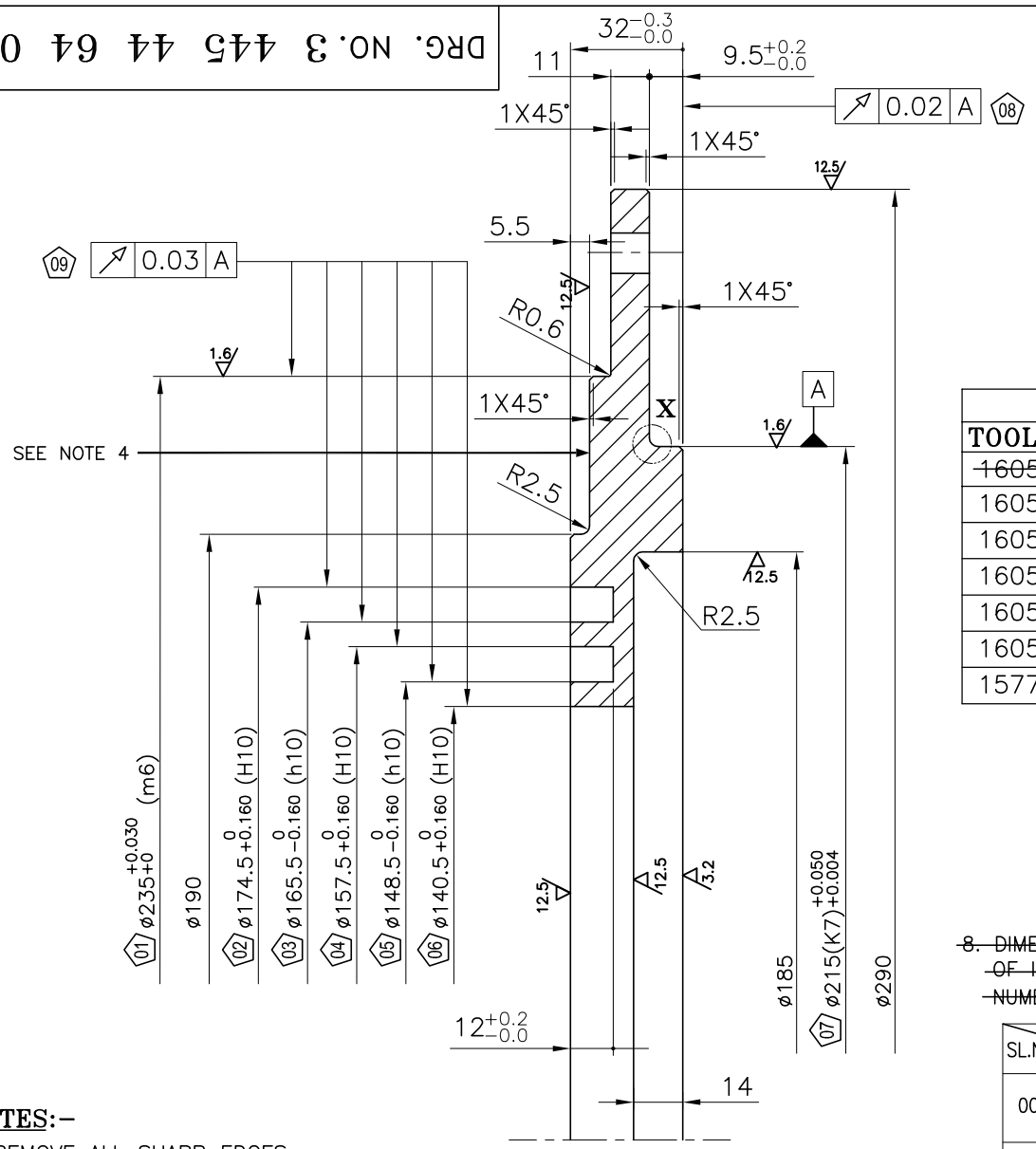
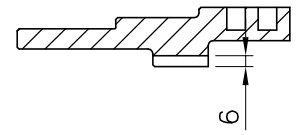
FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

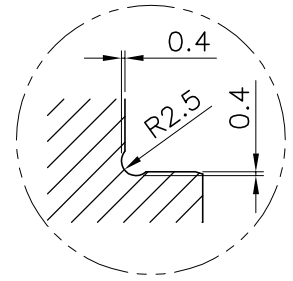
DRG. NO. 3 445 44 64 051



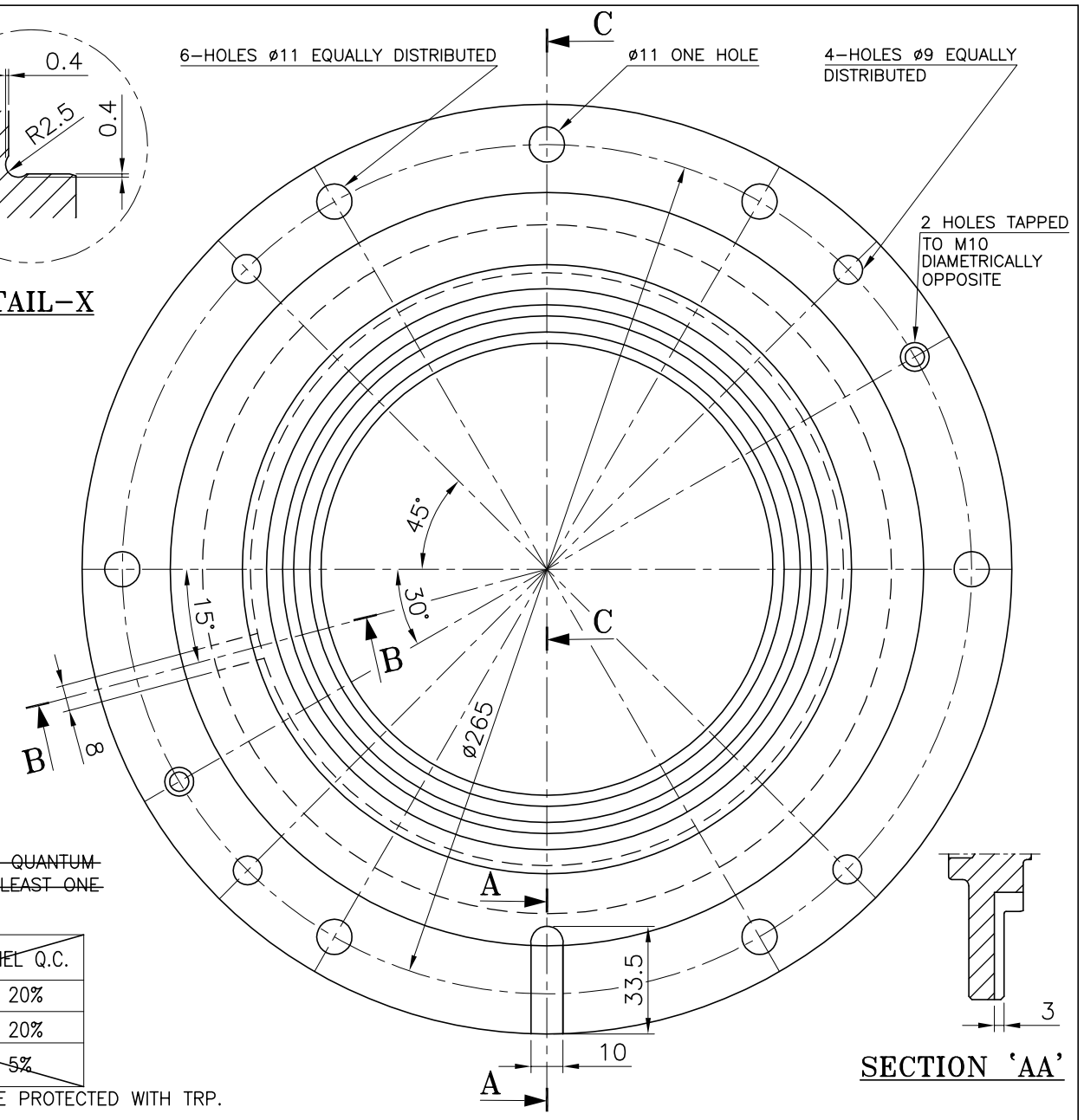
SECTION 'CC'



SECTION B–B



DETAIL–X



SECTION 'AA'

TOOL LIST	
TOOL NO.	DESCRIPTION
~~1605048~~	~~PIN GAUGE ø215 +0.050 +0.004~~
1605049	CALIPER GAUGE ø148 0 −0.160
1605050	CALIPER GAUGE ø165 0 −0.160
1605051	CALIPER GAUGE ø235 +0.03 0
1605052	PIN GAUGE ø158 +0.160 0
1605053	PIN GAUGE ø175 +0.160 0
1577979	CALIPER GAUGE ø215 +0.050 +0.004

~~8. DIMENSIONS TO BE CHECKED ON SAMPLE BASIS. QUANTUM OF INSPECTION SHALL BE AS GIVEN BELOW (AT LEAST ONE NUMBER).~~

SL.NO.	CHECKING PARAMETER		BHEL Q.C.
001	CTQ DIMS.	DIMENSIONAL TOLERANCE	20%
		GEOMETRICAL TOLERANCE	20%
002	REMAINING DIMS.		5%

9. ALL MACHINED/ R.MACHINED SURFACES TO BE PROTECTED WITH TRP.

NOTES:–

1. REMOVE ALL SHARP EDGES.
2. ~~MATERIAL: SPHEROIDAL GRAPHITE CAST IRON (SGCI) TO DIN–1693 PART–1 GR,GGG/40 OR GR–400/18 OF IS.1865–1991 (LATEST VERSION).~~
3. ALL 9 NOS. "⬠" MARKED DIMENSION ARE CRITICAL TO QUALITY (CTQ) & SL. NO. OF CTQ DIMENSION ARE INSCRIBED IN ⬠ e.g. (09).
4. SUPPLIER'S INITIAL/TRADE MARK, MANUFACTURERS SERIAL NO. BHEL PO NO. BATCH NO. & DATE OF MFG. IN MM–YY FORMAT TO BE ETCHED AT THE SHOWN LOCATION.
5. MACHINING ALLOWANCE ON EACH TOOL POINT TO BE 5–7 MM IN CASE CASTING IS SUPPLIED OR 3–5 MM IN CASE ROUGH MACHINED CASTING IS SUPPLIED.
6. FOR QUALITY REQUIREMENT OF COMPONENT SPECIFICATION TM12545 TO BE REFERRED.
7. QAP FOR CASTING TO BE AS PER QTM/QAP/VENDOR/13–14/001 (LATEST REV.).

	RAW WEIGHT 14.0 KG.		001	BEARING CAP NDE								KG	6.0		
										TM 11491					
59 64 QTY VAR 00	65 75 REMARKS	78 79 VAR. NO.	25 27 ITEM NO.	29 58 DESCRIPTION	59 STD	60 77 DRAWING NO.	29 31 IT.NO.	34 45 MATL. CODE	55 A–C	56 57 UNIT	58 65 UNIT WT.	72 GS	ZONE
							32 33 VAR.	46 54 MATL. SPCN.			68 71 QTY.		

ADDITIONAL INFORMATION
3TWD.096.032, (ALT.6)

STATUS OF DRAWING

DISTRIBUTION OF PRINTS
TME–1, TXM–3, TNX–1

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT

6FRA 6068

REV.	DATE	ALTERED	SDB	
09	18.10.18	CHECKED	ABHIJIT	
		APPROVED	ABHIJIT	

ZONE: NOTE–2 DELETED. NOTE–8 MODIFIED.

REV.	DATE	ALTERED	SDB	
08	28.09.18	CHECKED	ABHIJIT	
		APPROVED	ABHIJIT	

ZONE: VIEW OF SLOT SECTION–'BB' MODIFIED.

REV.	DATE	ALT.	SDB	
10	15.12.18	CHK.	ABHIJIT	
		APPD.	ABHIJIT	

ZONE: IN TITLE BLOCK R/WT & FINISH WT. WERE 15.50 & 5.32KG.

REV.	DATE	ALT.	SDB	
07	06.12.17	CHK.	ABHIJIT	
		APPD.	ABHIJIT	

ZONE: DIMS. 32 +0.0 −0.3 ,9.5 −0.0 +0.2 & 12.2 −0.0 +0.2 WERE 32,9.5 +0.0 −0.1 & 12.2. NOTE–7 & 8 ADDED.

REV.	DATE	ALT.	SDB	
11	24.07.19	CHK.	ABHIJIT	
		APPD.	ABHIJIT	

ZONE: DIMS. ø174.5, ø165.5, ø157.5, ø148.5, ø140.5 & 12 WERE ø175, ø165, ø158, ø148, ø141 & 12.2 (CLW LETTER REF. CLW/TM/18059/ PART–I/1 DATED 12/07/19). NOTE 8 DELETED & NOTE 9 ADDED.

बीएचईएल BHEL BHARAT HEAVY ELECTRICALS LTD. BHOPAL

	NAME	SIGN	DATE	NO. OF VAR.
DRN.	ASWINI	–sd–	07/09/10	
CHD.	D.K.	–sd–	07/09/10	
APPD.	A.S.	–sd–	07/09/10	

DEPT.	UNTOL. DIMS. GR.		SCALE	WEIGHT (K.G.)	REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEM
TME	'M'						
CODE 405	AA0230208		N.T.S.	6.0	0 445 10 64 051		001

TITLE: BEARING CAP (NDE) (CNC MACHINED)

DRAWING NO. 3 445 44 64 051 REV. 11

SHT. NO. 01 NO. OF SHT. 01

SIZE A3

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

REF. DRG. NO. | SIGN. & DATE | INVENTORY NO.