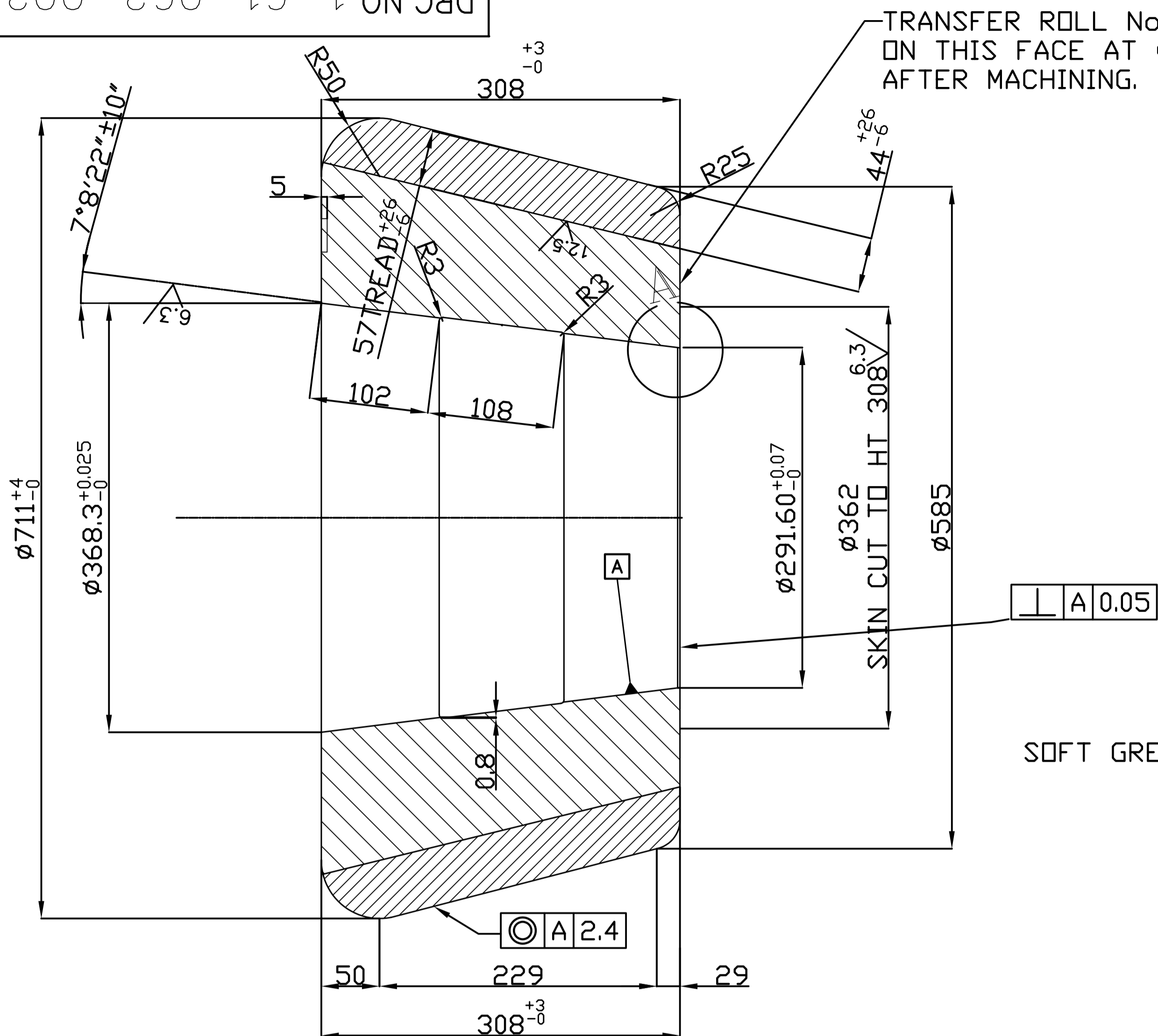
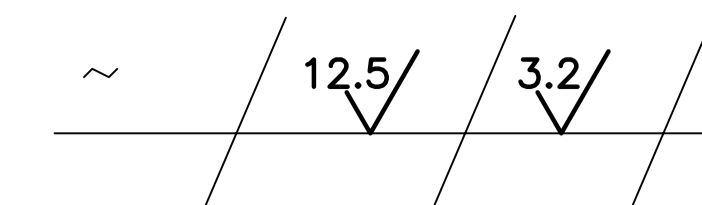


DRG.NO. 1-61-062-00253

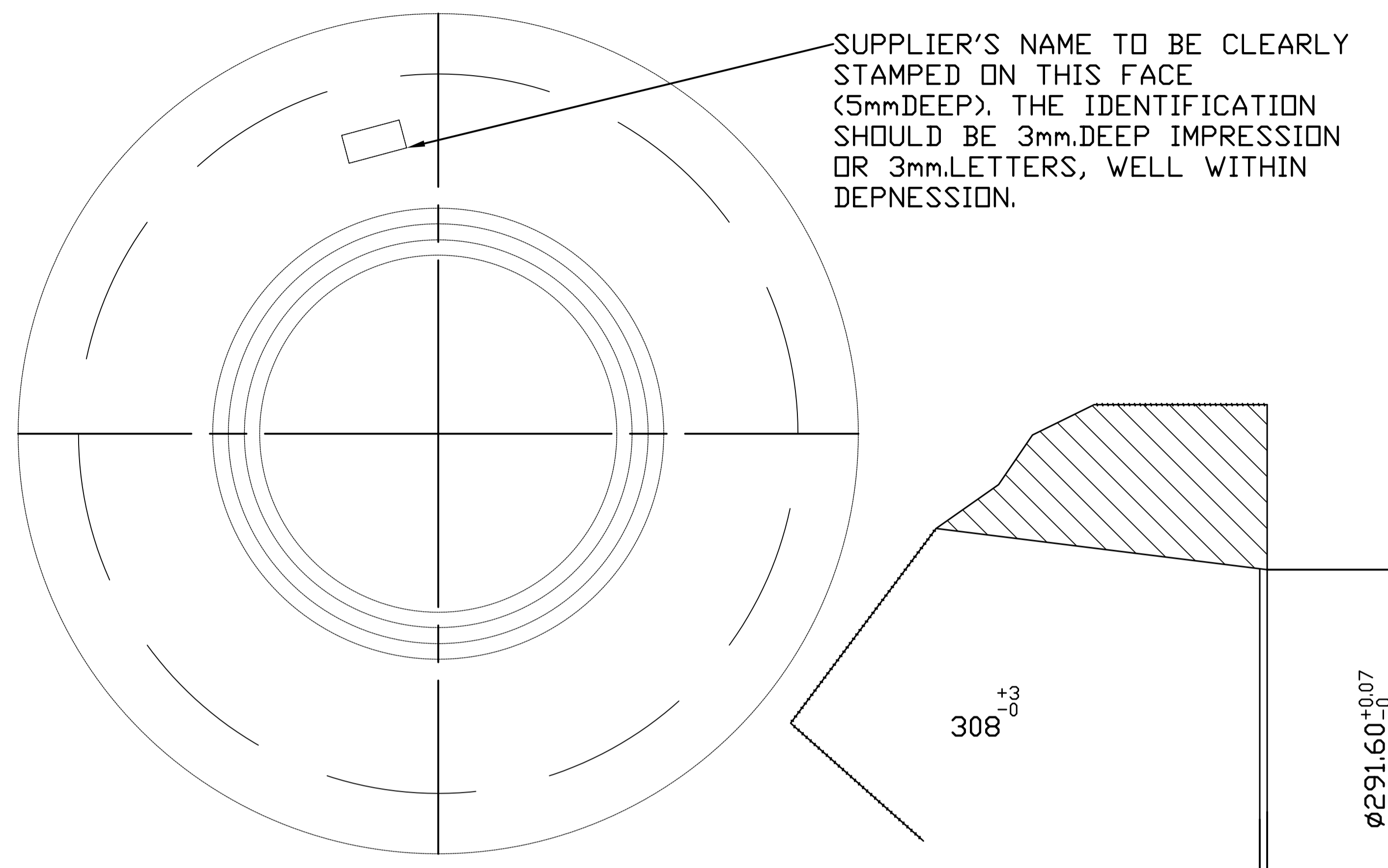
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TRANSFER ROLL No/SUPPLIER'S IDENTIFICATION ON THIS FACE AT  $\phi 350$  WITH 8mm PUNCH LETTERS AFTER MACHINING.



SUPPLIER'S NAME TO BE CLEARLY STAMPED ON THIS FACE (5mm DEEP). THE IDENTIFICATION SHOULD BE 3mm DEEP IMPRESSION OR 3mm LETTERS, WELL WITHIN DEPRESSION.



SOFT GREY IRON

MATERIAL ATTESTED

DETAIL-A

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.
- COAT THE MACHINED BORE SURFACE WITH BLUE LACQUER AND REMOVE THE BLUE LACQUER BEFORE ASSY.

01	CASTING			PATTERN M-67-324	BA9116850050	598.00	
					HY19768		1
ITEM NO.	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	MATERIAL CODE	NET WT.	GROSS WT.
					MATERIAL SPECN.	QUANTITY	

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED...

- REF. TO HY0230261 FOR UNSPECIFIED TOLERANCES.
- CHAMFER M/CD SHARP EDGES 1.2 TO 1.0 AT 45°.
- INTERNAL M/CD CORNER RADII 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 **62" BOWL MILL**

		NAME: E.M.ASHOK SIGN.: DATE: 19-07-02 NO. OF VAR.:	
BHARAT HEAVY ELECTRICALS LTD. HYDERABAD		CHD. N.D.S. DATE: 19-07-02	
APPD. RAMANNA DATE: 22-07-02		REF. TO ASSY DRG.	
DEPT. PULVE.ENGG	SCALE 1:6	WEIGHT (KG) 98.00	ITEM NO. 5
CODE 446			NO. OF ITEMS
TITLE GRINDING ROLL-28"		DRAWING NO. 1-61-062-00253	REV. 03
SHEET NO. 01		NO OF SHEETS 01	

REV.	DATE	ALTERED	REV.	DATE	ALTERED
		E.M.ASHOK	03	26.05.03	CHD. N.D.S. APPD. RAMANNA
ZONE	DRG. REDRAWN.				