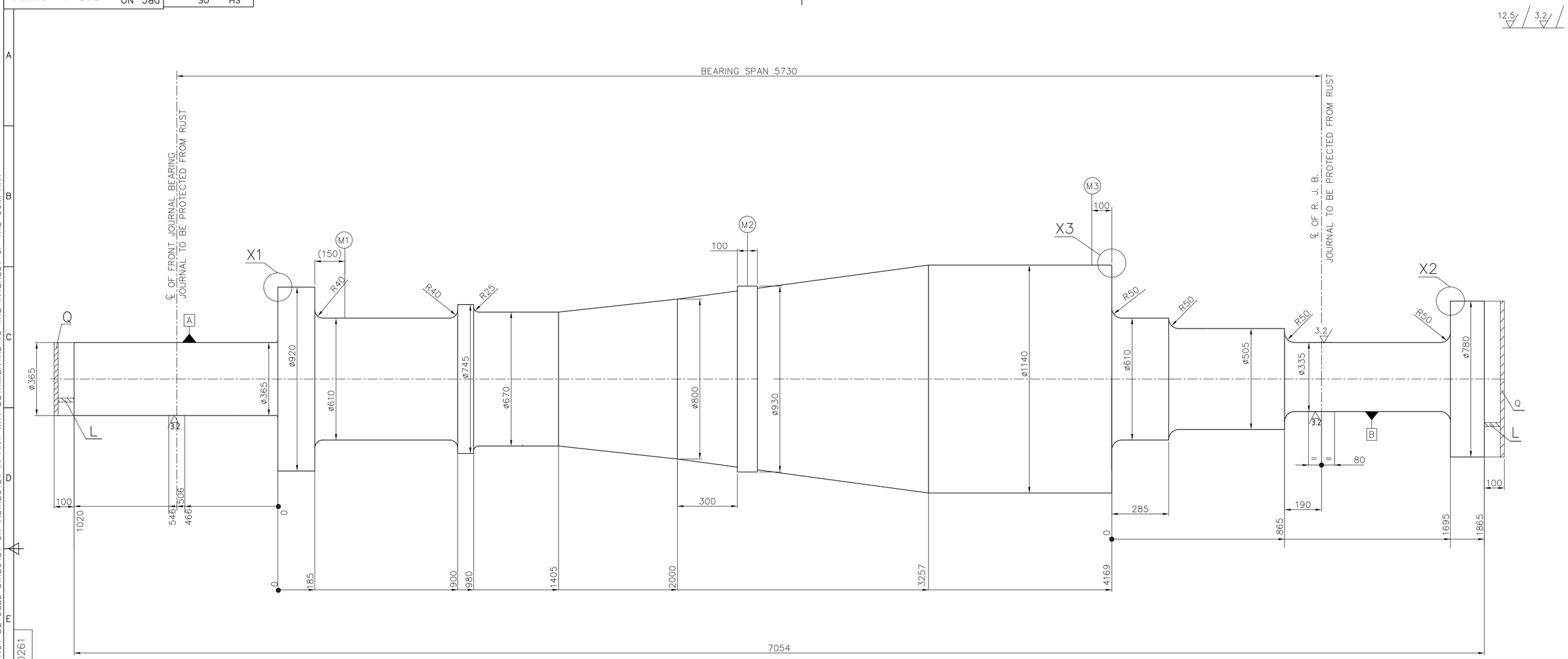
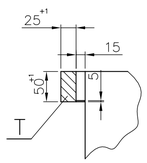
FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

DRG. NO. 1-303-01-20066 | SH. | OF




## DETAIL – X1, X2, X3 (MIRROR IMAGE)




M1 M2 M3 MEASURING LOCATIONS FOR THERMAL STABILITY TEST

EXACT LOCATION IN THE MEASURING LOCATION IS TO BE DECIDED BY THE SUPPLIER.

## NOTES: –

1. ROTOR FORGING TO BE SUPPLIED AS PER PURCHASE SPECIFICATION NO: HY19473
2. UNMENTIONED RADII R=10.
3. TOLERANCES OF DIMENSIONS: UPTO 500mm ±1mm.
   OVER 500mm ±2mm.

L = LONGITUDINAL TEST PIECE.
T = TANGENTIAL TEST PIECE.
Q = RADIAL TEST PIECE.

MATERIAL CODE: TC9507350209

MATERIAL : 30 CrMoNiV 511.

MATERIAL SPECIFICATION : HY19473

TURBINE TYPE: HNK71/3.2/32–4

00
VAR

TYPE OF PRODUCT OR
NAME OF CUSTOMER/PROJECT

BHARAT HEAVY ELECTRICALS LTD.
HYDERABAD

| | NAME | SIGN. | DATE | NO.OF VAR. |
|---|---|---|---|---|
| DRN. | P.M.RAO | | 24.5.03 | |
| CHD. | M.R.B | | 24.5.03 | |
| APPD. | M.R.B. | | 24.5.03 | |

CONFIDENTIAL

| ALTERED | REV. | DATE | ALTERED | REV. | DATE | ALTERED | REV. | DATE | ALTERED | REV. | DATE | ALTERED | REV. | DATE | ALTERED | REV. | DATE | ALTERED | REV. | DATE | ALTERED |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| CHD/APPD | | | CHD/APPD | | | CHD/APPD | | | CHD/APPD | | | CHD/APPD | | | CHD/APPD | 03 | 05.05.07 | CHD/APPD G.R.RAO D.S.RAO | 02 | 30.3.07 | CHD/APPD DSR |
| | ZONE | | | ZONE | | | ZONE | | | ZONE | | | ZONE | | | ZONE | THERMAL STABILTY TEST REQUIREMENT DELETED | ZONE | AXIAL TREPAN CORE IS DELETED. NOTE: 4 FOR FATT DELETED. |

| REV. | DATE | ALTERED |
|---|---|---|
| 01 | 11.05.04 | CHD/APPD M.R.BABU |
| ZONE | | DETAIL – D MODIFIED (M1) (M2) (M3) ADDED EXTRA FORGED MATERIAL ADDED. AXIAL CORE ADDED |

| DEPT. | UNTOL. DIMS. | | SCALE | WEIGHT (KG) | REF. TO ASSY. DRG. | ITEM NO. | NO.OF ITEMS |
|---|---|---|---|---|---|---|---|
| I.T.D. | GR. C/M/F | | | 23205 | –N.A.– | –N.A.– | –N.A.– |
| DEPT. CODE 415 | | | | | | | |

TITLE ROTOR (FORGING)

CARD CODE N.A.

DRAWING NO. 1-303-01-20066 REV. 03

SHT. No 1 NO. OF SHT. 1

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GENERAL DIMENSIONAL LIMITS, FITS & TOLERANCES AS PER HY0230261

INVENTORY NO | SIGN. AND DATE | REF. DRG. NO. | COMPUTER FILE NAME

12-05-2007
10:16:49

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