

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

DRG. NO. 1 22301 178 03

ALL OVER UNLESS  
OTHERWISE STATED.

6.3

#3499.45<sup>0</sup><sub>-0.30</sub>  
AFTER HVOF COATING

PCD 3340

#3178.95<sup>+0.30</sup><sub>0</sub>  
AFTER HVOF COATING8 HOLES EQUISPACED ON-CTRS  
DRILL & TAP THRU M30 ON PCD  
3340 FOR LIFTING & JACKING.  
(FROM FACE 'R')AFTER HVOF COATING  
110<sup>+0.3</sup><sub>0</sub>

FINISH IN SEAL GROOVE

P1

#3260<sup>-0.15</sup><sub>-0.30</sub>MINIMUM 500 MICRON HVOF  
COATING DEPOSITIONSECTION-AA  
(SCALE-2:1)TOP VIEW  
(SCALE-NTS)32 HOLES EQUISPACED OFF-CTRS  
DRILL AND C/Br ON PCD 3340 AS  
SHOWN IN SECTION-AA FOR  
BOLTING WITH RUNNER.  
THESE HOLES ARE TO BE MADE ON  
CNC MACHINE TO MAINTAIN  
INTERCHANGEABILITY327  
CHORD

## TECHNICAL REQUIREMENTS:-

1. REMOVE ALL BURRS AND SHARP EDGES
- 2a. NON-PERPENDICULARITY OF SURFACES-'P1', 'P2', 'Q' & 'R' w.r.t. DIAMETERS NOT TO EXCEED 0.05
- 2b. QUALITY OF DIAMETERS MARKED  $\phi$  NOT TO EXCEED 0.10
- 3a. \* MARKED DIAMETERS TO BE CONCENTRIC WITHIN 0.02
- 3b. DIAMETERS MARKED THUS  $\phi$  ARE CRITICAL FOR INSPECTION RE-VALIDATION DURING MEASUREMENT AT SHOP, ALSO THESE DIAMETERS SHOULD BE STRICTLY MAINTAINED FOR INTERCHANGEABILITY.
- 3c. DIAMETERS MARKED  $\phi$  ARE TO BE MEASURED IN CLAMP FREE CONDITION AT 8 ANGULAR POSITION EQUISPACED AND RECORD TO BE MAINTAINED.
4. LABYRINTH TO BE DISPATCHED ASSEMBLED IN A SUITABLE FIXTURE TO PREVENT DISTORTION / DAMAGE OF HVOF COATED AND MACHINED SURFACES DURING TRANSPORT & HANDLING.
5. NDT SHALL BE CARRIED OUT AS MENTIONED IN SPECIFICATION
6. REFER PURCHASE SPECIFICATION FOR MATERIAL, HVOF COATING, OTHER TECHNICAL DETAILS & INSPECTION
7. PAINT AND PROTECT TO HT00005 AS FOLLOWS-  
ALL SURFACES (WITHOUT HVOF COATING) TO CAT.-G

EXTENT OF HVOF COATING

68	VAR.00	69	REMARKS	70	VAR. NO.	71	ITEM NO.	72	DESCRIPTION	73	STD.	74	DRAWING NO.	75	VAR.	76	MATL. CODE	77	UNIT	78	QTY.	79	ZONE
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25 - CARD TYPE-3

25 - CARD TYPE-1

25 - CARD TYPE-2

DRAWING REVIEW				ADDITIONAL INFORMATION				TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT			
DEPT.	NAME	SIGN.	DATE	STATUS OF DRAWING U				RAMPUR HEP			
				DISTRIBUTION OF PRINTS				BHARAT HEAVY ELECTRICALS LTD. BHOPAL			
								DRN ANUJ 12.09.12			
								CKD ANUJ 12.09.12			
								APPD KP 12.09.12			
								DEPT. H.T.E. 32000049014			
								SCALE 1:1 & AS STATED			
								WEIGHT(K.G.) 1046.00			
								REF. TO ASSY.DRG. 0 20407 178 01			
								ITEM NO. 03			
								DRAWING NO. 1 22301 178 03			
								REV. 00			
								SHT. NO. 01 NO. OF SHT. 01			

UPPER LABYRINTH

A1 SIZE