

TD-106-1 Rev No. 5 Form No.		PRODUCT STANDARD PULVERISERS HYDERABAD	Product STD no.	BA 56289
			Rev No. 00	
			Page 1 of 3	

COPYRIGHT AND CONFIDENTIAL
 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.

BEARING HOUSING COVER LOWER FOR HP-1103 MILL

This specification is for the manufacturing of bearing housing cover lower finish machined. The same is being used in Bowl mills for coal pulverisers in Thermal Power Stations.

TOTAL WT : SEE TABLE

SCOPE OF SUPPLY : AS PER SPEC & BILL OF MATERIALS GIVEN IN BELOW:

S NO	DESCRIPTION	VAR	DRG/SPEC	QTY	Wt (Kg)
1	Bearing Housing cover lower	00	36132003706-00	1	57.62

1.0 List Of Drawings.

Sl. No.	Drawing No.	Description	Qty
1	36132003705-00	BEARING HOUSING COVER LOWER (FAB)	1

2.0 Bill of material for Bearing Housing cover lower

Sl.No.	Drawing. No.	Description	Applicable Specification
1	AA1011819210	PLATE 50 IS2062 GRE250(FE410W) QLTY-B	AA10119

All latest applicable drawings shall be enclosed along with drawing list at the time of enquiry / order.

3.0 RECOMMENDED MANUFACTURING SEQUENCE:

3.1 Fully fabricate & carry out NDT as per approved Quality Plan (QP). Attention may be provided to the notes given on the fabrication drawing.

3.2 Heat treatment as per HY0640763

3.2.1 Heat raise free below 425° C

3.2.2 Rate of heating : 101° C/Hour upto 600-650° C

3.2.3 Soaking Time : 128 minutes

TD-106-1 Rev No. 5	Form No.		PRODUCT STANDARD PULVERISERS HYDERABAD	Product STD no.	BA 56289
				Rev No. 00	
				Page 2 of 3	
COPYRIGHT AND CONFIDENTIAL 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.		3.2.4 Rate of cooling : 123° C/Hour upto 425° C 3.2.5 Free cooling below: 425° C 3.3 Final fabrication dimension inspection. 3.4 Machining as per drawing dimensions. Dimensions shall be maintained within tolerance. 3.5 Drill jigs shall be used for 16 holes x Ø14 on PCD 1032 and 16 holes x M10 on PCD 966. 4.0 <u>GENERAL INSTRUCTIONS:</u> 4.1) All the tolerance dimensions shall be as per the respective drawings/drawing notes. 4.2) For open dimensions, Std No. HY0230261 to be referred for unspecified tolerance. 4.3) Follow WPS as indicated in the drawing. Welding shall be done by the qualified welders. 4.4) LPI carried after back chipping of all butt welds as per AA0850131 acceptance as per AA0850129. 4.5) All butt welds shall 10% spot RT on all Butt welds as per HY0850170 & acceptance as per HY0850170 unless otherwise mentioned in the quality plan. 4.6) All fabricated items to be properly cleaned /grit blast cleaned and primer painted. Preservative/TRP to be applied on machined surfaces. 4.7) Any offloading to sub-vendor shall be done with prior approval of BHEL. 4.8) Plates greater than 25 mm thickness shall be procured from BHEL approved vendors only. 4.9) Plates 40 mm thickness and above shall be UT quality. 5.0 <u>Quality Plan:</u> 5.1 Approved Quality plan to be followed. 5.2 Inspection will be carried out by BHEL/BHEL nominated agency at the suppliers works before painting as per stage inspection finalized. 6.0 <u>Painting</u> 6.1 Abrasive blast clean to SA 2½ (ISO:8501-1) and apply 2 coats of primer as per customer approved painting schedule. 7.0 <u>PACKING</u> 7.1 Items shall be firmly fixed on to trailer/wagon by suitable means to avoid all transit damages.			

TD-106-1 Rev No. 5	Form No.		PRODUCT STANDARD PULVERISERS HYDERABAD	Product STD no.	BA 56289
				Rev No. 00	
				Page 3 of 3	

RECORD OF REVISIONS

REV. NO	DATE	REVISION DETAILS	REVISED	APPROVED

COPYRIGHT AND CONFIDENTIAL
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.