FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

DRG.NO. 3-61-004-90184

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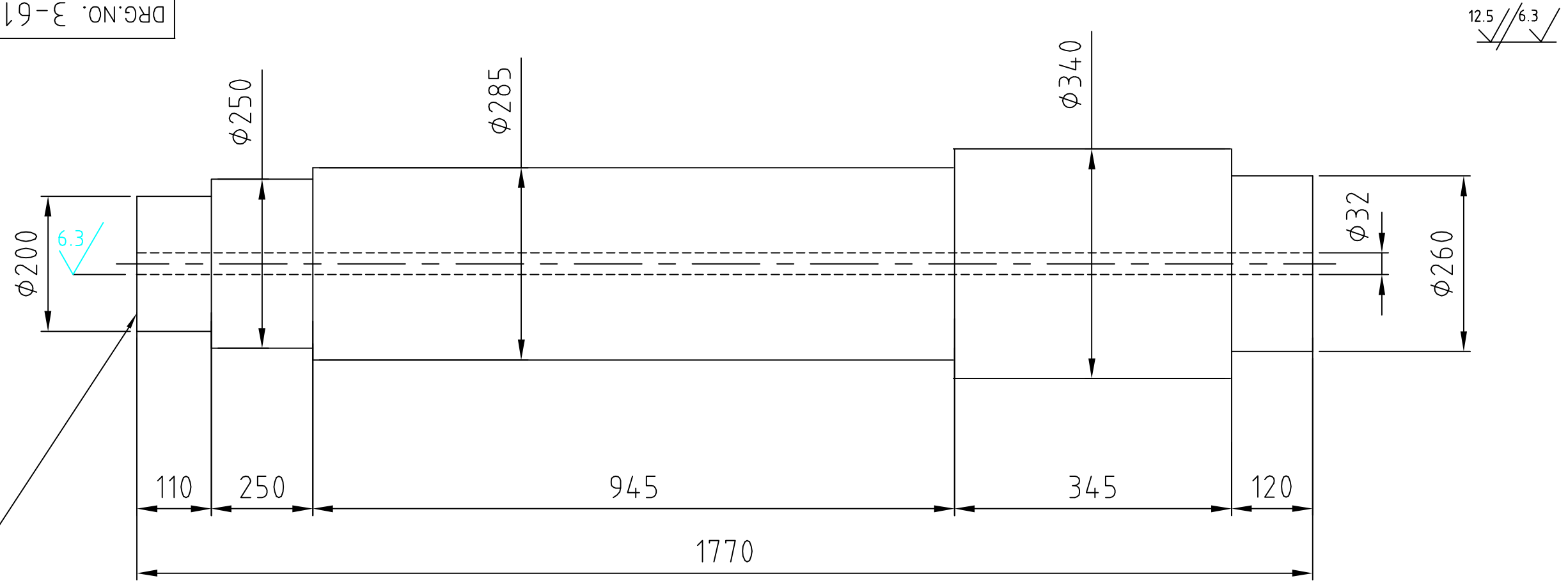
36190184.DWG FILE NAME

1-61-004-01183 REF.DRG.NO.

INVENTORY NO.



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
3.TEST ULTRASONICALLY AS PER SPECIFICATIONS
AA0850118 CAT-3
4. FORGING SHOULD BE AS PER SPECIFICATIONS AA19332
5. TOLERENCE ON DIAMETERS AND LENGTHS ± 1MM
6. HOLE ϕ32 SHIULD BE CONCENTRIC WITH CENTRE LINE
WITH ± 1MM
7. FOR FINISH MACHININING REFER 1-61-004-01183

REV.	DATE	ALTERED		REV.	DATE	ALTERED PKP	
		CHD.	APPD.	01	07.11.12	CHD. CKP	APPD. V KUMAR
ZONE				ZONE	DRAWING DRAWN ON AUTOCAD DIM. 120, 945, 250 WERE 105, 950 AND 260 RESPECTIVELY.		

ITEM NO	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	MATERIAL CODE	NET WT.	GROSS WT.
01	FORGING				BA9413253242	890	
					AA19332		
					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: 1043 XRP BOWL MILL CHANDRAPUR 500 MW

BHARAT HEAVY ELECTRICALS LTD.
HYDERABAD

	NAME	SIGN.	DATE	NO.OF VAR.
DRN.	PKP		07.11.12	
CHD.	CKP		07.11.12	
APPD.	V KUMAR		07.11.12	

DEPT.	SCALE	WEIGHT (KG)	REF. TO ASSY DRG.	ITEM NO.	NO.OF ITEMS
PULVE.ENGG	NTS	890.00			
CODE 446					

TITLE: JOURNAL SHAFT (ROUGH MACHINED)

DRAWING NO. 3-61-004-90184 REV. 01

SHEET NO. 01 NO OF SHEETS 01

TD-151/REV. 03 SIZE A3