

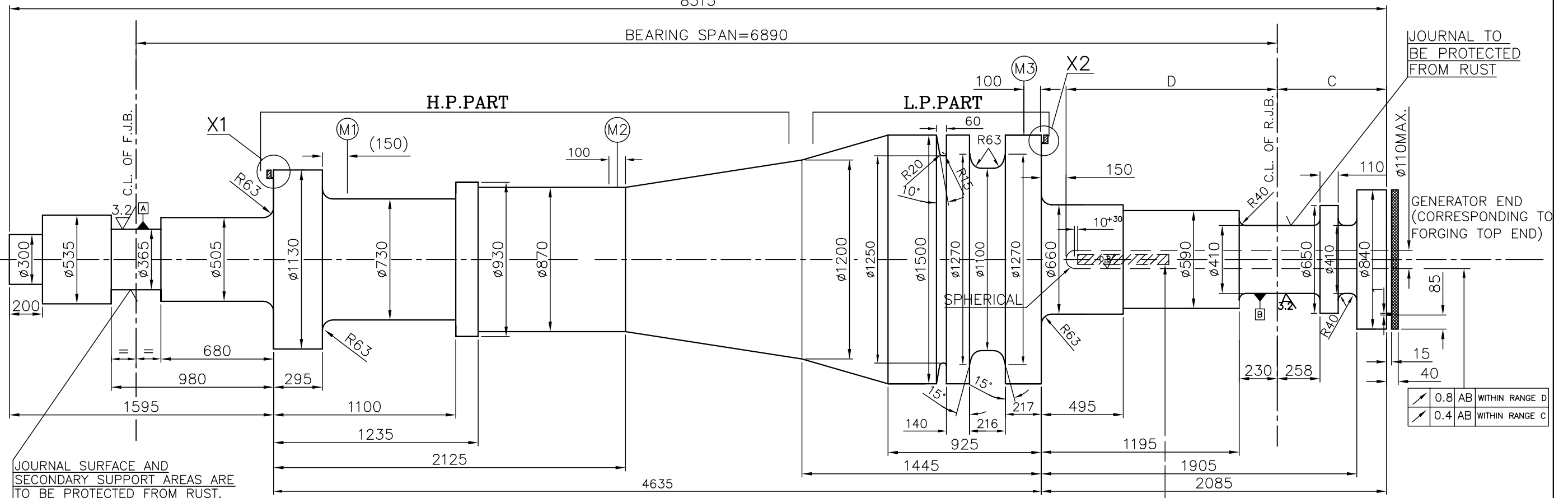
GENERAL DIMENSIONAL LIMITS, FITS & TOLERANCES AS PER HY0230261

DRG. NO. 3-303-01-20138

SH. 01 OF 01

8315

BEARING SPAN=6890

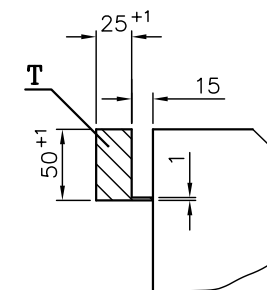


(M1) (M2) (M3) MEASURING LOCATIONS FOR THERMAL STABILITY TEST
EXACT LOCATION IN THE MEASURING LOCATION IS TO BE DECIDED BY THE SUPPLIER.

NOTES:—


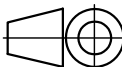
1. ROTOR FORGING TO BE SUPPLIED AS PER PURCHASE SPEC. NO. MENTIONED IN VARIANT TABLE.
2. UNMENTIONED RADII $R=10$
3. THERMAL STABILITY TEST IS TO BE DONE.
4. TOLERANCES OF DIMENSIONS AS PER PURCHASE SPECIFICATION.
5. THE AXIAL CORE SHALL BE TESTED BY THE SUPPLIER AS PER OUR PURCHASE SPECIFICATION MENTIONED IN VARIANT TABLE. THE SUPPLIER SHALL SUBMIT TO BHEL THE TEST CERTIFICATES WITH ALL THE TEST RESULTS AND THE SAMPLING PLAN. THE REMAINING AXIAL CORE DULY MARKED FOR IDENTIFICATION SHALL BE SENT TO BHEL.
6. IN CASE THE TEST RESULTS ON FIRST AXIAL CORE ARE UNSATISFACTORY, BHEL MAY BE APPROACHED FOR NECESSARY ACTION.
7. THE AXIAL BORE AFTER TESTING SHALL BE PLUGGED BY DETACHABLE PLUG. THE PRESERVATIVE USED FOR PROTECTING THE BORE AGAINST CORROSION MUST BE REMOVABLE BY COLD DEGREASING AGENT.

DETAIL – X1 &
X2 (MIRROR IMAGE)



CORE IS TO BE MARKED
WITH THE IDENTIFICATION
NUMBER, CORE NUMBER
AND ACCEPTANCE STAMP

TC9518050015	40724	23CrMoNiWV88 HY19480	00
MATERIAL CODE	Weight (Kg)	MATERIAL PURCHASE SPEC.	VAR.

TYPE OF PRODUCT OR					HNK 90/5.0-7				
NAME OF CUSTOMER/PROJECT									
<div></div> <div>BHARAT HEAVY ELECTRICALS LTD. HYDERABAD</div>						NAME	SIGN.	DATE	NO.OF VAR.
					DRN.	RAJIV	<div>CONFIDENTIAL</div>	29.09.04	
					CHD.	RAJIV		29.09.04	
					APPD.	A. GUPTA		29.09.04	
DEPT. I.T.D	UNTOL. DIMS. GR. C/M/F		SCALE 1: 20	WEIGHT (KG) N.A.	REF. TO ASSY. DRG.		ITEM NO.	NO.OF ITEMS	
CODE 415									
TITLE ROTOR FORGING HNK 90/5.0-7					CARD CODE N.A.	DRAWING NO.			REV.
						3-303-01-20138			
					SHT. No 01		NO. OF SHT. 01		

20-08-2007
09:32:50

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