

INVENTORY NO. SIGN. AND DATE REF. DRG. NO. COMPUTER FILE NAME 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

GENERAL DIMENSIONAL LIMITS, FITS & TOLERANCES AS PER HY0230261

DRG. NO. 3-303-01-20222

SH. 01 OF 01

8320

BEARING SPAN=6890

FOR THE HEAT TREATMENT REFER NOTES-9.

EXTRA FORGING MATERIAL.
AXIAL CORE SAMPLES FOR TESTING
IN THIS ZONE ONLY.

12.5/3.2/

JOURNAL TO
BE PROTECTED
FROM RUST

GENERATOR END
(CORRESPONDING TO
FORGING TOP END)

JOURNAL SURFACE AND
SECONDARY SUPPORT AREAS ARE
TO BE PROTECTED FROM RUST.

(M1) (M2) (M3) MEASURING LOCATIONS FOR THERMAL STABILITY TEST

NOTES:-

EXACT LOCATION IN THE MEASURING LOCATION IS TO BE DECIDED BY THE SUPPLIER.

1. ROTOR FORGING TO BE SUPPLIED AS PER PURCHASE SPEC. NO. MENTIONED IN VARIANT TABLE.
2. UNMENTIONED RADII R=10
3. THERMAL STABILITY TEST IS TO BE DONE.
4. TOLERANCES OF DIMENSIONS AS PER PURCHASE SPECIFICATION.
5. THE AXIAL CORE SHALL BE TESTED BY THE SUPPLIER AS PER SPEC: AA0850155 & PROPERTIES TO BE ACHIEVED AS PER CLAUSE 11.3 OF SPECIFICATION MENTIONED IN VARIANT TABLE. THE SUPPLIER SHALL SUBMIT TO BHEL THE TEST CERTIFICATES WITH ALL THE TEST RESULTS AND THE SAMPLING PLAN. THE REMAINING AXIAL CORE DULY MARKED FOR IDENTIFICATION SHALL BE SENT TO BHEL.
6. IN CASE THE TEST RESULTS ON FIRST AXIAL CORE ARE UNSATISFACTORY, BHEL MAY BE APPROACHED FOR NECESSARY ACTION.
7. THE AXIAL BORE AFTER TESTING SHALL BE PLUGGED BY DETACHABLE PLUG. THE PRESERVATIVE USED FOR PROTECTING THE BORE AGAINST CORROSION MUST BE REMOVABLE BY COLD DEGREASING AGENT.
7. THE AXIAL BORE AFTER TESTING SHALL BE PLUGGED BY DETACHABLE PLUG.
8. MANUFACTURING & INSPECTION SEQUENCE PLAN (MIP) FOR FORGING AS PER SPEC: HY0652099.
9. MECHANICAL PROPERTIES AS PER LP PART(REFER CLAUSE 11.1 OF SPEC: HY19480)

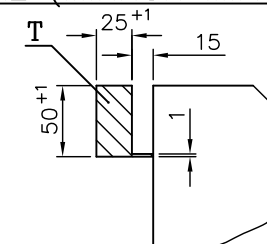
T = TANGENTIAL TEST PIECE

Q = RADIAL TEST PIECE

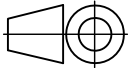
THE HATCHED PORTION IS TO BE
MACHINED OFF AFTER SUCCESSFUL
TESTING OF AXIAL CORE TEST PIECE

CORE IS TO BE MARKED
WITH THE IDENTIFICATION
NUMBER, CORE NUMBER
AND ACCEPTANCE STAMP

DETAIL - X1 &
X2 (MIRROR IMAGE)



TC9518050031	40946	23CrMoNiWV88 HY19480	00
MATERIAL CODE	Weight (Kg)	MATERIAL PURCHASE SPEC.	VAR.

TYPE OF PRODUCT OR				HNK 90/5.0-7				
NAME OF CUSTOMER/PROJECT								
		BHARAT HEAVY ELECTRICALS LTD. HYDERABAD			NAME	SIGN.	DATE	NO.OF VAR.
				DRN.	PATIL		24.10.18	N.A.
				CHD.	RATHOD		24.10.18	
				APPD.	ASHOK		24.10.18	
DEPT. I.T.D	UNTOL. DIMS. GR. C/M/F		SCALE N.T.S	WEIGHT (KG) N.A.	REF. TO ASSY. DRG. N.A.		ITEM NO. N.A.	NO.OF ITEMS N.A.
CODE 415								
TITLE ROTOR FORGING HNK 90/5.0-7				CARD CODE N.A.	DRAWING NO. 3-303-01-20222			REV 00
				SHT. No 01		NO. OF SHT. 01		