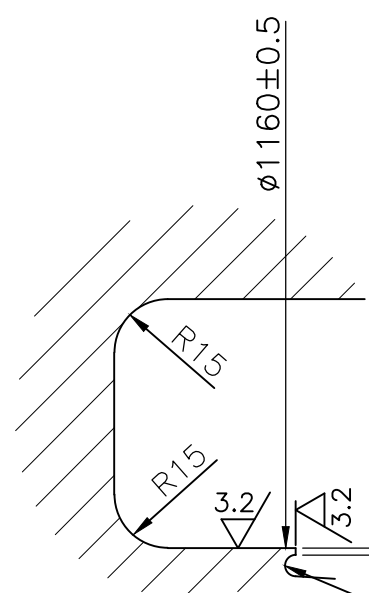
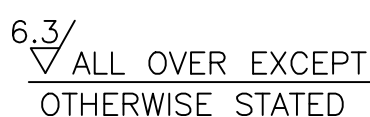




1. MATERIAL:- 1.5% MANGANESE STEEL FORGING (NORMALISED & TEMPERED) TO BHEL STANDARD AA193342 (Rev.08)
FORGING TO BE SUPPLIED IN HEAT TREATED AND ROUGH MACHINED CONDITION AS PER DRAWING DIMENSIONS.
2. SHAFT FORGING SHALL CONFORM TO OUR PURCHASE SPECIFICATION HT00242 (LATEST REV.) IN GENERAL,
UNLESS STATED OTHERWISE IN THE DRAWING.
3. FOR FINISH MACHINING AT BHEL WORKS, AN ALLOWANCE OF 6mm ON DIAMETERS AND 3mm ON FACES
IS INCLUDED IN THE DIMENSIONS SPECIFIED IN THE DRAWING EXCEPT THE BORE AND DIMENSIONS PERTAINING
TO SURFACE 'A' WHICH ARE TO BE FINISH MACHINED BY THE VENDOR AT HIS WORKS TO THE DIMENSIONS
AND SURFACE FINISH SHOWN IN THE DRAWING. ALSO REFER T.R.7.
4. TWO BELTS, CONCENTRIC TO THE BORE, TO BE MACHINED TO SURFACE FINISH $\nabla^{1.6/}$ AT THE
LOCATIONS SHOWN IN THE DRAWING. CONCENTRICITY & CIRCULARITY TO BE WITHIN 0.03 mm.
5. FORGING TO BE SUPPLIED WITHIN A TOLERANCE OF $^{+3}_0$ mm ON DIAMETER. HOWEVER TOLERANCES
ON LENGTH SHALL BE AS PER DRG.
6. CONCENTRICITY & CIRCULARITY OF BORE $\phi 250$ IN ZONE 'M' TO BE WITHIN 0.03 MM.
7. DIMENSIONS PERTAINING TO SURFACE-A & BORE $\phi 250$ TO BE FINISH MACHINED AT VENDOR'S WORKS AND
NO FURTHER MACHINING SHALL BE DONE AT BHEL WORKS.
8. ANTI CORROSIVE TREATMENT TO BE CARRIED OUT ON FINISH MACHINED PORTION MARKED AS 'SURFACE-A', $\phi 1020$ & COMPLETE
BORE $\phi 250$, FOR DETAIL OF ANTICORROSIVE COMPOUND REFER CLAUSE NO.10 OF OUR PURCHASE SPECN. HT00242 (LATEST REV.).
9. TEST PIECE TO BE PROVIDED AT BOTH ENDS OF THE FORGING. RADIAL & TANGENTIAL TEST PIECES SHALL BE REMOVED
FROM BOTH ENDS OF FORGING AT SUPPLIER'S WORK IN ACCORDANCE WITH THE PURCHASE SPECIFICATION HT00242 (LATEST REV.)
IN PRESENCE OF INSPECTION AGENCY AND CUSTOMER. AUTHENTICATION OF TEST SAMPLES SHALL BE DONE BY INSPECTION
AGENCY BY PUTTING HARD PUNCHES BOTH ON TEST SAMPLE AND PARENT METAL.

NOTE- BEFORE START OF MANUFACTURING VENDOR TO GET THE LATEST REVISION NO. OF DRAWING, PRODUCT STANDARD AND PURCHASE SPECIFICATION CONFIRMED FROM HYDRO TURBINE ENGINEERING, BHEL, BHOPAL.

IN CASE OF SLIGHTEST DOUBT CONSULT HYDRO TURBINE ENGINEERING, BHEL, BHOPAL

										O1										SHAFT FORGING																														SEE T.R.1										39160																																		
59		64		65		75		78		79		25		27		58		59		60		77		29		31		34		MATL. CODE		45		56		57		58		UNIT WT.		65																																																				
VAR.OO										REMARKS										DESCRIPTION										STD.										DRAWING NO.										VAR.										32		33		46		MATL. SPGN.		54		UNIT		68		QTY.		71																		
ADDITIONAL INFORMATION															PROJECT										ARUN-3 HYDRO ELECTRIC PROJECT, NEPAL (4x 225 MW)																																																																					
STATUS OF DRAWING															U										COSTUMER										 SJVN LIMITED (A JOINT VENTURE OF GOVT. OF INDIA & GOVT. OF HP)																																																											
DISTRIBUTION OF PRINTS															CONSULTANT										SJVN ARUN-3 POWER DEVELOPMENT COMPANY PVT. LTD. (SAPDC LTD.)																																																																					
<table border="1"> <thead> <tr> <th>NAME</th> <th>SIGN</th> <th>DATE</th> <th>NO. OF VAR.</th> </tr> </thead> <tbody> <tr> <td>DRWN RAMESH</td> <td></td> <td>31.12.18</td> <td></td> </tr> <tr> <td>CHKD ND</td> <td></td> <td>31.12.18</td> <td></td> </tr> <tr> <td>APPD SK</td> <td></td> <td>31.12.18</td> <td></td> </tr> </tbody> </table>															NAME	SIGN	DATE	NO. OF VAR.	DRWN RAMESH		31.12.18		CHKD ND		31.12.18		APPD SK		31.12.18		CONTRACTOR										 भारत हेवी इलेक्ट्रिकल्स लिमिटेड, भोपाल Bharat Heavy Electricals Limited, Bhopal																																																					
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SUB-SUPPLIER / VENDOR															DEPT HTE CODE 402										UNTO. DIMS. GR.										ANGLE 										SCALE 1:10										WEIGHT(kg) 39160										REF.TO ASSY.DRG.										ITEM NO 01										NO OF ITEMS 01									
TITLE															SHAFT (FORGING)																																			DRAWING NO.										REV.																																		
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