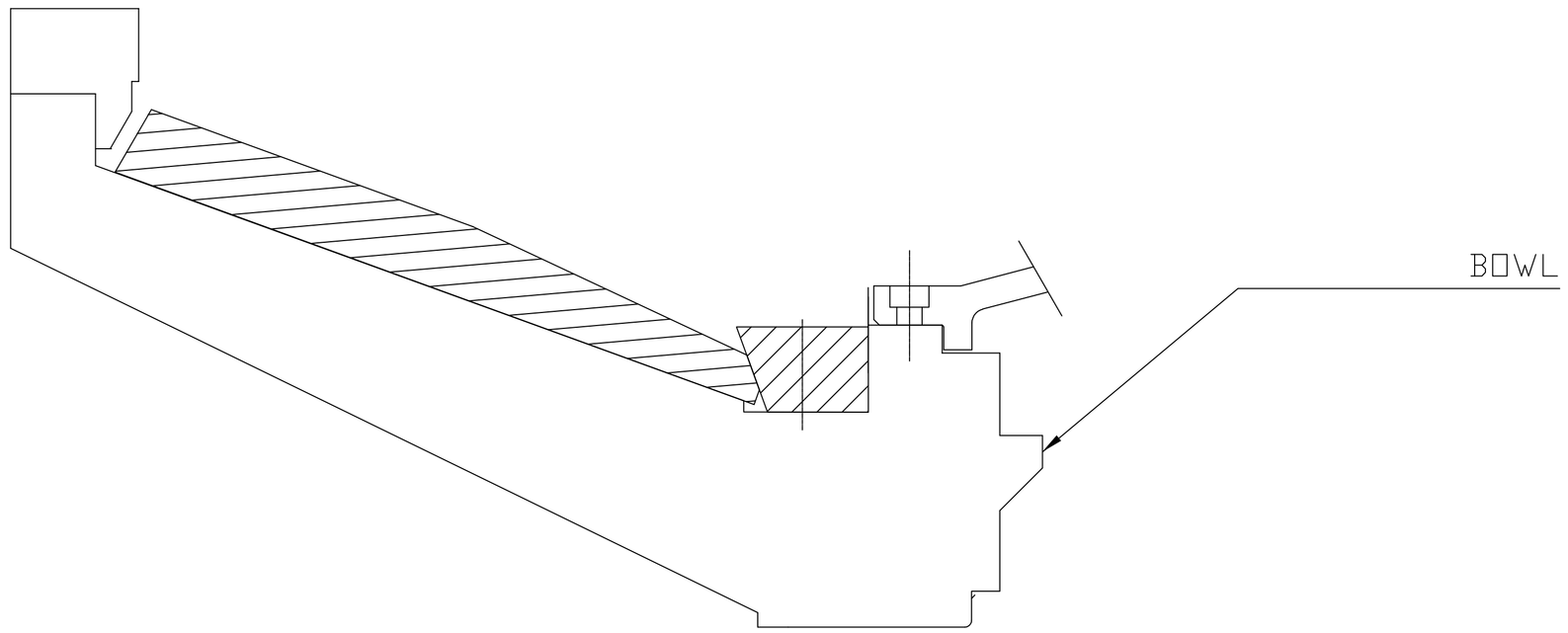
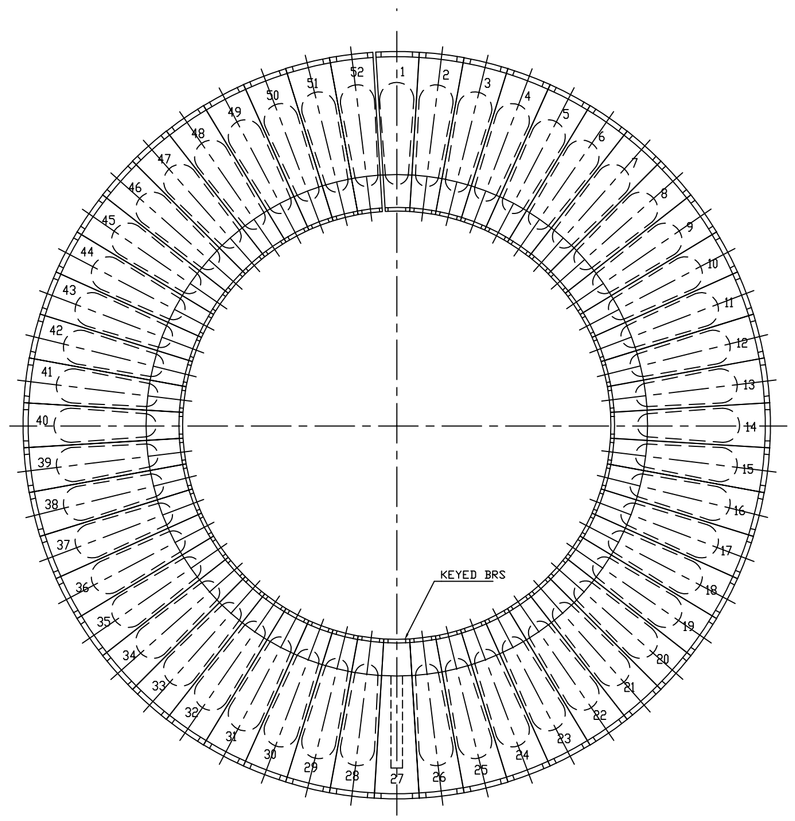
COMPUTER FILE NAME | REF. DRG. NO. | SIGN. AND DATE | INVENTORY NO





NOTES:-

01. TOTAL NUMBER OF BULL RING SEGMENTS SHALL BE 52 Nos. (51 Nos. PLAIN & 1 No. KEYED BRS).
02. IN THE ASSEMBLED CONDITION OF BRS THE GAP BETWEEN SIDE FACES SHOULD BE LESS THAN 1.6 MM. THE GAP IS TO BE CONTROLLED TO LESS THAN 0.8 MM. OVER A LENGTH OF 75 MM. AT BOTH INNER AND OUTER DIAMETERS OF ASSEMBLY.
03. ALL THE SEGMENTS SHOULD BE ASSEMBLED AND MATCHED AS A SET IN CHECK BOWL & NUMBERED SERIALLY
04. REQUIRED QTY. OF QUATER AND HALF SEGMENTS CAN BE USED.
05. M.S SHIMS OF THICKNESS 3.2 MM, 12 MM, 16MM & 18 MM WILL BE SUPPLIED WITH EACH SET.
06. THE BULL RING SEGMENTS SHOULD BE IN LEVEL WITH EACH OTHER WITHIN 3 MM.
07. AFTER ASSEMBLY OF 52 SEGMENTS, FINAL "ZERO"(0) GAP TO BE ENSURED.
08. B R SEGMENT PLAIN 2-61-110-02904 (51 NOS).
09. B R SEGMENT KEYED 2-61-110-02905(1 NO).

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 STATED.

1. REF. TO HY0230261 FOR UNSPECIFIED TOLERANCES.
2. CHAMFER M/CD. SHARP EDGES 1.2 TO 1.0 AT 45°.
3. INTERNAL M/CD. CORNER RADII 1 TO 0.7
4. THE SURFACE ROUGHNESS WHERE-EVER NOT SHOWN SHALL BE TAKEN FROM THE SURFACE ROUGHNESS SHOWN OUT SIDE THE BACK SLASH GIVEN OR THE TOP MOST RIGHT CORNER OF THE DRG.

TYPE OF PRODUCT

NAME OF CUSTOMER/PROJECT

BHARAT HEAVY ELECTRICALS LIMITED
HYDERABAD

	NAME	SIGN.	DATE	NO.OF VAR.
DRN.	R.RANJAN		26.6.09	
CHD.	A.SURIN		26.6.09	
APPD.	S.GHATGE		26.6.09	

DEPT.	UNTOL. DIMS. GR.		SCALE	WEIGHT (KG)	REF. TO ASSY DRG.	ITEM NO.	NO.OF ITEMS
PULV ENGG. CODE 446	¢/M/¢		NTS	1:2.75			

TITLE BULL RING SEGMENT ASSEMBLY

DRAWING NO. 1-61-110-01564 REV. 01

SHEET NO. 01 NO OF SHEETS 01

REV.	DATE	ALTERED	APPD.	REV.	DATE	ALTERED	APPD.	REV.	DATE	ALTERED	APPD.
		CHD.				CHD.		01	24.11.14	CHD. MTT AMAN	SG
ZONE				ZONE				ZONE			
								E,6		POINT 07 IN THE NOTE CHANGED.	