



SUPPLIERS NAME & ROLL NO. TO BE CLEARLY STAMPED ON THIS FACE (5mm DEEP). THE IDENTIFICATION SHOULD BE 3mm DEEP IMPRESSION OR 3mm LETTERS WELL WITHIN THE DEPRESSION

0.26330 : 1

COAT ON THIS SURFACE WITH BLUE LACQUER AFTER MACHINING REMOVE BLUE LACQUER BEFORE ASSY.

- 12 TAPPED HOLES M36, 80MM DEEP, MAX CHAMFER 6x45° USE DRILL JIG (100% INSPECTION)
- BOLT SIZE M36x110L, P8.8, (IS 1364)

SECTION AA

NOTES:

- TOLERANCE FOR UNTOLERENCED DIM FOR CASTING AA0230402 - CLASS3
- FOR MACHINED DIMENSION AA 0230208 MEDIUM CLASS
- TAPER MUST BE CHECKED WITH PLATE GAUGE WITH MINIMUM 80% OF ITS CONTACT AREA. CHECKED AT 3 PLACES 120° APART.
- FOR NIHARD, MINIMUM HARDNESS IS 550 BHN
- MANUFACTURE AS PER CUSTOMERS / BHEL APPROVED QP.

ITEM NO.	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG. NO. OR FORGING DRG. NO.	MATERIAL CODE	NET WT.	GROSS WT.
	62" GRINDING ROLL				BA35008	2390.000	

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED...

- REF. TO HY0230261 FOR UN TOLERANCES.
- CHAMFER M/CD SHARP ED 1.2 TO 1.0 AT 45°.
- INTERNAL M/CD CORNER RADI 1 TO 0.7.
- THE SURFACE ROUGHNESS WHEREVER NOT SHOWN SHALL BE TAKEN FROM THE SURFACE ROUGHNESS SHOWN OUT SIDE BACK SLASHES GIVEN AT THE TOP MOST RIGHT CORNER OF THE DRG.

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT: **CHANDRAPUR-500MW**

BHEL BHARAT HEAVY ELECTRICALS LTD. HYDERABAD

DRN.	E.M.ASHOK	SIGN.	DATE	NO. OF VAR.
CHD.	S.G		19.08.02	NA
APPD.	J.G.K		22.08.02	

DEPT. BMD SCALE 1:5 WEIGHT (KG) 2390.000 REF. TO ASSY DRG. ITEM NO. NA NO. OF ITEMS NA

TITLE: **GRINDING ROLL-62" (WITH INSERTS)** DRAWING NO. **1-61-004-01317\_01** REV. NO. OF SHEETS 01

INVENTORY NO. SIGN. AND DATE REF. DRG. NO. COMPUTER FILE NAME: 16101317.DWG