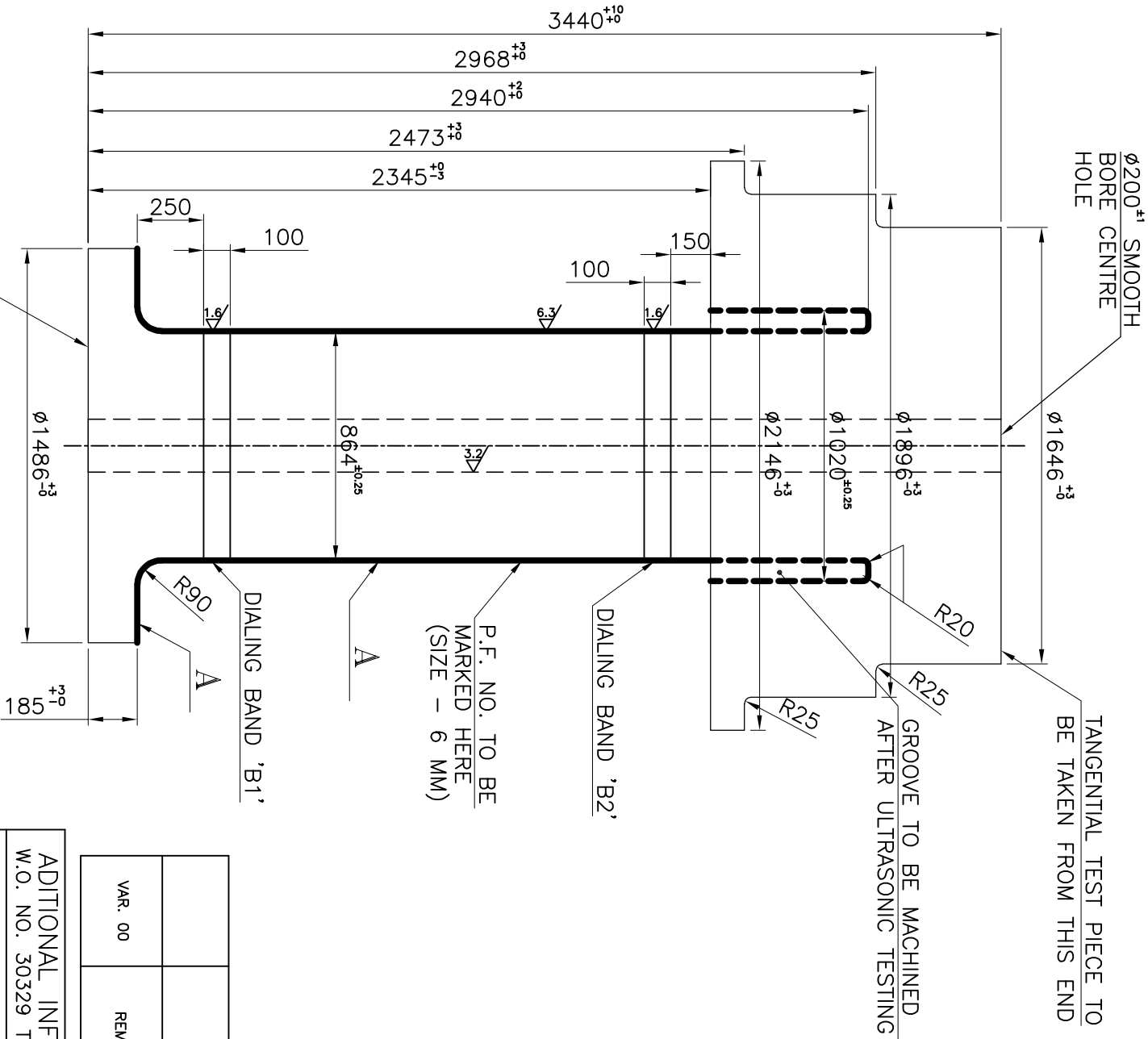


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BHARAT HEAVY ELECTRICALS LTD.  
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IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.



TECHNICAL REQUIREMENTS:

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

| UNIT NO. | P.F. NO. | KALESHWARAM | LINK-II PKG-2 | P.F. NO. |
|----------|----------|-------------|---------------|----------|
| 1        | 310841   |             |               |          |
| 2        | 310842   |             | 1             | 310853   |
| 3        | 310843   |             | 2             | 310854   |
| 4        | 310844   |             | 3             | 310855   |
| 5        | 310845   |             | 4             | 310856   |
| 6        | 310846   |             |               |          |
| 7        | 310847   |             |               |          |
| 8        | 310848   |             |               |          |
- SURFACE FINISH SHALL BE 6.3 MICRONS ALL OVER EXCEPT OTHERWISE STATED.
- ALL FACES SHALL BE PARALLEL AND SQUARE TO THE AXIS.
- INSPECTION SHALL BE CARRIED OUT IN THE PRESENCE OF BHEL/THIRD PARTY/CUSTOMER.
- SHAFT FORGING, INCLUDING THE BORE, SHALL BE PAINTED WITH ANTI-RUST PAINT TO BP0690084.
- 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.
- CENTRAL HOLE OF DIAMETER 200 IS FINAL FINISHED AND THIS DIAMETER SHALL BE COAXIAL AND CONCENTRIC WITH MAIN DIAMETER 1646.
- WELD REPAIR & COLD WORKING OF THE FORGING IS NOT PERMISSIBLE AT ANY STAGE.
- SHAFT FORGING SHALL BE AS PER PRODUCT STANDARD HG10035.
- MACHINING BAND B1 & B2 SHALL BE USED FOR RESETTING SHAFT AT BHEL WORKS. THEY SHALL BE DIALED WITHIN 0.05 MM.
- 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 TRANSPORT/HANDLING.

IMPORTANT NOTES FOR SUPPLIER:

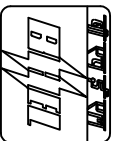
- THE SUPPLIER IS TO CONFIRM COMPLIANCE TO THE DRAWING AND PRODUCT STANDARD HG10035 CLAUSE-BY-CLAUSE. ANY DEVIATION SHALL BE CLEARLY BROUGHT OUT IN THE OFFER.
- CLAUSE-BY-CLAUSE COMPLIANCE OF QA PLAN NO. QSP/HG/104 (TWO SHEETS) SHALL BE CONFIRMED BY THE SUPPLIER.
- OFFERS NOT MEETING THE ABOVE REQUIREMENTS,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

|         |         |                      |          |             |             |         |              |
|---------|---------|----------------------|----------|-------------|-------------|---------|--------------|
|         | 001     | BOTTOM SHAFT FORGING |          |             | HG10035     | 33023   |              |
| VAR. 00 | REMARKS | VAR NO.              | ITEM NO. | DESCRIPTION | DRAWING NO. | IT. NO. | MATL. CODE.  |
|         |         |                      |          |             |             | VAR     | MATL. SPECN. |
|         |         |                      |          |             |             |         | UNIT WT.     |
|         |         |                      |          |             |             |         | QTY.         |

ADDITIONAL INFORMATION  
W.O. NO. 30329 TO 36-A-23154

STATUS OF DRAWING

DISTRIBUTION OF PRINTS



Hkkljr gsoh bysVDvYl fyfeVsm  
Hkksilyk  
BHARAT HEAVY ELECTRICALS LTD.  
BHOPAL

|                                              |                           |                        |                                     |                 |                     |                     |              |
|----------------------------------------------|---------------------------|------------------------|-------------------------------------|-----------------|---------------------|---------------------|--------------|
| foHkxx Vmkbz<br>DEPT HGE<br>dksm<br>CODE 403 | UNTOL DIMS<br>32500001404 | SCALE<br>vuqlkr<br>NTS | Hkklj fd_xzk<br>WEIGHT(kg)<br>33023 | uqe NAME<br>LU  | qlrk SIGN<br>ksooni | fn DATE<br>15.01.21 | NO OF<br>VAR |
|                                              |                           |                        |                                     | uqe NAME<br>ILA | qlrk SIGN<br>scnt   | fn DATE<br>15.01.21 | NO OF<br>VAR |
|                                              |                           |                        |                                     | uqe NAME<br>RG  | qlrk SIGN<br>ksooni | fn DATE<br>15.01.21 | NO OF<br>VAR |

TITLE 'kh"KZd  
BOTTOM SHAFT FORGING

DRAWING NO.  
3 254 01 14702  
REV  
01