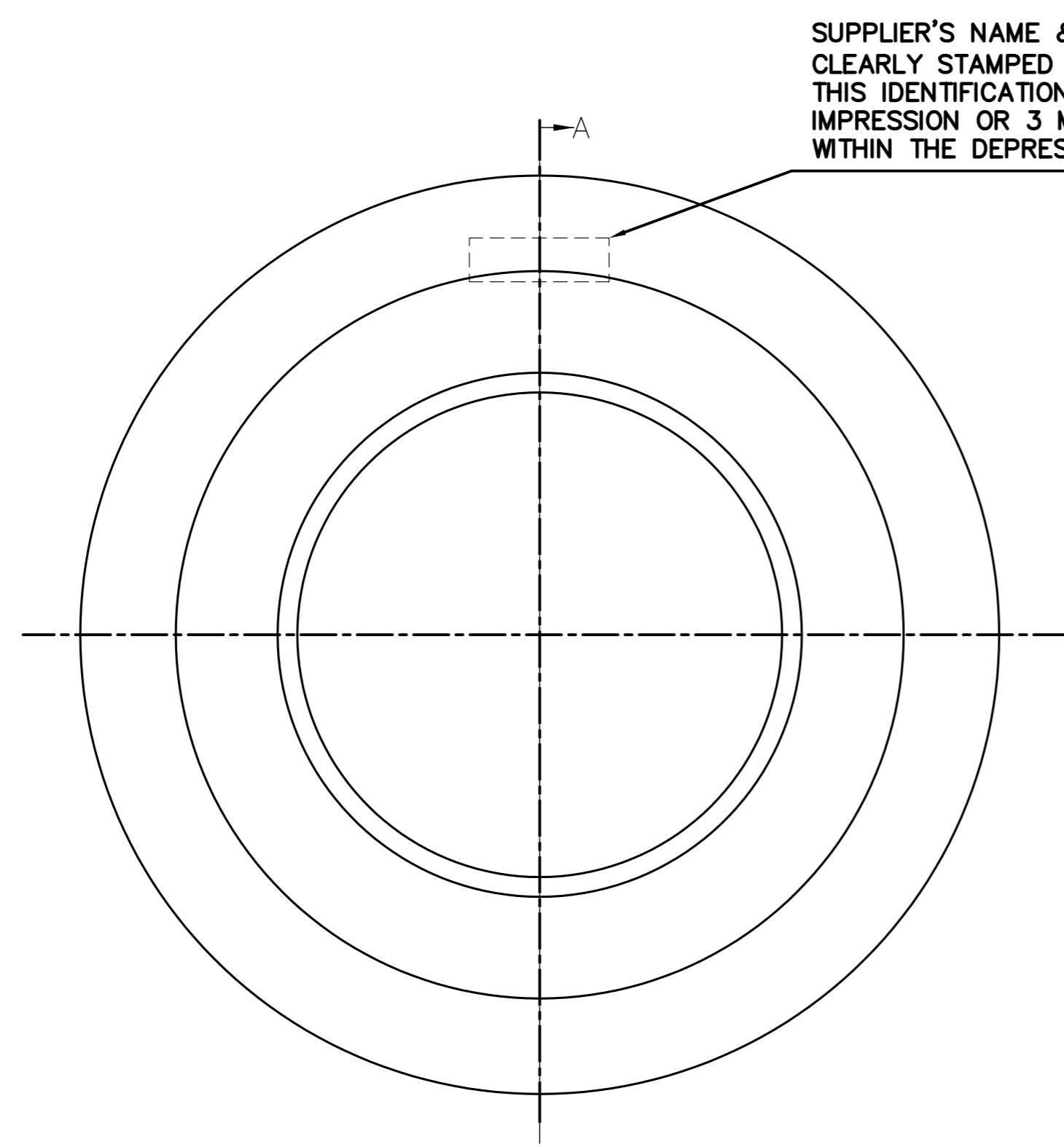


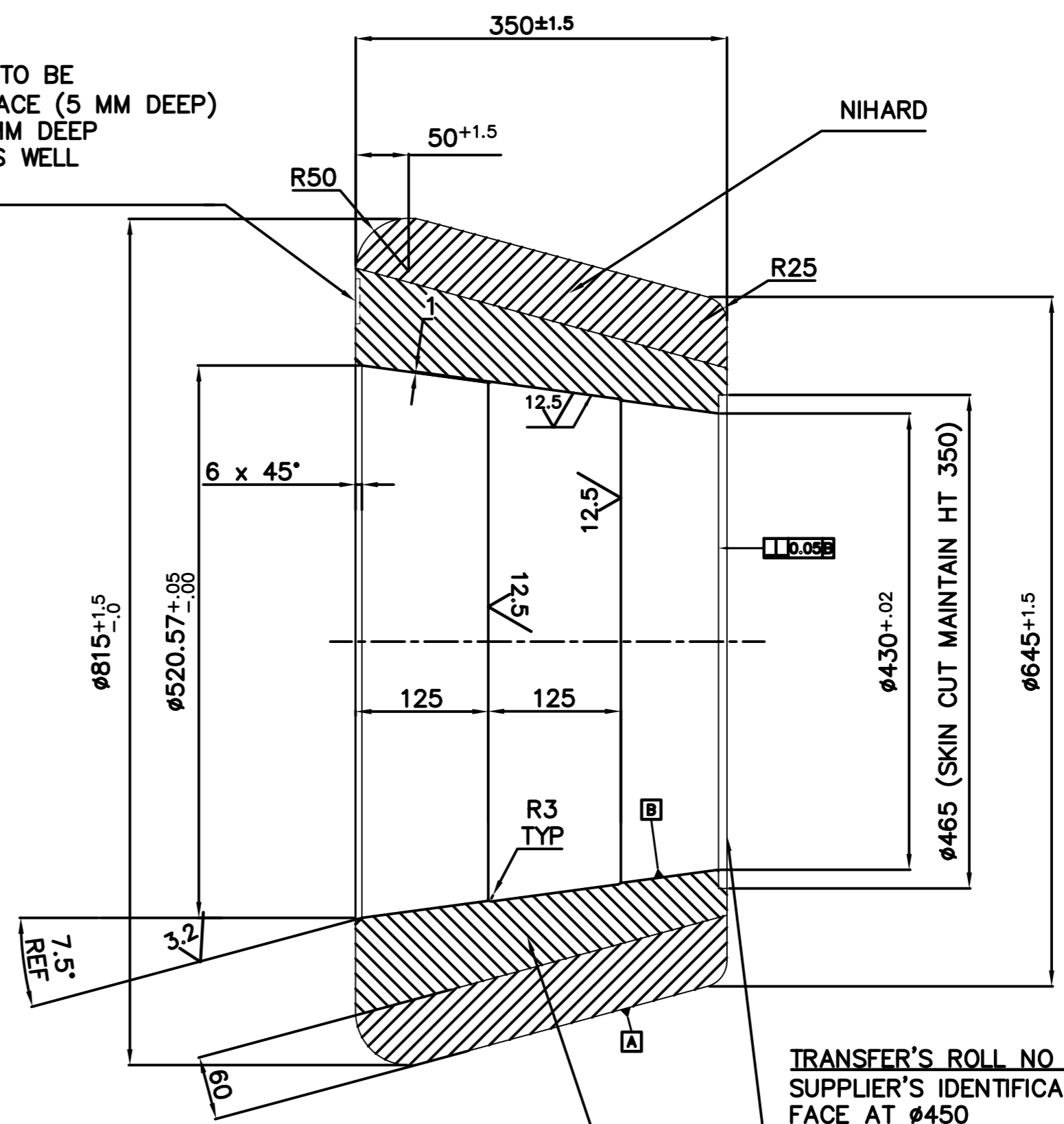
DRG. NO. 2-61-070-02451

~ / 3.2 / 12.5 /

INVENTORY NO. SIGN. AND DATE REF. DRG. NO. 26102451



SUPPLIER'S NAME & ROLL No. TO BE CLEARLY STAMPED ON THIS FACE (5 MM DEEP) THIS IDENTIFICATION TO BE 3MM DEEP IMPRESSION OR 3 MM LETTERS WELL WITHIN THE DEPRESSION.



TRANSFER'S ROLL NO & SUPPLIER'S IDENTIFICATION ON THIS FACE AT 0450 WITH 8 MM PUNCH LETTERS AFTER MACHINING.

SECTION A-A SOFT GREY IRON

- 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

		PATTERN M-67-469			BA9116850114	660.00
					HY19768	
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 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: **703 XRP BOWL MILL**

NAME OF CUSTOMER/PROJECT: **BHARAT HEAVY ELECTRICALS LIMITED HYDERABAD**

DRN.	E.M.ASHOK	NAME	SIGN.	DATE	NO.OF VAR.
CHD.	N.S.D			3-08-02	
APPD.	RAMANNA				

DEPT. 446 UNTO. DIMS. GR. 0/M/F SCALE 1:5 WEIGHT (KG) 660.00 REF. TO ASSY DRG. ITEM NO. NO.OF ITEMS

TITLE: **GRINDING ROLL-32"** CARD CODE DRAWING NO. 2-61-070-02451 REV. 02

SHEET NO. NO OF SHEETS

REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED
		CHD./APPD.	02	10.6.08	CHD./APPD.	01	3.08.02	CHD./APPD.
								E.M.ASHOK
ZONE			ZONE			ZONE		
								DIM LINE FOR DIM 350 CORRECTED. DIM 325 DELETED.
								DRG.RETRACED.