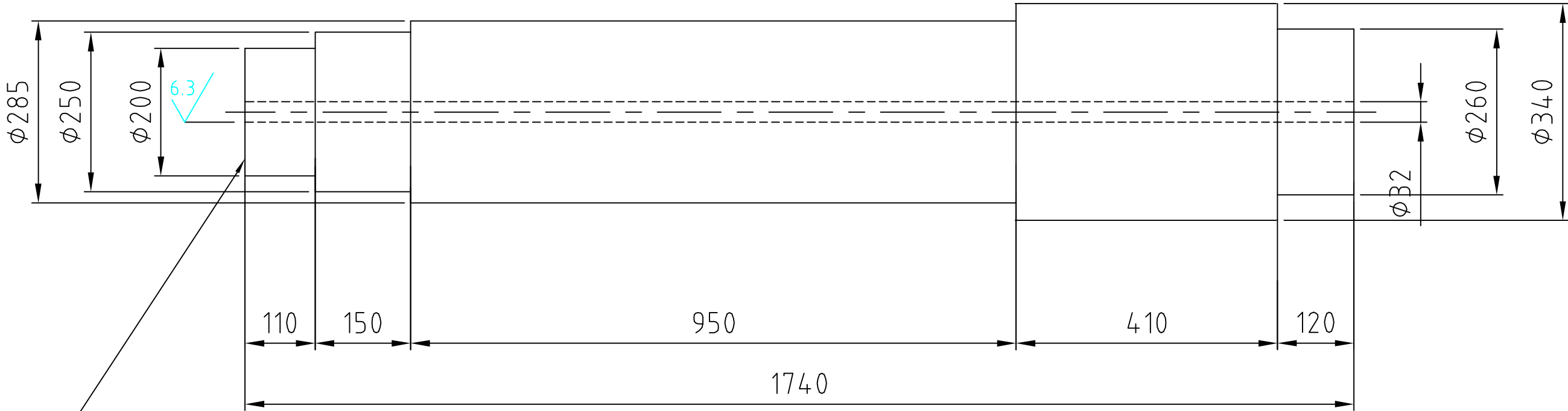


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DRG.NO. 3-61-000-90173




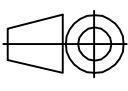
LOCATE HARE ATTESTATION DETAILS VIZ.
SUPPLIERS CODE
FORGE No.
MAT. SPECN.
MELT.No.

NOTE

1. FORGING TO BE MACHINED TO DIMENSIONS INDICATED IN THE DRAWING
- 2 CHAMFER SHARP CORNERS TO R2 & ALL FILLET RADIUS TO R3
- 3TEST ULTRASONICALLY AS PER SPECIFICATIONS AA0850118 CAT-3
- 4.FORGING SHOULD BE AS PER SPECIFICATIONS AA19332
5. TOLERANCE ON DIAMETERS AND LENGTHS ± 1 MM
6. HOLE $\phi 32$ SHIULD BE CONCENTRIC WITH CENTRE LINE WITH ± 1 MM
7. FOR FINISH MACHINING REFER 1-61-000-00363

	FORGING			BA9413253226	876.00	
				AA19332		
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 500 MW			
 BHARAT HEAVY ELECTRICALS LTD. HYDERABAD		DRN.	NARAYANA	SIGN.	DATE
		CHD.	N.D.S		4.11.04
		APPD.	S.GHATGE		4.11.03
DEPT.	PULVE.ENG	SCALE	WEIGHT (KG)	REF. TO ASSY DRG.	ITEM NO.
CODE	446	 1:10	876.00	1-61-000-00363	
TITLE				DRAWING NO.	REV.
JOURNAL SHAFT (ROUGH MACHINED)				3-61-000-90173	01
		SHEET NO. 01		NO OF SHEETS 01	