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BEARING HOUSING INNER - HP-1103 MILL

This specification is for the manufacturing of bearing housing inner finished 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-INNER	00	16131001844-00	1	557.400

1.0 List Of Drawings.

Sl. No.	Drawing No.	Description	Qty
1	16131001844-00	BEARING HOUSING INNER- F/M	1
2	26131003242-00	BEARING HOUSING-INNER (FAB)	1

2.0 Bill of Material for bearing housing inner

Sl.No.	Drawing. No.	Description	Applicable Specification
1	AA1011819201	PLATE 45 IS2062 GRE250(FE410W) QLTY-B	AA10119
2	AA1011808030	PLATE 6 IS2062 GRE250(FE410W)QLTY-A	AA10108

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

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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 : 125° C/Hour upto 600-650° C
- 3.2.3 Soaking Time : 108 minutes
- 3.2.4 Rate of cooling : 127° C/Hour upto 425° C
- 3.2.5 Free cooling below: 425° C

3.3 Final fabrication and dimension inspection.

3.4 Machining as per drawing dimensions. Dimensions shall be maintained within tolerance.

3.5 Drill jigs shall be used for 24 holes x M16 on PCD 819.

4.0 GENERAL INSTRUCTIONS:

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.

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5.0 Quality Plan:

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 Painting

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 PACKING

7.1 Items shall be firmly fixed on to trailer/wagon by suitable means to avoid all transit damages.

RECORD OF REVISIONS

REV. NO	DATE	REVISION DETAILS	REVISED	APPROVED

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