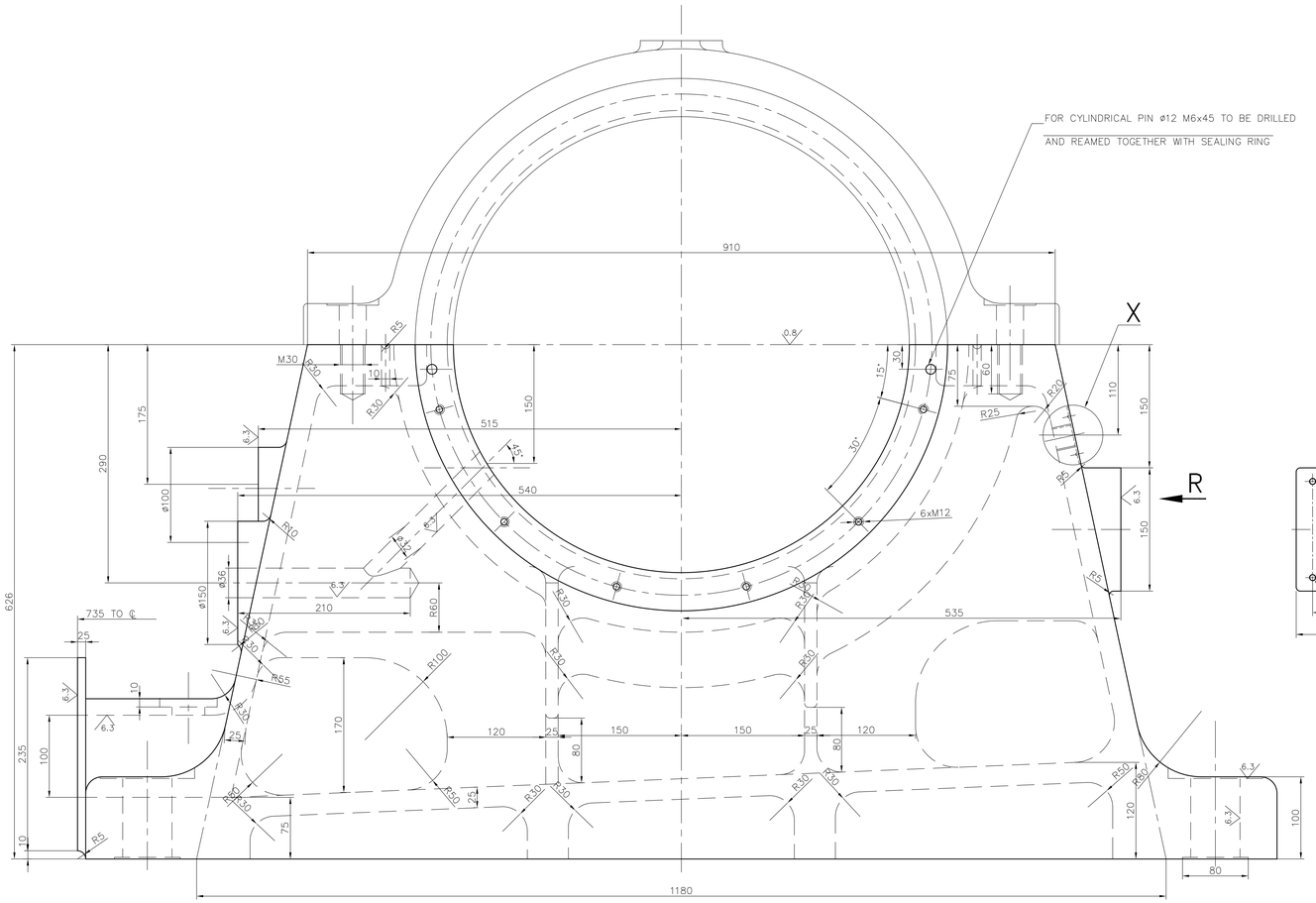
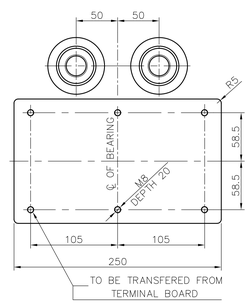
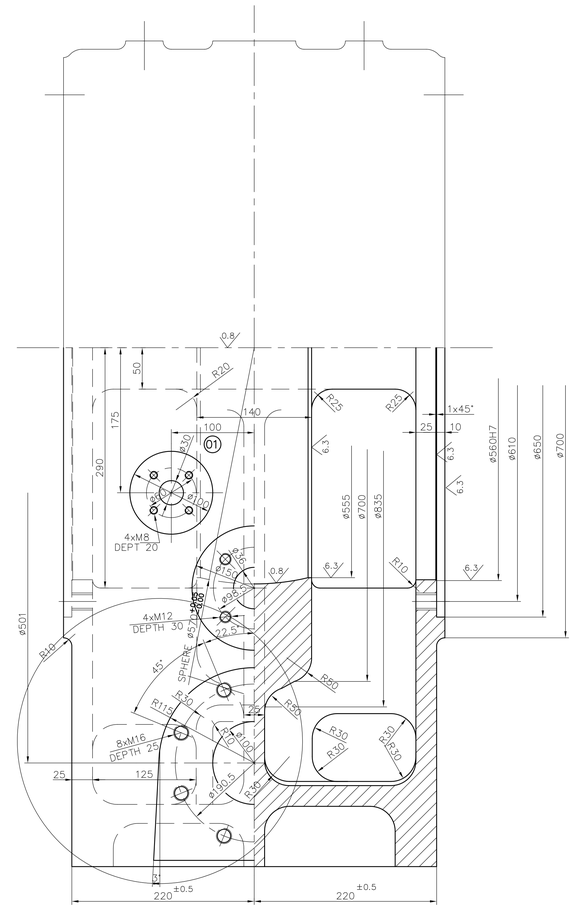
FIRST ANGLE PROJECTION

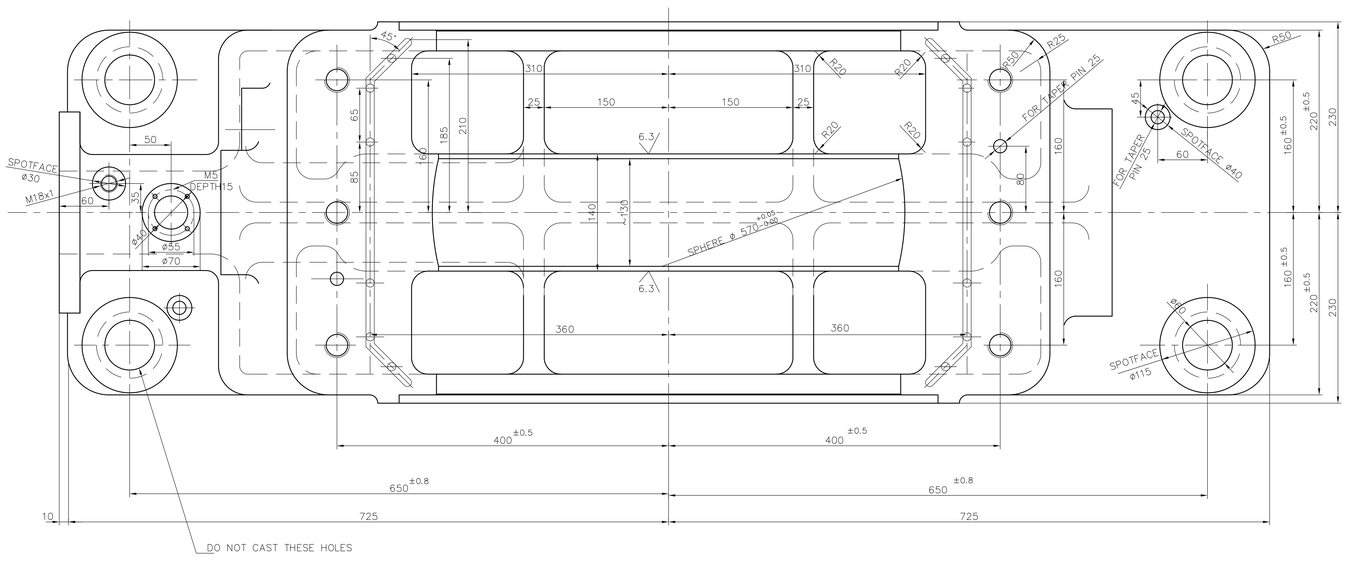
(ALL DIMENSIONS ARE IN mm)

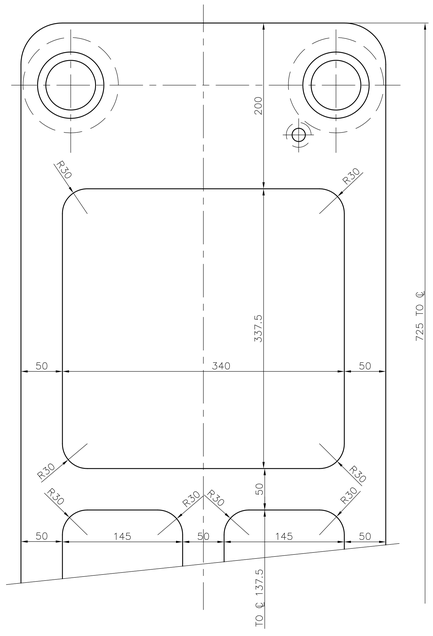
DRG. NO. 0-139-01-31116/00



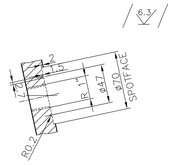








DETAIL–X



REMARKS:

1. BEARING PEDESTAL SHOULD BE SHOT BLASTED BEFORE MACHINING.
2. MACHINE THE INTERNAL DIAMETERS TOGETHER WITH THE TOP HALF OF BEARING PEDESTAL.
3. BEARING PEDESTAL MUST BE LEAK PROOF. LEAKGE TEST SHOULD BE CONDUCTED. BEFORE AND AFTER MACHINING WITH KEROSENE AS PER HY0850061
4. CLEAN CAREFULLY THE INTERNAL SURFACE OF THE BEARING PEDESTAL EXCEPT THE MACHINED SURFACES AND APPLY WHITE CRANK CASE SEALER.
5. ACCURACY OF CASTING ACCORDING TO AA0230402 CLASS4.
6. CASTING SHALL BE STRESS RELIEVED AT 520 TO 580°C FOR 5 HOURS.
   PATTERN No. M–20–338

ITEM NO.	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG. NO. OR FORGING DRG. NO.	MATERIAL CODE	NET WT.	GROSS WT.
						910	953
						2	
					MATERIAL SPECN.	QUANTITY	

THE FOLLOWING CONDITION: 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 SHSOWN OUT SIDE BACK SLASHS GIVEN AT THE TOP MOST RIGHT CORNER OF THE DRG.

APPROVED SAP

TYPE OF PRODUCT: TARI 700/800 – 15 to 24P

NAME OF CUSTOMER/PROJECT

BHARAT HEAVY ELECTRICALS LIMITED HYDERABAD

RESTRICTED

	NAME	SIGN.	DATE	NO.OF VAR.
DRN.	R.S.KUMAR		4–1–87	
CHD.	T.K.RAJU		4–1–87	NA
APPD.	M.M.RAJU		4–1–87	

DEPT.	SCALE	WEIGHT (KG)	REF. TO ASSY DRG.	ITEM NO.	NO.OF ITEMS
EME	NTS	910	1–139–01–31044	2	2
CODE 425					

TITLE	CARD CODE	DRAWING NO.	REV.
BOTTOM PART OF BEARING PEDESTAL MACHINING	NA	0–139–01–31116	01

REV.	DATE	ALTERED	CHD./APPD.
01	25.10.21	MJK	PDN/KCP
		JACK OIL HOLE ø25 CHANGED TO ø30	

ZONE D14

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COMPUTER FILE (NAME) DE.A0016

FILE NAME | SIGN. AND DATE | INVENTORY NO.

Oct Tue 26 10:54 2021

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