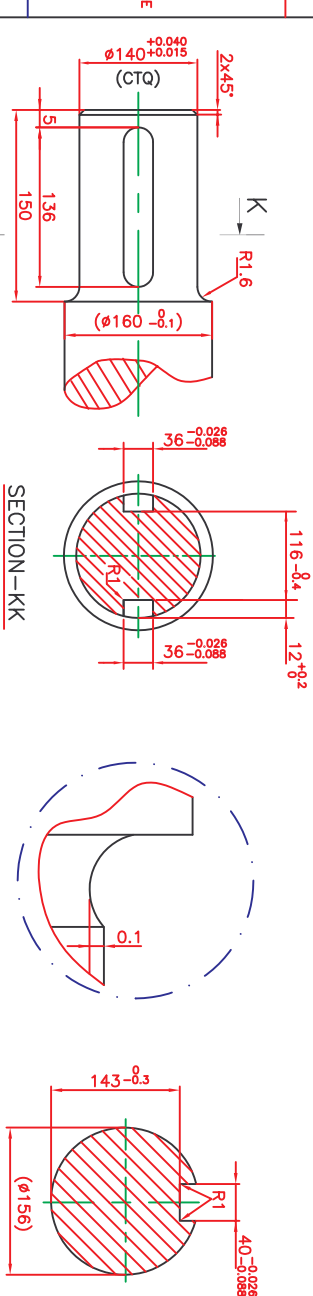


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GAUGE LIST	

TOOL LIST	

11.	TOOL NO.	DESCRIPTION
	1610862	COMMON DRILL PLATE FOR Ø8 INCLINED HOLE
	1610863	TUNNING TOOL FOR TRAPEZOIDAL THREAD
	1610864	GROOVING TOOL FOR 2.5 DEEPX12 WIDE
	1610865	RADIUS TOOL R4
	1610860	DRILL Ø8X400L.G.
	1610980	DRILL JIG FOR 4XM16 HOLE ON PCD 105±0.3

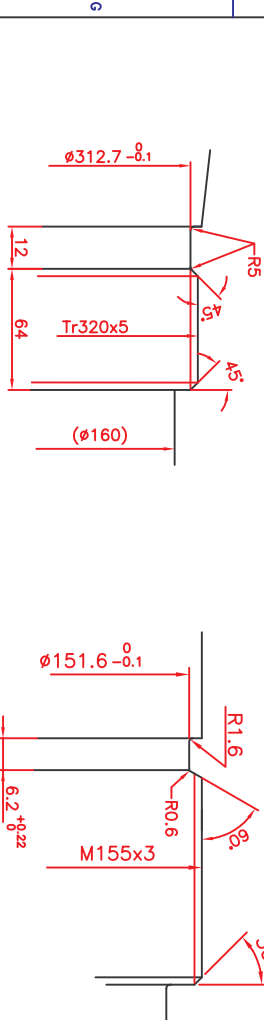
GAUGE LIST	
IT. TOOL NO.	DIAMETER
1516281	CALIPER GAUGE Ø140- ^{+0.040} / _{-0.040}
1610932	CALIPER GAUGE Ø160- ^{+0.040} / _{-0.040}
1610933	CALIPER GAUGE Ø160- ^{+0.1} / _{-0.1}
1610934	CALIPER GAUGE Ø170- ^{+0.133} / _{-0.108}
1610935	CALIPER GAUGE Ø350-6- ^{+0.038} / _{-0.038}
1610936	CALIPER GAUGE Ø335- ^{+0.028} / _{-0.028}
1610937	CALIPER GAUGE Ø160- ^{+0.1} / _{-0.1}
1610938	CALIPER GAUGE Ø156- ^{+0.040} / _{-0.040}

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TECHNICAL REQUIREMENTS :-

1. FOR THREADED CENTRE HOLES ON BOTH ENDS REFER DRG. AM 54079 ITEM 04.
 2. HOLES ON SHAFT ENDS ARE NOT TO BE USED FOR LIFTING PURPOSES.
 3. DIMENSIONS IN BRACKETS ARE FOR D.O. REFERENCE ONLY.
 4. M/CING ALLOWED ²⁰/₁₀₀ UNLESS STATED OTHERWISE.
 5. ALL RADII SHOULD BE FINISHED SMOOTH (NO TOOL MARKS).
 6. DIMENSIONS/PARAMETERS MARKED AS (CTO) ARE CRITICAL TO QUALITY. REFER PRODUCT STANDARD AM 54168.
 7. IT MUST BE ENSURED THAT DURING ROTOR BALANCING, THE ROTOR ROTATES IN ITS ACTUAL DIRECTION OF ROTATION ONLY. ACCORDING TO THIS, THE HOLES FOR DYNAMIC BALANCING ADAPTOR SHALL BE DRILLED EITHER ON DE OR NDE SHAFT FACE.
 8. 50mm WIDE COLLAR TO BE KEPT FOR LIFTING OF ROTOR & TO BE MACHINED OFF TO FINISH DIAMETER AT THE TIME OF FINAL MACHINING.
 9. TAPEIR SURFACE TO BE CHECKED USING 'RING GAUGE' SUPPLIED BY M/s. KSB. AFTER ASSEMBLY OF RING GAUGE, DIMENSION 'd' TO BE 11.5-1²₈.
- BLUE MATCHING SHALL BE DONE TO ENSURE MINIMUM 80% COMPLT.


VIEW AS ARROW-X



IMP:- SHAFT SHALL BE MACHINED IN TWO STAGES-

- c) IN FIRST STAGE ONLY CORE SEATING DIAMETER SHALL BE FINISHED AND SHAFT SENT FOR CORE ASSEMBLY. GRINDING ALLOWANCE SHALL BE LEFT ON ALL OTHER CLOSELY TOLERATED DIMENSIONS, BEARING JOURNAL (WITH THE GRINDING ALLOWANCE) SHALL BE REASONABLY SMOOTH AS THE FIRST STAGE BALANCING SHALL BE DONE WITH THIS DIAMETER RESTING ON ROLLERS.
- b) AFTER BRAZING OF S.C. BARS TO S.C. RINGS, SHAFT SHALL BE FINISH GRINDED TO DRG. DIMENSIONS.

[illegible]

ACROPLAST INFORMATION W.O. 4218BA423-11		TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		1TC3631-4P NPCL	
STATUS OF DRAWING					
DISTRIBUTION OF REVISIONS					
A/E -1 P/LM -4		TCX(P/LM)-1			
		BHARAT HEAVY ELECTRICALS LTD. BHOPL			
		NAME		DATE	
		DRN LP		16.12.2003	
		SIGN.		16.12.2003	
		-S-		16.12.2003	
		O.H.		16.12.2003	
		R/P		16.12.2003	
		SB		16.12.2003	
		-S-		16.12.2003	
		APPD		16.12.2003	

REV.	DATE	APPROVED	DEFINITION	SCALE	WEIGHT(Kg)	REF. TO ASSY. DRG.
01	24.12.2003	CHECKED	GRADE OF INT.DIM. G/M/M	N.T.S.	1810	
		APPROVED				
GAUGE LIST ADDED.						
TITLE			DRAWING NO.			
SHAFT (MACHINING)			14028142208			
CARD CODE			SHEET NO. 01 NO. OF SHEETS 01			