

DRG. NO. 1-61-120-01565

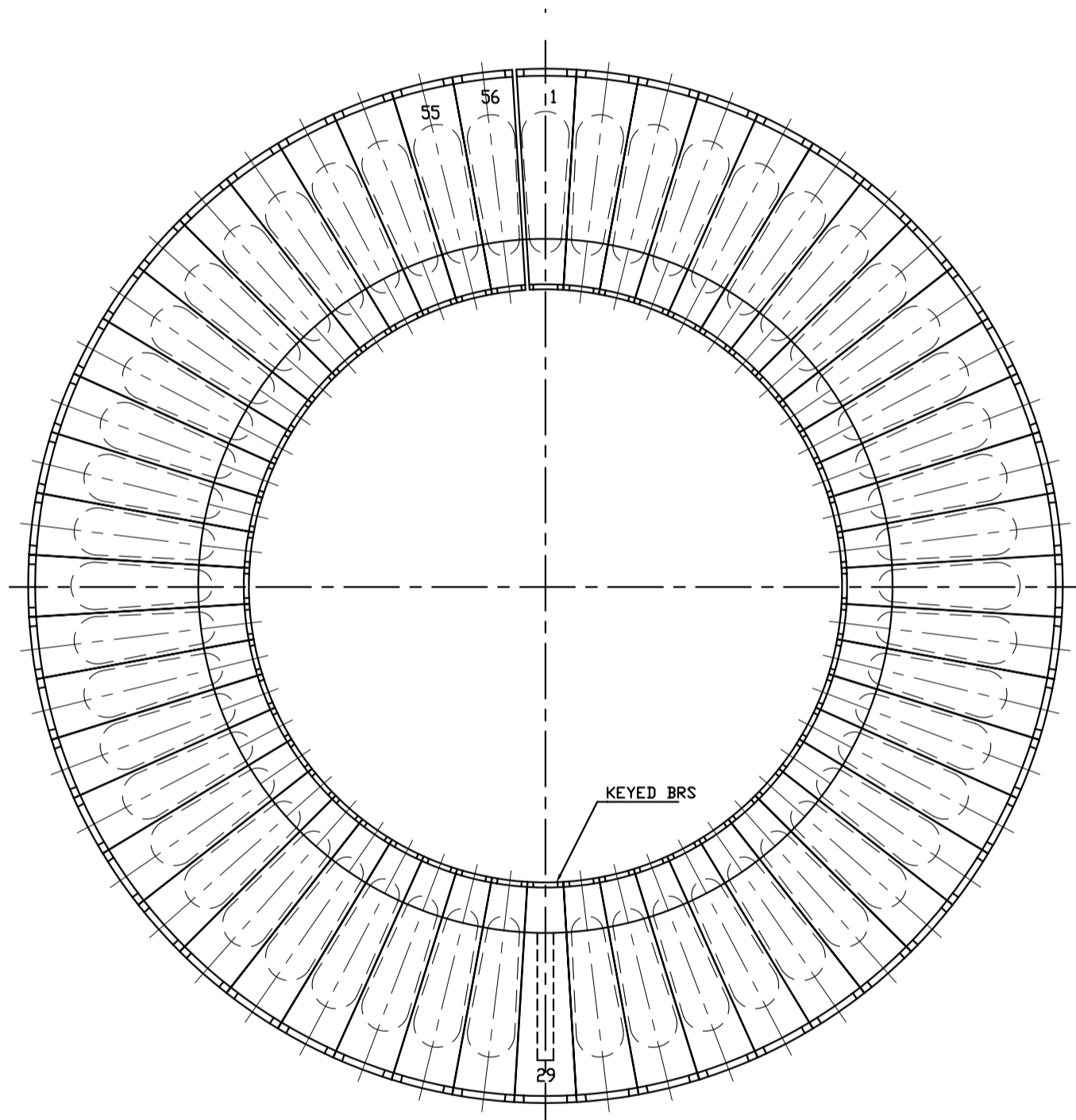
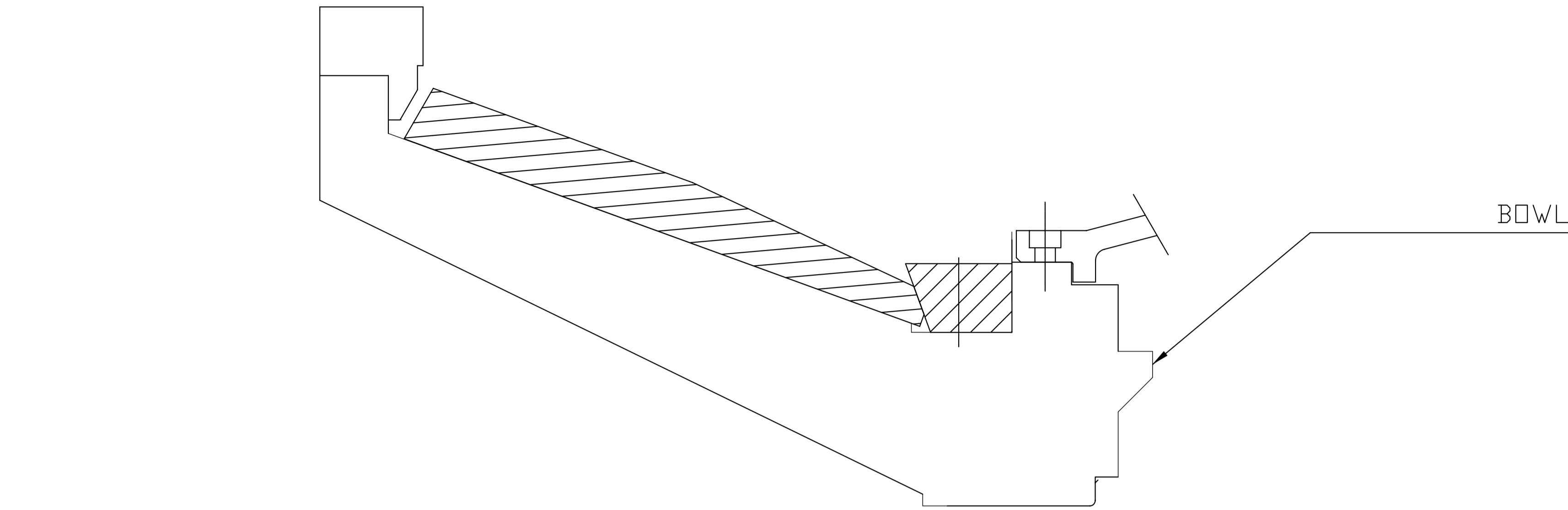
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COMPUTER FILE NAME

REF. DRG. NO.

SIGN. AND DATE

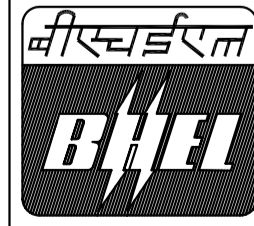
INVENTORY NO



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.				TYPE OF PRODUCT			
1. REF. TO HY0230261 FOR UNSPECIFIED TOLERANCES.				NAME OF CUSTOMER/PROJECT			
2. CHAMFER M/CD. SHARP EDGES 1.2 TO 1.0 AT 45°.				 BHARAT HEAVY ELECTRICALS LIMITED HYDERABAD			
3. INTERNAL M/CD. CORNER RADII 1 TO 0.7				DRN.	R.RANJAN	SIGN.	DATE
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.				CHD.	A.SURIN		26.6.09
				APPD.	S.GHATGE		26.6.09
DEPT.	UNTO. DIMS.	SCALE	WEIGHT (KG)	REF. TO ASSY DRG.		ITEM NO.	NO.OF ITEMS
PULLV ENGG. CODE 446	Ø/M/Ø	NTS					
TITLE				DRAWING NO.		REV.	
BULL RING SEGMENT ASSEMBLY- HP1203				1-61-120-01565		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			