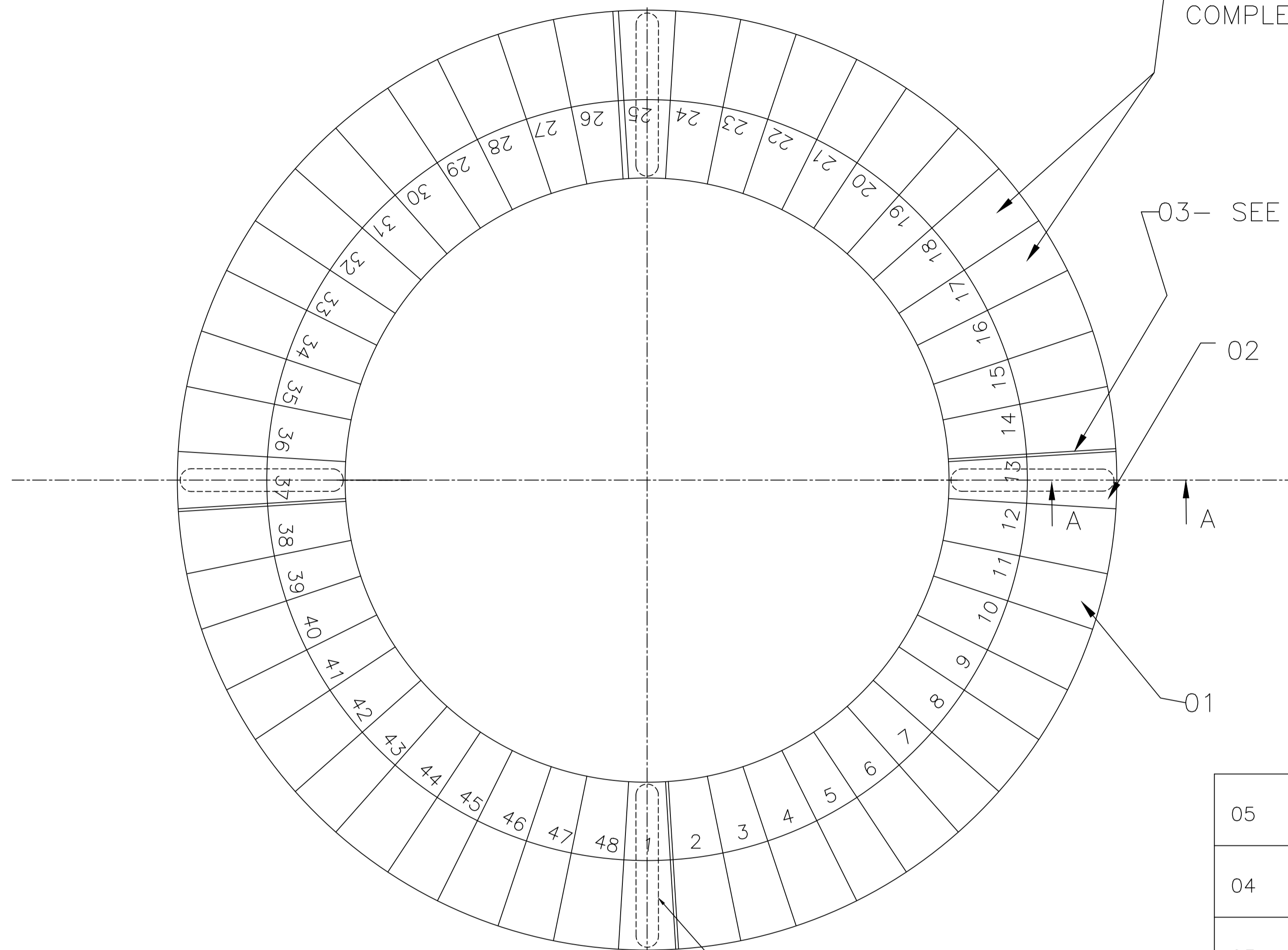


DRG. NO. 2-61-104-02603

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1.5 MAX MISMATCH IS ALLOWED BETWEEN THESE SURFACES OF ANY PAIR AND 3 MAX. MISMATCH ALLOWED IN COMPLETE ASSEMBLY

ACCEPTANCE CRITERION ON CHECK BOWL.

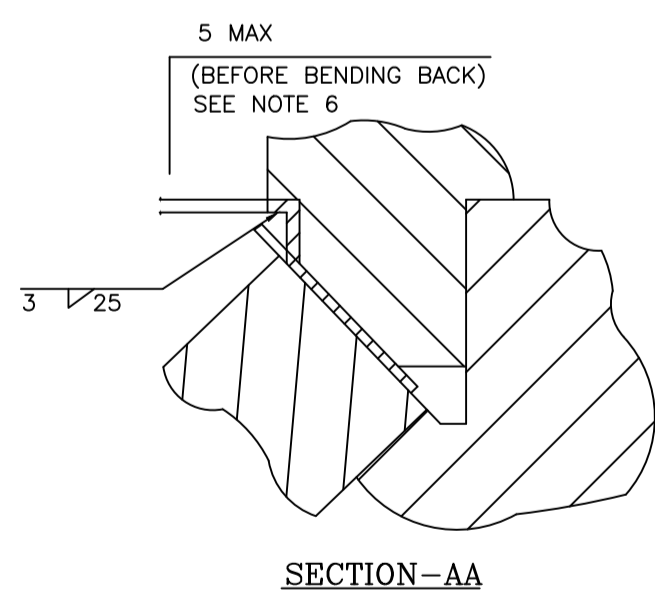
1. GAP BETWEEN THE FIRST AND THE LAST SEGMENT SHALL BE 6 ± 2 MM BEFORE SHIM FITTING.
2. USE REQUIRED QUANTITY OF QUARTER SEGMENTS TO ACHIEVE THIS.
3. GAP TO BE CLOSED WITH ONE NO. OF 3.15 (VAR 01) OR 6 (VAR 02) SHIM.

- NOTE:
1. ONLY ONE BULL RING SEGMENT SIDE SHIM IS PERMITTED BETWEEN EACH KEYED SEGMENT. SHIM TO BE LOCATED AS SHOWN. DRIVE ALL SEGMENTS COUNTER CLOCK WISE TO SEAT KEY SURFACE 'X' BEFORE GAUGING SHIM GAP. ALL (4) KEYED SEGMENTS MUST BEAR ON BOWL KEYWAY AT SURFACE 'X'. MARK ALL SEGMENTS WITH SEQUENCE NUMBERS WITH A KEYED SEGMENT AS #1.
 2. FURNISH FOLLOWING WITH EACH ASSEMBLY SECURELY WRAPPED, WIRED AND MARKED WITH THICKNESS, DRG NO & VAR. NO
 1. 4 SETS OF B.R.SIDE SHIM ITEM NO. 3
 2. ONE SET OF B.R.S. END SHIM ITEM NO. 4
 3. 2 NOS OF QUARTER SEGMENTS (ITEM NO.05)

CAUTION FOR ERECTION

1. NO GAP IS PERMITTED AT SITE. HAMMER IN SHIMS/WEDGES TO ACHIEVE TIGHTFIT ASSEMBLY.

SURFACE 'X'. SEE NOTE 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	
05	BULL RING SEGMENT QUARTER	2-61-104-02341				10.00	
04	BULL RING SEGMENT END SHIM SET	4-61-104-01026	VAR 1 TO 5			11.00	
03	BULL RING SEGMENT SIDE SHIM SET	3-61-104-01020	VAR 1 TO 3			9.00	
02	BULL RING SEGMENT KEYED	2-61-104-02340				48.00	
01	BULL RING SEGMENT PLAIN	2-61-104-02339				43.00	44

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.

NOTE 1 MODIFIED. NOTE 4 DELETED. CAUTION FOR ERECTION ADDED.

TYPE OF PRODUCT				NAME OF CUSTOMER/PROJECT				
BHARAT HEAVY ELECTRICALS LIMITED HYDERABAD				DRN.	NAME	SIGN.	DATE	NO.OF VAR.
				CHD.	ND SAMUEL	<i>[Signature]</i>	5.08.03	
				APPD.	S.GHATGE	<i>[Signature]</i>	5.08.03	
DEPT. PULV ENGG. CODE 446	UNTO. DIMS. GR. ϕ /M/F	SCALE NTS	WEIGHT (KG) 1852.0	REF. TO ASSY DRG.	ITEM NO.	NO.OF ITEMS		
TITLE				DRAWING NO.		REV.		
BULL RING ASSEMBLY				2-61-104-02603		01		
				SHEET NO. 01		NO OF SHEETS 01		

REV.	DATE	ALTERED	APPD.	REV.	DATE	ALTERED	APPD.
ZONE		CHD.		ZONE		CHD.	