

DRG. NO. 1-61-120-01565

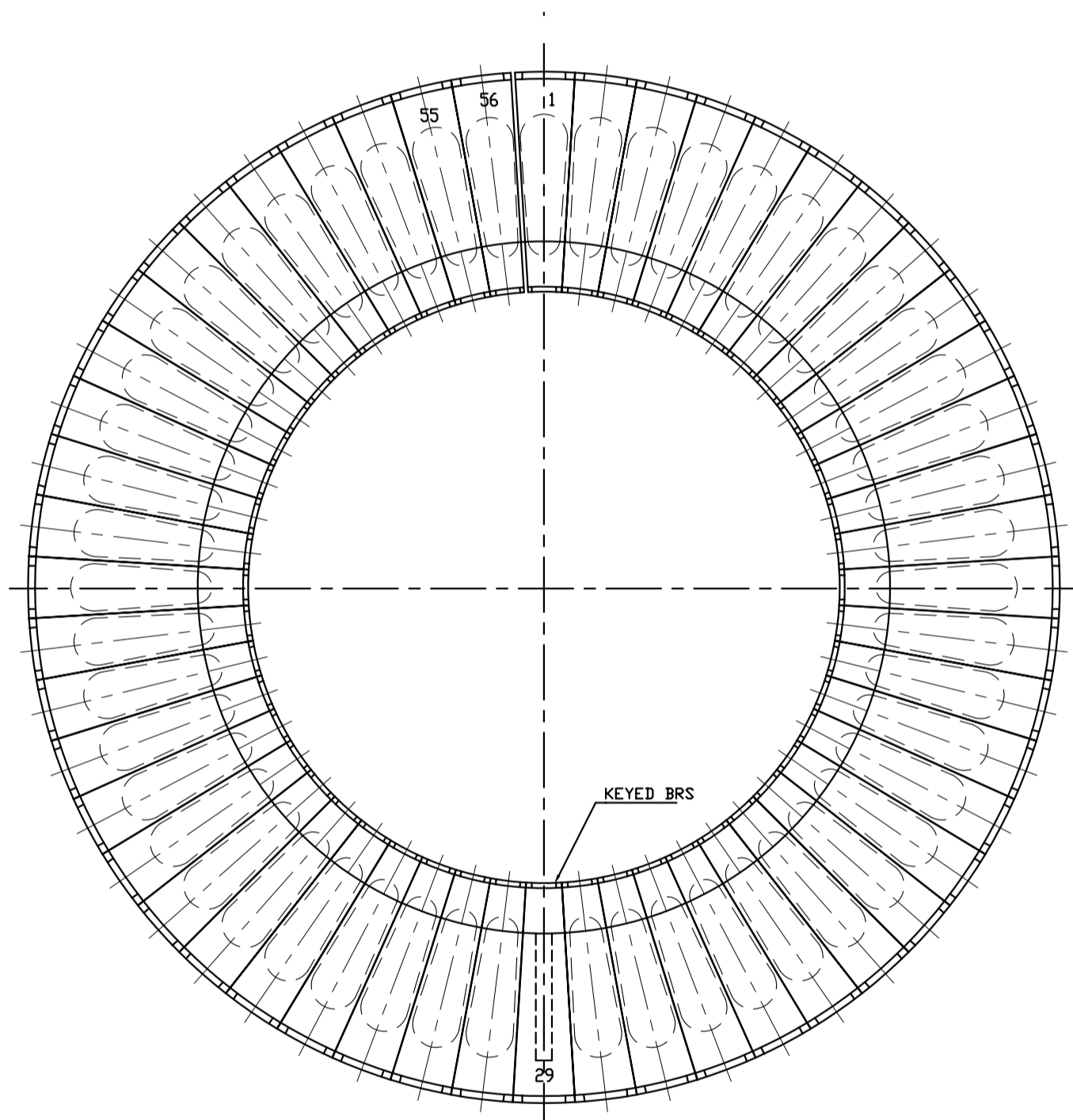
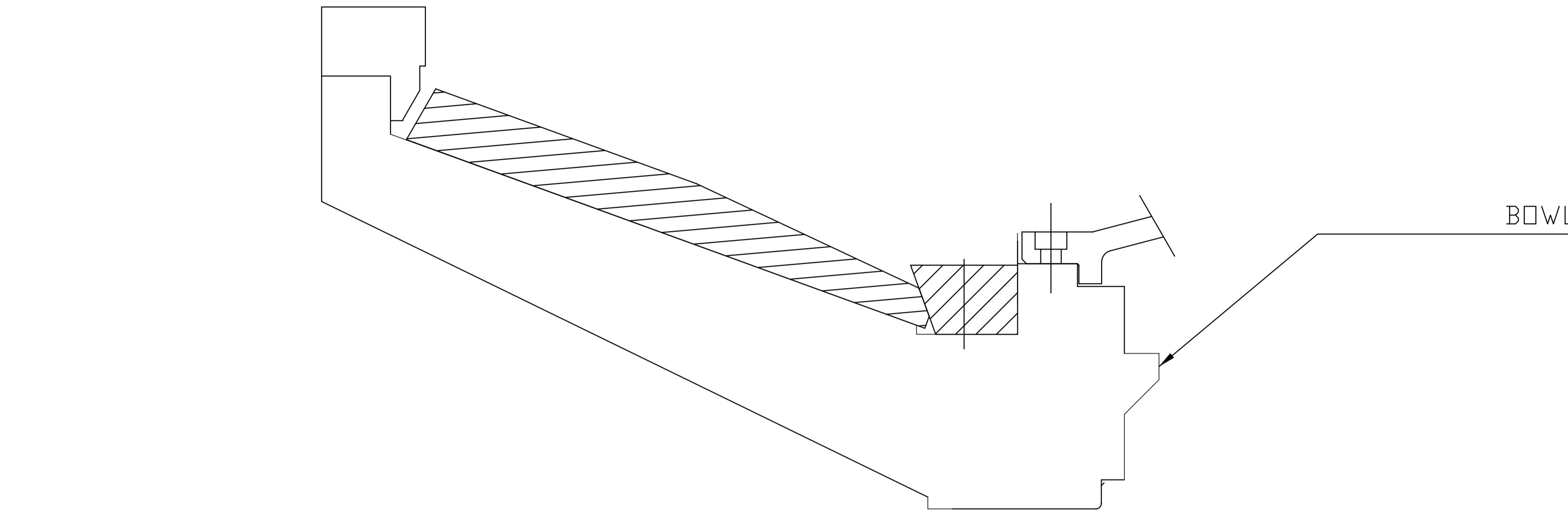
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COMPUTER FILE NAME

REF. DRG. NO.

SIGN. AND DATE

INVENTORY NO



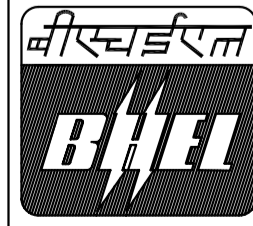
NOTES:-

01. TOTAL NUMBER OF BULL RING SEGMENTS SHALL BE 56 Nos. (55 Nos. PLAIN & 1 No. KEYED BRS).
02. IN THE ASSEMBLED CONDITION OF BRS THE GAP BETWEEN SIDE FACES SHOULD BE LESS THAN 1.6 MM. THE GAP IS TO BE CONTROLLED TO LESS THAN 0.8 MM. OVER A LENGTH OF 75 MM. AT BOTH INNER AND OUTER DIAMETERS OF ASSEMBLY.
03. ALL THE SEGMENTS SHOULD BE ASSEMBLED AND MATCHED AS A SET IN CHECK BOWL & NUMBERED SERIALLY
04. REQUIRED QTY. OF QUATER AND HALF SEGMENTS CAN BE USED.
05. M.S SHIMS OF THICKNESS 3.2 MM, 12 MM, 16MM & 18 MM WILL BE SUPPLIED WITH EACH SET.
06. THE BULL RING SEGMENTS SHOULD BE IN LEVEL WITH EACH OTHER WITHIN 3 MM.
07. AFTER ASSEMBLY OF 52 SEGMENTS, FINAL GAP SHOULD NOT BE MORE THAN 20 MM.
08. B R SEGMENT PLAIN 2-61-120-02906 (55 NOS).
09. B R SEGMENT KEYED 2-61-120-02907(1 ND).

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.

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				NAME OF CUSTOMER/PROJECT				
 BHARAT HEAVY ELECTRICALS LIMITED HYDERABAD				DRN.	NAME	SIGN.	DATE	NO.OF VAR.
				CHD.	A.SURIN		26.6.09	
				APPD.	S.GHATGE		26.6.09	
DEPT. PULV. ENGG. CODE 446	UNTO. DIMS. Ø/M/Y	SCALE NTS	WEIGHT (KG)	REF. TO ASSY DRG.		ITEM NO.	NO.OF ITEMS	
TITLE BULL RING SEGMENT ASSEMBLY- HP1203				DRAWING NO. 1-61-120-01565		REV. 00		
SHEET NO. 01			NO OF SHEETS 01					

REV.	DATE	ALTERED CHD.	APPD.	REV.	DATE	ALTERED CHD.	APPD.	REV.	DATE	ALTERED CHD.	APPD.
ZONE				ZONE				ZONE			