

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

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COMPUTER FILE NAME
3-30301-20195/M

SIGN. AND DATE

INVENTORY NO

GENERAL DIMENSIONAL LIMITS, FITS & TOLERANCES AS PER HY0230261

DRG. NO. 3-303-01-20225

SH. 01 OF 01

8320

BEARING SPAN=6890

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

12.5/3.2

JOURNAL TO
BE PROTECTED
FROM RUSTGENERATOR END
(CORRESPONDING TO
FORGING TOP END)JOURNAL SURFACE AND
SECONDARY SUPPORT AREAS ARE
TO BE PROTECTED FROM RUST.

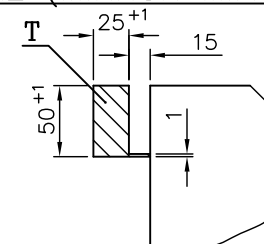
NOTES:-

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

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 THE 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. THERMAL STABILITY TEST SHALL BE DONE AS PER PURCHASE SPECIFICATION.

T = TANGENTIAL TEST PIECE
Q = RADIAL TEST PIECE

THE HATCHED PORTION IS TO BE
MACHINED OFF AFTER SUCCESSFUL
TESTING OF AXIAL CORE TEST PIECECORE IS TO BE MARKED
WITH THE IDENTIFICATION
NUMBER, CORE NUMBER
AND ACCEPTANCE STAMPDETAIL - X1 &
X2 (MIRROR IMAGE)

TC9519950028	40946	30CrMoNiV511 HY19499	00
MATERIAL CODE	Weight (Kg)	MATERIAL PURCHASE SPEC.	VAR.

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		HNK 90/5.0-7			
 BHARAT HEAVY ELECTRICALS LTD. HYDERABAD	DRN.	NAME	SIGN.	DATE	NO. OF VAR.
	CHD.	PATIL		24.10.18	N.A.
	APPD.	RATHOD		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.
CODE 415					
TITLE ROTOR FORGING HNK 90/5.0-7		CARD CODE N.A.	DRAWING NO. 3-303-01-20225		REV. 00
		SHT. No 01		NO. OF SHT. 01	

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