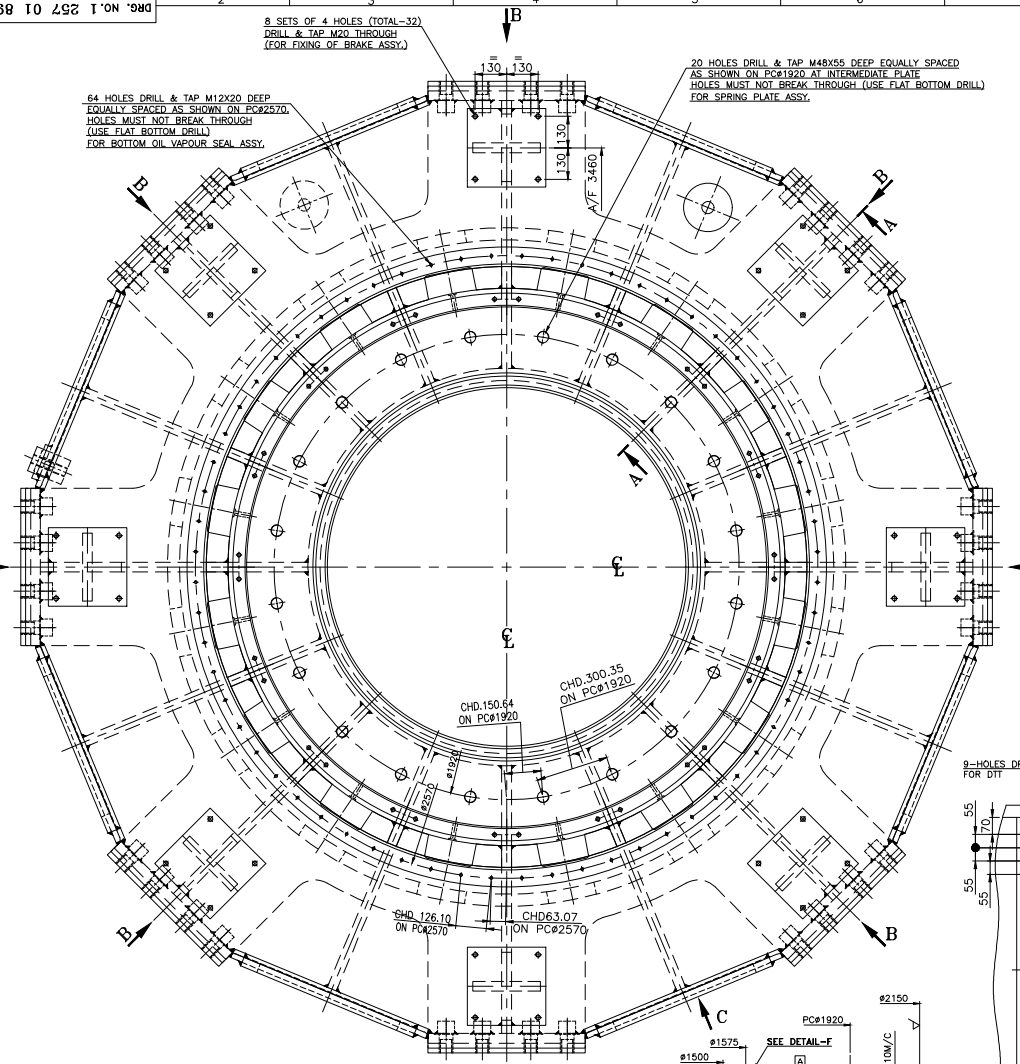
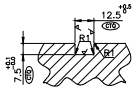
FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

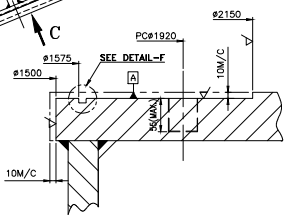
DRG. NO. 1 257 01 89604



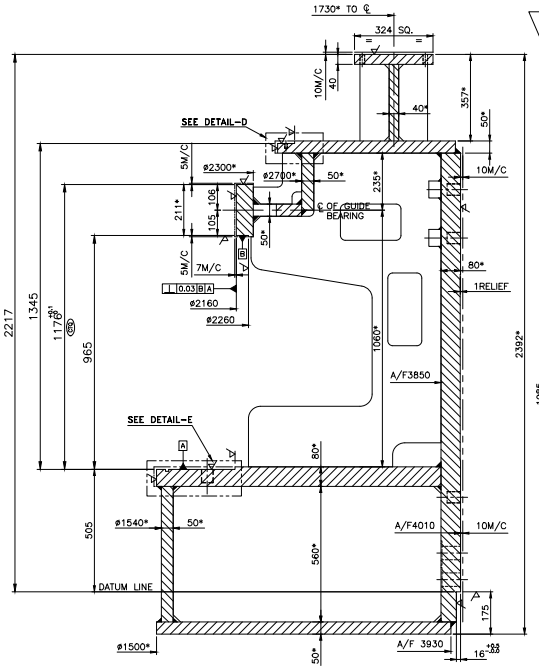
SUCTION END ASSEMBLY



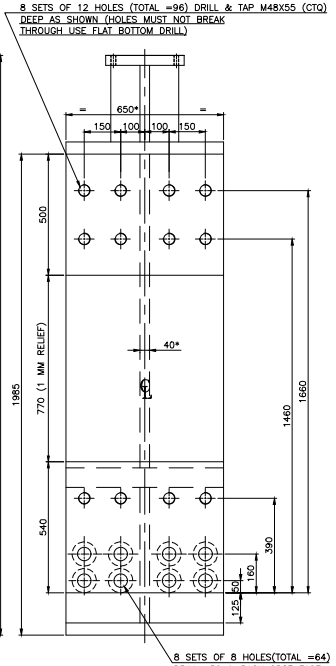
ENLARGED DETAIL-F



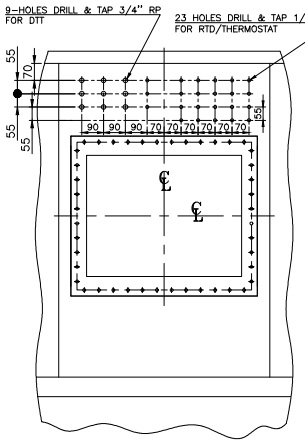
ENLARGED DETAIL-E



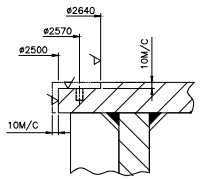
SECTION-AA



VIEW AS ARROW-B



VIEW AS ARROW-C



ENLARGED DETAIL-D

TECHNICAL REQUIREMENTS:-

1. APPLY TRP ON MACHINED SURFACES TO BP 0690084.
2. DIMENSIONS MARKED THUS * ARE FOR D.O. REFERENCE ONLY.
3. SURFACE FINISH OF MACHINED SURFACES SHALL BE 3.2 MICRONS OF BETTER.
4. DIMENSION MARKED THUS (CTQ) ARE CRITICAL & MUST BE MAINTAINED.
5. PAINTING SHALL BE CARRIED OUT AS PER HG 12007.

TOOL LIST		
IT. NO.	TOOL NO.	DESCRIPTION
1.	1598453 (EXISTING)	DRILL JIG FOR 12 HOLES M48 AND 8 HOLES ON DIAMETER JOINT FACE (COMMON BOTTOM BRACKET)
2.	1598461 (EXISTING)	DRILL JIG FOR 20 HOLES M48 IN PCD 1920 INTERMEDIATE PLATE (COMMON WITH SPRING PLATE ASSEMBLY).
3.	AA6312017257 (EXISTING)	DRILL 56 DIAMETER.
4.	SFB100/056 (EXISTING)	BACK SPOT FACE CUTTER ø100 WITH ø56 PILOT

QTY VAR00	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	STS	DRAWING NO.	IT.NO.	MATL. CODE	MATL. SPCN.	UNIT WT.	QTY.	GS	ZONE
001			001	BOTTOM BRACKET CENTRE ASSY.(FAB.)		0 257 01 89601	00				30610.00		

CARD TYPE-3 — CARD TYPE-1 — CARD TYPE-2

ADDITIONAL INFORMATION
W.O. 36201 TO 09 A 23157 STAGE-3
W.O. 36210 TO 18 A 23157 STAGE-3

STATUS OF DRAWING: U

DISTRIBUTION OF PRINTS
HGE-1 TEX-1
HGM-2

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT: HMS-713/170-24K PALAMURU RANGAREDDY LIS STAGE-2&3 (MEIL/TSGENCO)

BHARAT HEAVY ELECTRICALS LTD. BHOPAL

	NAME	SIGN	DATE
DRN.	RKP		30.09.20
CHK.	AKV/NS		30.09.20
APPD.	RG/AD		30.09.20

SCALE 1:10 — WEIGHT (KG) 29(GR) (M/C) — REF. TO ASSY. DRG. — ITEM NO. 001 — NO. OF ITEM 001 — REV. 00

BOTTOM BRACKET CENTRE ASSY. (M/C)

DRAWING NO. 1 257 01 89604 — REV. 02

REV.	DATE	ALTERED	CHECKED	APPROVED	ZONE	REMARKS
02	22.01.21					AS PER CUSTOMER'S REQUIREMENT, DTT HOLES UPDATED.
01	10.11.20	LAXMI	NS	RG		TOOL LIST ADDED AS PER TCM NO. 1100 DTD.-03.11.20

THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

REF. DRG. NO. — SIGN. & DATE — INVENTORY NO.

A1