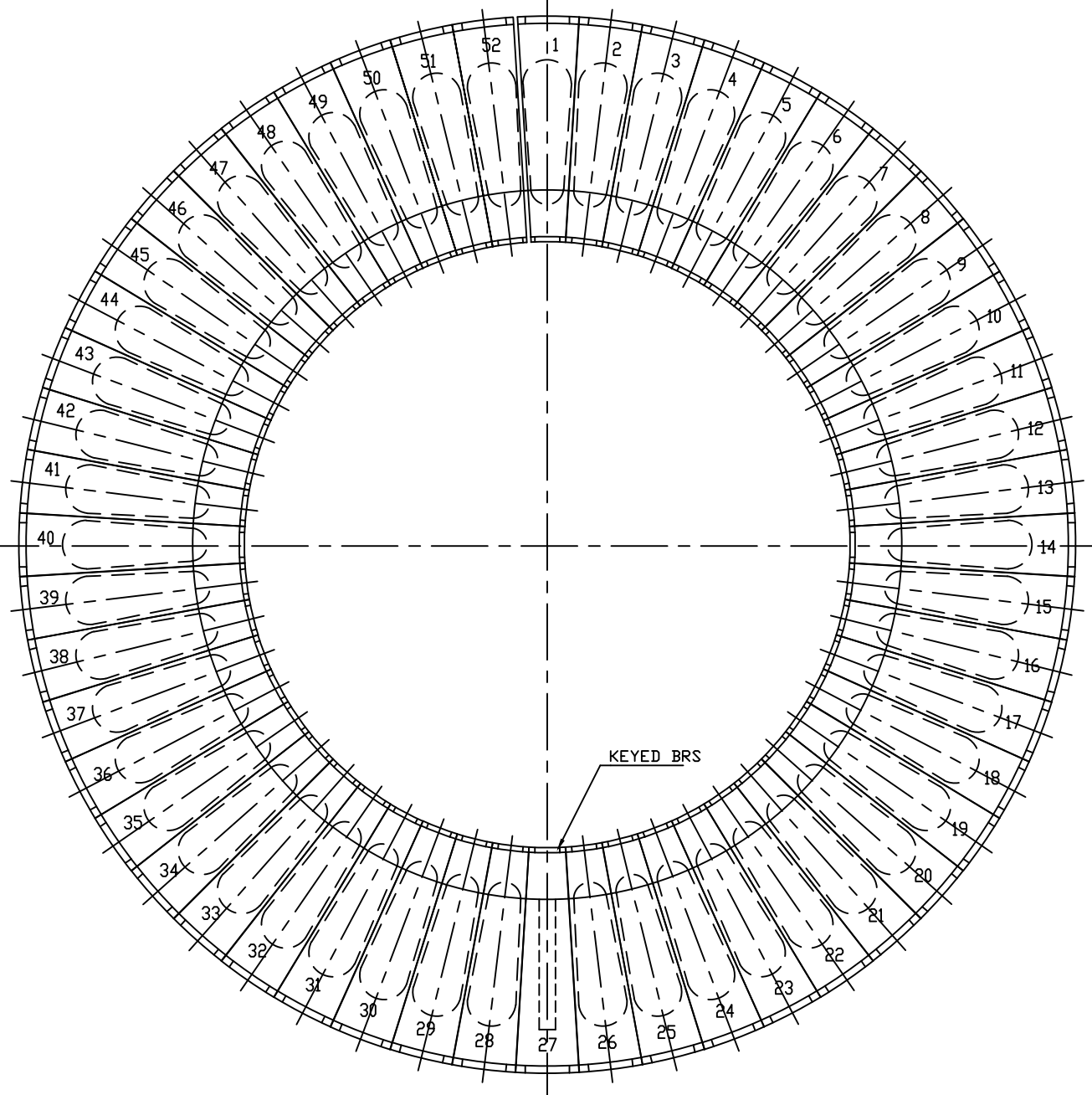


INVENTORY NO
SIGN. AND DATE
REF. DRG. NO.
COMPUTER FILE NAME
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FIRST ANGLE PROJECTION

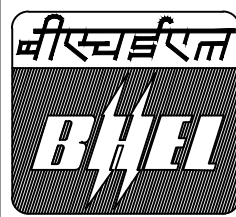
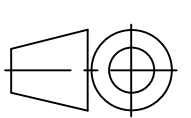
(ALL DIMENSIONS ARE IN mm)



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 SERIALY
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.										TYPE OF PRODUCT									
1. REF. TO HY0230261 FOR UNSPECIFIED TOLERANCES.										NAME OF CUSTOMER/PROJECT									
2. CHAMFER M/CD. SHARP EDGES 1.2 TO 1.0 AT 45°.											BHARAT HEAVY ELECTRICALS LIMITED		DRN.	R.RANJAN	SIGN.		DATE	26.6.09	NO.OF VAR.
3. INTERNAL M/CD. CORNER RADII 1 TO 0.7											HYDERABAD		CHD.	A.SURIN			26.6.09		
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.													APPD.	S.GHATGE			26.6.09		
DEPT. PULV ENGG. CODE 446		UNTOL. DIMS. GR. ϕ /M/7				SCALE NTS		WEIGHT (KG) 1:2.75		REF. TO ASSY DRG.				ITEM NO.		NO.OF ITEMS			
TITLE BULL RING SEGMENT ASSEMBLY										DRAWING NO. 1-61-110-01564				REV. 01					
										SHEET NO. 01				NO OF SHEETS 01					