

1. PROCESS PER ITEM 2.
2. FORGING VENDOR REQUIRED TO PERFORM 100% ULTRASONIC INSPECTION PER ITEM 2.
3. UNLESS OTHERWISE SPECIFIED ALL DIAMETERS TO HAVE

22	0.76	A B
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4. ALL DIMENSIONS ARE IN MM

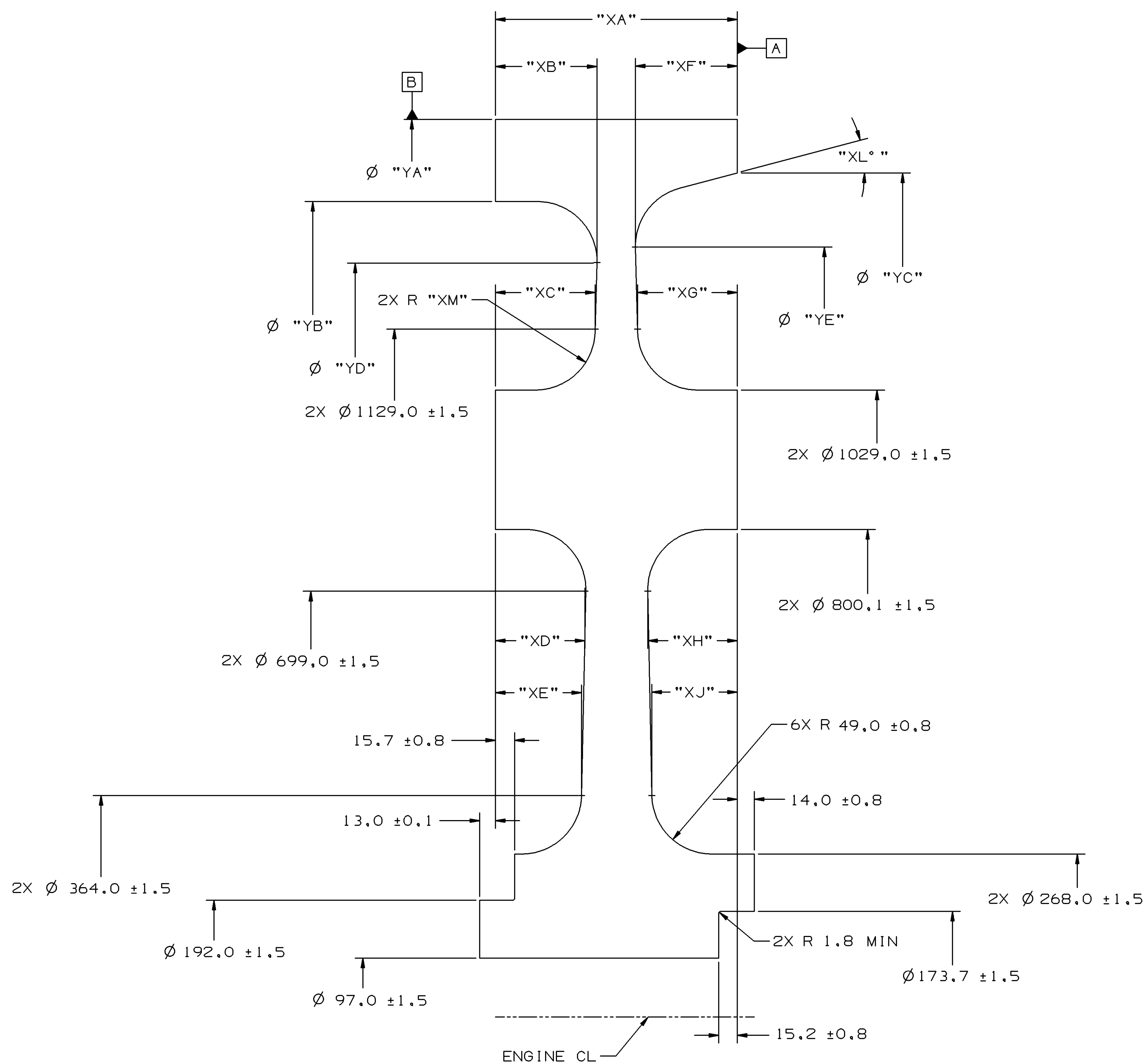


FIG. 1

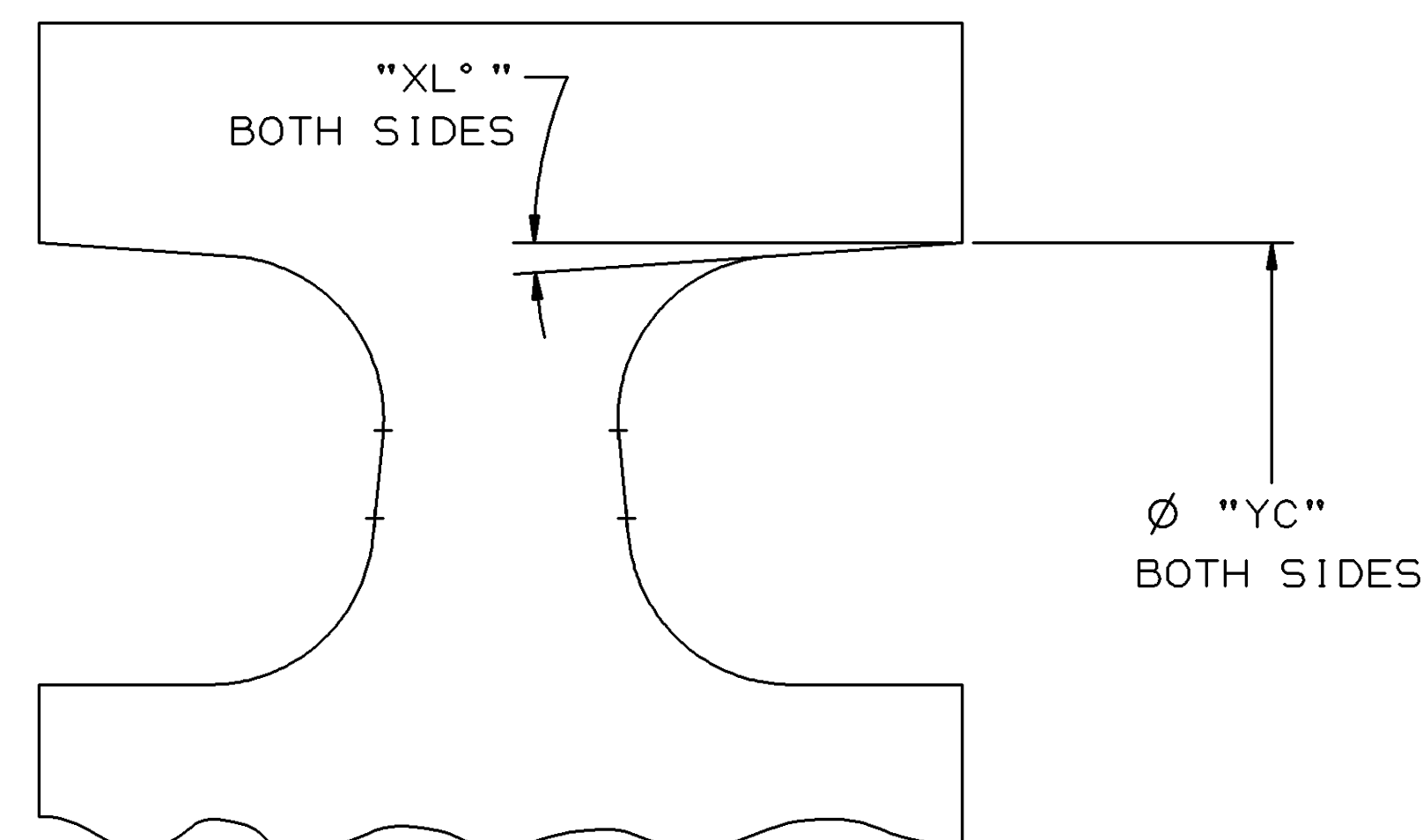


FIG. 2
(OTHERWISE SAME AS FIG. 1)



MATERIAL: STL (B50A420B10) HY19460 CLASS 'A'


VAR. NO.	STG	FIG. NO.	ϕ "YA" ± 1.5	ϕ "YB" ± 1.5	ϕ "YC" ± 1.5	ϕ "YD" ± 1.5	ϕ "YE" ± 1.5	"XA" ± 1.5	"XB" ± 0.76	"XC" ± 0.76	"XD" ± 0.76	"XE" ± 0.76	"XF" ± 0.76	"XG" ± 0.76	"XH" ± 0.76	"XI" ± 0.76	"XJ" ± 0.76	"XM" ± 0.76	"XL" ± 0.76	WT - KGS
02	2	2	1426,7	-	1294,6	1181,9	1181,9	277,4	103,4	100,8	74,9	63,2	103,4	100,8	74,9	63,2	49,0	4,04	2172	
03	3	2	1426,7	-	1294,6	1183,4	1183,4	263,7	106,4	104,6	86,1	78,2	97,5	95,8	77,2	69,3	49,0	4,29	1956	
04	4	2	1426,7	-	1294,6	1197,1	1197,1	258,8	108,7	107,4	94,7	89,9	108,7	107,2	94,7	89,9	49,0	10,98	1588	
05	5	1	1473,2	1398,1	1323,3	1237,3	1237,3	198,4	83,3	73,4	73,4	63,3	73,4	73,4	63,3	73,4	73,4	49,0	14,70	956
06	6	1	1426,7	1394,7	1436,9	1295,7	1320,1	178,6	75,9	74,4	67,3	64,5	72,6	74,4	67,3	64,5	49,0	14,60	1007	
07	7	1	1549,4	1434,9	1473,2	1355,5	1360,2	162,3	88,6	86,8	59,9	57,4	68,8	66,8	59,9	57,4	49,0	14,64	956	
08	8	1	1592,1	1470,7	1515,4	1370,8	1395,7	188,7	80,0	77,2	68,8	65,5	80,3	77,2	68,8	65,5	49,0	14,70	1152	

2	ACPT REQ	P29A-A0211	GT10117
1	APPLIED PRACTICE	I18D5700	13530491005
IT.	NOMENCLATURE	IDENT	BHEL SPECS
LIST OF COMPLEMENTARY DOCUMENTS			

TYPE OF PRODUCT OR

NAME OF CUSTOMER/PROJECT

		SHARAT HEAVY ELECTRICALS LIMITED			NAME	SIGN.	DATE	NO. OF VAR.
		HYDERABAD		DRN.	KR		06.01.15	
				CHD.	SATPAL		06.01.15	
				APPD.	KDG		06.01.15	

DEPT.	UNTOL. DIMS.		SCALE	WEIGHT (KG)	REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEMS
GTD	GR.		NTS	REFER B-4		NA	NA
CODE.	ϕ /M/f						
423							

TITLE	WHEEL FORG. CPRSR STAGE 2 TO 6 AND 8	CARD CODE	DRAWING NO.	REV
			0-353-04-98001	00
			SHT. No. 01	NO. OF SHT. 01

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GENERAL DIMENSIONAL LIMITS, FITS & TOLERANCES AS PER HY0230261