FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

DRG.NO. 3-61-989-04522

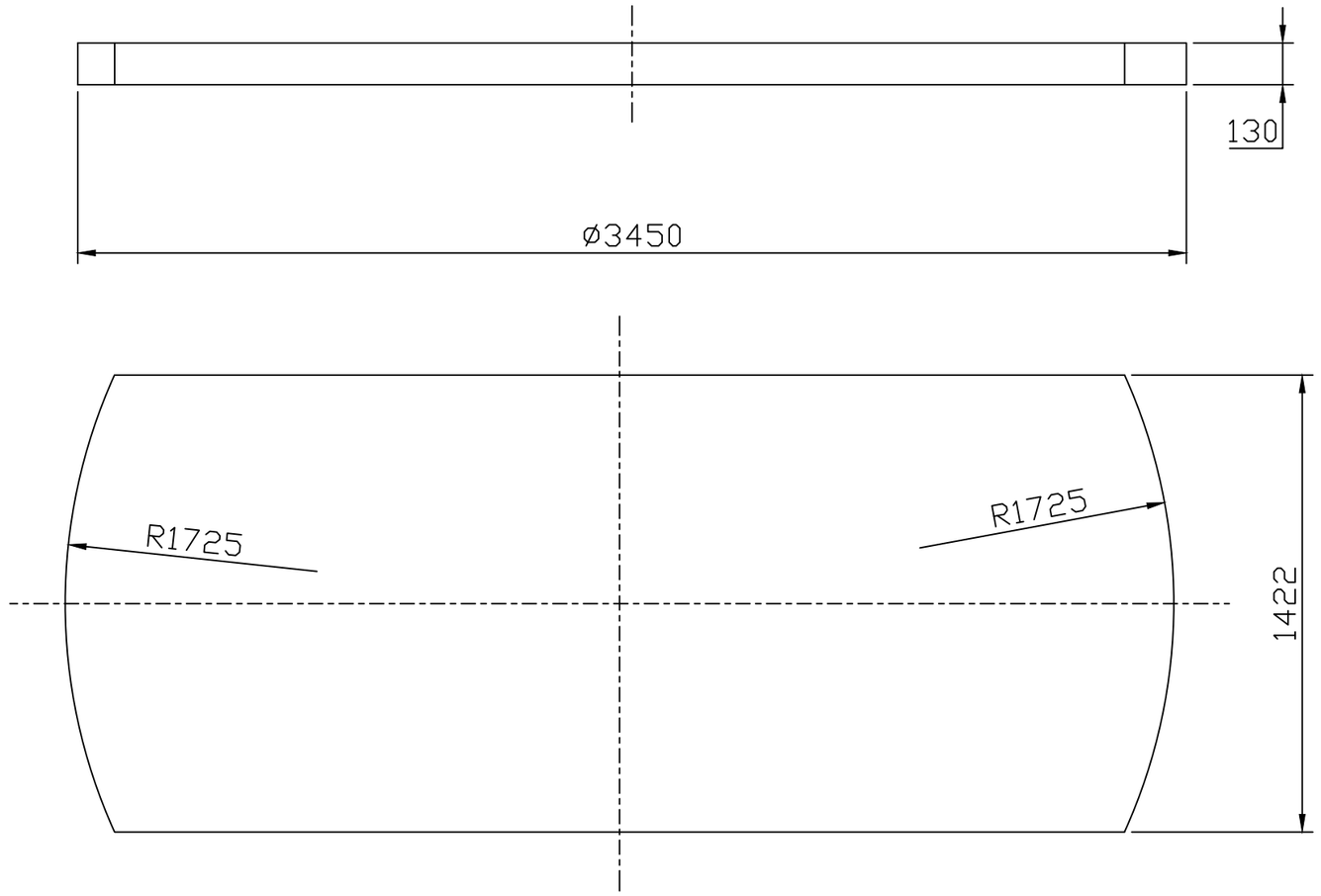
THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LTD.
IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

FILE NAME

1 212 02 20106 REF.DRG.NO.

INVENTORY NO.

12.5



TECHNICAL REQUIREMENTS:

1. DRG. SHOWS THE CASTING IN ROUGH MACHINED CONDITION.
2. SURFACE FINISH OF THE ROUGH MACHINED CASTING TO BE 12.5 MICRONS.
3. FOLLOWING NDT TO BE DONE ON ROUGH M/CED CASTING.
   100% UT AS PER LEVEL-II OF AA0850104
   100% MPI AS PER LEVEL-II OF AA0850134

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

ITEM NO.	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG. NO. OR FORGING DRG. NO.	MATERIAL CODE	NET WT.	GROSS WT.
1	CASTING				AA19511	1	
					MATERIAL SPECN.	QUANTITY	

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.

TYPE OF PRODUCT
OR
NAME OF CUSTOMER/PROJECT

BHARAT HEAVY ELECTRICALS LTD.
HYDERABAD

	NAME	SIGN.	DATE	NO.OF VAR.
DRN.	BGK		10.06.22	
CHD.	MANIVAS		10.06.22	
APPD.	MAHESH		10.06.22	

DEPT. PULV ENGG.	SCALE	WEIGHT (KG)	REF. TO ASSY DRG.	ITEM NO.	NO.OF ITEMS
CODE 446	NTS	4756	3-61-989-04523	01	01

TITLE: DISC SEGMENT-I (CASTING) ROUGH MACHINED

DRAWING NO. 3-61-989-04522 REV. 00

SHEET NO. | NO OF SHEETS

TD-151/REV. 03 SIZE A3