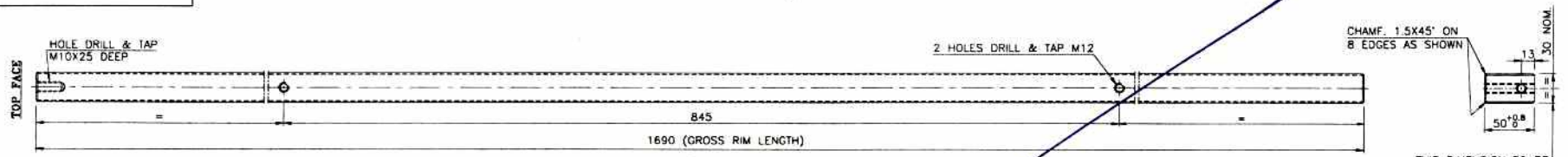
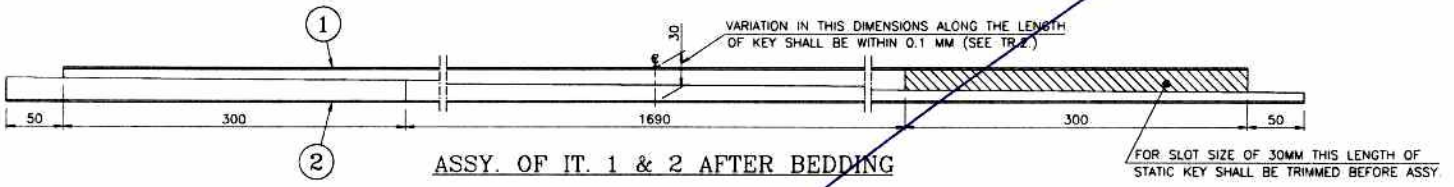
FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm

DRG. NO. 2 252 03 05701

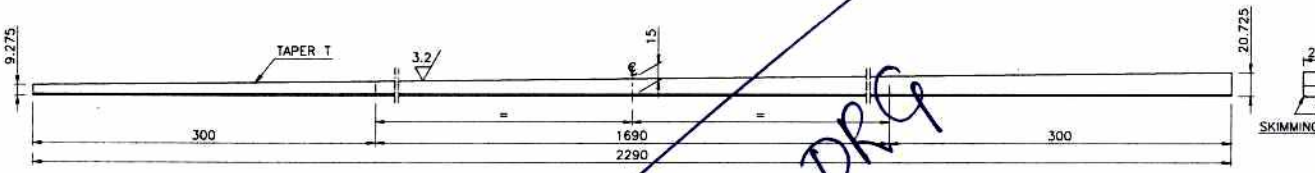


③ ▽ALL OVER

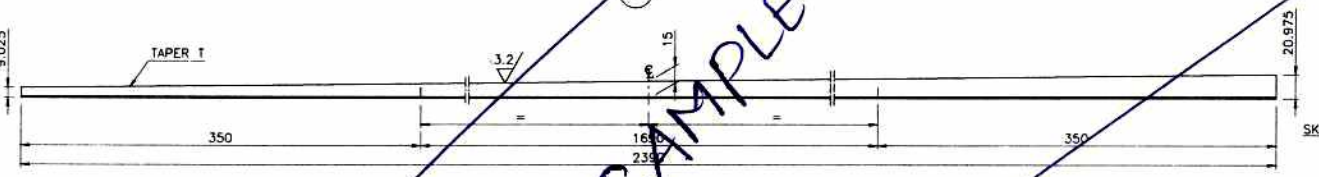


ASSY. OF IT. 1 & 2 AFTER BEDDING

GROSS RIM LENGTH.	TAPER T	A
1690	1 IN 200	300



①

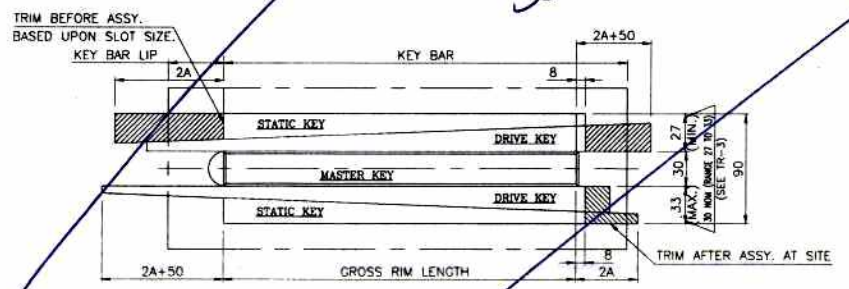


②

SAMPLE DRG

TECHNICAL REQUIREMENTS:-

1. THE TAPER MACHINING SHALL BE DONE ON A PAIR OF KEYS & THE KEYS SHALL BE MATCH MARKED. DIMENSIONS AFTER PAIRING SHALL BE AS SHOWN IN THE ASSEMBLY. KEYS ARE REQUIRED TO BE PARALLEL ALONG THE LENGTH WITHIN 0.1MM, WHEN PAIRED TOGETHER IN THE CLAMPED CONDITION.
2. THE MATCHING TAPER FACES OF RIM KEYS SHOULD BE FLAT. CONVEXITY ON THESE FACES IS NOT ALLOWED. CONCAVITY ON THESE FACES SHALL NOT EXCEED 0.05MM. WHEN KEYS IN PAIR, OBSERVED IN THE CLAMPED CONDITION KEYS ARE ACCEPTABLE IF A 0.05 MM FEELER GAUGE DOES NOT PASS THROUGH THE GAP BETWEEN THEM.
3. BY ADJUSTING STATIC & DRIVE KEYS AS SHOWN, VARIATION IN THE POCKET WIDTH CAN BE ACCOUNTED FOR.
4. THE SURFACE FINISH OF MACHINED SURFACES SHALL BE 3.2 MICRONS OR BETTER.
5. APPLY TRP ON MACHINED SURFACES AS PER BP0690084.



TYPICAL METHOD OF ASSEMBLY OF KEYS FOR 30±3 MM RIM SLOTS

VARGO	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.NO. / VAR.	MATL. CODE / MATL. SPCN.	A / UNIT	UNIT WT. / QTY.	CS	ZONE
			003	MASTER KEY 40TK.X60X1690LG. H.R.C.S. BAR				AA1030305976 / AA10305	NA	NO / 19.74		
			002	DRIVE TAPER KEY 25TK.X25X2390LG. H.R.C.S. BAR				AA1030405116 / AA10305	NA	NO / 6.99		
			001	STATIC TAPER KEY 25TK.X25X2290LG. H.R.C.S. BAR				AA1030405116 / AA10305	NA	NO / 6.70		
28 — CARD TYPE-3			28 — CARD TYPE-1				28 — CARD TYPE-2					

ADDITIONAL INFORMATION
W.O :--36221 TO 26 A 23152

STATUS OF DRAWING
U

DISTRIBUTION OF PRINTS
HGE-2 TEX-1
HGM-2

उत्पाद का प्रकार या ग्राहक / परियोजना का नाम
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT

HGT-540/150-16D
BALIMELA HEP (R & M)/OHPC

भारत हेवी इलेक्ट्रिकल्स लिमिटेड भोपाल
BHARAT HEAVY ELECTRICALS LTD. BHOPAL

	नाम / NAME	हस्ता / SIGN	दिनांक / DATE
बनाया DRN.	RKP		31.10.17
देखा CKD.	AG/AKV		31.10.17
अनुमोदित APPD.	RG/AD		31.10.17

REV.	DATE	ALTERED / CHECKED / APPROVED

विभाग DEPT.	अनुमत नाप की थपी UNTOL. DIMS. CR.	अनुपात SCALE	भार (कि.ग्रा.) WEIGHT (K.G.)	अंगी ड्राइंग का संदर्भ REF. TO ASSY. DRG.	मद क्र. ITEM NO.	मद संख्या NO. OF ITEM
कोड CODE 403	32500001404	1:3	47.12	0 252 03 05704	009-011	003

शीर्षक / TITLE
SET OF ROTOR RIM KEYS

ड्राइंग क्र. / DRAWING NO. 2 252 03 05701 — पुनः / REV. 00

शीट क्र. / SHT. NO. 01 — शीटों की संख्या / NO. OF SHT. 01

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.

REF. DRG. NO. | SIGN AND DATE | INVENTORY NO.

A2

8