

INVENTORY NO
SIGN. AND DATE
REF. DRG. NO.
COMPUTER FILE NAME
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GENERAL DIMENSIONAL LIMITS, FITS & TOLERANCES AS PER HY0230261

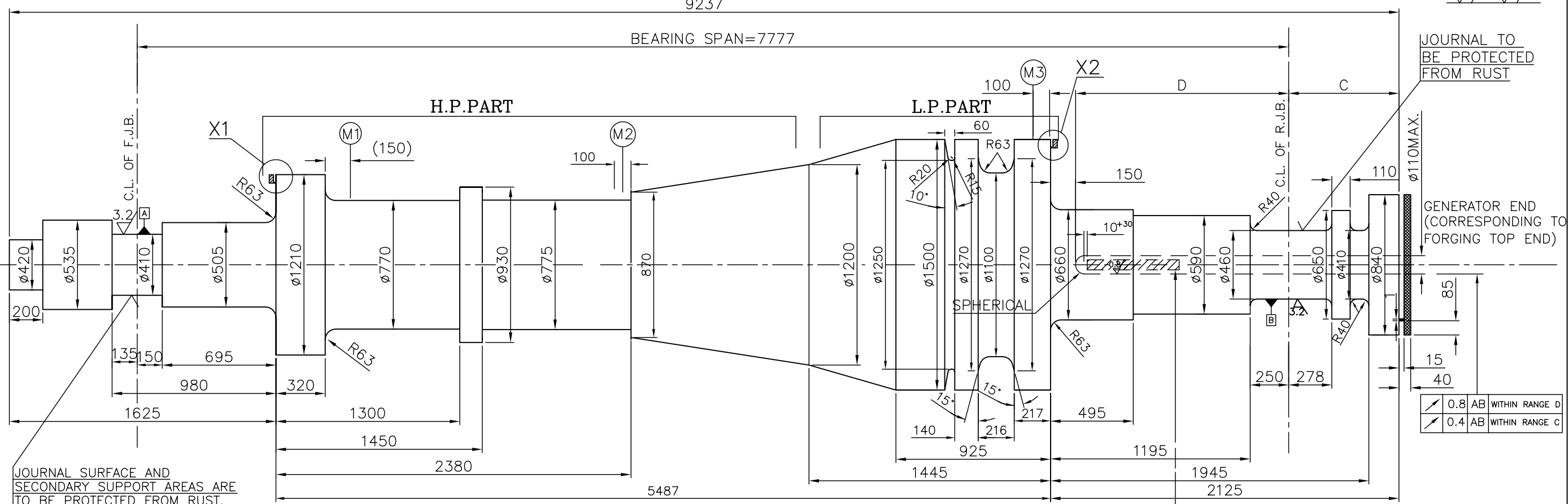
DRG. NO. 3-303-01-20154

SH. 01 OF 01

9237

BEARING SPAN=7777

12.5/3.2/

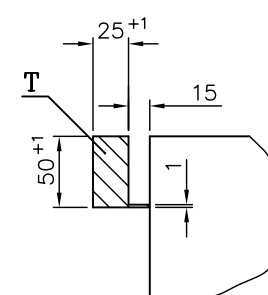


(M1) (M2) (M3) MEASURING LOCATIONS FOR THERMAL STABILITY TEST
EXACT LOCATION IN THE MEASURING LOCATION IS TO BE DECIDED BY THE SUPPLIER.

NOTES:-

1. ROTOR FORGING TO BE SUPPLIED AS PER PURCHASE SPEC. NO. MENTIONED IN VARIANT TABLE.
2. UNMENTIONED RADII R=10
3. TOLERANCES OF DIMENSIONS AS PER PURCHASE SPECIFICATION.
4. 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.
5. IN CASE THE TEST RESULTS ON FIRST AXIAL CORE ARE UNSATISFACTORY, BHEL MAY BE APPROACHED FOR NECESSARY ACTION.
6. 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

TC9518050023	46806	23CrMoNiWV88 HY19480	00
MATERIAL CODE	Weight (Kg)	MATERIAL PURCHASE SPEC.	VAR.

TYPE OF PRODUCT OR
NAME OF CUSTOMER/PROJECT

BHARAT HEAVY ELECTRICALS LTD. HYDERABAD	NAME	SIGN	DATE	NO. OF VAR.
	DRN.	CNVR	2-5-08	
	CHD.	CNVR	2-5-08	
DEPT. I.T.D	APPD.	CNVR	2-5-08	

DEPT. I.T.D	UNTOL. DIMS. GR. C/M/F	SCALE NTS	WEIGHT (KG) N.A.	REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEMS
CODE 415						
TITLE ROTOR FORGING			CARD CODE N.A.	DRAWING NO. 3-303-01-20154	REV. 01	
				SHT. No 01	NO. OF SHT. 01	