FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

DRG.NO. 3 254 01 14702

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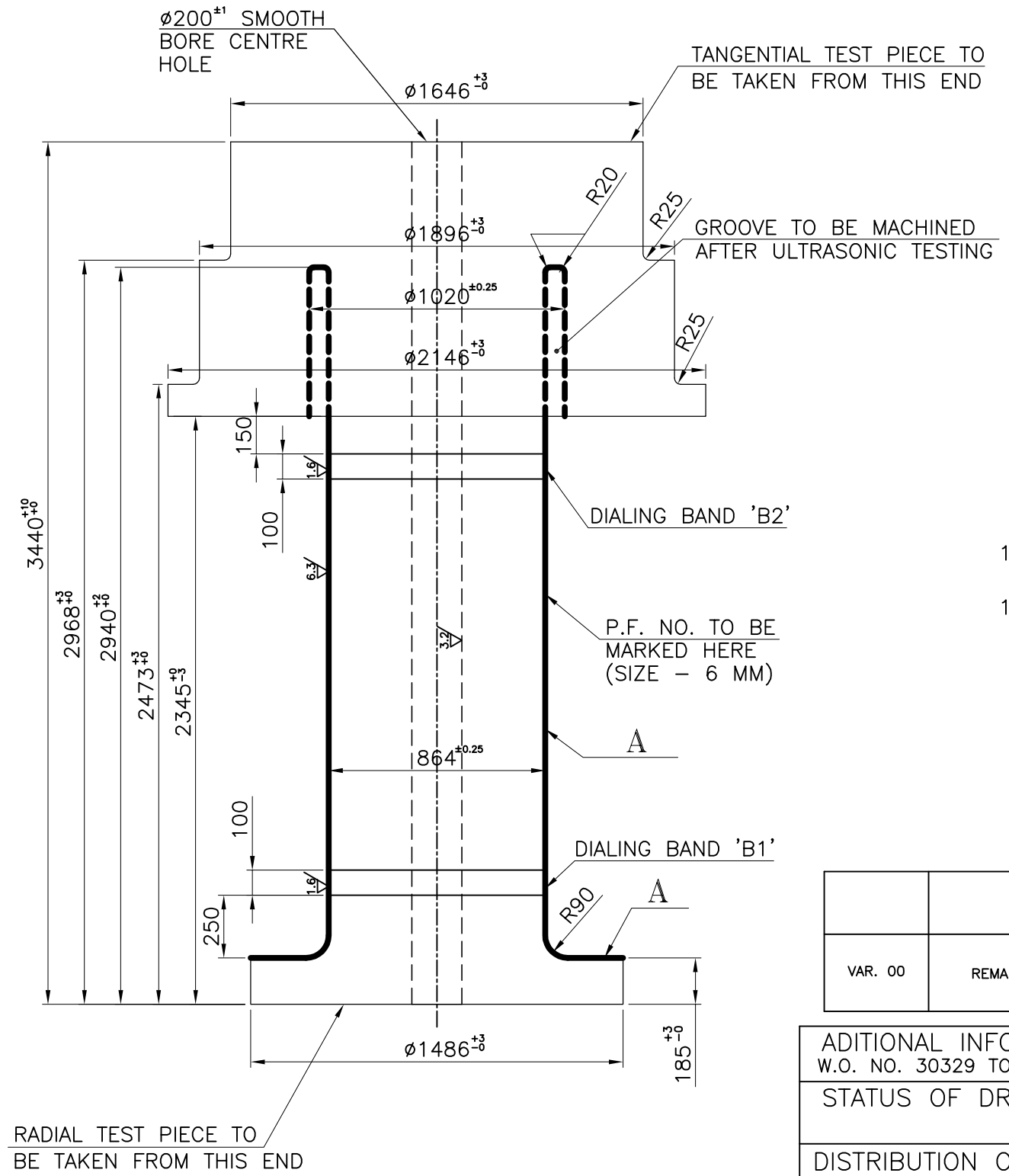
REF.DRG.NO.

SIGN.DATE

INVENTORY NO.



TECHNICAL REQUIREMENTS:

1. P.F. NOS. ARE TO BE STAMPED AT PLACE SHOWN ON DRAWING AND RESTAMPED JUST AFTER MACHINING.

PALAMURU RANGAREDDY STAGE–1 UNIT NO.	P.F. NO.	KALESHWARAM LINK–II PKG–2	P.F. NO.	KALESHWARAM LINK–IV PACKAGE–1	P.F. NO.
1	310841	1	310853	1	311529
2	310842	2	310854	2	311530
3	310843	3	310855	3	311531
4	310844	4	310856	4	311532
5	310845				
6	310846				
7	310847				
8	310848				

2. SURFACE FINISH SHALL BE 6.3 MICRONS ALL OVER EXCEPT OTHERWISE STATED.
3. ALL FACES SHALL BE PARALLEL AND SQUARE TO THE AXIS.
4. INSPECTION SHALL BE CARRIED OUT IN THE PRESENCE OF BHEL/THIRD PARTY/CUSTOMER.
5. SHAFT FORGING, INCLUDING THE BORE, SHALL BE PAINTED WITH ANTI–RUST PAINT TO BP0690084.
6. 6 COPIES OF TEST CERTIFICATES SHALL BE SUBMITTED. THE P.F. NOS. OF THE FORGINGS AND THE CAST NOS. OF THE BILLETS SHALL BE QUOTED ON THE CORRESSPONDING COPIES OF THE TEST CERTIFICATES.
7. CENTRAL HOLE OF DIAMETER ø200 IS FINAL FINISHED AND THIS DIAMETER SHALL BE COAXIAL AND CONCENTRIC WITH MAIN DIAMETER ø864.
8. WELD REPAIR & COLD WORKING OF THE FORGING IS NOT PERMISSIBLE AT ANY STAGE.
9. SHAFT FORGING SHALL BE AS PER PRODUCT STANDARD HG10035.
10. MACHINING BAND B1 & B2 SHALL BE USED FOR RESETTING SHAFT AT BHEL WORKS. THEY SHALL BE DIALLED WITHIN 0.05 MM.
11. PORTIONS OF SHAFT MARKED 'A' ARE FINAL FINISHED AND THESE DIAMETERS SHALL BE CO–AXIAL AND CONCENTRIC. THESE PORTIONS SHALL BE ADEQUATELY PROTECTED TO AVOID DAMAGE DURING TRANSPORTION/HANDLING.

IMPORTANT NOTES FOR SUPPLIER:

1. THE SUPPLIER IS TO CONFIRM COMPLIANCE TO THE DRAWING AND PRODUCT STANDARD HG10035 CLAUSE–BY–CLAUSE. ANY DEVIATION SHALL BE CLEARLY BROUGHT OUT IN THE OFFER.
2. CLAUSE–BY–CLAUSE COMPLIANCE OF QA PLAN NO. QSP/HG/104 (TWO SHEETS) SHALL BE CONFIRMED BY THE SUPPLIER.
3. OFFERS NOT MEETING THE ABOVE REQUIREMENTS, MAY BE REJECTED IN THE FIRST INSTANCE ITSELF.

VAR. 00	REMARKS	VAR NO.	ITEM NO.	DESCRIPTION	STD.	DRAWING NO.	IT. NO. / VAR	MATL. CODE. / MATL. SPCN.	A/C	UNIT	UNIT WT. / QTY.	GS.
			001	BOTTOM SHAFT FORGING				HG10035	NA	NA	33023	

ADITIONAL INFORMATION
W.O. NO. 30329 TO 36–A–23154

STATUS OF DRAWING

DISTRIBUTION OF PRINTS
TEX–1 HGM–1
HGE–1

उत्पाद का प्रकार या ग्राहक /परियोजना का नाम
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT: HMS–790/150–30K PALAMURU RANGAREDDY LIS STAGE–1,PACKAGE–1 (IRRIGATION & CAD DEPT, GOVT. OF TELANGANA)

भारत हेवी इलेक्टिकल्स लिमिटेड भोपाल
BHARAT HEAVY ELECTRICALS LTD. BHOPAL

	नाम NAME	हस्ता. SIGN	दि. DATE	NO.OF VAR
बनाया DRN	LU		15.01.21	वेरि की संख्या –
जाँचा CHD	ILA		15.01.21	
स्वीकृत APPD	RG		15.01.21	

विभाग DEPT HGE	UNTOL DIMS	SCALE अनुपात	भार WEIGHT(kg)	असे. ड्राईंग का संदर्भ REF TO ASSY DRG	मद क्र. ITEM NO.	मद संख्या NO.OF ITEM
कोड CODE 403	32500001404	NTS	33023	–	–	001

TITLE शीर्षक
BOTTOM SHAFT FORGING

DRAWING NO. 3 254 01 14702 — पुन. REV 02

पृष्ठ क्र. SHT NO. 01 — पृष्ठों की सं. NO.OF SHT. 01

REV	DATE	ALTERED / CHECKED / APPROVED	REV	DATE	ALTERED / CHECKED / APPROVED
02	05.07.21	ALTERED LU; CHECKED ILA; APPROVED RG	01	11.03.21	ALTERED LU; CHECKED NK; APPROVED RG
ZONE		PF NO. ADDED FOR KALESHWARAM LINK–IV PACKAGE–1.	ZONE		PF NO. ADDED IN KALESHWARAM LINK–II PKG–2.