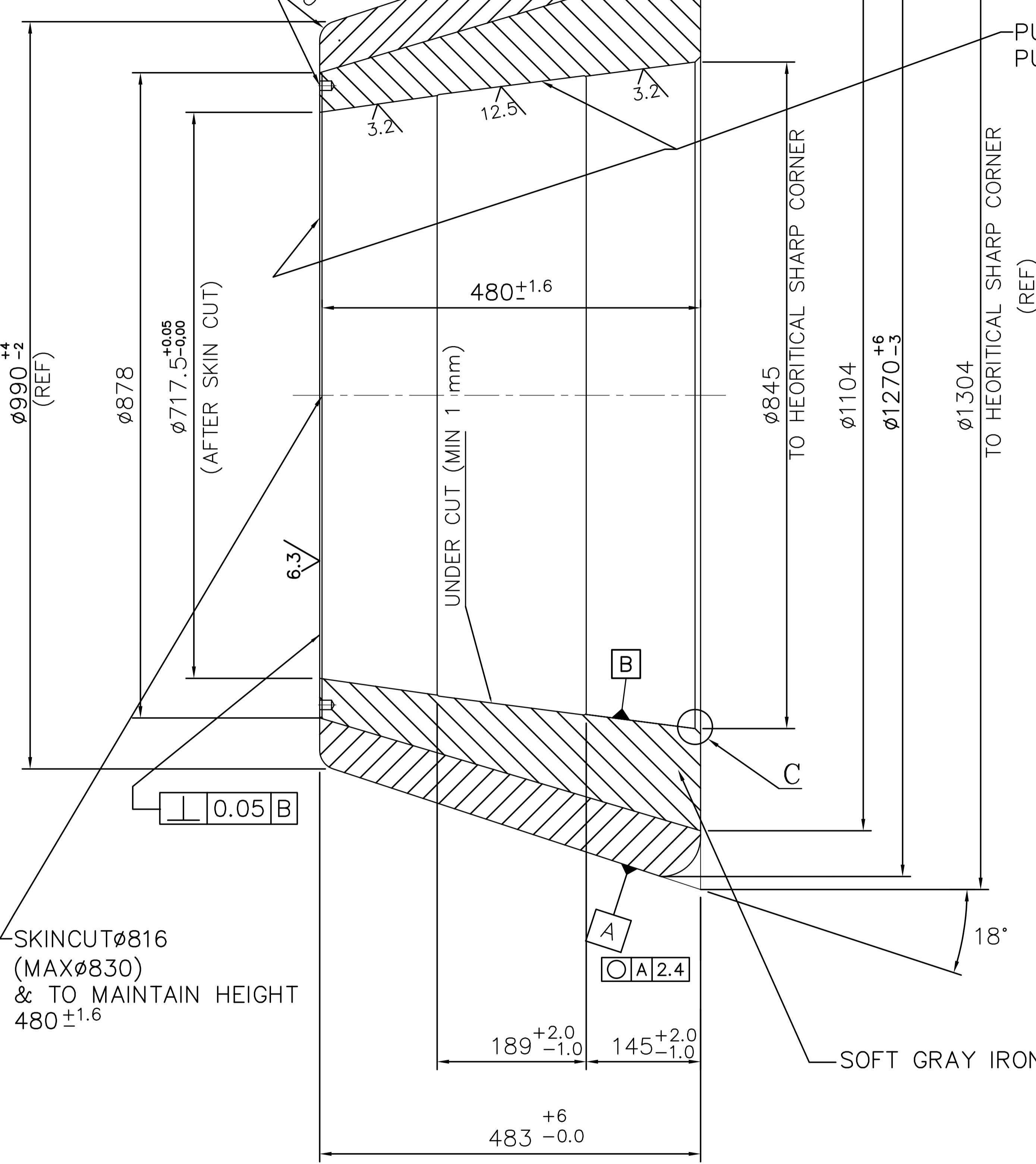


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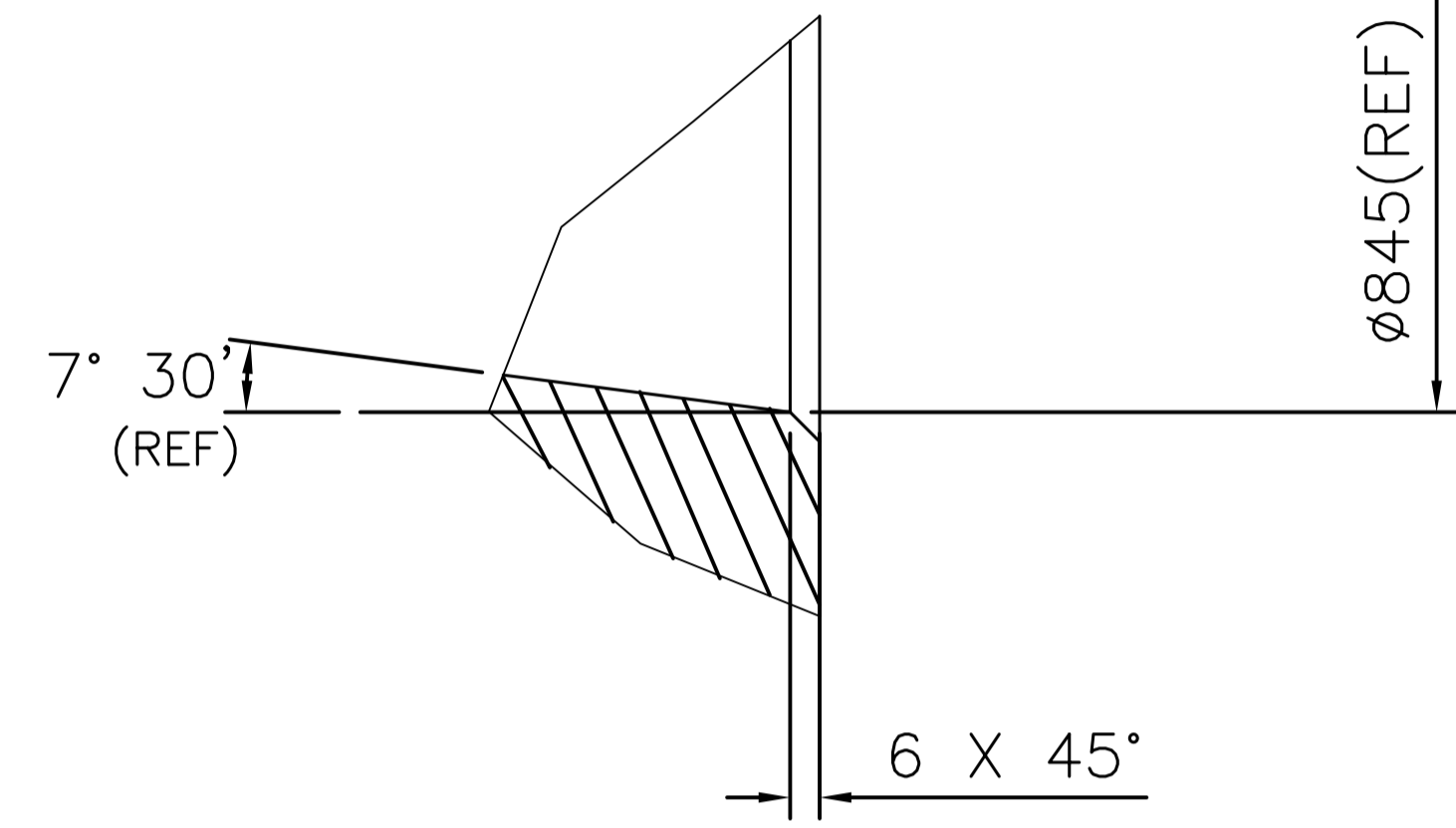
INVENTORY NO. 16190057.DWG
SIGN. AND DATE REF. DRG. NO. 16190057

DRG. NO. 1-61-000-90057

2 HOLES-M24X30 DEEP
2 PLACES-180°APRT
AT PCD 785 FOR
LIFTING



PUNCH ROLL WITH 10 mm
PUNCH AT 2 PLACES.



DETAIL-C

NOTES:

1. TOLERANCE FOR UNTOLERENCED DIM FOR CASTING AA0230402 - CLASS3
2. FOR MACHINED DIMENSION AA 0230208 MEDIUM CLASS
3. TAPER MUST BE CHECKED WITH PLATE GUAGE WITH MINIMUM 80% OF ITS CONTACT AREA. CHECKED AT 3 PLACES 120°APART.
4. FOR NIHARD, MINIMUM HARDNESS IS 550 BHN
5. MANUFACTURE AS PER CUSTOMERS / BHEL APPROVED QP.
6. COAT THE MACHINED BORE SURFACE WITH BLUE LACQUER AND REMOVE THE BLUE LACQUER BEFORE ASSY.

ITEM NO.	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG. NO. OR FORGING DRG. NO.	MATERIAL SPECN.	NET WT.	GROSS WT.	QUANTITY
	INSERTS TYPE	PATTERN M-67-497	02		BA9116811011	1880.00	2180.00	1
	CASTING - NIHARD	PATTERN M-67-425	01		BA9116850084 HY19768	1880.00	2180.00	1

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED.

1. REF. TO HY0230261 FOR UNSPECIFIED TOLERANCES.
2. CHAMFER M/CD. SHARP EDGES 1.2 TO 1.0 AT 45°.
3. INTERNAL M/CD. CORNER RADII 1 TO 0.7
4. THE SURFACE ROUGHNESS WHERE-EVER NOT SHOWN SHALL BE TAKEN FROM THE SURFACE ROUGHNESS SHOWN OUT SIDE THE BACK SLASH GIVEN OR THE TOP MOST RIGHT CORNER OF THE DRG.

TYPE OF PRODUCT		XRP 1003			
NAME OF CUSTOMER/PROJECT		BHARAT HEAVY ELECTRICALS LIMITED HYDERABAD			
DRN.	NAME	SIGN.	DATE	NO.OF VAR.	
CHD.	E.M.A.K.		15-07-02		
APPD.	S.GHATGE		15-07-02		
APPD.	RAMANNA		15-07-02		
DEPT. 446	UNTOL. DIMS. C/M/F	SCALE 1:2	WEIGHT (KG) 1880.00	REF. TO ASSY DRG.	ITEM NO. ---
CODE PULV.					NO.OF ITEMS ---
TITLE		GRINDING ROLL 50"		DRAWING NO. 1-61-000-90057	
SHEET NO.		NO OF SHEETS		REV. 04	

REV.	DATE	ALTERED CHD./APPD.	REV.	DATE	ALTERED CHD./APPD.	REV.	DATE	ALTERED CHD./APPD.	E.M.ASHOK
04	15-07-02								
DRG. REDRAWN									