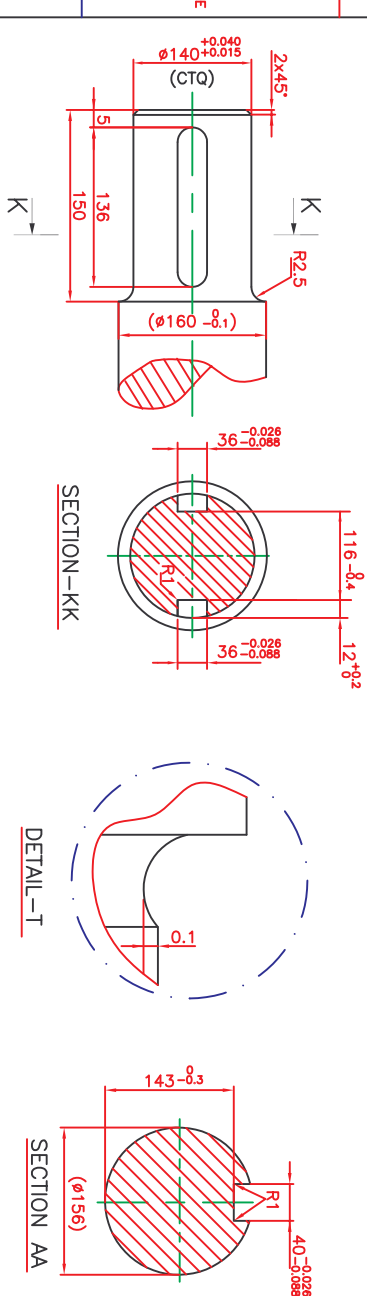


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IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.



GAUGE LIST	
IT, TOOL NO.	DIAMETER
1516281	CALPER GAUGE $\phi 140_{-0.040}^{+0.040}$
1610932	CALPER GAUGE $\phi 160_{-0.110}^{+0.085}$
1610933	CALPER GAUGE $\phi 160_{-0.1}^{+0.1}$
1610934	CALPER GAUGE $\phi 170_{-0.133}^{+0.133}$
1610935	CALPER GAUGE $\phi 250.6_{-0.036}^{+0.036}$
1610936	CALPER GAUGE $\phi 335_{-0.180}^{+0.228}$
1610937	CALPER GAUGE $\phi 160_{-0.1}^{+0.1}$
1610938	CALPER GAUGE $\phi 156_{-0.045}^{+0.045}$

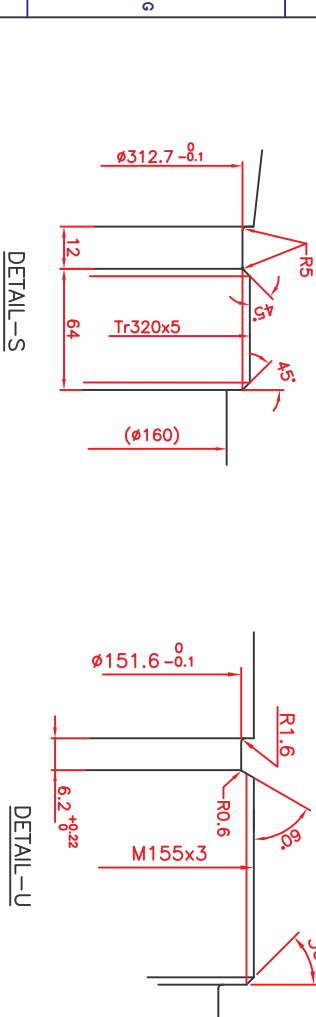
TOOL LIST	
IT.	DESCRIPTION
1610862	COMMON DRILL PLATE FOR Ø8 INCLINED HOLE
1610863	TURNING TOOL FOR TRAPEZOIDAL THREAD
1610864	GROOVING TOOL FOR 2.5 DEEPX12 WIDE
1610865	RADIUS TOOL R4
1610860	DRILL Ø8x400LG.
1610980	DRILL JIG FOR 4M16 HOLE ON PCD 105±0.3

## TECHNICAL REQUIREMENTS :-

1. FOR THREADED CENTRE HOLES ON BOTH ENDS REFER DRG. AM 54079 ITEM 1.
  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 <sup>2</sup>/<sub>3</sub> UNLESS STATED OTHERWISE.
  5. ALL RADII SHOULD BE FINISHED SMOOTH (NO TOOL MARKS).
  6. DIMENSIONS/PARAMETERS MARKED AS (CTQ) 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 NE 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<sup>+0.6</sup><sub>-0.6</sub>
- BLUE MATCHING SHALL BE DONE TO ENSURE MINIMUM 80% CONTECT.

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.



01		B.O.		01		44028142293		01		2228.0	
59		65		75 76 77 78 79 80		59 60		79 80 81 82		65 72	
WIR 00		REMARKS		ITEM NO.		DESCRIPTION		DRAWING NO.		ZONE	
28		28		28		28		28		28	
CARD TYPE-3		CARD TYPE-1		CARD TYPE-2		CARD TYPE-2		CARD TYPE-2		CARD TYPE-2	

[illegible]

REV.	DATE	APPROVED	NAME	GRADE OR TITLE	SCALE	WEIGHT (KG.)	REF. TO ASST. DRG.	ITEM NO.
	CHECKED	APPROVED	DATE	GRADE OR TITLE	SCALE	WEIGHT (KG.)	REF. TO ASST. DRG.	ITEM NO.
			404	1/8" = 1"	N.T.S.	1810		
TITLE					DRAWING NO.			
SHAFT (MACHINING)					14028142226			
CARD CODE					SHEET NO. 01 NO. OF SHEETS 01			