FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

POORNIMA CAD

DRG. NO. 1-61-100-00239

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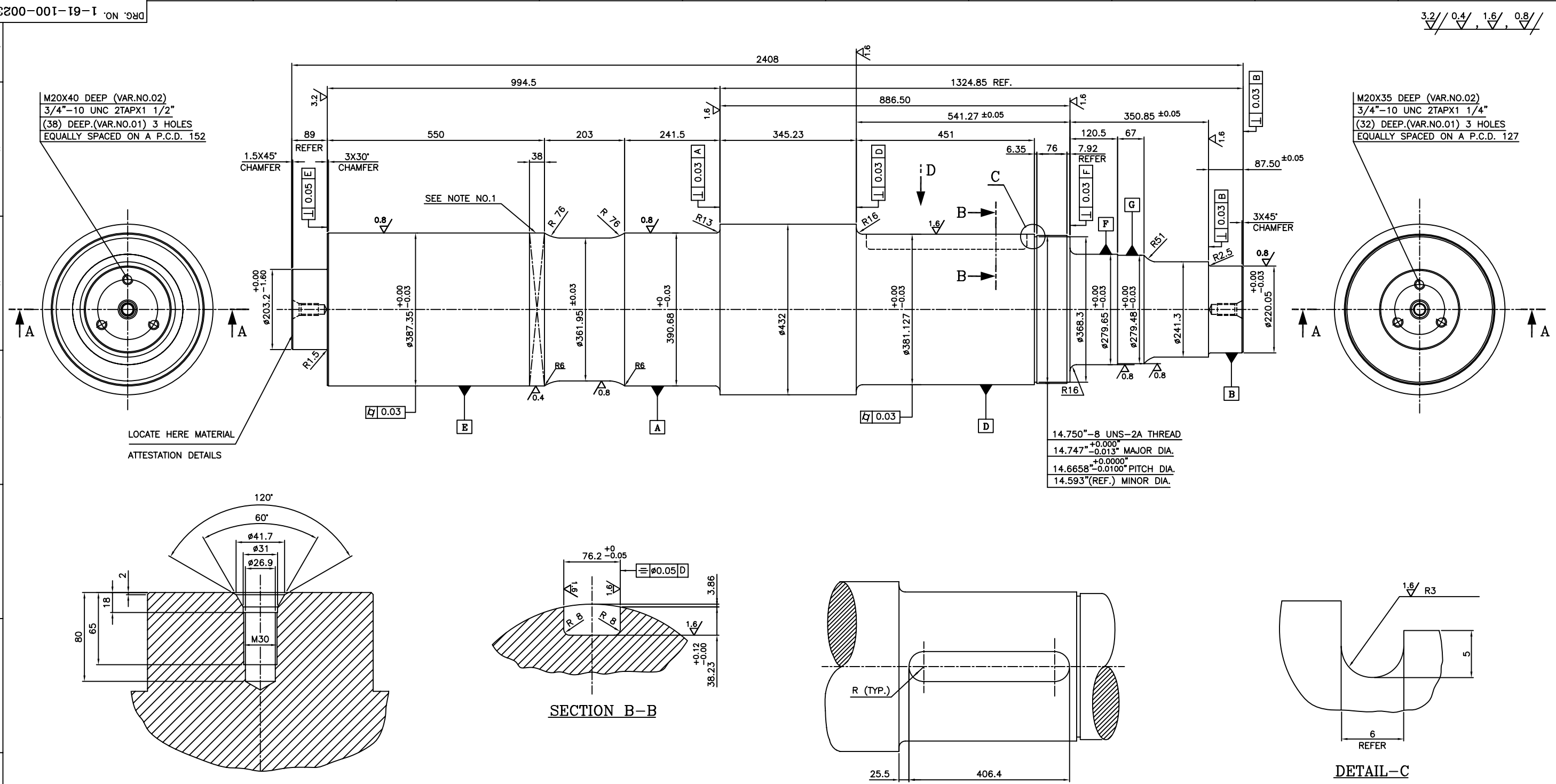
COMPUTER FILE NAME : 1610023S.DWG

INVENTORY NO. SIGN. AND DATE REF. DRG. NO.



SECTION A-A

SECTION B-B

VIEW D

DETAIL-C

VAR. NO	DESCRIPTION
01	INCH THREADING
02	METRIC THREADING

NOTES :-

1. POLISHED AREAS MUST BE WELL PROTECTED AGAINST ANY DAMAGE ANY DURING ROUTINE HANDLING
2. 100% INSPECTION OF ALL THREADS REQUIRED
3. UNLESS OTHERWISE SPECIFIED : (A) FINISH ; (B) FINISH ALL FILLETS
   (A) FINISH 3.2
   (B) FINISH ALL FILLETS 0.8
   (C) TOLERANCE ON ALL FILLETS +0.4
   (D) ALL DIAMETERS TO BE CONCENTRIC TO DATUMS "A" & "B" WITHIN 0.03 MM TOTAL INDICATOR READING
   (E) BREAK ALL SHARP CORNERS TO R3.
4. BLEND DIAMETER CHANGE TO R3 UNLESS OTHERWISE SPECIFIED.
5. TRP AS PER CAT 'D' OF HY 0490563
6. MANUFRACTURE AS PER CUSTOMER'S APPROVED QUALITY PLAN

STEEL FORGING - AIM AT 13mm (RADIAL) MACHINING ALLOWANCE. HEAT TREATMENT (FOLLOWING ROUGH MACHINING): NORMALIZE, QUENCH & TEMPER TO GIVE BRINELL OF 269-302. AIM AT 285 BHN.

ROUGH MACHINED FORGING WEIGHT 2150KGS.

ITEM NO	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.		
	FORGING	3-61-100-90172			BA9516953107	1970.00
					HY19369	1
					MATERIAL CODE	NET WT. / GROSS WT.
					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 WHEREVER NOT SHOWN SHALL BE TAKEN FROM THE SURFACE ROUGHNESS SHOWN OUT SIDE BACK SLASHES GIVEN AT THE TOP MOST RIGHT CORNER OF THE DRG.

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT: 1003 XRP BOWL MILL

BHARAT HEAVY ELECTRICALS LTD. HYDERABAD

	NAME	SIGN.	DATE	NO.OF VAR.
DRN.	N.D.SAMUEL		13.12.98	-NA-
CHD.	S.GHATGE		13.12.98	
APPD.	K.M.RAO		13.12.98	

DEPT.	SCALE	WEIGHT (KG)	REF. TO ASSY DRG.	ITEM NO.	NO.OF ITEMS
PULV.ENGG.	N.T.S	1970.00	D-101-01141-1	-NA-	-NA-
CODE 446					

TITLE: MAIN VERTICAL SHAFT

DRAWING NO. 1-61-100-00239 REV. 05

SHEET NO. 01 NO OF SHEETS 01

REV.	DATE	ALTERED	CHECKED	APPD.	ZONE
05	06.08.04	NOTE 5(NOT REQD IF DONE WITH TRACING EQUIP)REMOVED,NOTES RENUMBERED. IN DET C, 6.0 &5.0 WERE 6.35 & 4.762 RESP.			
05	06.08.04	CONCENTRICITY SYMBOLS REMOVED(ALREADY IN NOTE 3D) LOC FOR MAT ATTEST SHOWN			
04	13.12.98	RADIUS R6 ADDED. NOTES 3E & 4 MODIFIED.			D5 H4
03	13.12.98	DRAWING REDRAWN. TAPPED HOLE IN(VIEW-D) KEY WAY DELETED NOTE-6 REMOVED.	CHECKED	APPD.	
02	07.10.96	REF. STD FOR NOTE 6 WAS IS:8000 R/M FORGING DRG&WT. INDICATED VER. 01 & 02 INDICATED	CHECKED	APPD.	
01	29.11.85	NOTE 7 & 8 ADDED.	CHECKED	APPD.	