



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 HY850061
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 CLASS54.
6. CASTING SHALL BE STRESS RELIEVED AT 520 TO 580°C FOR 5 HOURS.
PATTERN No. M-20-338

<p>THE FOLLOWING CONDITIONS APPLY TO THE EXCEPT OTHERWISE STATED:</p> <ol style="list-style-type: none"> 1. REF. TO HYD20261 FOR UNSPECIFIED TOLERANCES. 2. CHAMFER M/C/D. SHARP EDGES 1.2 TO 1.0 AT 45°. 3. INTERNAL M/C/D. CORNER RADI 1 TO 0.7 4. THE SURFACE ROUGHNESS WHEREVER NOT SHOWN SHALL BE TAKEN FROM THE SURFACE ROUGHNESS SHOWN ON SIDE BACK OF PART GIVEN AT THE TOP MOST RIGHT CORNER OF THE DRG. 		<table style="width: 100%;"> <tr> <th colspan="2" style="text-align: left;">TYPE OF PRODUCT</th> <th colspan="4" style="text-align: right;">TARI 860 - 21P</th> </tr> <tr> <th colspan="6" style="text-align: left;">NAME OF CUSTOMER/PROJECT</th> </tr> <tr> <td style="width: 10%;"></td> <td style="width: 40%;">BHARAT HEAVY ELECTRICALS LIMITED HYDERABAD</td> <td style="width: 10%;">DRN. CHD. APP'D</td> <td style="width: 15%;">NAME M.ASRIM K.C.PANDA</td> <td style="width: 10%;">SIGN. </td> <td style="width: 15%;">DATE 27.07.16 27.07.16 27.07.16</td> </tr> <tr> <td>DEPT.</td> <td>EME</td> <td>SCALE</td> <td>WEIGHT (KG)</td> <td>REF. TO ASSY DRG.</td> <td>ITEM NO.</td> </tr> <tr> <td>CODE</td> <td>425</td> <td>NTS</td> <td>910</td> <td>1-139-01-31298</td> <td>2</td> </tr> <tr> <td>TITLE</td> <td colspan="2">BOTTOM PART OF BEARING PEDestal MACHINE</td> <td>CARD CODE NA</td> <td>DRAWING NO.</td> <td>REV.</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td>0-139-01-31139</td> <td>00</td> </tr> </table>	TYPE OF PRODUCT		TARI 860 - 21P				NAME OF CUSTOMER/PROJECT							BHARAT HEAVY ELECTRICALS LIMITED HYDERABAD	DRN. CHD. APP'D	NAME M.ASRIM K.C.PANDA	SIGN. 	DATE 27.07.16 27.07.16 27.07.16	DEPT.	EME	SCALE	WEIGHT (KG)	REF. TO ASSY DRG.	ITEM NO.	CODE	425	NTS	910	1-139-01-31298	2	TITLE	BOTTOM PART OF BEARING PEDestal MACHINE		CARD CODE NA	DRAWING NO.	REV.					0-139-01-31139	00
TYPE OF PRODUCT		TARI 860 - 21P																																										
NAME OF CUSTOMER/PROJECT																																												
	BHARAT HEAVY ELECTRICALS LIMITED HYDERABAD	DRN. CHD. APP'D	NAME M.ASRIM K.C.PANDA	SIGN. 	DATE 27.07.16 27.07.16 27.07.16																																							
DEPT.	EME	SCALE	WEIGHT (KG)	REF. TO ASSY DRG.	ITEM NO.																																							
CODE	425	NTS	910	1-139-01-31298	2																																							
TITLE	BOTTOM PART OF BEARING PEDestal MACHINE		CARD CODE NA	DRAWING NO.	REV.																																							
				0-139-01-31139	00																																							

This Drawing is under the control of Digital Archive System (E-DAS)

The above signatures are not essentially required.