FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

DRG. NO. 3-303-01-20217

SH. 01 OF 01

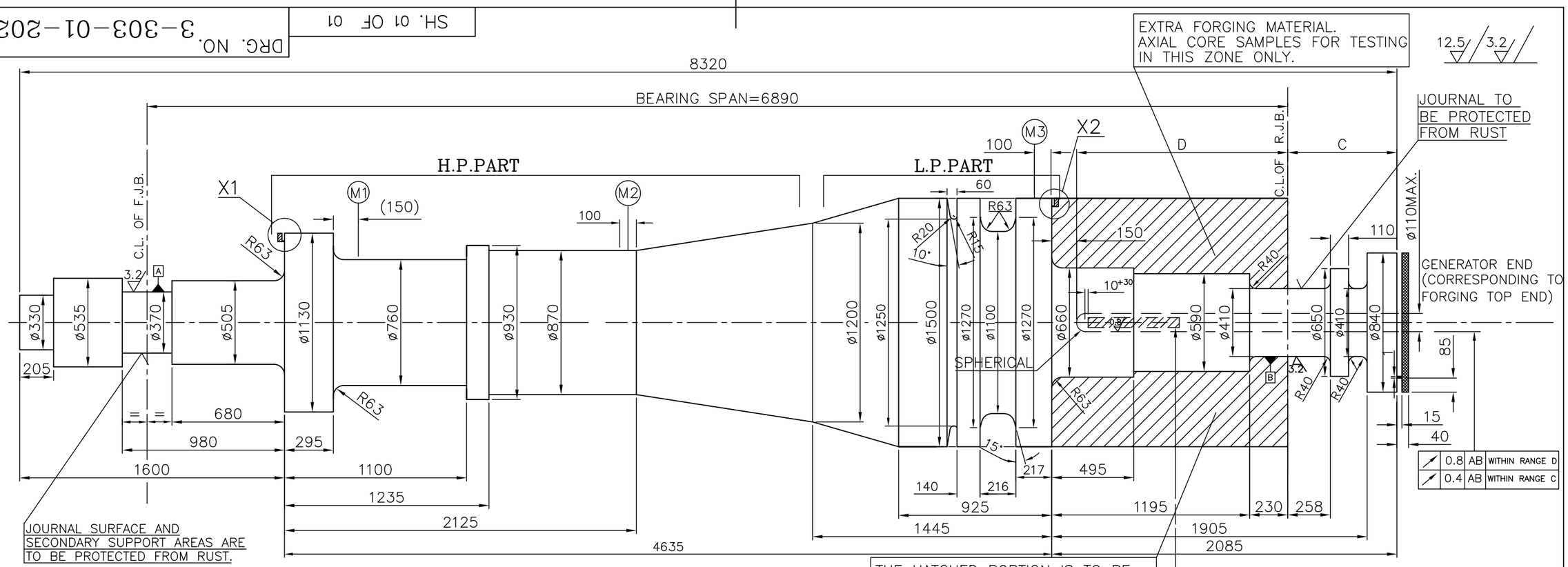
COMPUTER FILE NAME

REF. DRG. NO. 3-30301-20195/M

SIGN. AND DATE

INVENTORY NO

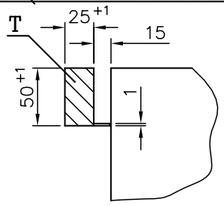
GENERAL DIMENSIONAL LIMITS, FITS & TOLERANCES AS PER HY0230261



M1 M2 M3 MEASURING LOCATIONS FOR THERMAL STABILITY TEST

EXACT LOCATION IN THE MEASURING LOCATION IS TO BE DECIDED BY THE SUPPLIER.

DETAIL – X1 & X2 (MIRROR IMAGE)



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.

T = TANGENTIAL TEST PIECE
Q = RADIAL TEST PIECE

TC9517350023	40946	30CrMoNiV511 HY19473	00
MATERIAL CODE	Weight (Kg)	MATERIAL PURCHASE SPEC.	VAR.

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT: HNK 90/5.0-7

BHARAT HEAVY ELECTRICALS LTD. HYDERABAD

	NAME	SIGN.	DATE	NO.OF VAR.
DRN.	PATIL		22.09.15	
CHD.	ASHOK		22.09.15	N.A.
APPD.	MRB		22.09.15	

RESTRICTED USE

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

DEPT.	UNTOL. DIMS.		SCALE	WEIGHT (KG)	REF. TO ASSY. DRG.	ITEM NO.	NO.OF ITEMS
I.T.D	GR. C/M/F		N.T.S	N.A.	N.A.	N.A.	N.A.
CODE 415							

TITLE: ROTOR FORGING HNK 90/5.0-7

CARD CODE: N.A.

DRAWING NO. 3-303-01-20217 REV. 00

SHT. No 01 NO. OF SHT. 01