

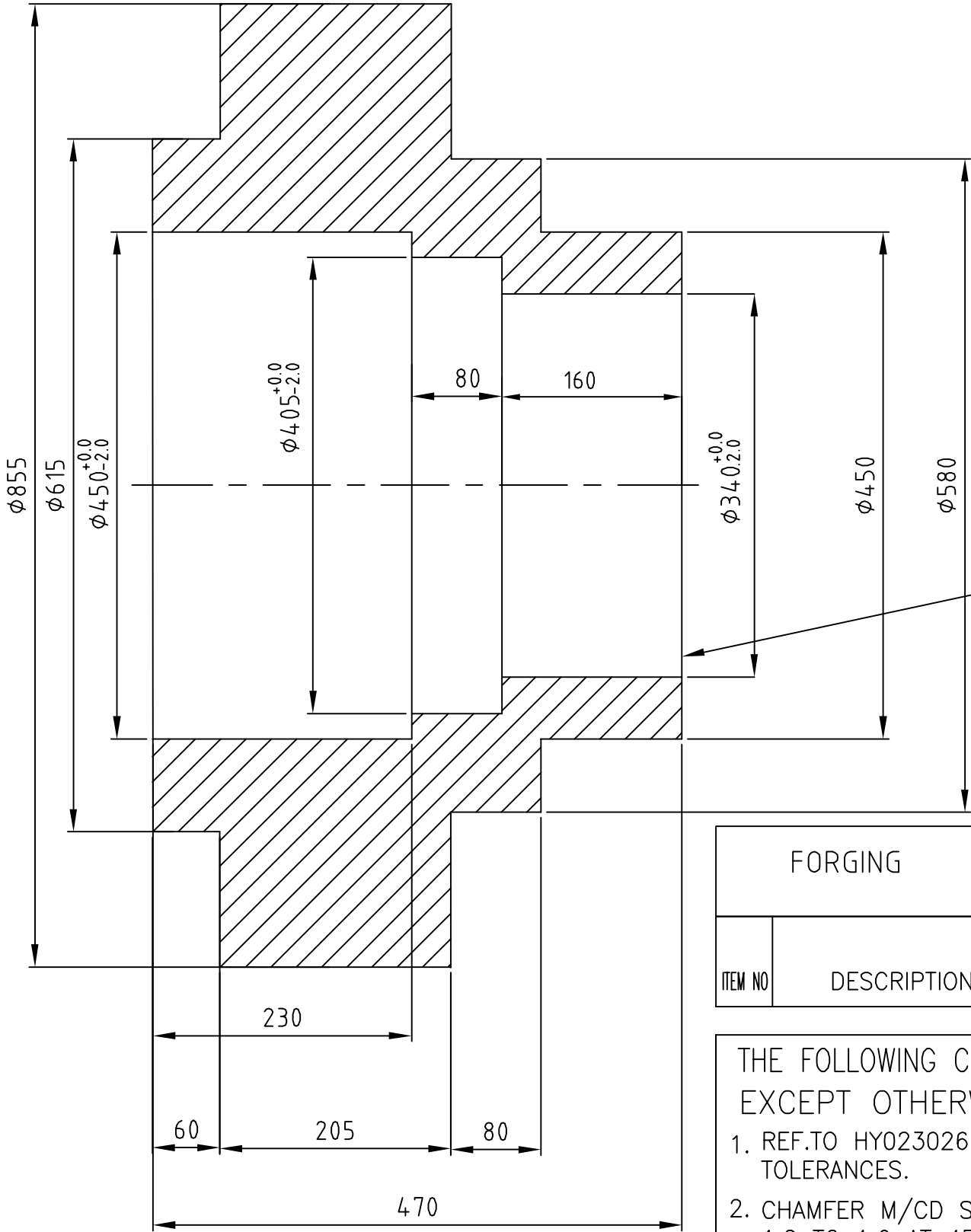
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FILE NAME

1-61-000-90168
REF.DRG.NO.

INVENTORY NO.

DRG.NO. 3-61-000-90168



NOTE


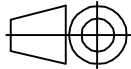
1. FORGING TO BE ROUGH MACHINED TO DIMENSIONS INDICATED IN THE DRAWING
- 2.CHAMFER CORNERS TO R2 & FILLET RADIUS ARE TO BE R3
3. TEST ULTRASONICALLY AS PER SPECIFICATIONS AA0850118 CAT-3
4. FORGING SHOULD BE AS PER SPECIFICATIONS AA19332
5. TOLERANCE ON DIAMETERS AND LENGTHS±1MM
6. FOR FINISH MACHINING REFER 1-61-000-00365

12.5

FORGING					BA9413221235		
					AA 19332		
ITEM NO	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	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 KORBA&RAMAGUNDAM 500MW				
<div>BHARAT HEAVY ELECTRICALS LTD. HYDERABAD</div>						NAME	SIGN.	DATE	NO.OF VAR.
					DRN.	NARAYANA		3.11.03	
					CHD.	N.D.S		3.11.03	
					APPD.	S.GHADGE			
DEPT.	PULVE.ENGG		SCALE	WEIGHT (KG)	REF. TO ASSY DRG.		ITEM NO.	NO.OF ITEMS	
CODE	446		1:5	854.00	1-61-000-90168				
TITLE					DRAWING NO.				REV.
UPPER JOURNAL HOUSING					3-61-000-90168				01
					SHEET NO. 01		NO OF SHEETS 01		