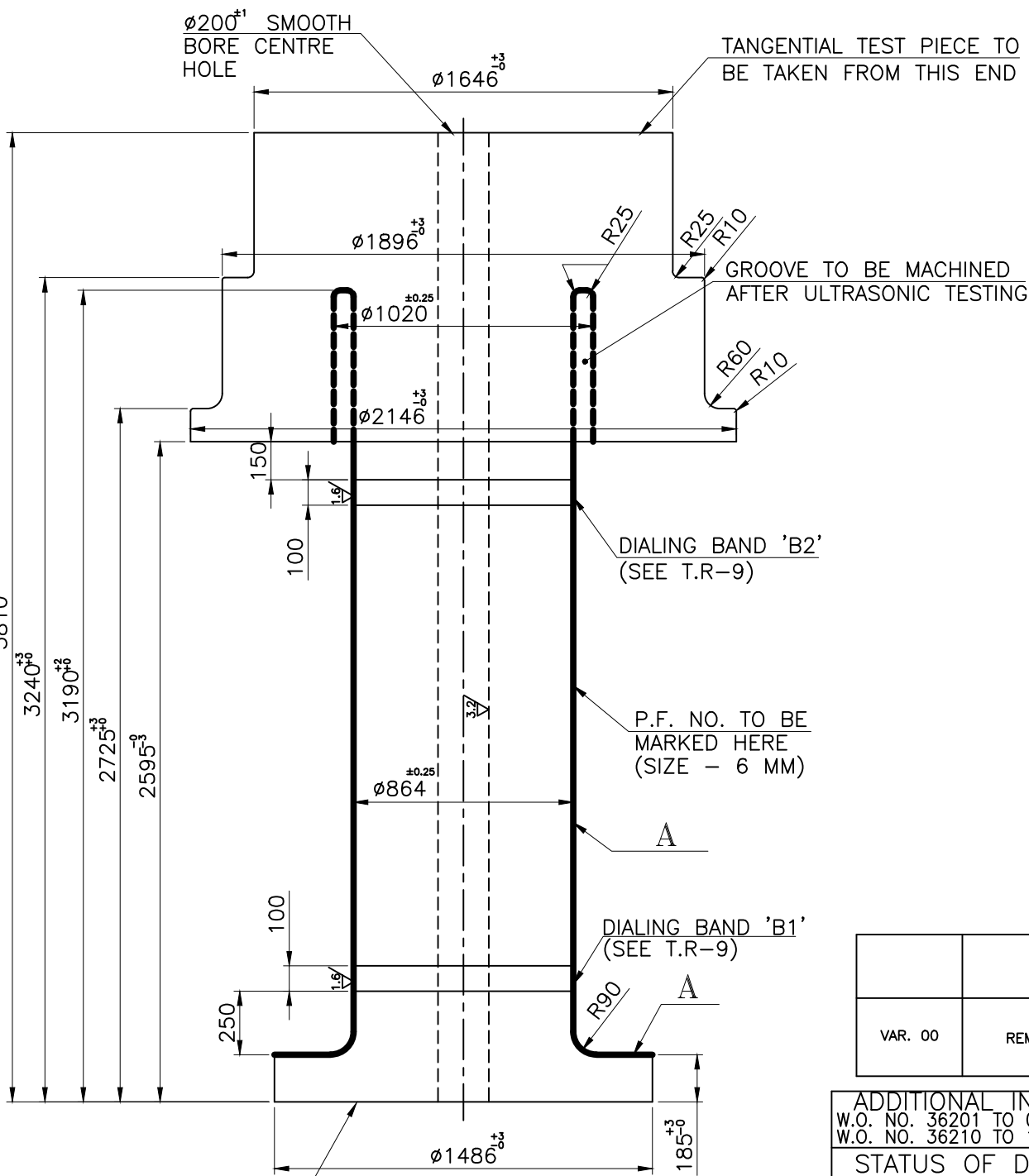


FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

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

10968 10 452 8
DRG. NO. 3 254 01 89601



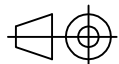
TECHNICAL REQUIREMENTS:

1. P.F. NOS. ARE TO BE STAMPED AT PLACE SHOWN ON DRAWING AND RESTAMPED JUST AFTER MACHINING.
- | UNIT NO. (STAGE-2) | P.F. NO. | UNIT NO. (STAGE-3) | P.F. NO. | UNIT NO. (STAGE-4) | P.F. NO. | KALESHWARAM LINK-2 | PKG-1 | P.F. NO. |
|--------------------|----------|--------------------|----------|--------------------|----------|--------------------|-------|----------|
| 1 | 308152 | 1 | 308161 | 1 | 310857 | 1 | | 310872 |
| 2 | 308153 | 2 | 308162 | 2 | 310858 | 2 | | 310873 |
| 3 | 308154 | 3 | 308163 | 3 | 310859 | 3 | | 310874 |
| 4 | 308155 | 4 | 308164 | 4 | 310860 | 4 | | 310875 |
| 5 | 308156 | 5 | 308165 | 5 | 310861 | 5 | | 310876 |
| 6 | 308157 | 6 | 308166 | | | | | |
| 7 | 308158 | 7 | 308167 | | | | | |
| 8 | 308159 | 8 | 308168 | | | | | |
| 9 | 308160 | 9 | 308169 | | | | | |
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 CORRESPONDING COPIES OF THE TEST CERTIFICATES.
7. CENTRAL HOLE OF DIAMETER 200 IS FINAL FINISHED AND THIS DIAMETER SHALL BE COAXIAL AND CONCENTRIC WITH MAIN DIAMETER 864.
8. WELD REPAIR & COLD WORKING OF THE FORGING IS NOT PERMISSIBLE AT ANY STAGE.
9. DIALING BAND B1 & B2 SHALL BE USED FOR RESETTNG SHAFT AT BHEL WORKS. THEY SHALL BE DIALLED WITHIN 0.05 MM.
10. 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.
11. SHAFT FORGING SHALL BE AS PER PRODUCT STANDARD HG10035.

IMPORTANT NOTES FOR SUPPLIER:

1. THE SUPPLIER IS TO CONFIRM COMPLIANCE TO THE DRAWING AND PRODUCT STANDARD HG10035 (REV-07) 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.	MATL. CODE.	A	Z	UNIT	UNIT WT.	GS.
				001 BOTTOM SHAFT FORGING				HG10035				36300	
							VAR	MATL. SPCN.	C			QTY.	

ADDITIONAL INFORMATION W.O. NO. 36201 TO 09-A-23154-STAGE-2 W.O. NO. 36210 TO 18-A-23154-STAGE-3			mRikn dk izdkj ;k xzkgd @ifj;kstuk dk uke TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT			HMS-713/170-24K PALAMURU RANGAREDDY LIS STAGE-2&3 (MEIL/TSGENCO)										
STATUS OF DRAWING U			 Hkkjr gsoh bysfDVdYl fyfeVsM Hkksiky BHARAT HEAVY ELECTRICALS LTD. BHOPAL			cuk;k DRN LU		gLnk SIGN Lxomi		fn DATE 07.10.19		NO.OF VAR osfj dh ld;k				
DISTRIBUTION OF PRINTS HGE - 2 HGM - 2 TEX - 1			tkgpk CHD NS		Lohd=r APPD RG		07.10.19		07.10.19		-					
foHkxk Vhwkbz DEPT HGE dksM CODE 403			UNTOL DIMS 32500001404				SCALE vuqkr NTS		Hkkj fd_xzk WEIGHT(kg) 36300		MkzbZax dk lanHkZ REF TO ASSY DRG 0 254 01 89601		en dz_o ITEM NO. 001		en ld;k NO.OF ITEM 001	
TITLE 'kh" kZd BOTTOM SHAFT FORGING			DRAWING NO. 3 254 01 89601		iqu REV 02		i="B dzSHT NO. 01		i="Bksa dh NO.OF SHT. 01							

RADIAL TEST PIECE TO
BE TAKEN FROM THIS END

REV	DATE	ALTERED LU	LU	REV	DATE	ALTERED LU	LU
02	11.03.21	CHECKED NS		01	02.03.21	CHECKED NS	
		APPROVED RG				APPROVED RG	
ZONE	PF NO. ADDED IN KALESHWARAM LINK-2 PKG-1.			ZONE	PF NO. ADDED IN PALAMURU STAGE-4.		