

INVENTORY NO.

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8

6.3/ ALL OVER EXCEPT  
OTHERWISE STATED

(C.R.) \* -0.25  
ø3580 -0.20

\*  
/D 3.340 +0.60  
+0.20

PCD 3540

3.2 IN  
SEAL  
GROOVE

1

/D 3340 <sup>+0.20</sup>

40-HOLES M20 EQUISPACED OFF-CTRS TO BE  
DRILL 28 DEEP & TAP M20x25 DEEP ON PCD  
3540 FOR BOLTING WITH TOP COVER (USE FLAT  
DRILL) THESE HOLES ARE TO BE MADE ON CNC  
MACHINE TO MAINTAIN INTERCHANGEABILITY

MINIMUM 500 MICRON  
HVOF COATING

— MINIMUM 500 MICRON  
HVOF COATING

CHORD LENGTH





TOP VIEW

SECTION-AA

### TECHNICAL REQUIREMENTS:-

1. REMOVE ALL BURRS AND SHARP EDGES
  - 2a. NON-PERPENDICULARITY OF SURFACES- 'P', 'Q' & 'R' w.r.t. DIAMETERS NOT TO EXCEED 0.05
  - 2b. QUALITY OF DIAMETERS MARKED (C.R) NOT TO EXCEED 0.10
  - 3a. \* MARKED DIAMETERS TO BE CONCENTRIC WITHIN 0.02
  - 3b. DIAMETERS MARKED THUS (C.R) ARE CRITICAL FOR INSPECTION RE-VALIDATION DURING MEASUREMENT AT SHOP, ALSO THESE DIAMETERS SHOULD BE STRICTLY MAINTAINED FOR INTERCHANGEABILITY.
  - 3c. DIAMETERS MARKED (C.R) 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

[illegible]

DRAWING REVIEW				ADDITIONAL INFORMATION				TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT				RAMPUR HEP					
DEPT.	NAME	SIGN.	DATE														
				DISTRIBUTION OF PRINTS				<div></div> <div>BHARAT HEAVY ELECTRICALS LTD. BHOPAL</div> <div><div>DRN</div><div>NAME</div><div>SIGN</div><div>DATE</div><div>NO. OF VAR.</div></div> <div><div>CKD</div><div>ANUJ</div><div></div><div>12.09.12</div><div>—</div></div> <div><div>APPD</div><div>K.PRASAD</div><div></div><div>12.09.12</div><div>—</div></div>									
REV.	DATE	ALTERED		REV.	DATE	ALTERED		DEPT.	UNTOL. DIMS. GR.		SCALE 1:1 & AS STATED	WEIGHT (K.G.)	REF.TO ASSY.DRG.		ITEM NO.	NO.OF ITEM	
		CHECKED				CHECKED		H.T.E.									
		APPD.				APPD.		CODE	32000049014				0 20301 178 01		044		
ZONE				ZONE				TITLE				DRAWING NO.				REV.	
								UPPER OUTER STATIONARY LABYRINTH				2 22301 178 01				00	
												SHT. NO. 01		NO. OF SHT. 01			