FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

DRG. NO. 32530239601

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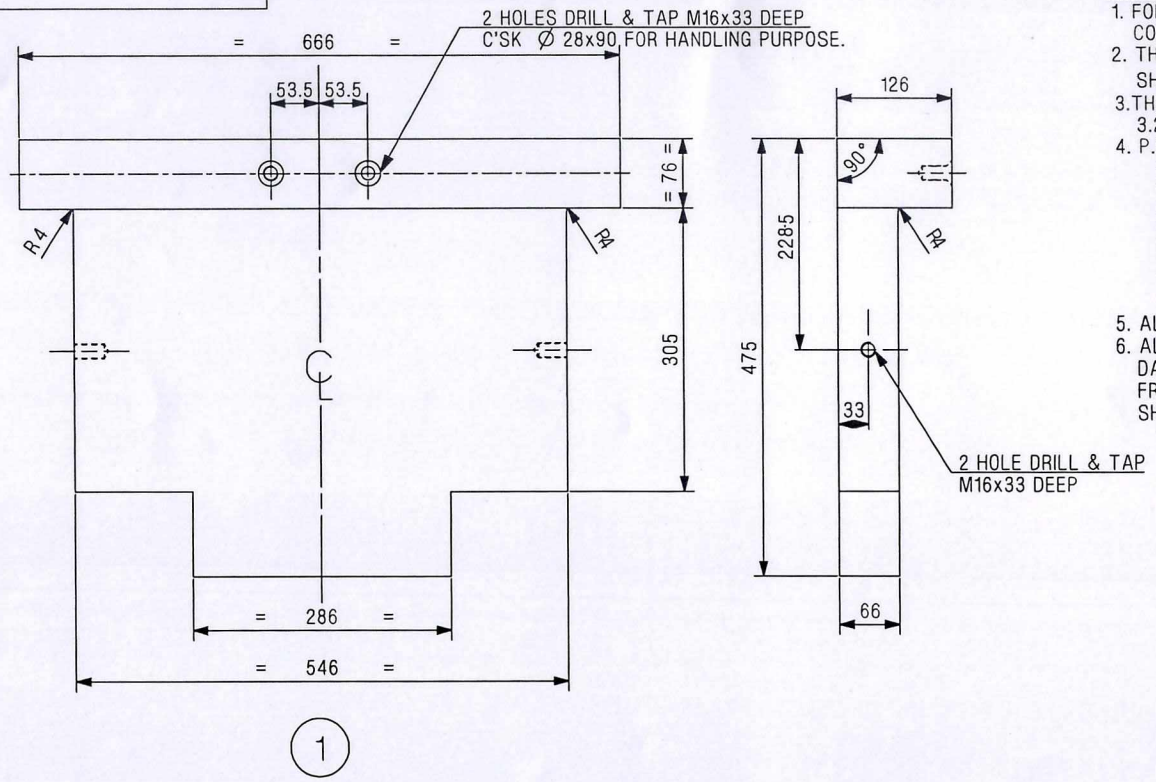

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TECHNICAL REQUIREMENTS :-

1. FORGINGS SHALL BE SUPPLIED INACCORDANCE WITH CONDITIONS LAID DOWN IN DRG. NO. 3 253 02 01400.
2. THE END PLATES ARE TO BE ROUGH MACHINED TO DIMENSION SHOWN MACHINING TOLERANCE $^{+2}_{-0}$.
3. THE SURFACE FINISH OF MACHINED SURFACE SHALL BE 3.2 MICRONS OR BETTER.
4. P.F. NOS TO BE STAMPED IN 6 MM SIZE AS BELOW
   - I. FOR FIRST SET USE P.F NO 306834 TO 306882
   - II. FOR SECOND SET USE P.F NO 306883 TO 306930
   - III. FOR THIRD SET USE P.F NO 306931 TO 306978
   - IV. FOR FOURTH SET USE P.F NO 306979 TO 307026
   - V. FOR FIFTH SET USE P.F NO 307027 TO 307074
   - VI. FOR SIXTH SET USE P.F NO 307075 TO 307122
   - VII. FOR SPARE SET USE P.F NO 307123 TO 307134
5. ALL SURFACES SHALL BE PARALLEL & SQUARE.
6. ALL FORGING SHALL BE TESTED ULTRASONICALLY IN ACCORDANCE WITH CORPORATE STANDARD AA 0850118 TO ENSURE FREEDOM FROM INTERNAL DEFECTS. THE NORMS OF ACCEPTANCE SHALL BE AS PER CATEGORY-2 OF THE ABOVE STANDARD.

VAR00	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	STD	DWG_NO	IT.NO	VAR	MATL. CODE	MATL. SPEC.	A/C	UNIT	UNIT WT.	QTY.(KG)	GS	ZONE
	-	-	001	POLE END PLATE FORGING	-	-	-	-	HG06004	-	-	-	149.69	-	-	-

ADDITIONAL INFORMATION
W.O. 32001 TO 06-X-231 53

STATUS OF DRAWING U

DISTRIBUTION OF PRINTS
HGE - 4 TEX - 3
PLM - 4

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT
HYDRO GENERATOR
HGS 818/200-24D 6x170 MW PUNATSANGCHHU-II

BHARAT HEAVY ELECTRICALS LTD. BHOPAL

	NAME	SIGN	DATE
DRN	BPN	SD	25/6/2013
CKD	AKV	SD	25/6/2013
APPD	KNS	SD	25/6/2013

NO. OF VAR. NA

REV.	DATE	ALTERED / CHECKED / APPD.	REV.	DATE	ALTERED / CHECKED / APPD.	REV.	DATE	ALTERED / CHECKED / APPD.

DEPT. HGE CODE 403 | UNTOL. DIMS. GR. | SCALE 1:1 | WEIGHT (K.G.) 149.69 | REF. TO ASSY. DRG. 12530239603 | ITEM NO. 01 | NO. OF ITEM 01

TITLE POLE END PLATE FORGING

DRAWING NO. 32530239601 | REV. 00

SHT. NO. 01 | NO. OF SHT. 01

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

A3 SIZE