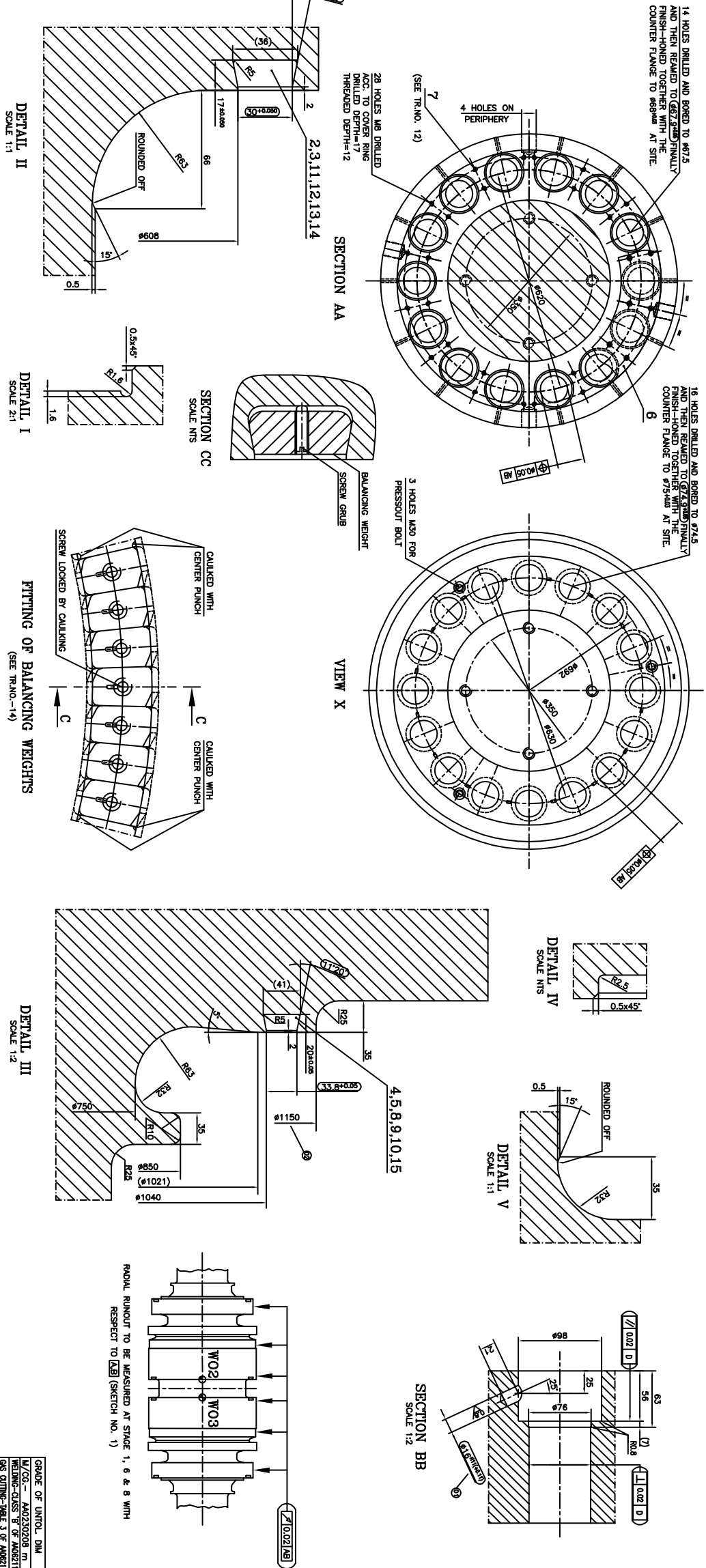


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### TECHNICAL REQUIREMENTS :-

1. IT SHOULD BE ISSUED DURING WELDING THAT THE CORROSION STATE OF AXES ON THERE AND MATCHES WITH THE CORROSION STATE OF AXES ON THE GENERATOR END.
  2. GROOVES FOR BALANCING WEIGHTS AS PER DETAIL -1 ARE NOT TO BE USED DURING BALANCING OF ROTOR IN THE PLANT. THESE ARE TO BE USED ONLY FOR ADDITIONAL BALANCING OF ROTOR, IF REQUIRED, AT SITE.
  3. THE EXACT QUANTITY OF ITEM NO. 004 & 005 TO BE USED IS DETERMINED DURING BALANCING OF ROTOR IN THE PLANT.
  4. 40 FEET COIL OF THE ITEM NO. 002 & 003 ARE TO BE SUPPLIED LOOSE TO SITE FOR ADDITIONAL BALANCING OF ROTOR, IF REQUIRED, AT SITE.
  5. FOR FORGING DRAWING OF THE SHAFT REEFER DRG. NO. 1-103201-46999.
  6. WEIGHT OF BLADED ROTOR = 56277 Kg.
  7. DIMENSIONS WITHIN ( ) ARE FOR REFERENCE ONLY.
  8. HOLES FOR COUPLING BOLTS (SECTION-A & NEW-A) ARE TO BE DRILLED AND REAMED WITH THE HELP OF JOE AND THE SAME JOE MUST BE USED FOR DRILLING AND REAMING OF COUPLING HOLES ON THE FLANGE OF THE MAIN ROTOR AS WELL.
  9. THE WELD DRAWING IS TO BE TAKEN FROM THE END OF THE PROJECT AGAINST CONCERNED PPMN 10304, AS PER Q.A. DOCUMENT NO. 0-10301-46900 FS.
  10. (a) RUNDOUT VALUES OF LP ROTOR, BEFORE AND AFTER BALANCING & OVERSPEEDING TEST MUST BE RECORDED AS PER Q.A. DOCUMENT NO. 0-10301-46900 FS.
  11. (b) BALANCING AND OVERSPEEDING TO BE DONE AS PER PRODUCT STANDARD NO STV7004.
  12. IF THE ROTOR FLOWING IS HAVING THE AXIAL THERMAL CORE HOLE, IT SHALL BE PLACED AS PER DRAWING MENTIONED AGAINST PPMN 10304.
  13. THE SPACERS (ITEM NO. 007) (SECTION-A) SHOULD BE CALKED AT TWO DIAGONALLY OPPOSITE LOCATION BY CENTRE PUNCH, AFTER ASSEMBLY OF OTHER ITEM NO. 008 (SECTION-A) AT SITE.
  14. THESE POINTS ARE Rotor SLIDING POINTS, SEE ROBERTY (VENTER STREET) 1000(2004-0716) ALONGSIDE THE SLAMS DURING LIFTING OF ROTOR TO AVOID ANY DAMAGE OF MACHINED SURFACES.
  15. THE END BALANCING MEANS OF ANY SECTION ON EITHER SIDE SHOULD BE STUTLE -46 (ITEM NO. 014 & 015), IDENTIFICATION ACCORDING TO HORIZONTAL AT THE PLACE MARKED WITH IN.
  16. PLACES MARKED WITH SHAG ( ) ARE THE SURFACES FOR CHECKING ROTOR, RUNDOUT.
  17. DIMENSIONS WITHIN      AND ALL GEOMETRICAL TOLERANCES ARE CRITICAL TO QUALITY (CRQ).
  18. CONSERVATION OF PPMN AS PER STV3004.
- CAUTION :-**

### DATA FOR OVERSPEED TEST :-

- OVERSPEED FREQUENCY = 7550 RPM (62.5 Hz).
  - DURATION OF OVERSPEED = 2 MINUTES.
  - CRITICAL SPEED OF THE ROTOR = 1433 RPM (23.889 Hz).
  - OPERATIONAL SPEED = 3000 RPM (50 Hz).
  - EXCITING ENERGY OF THE ROTOR IS MORE THAN 7500 TONNE-METRE.
- 0 DIRECTION OF ROTATION OF ROTOR WHEN SEEN IN DIRECTION OF THE GENERATOR : ANTICLOCKWISE.
- 9 CAUTION :-

**THE ASSEMBLY OF ROTOR SHOULD BE COMPLETE IN ALL RESPECT BEFORE BALANCING AND OVERSPEEDING TEST.**

[illegible]