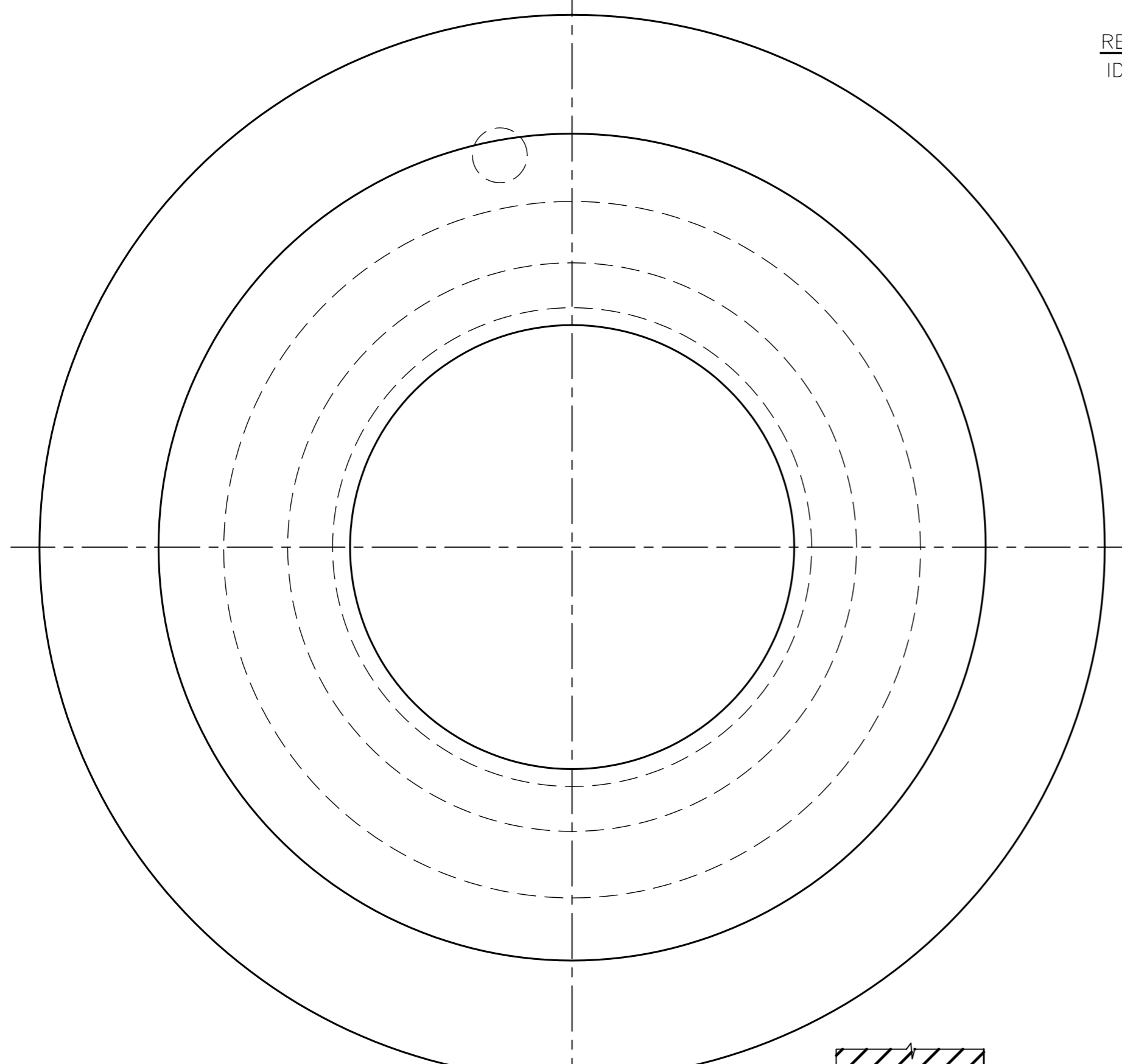


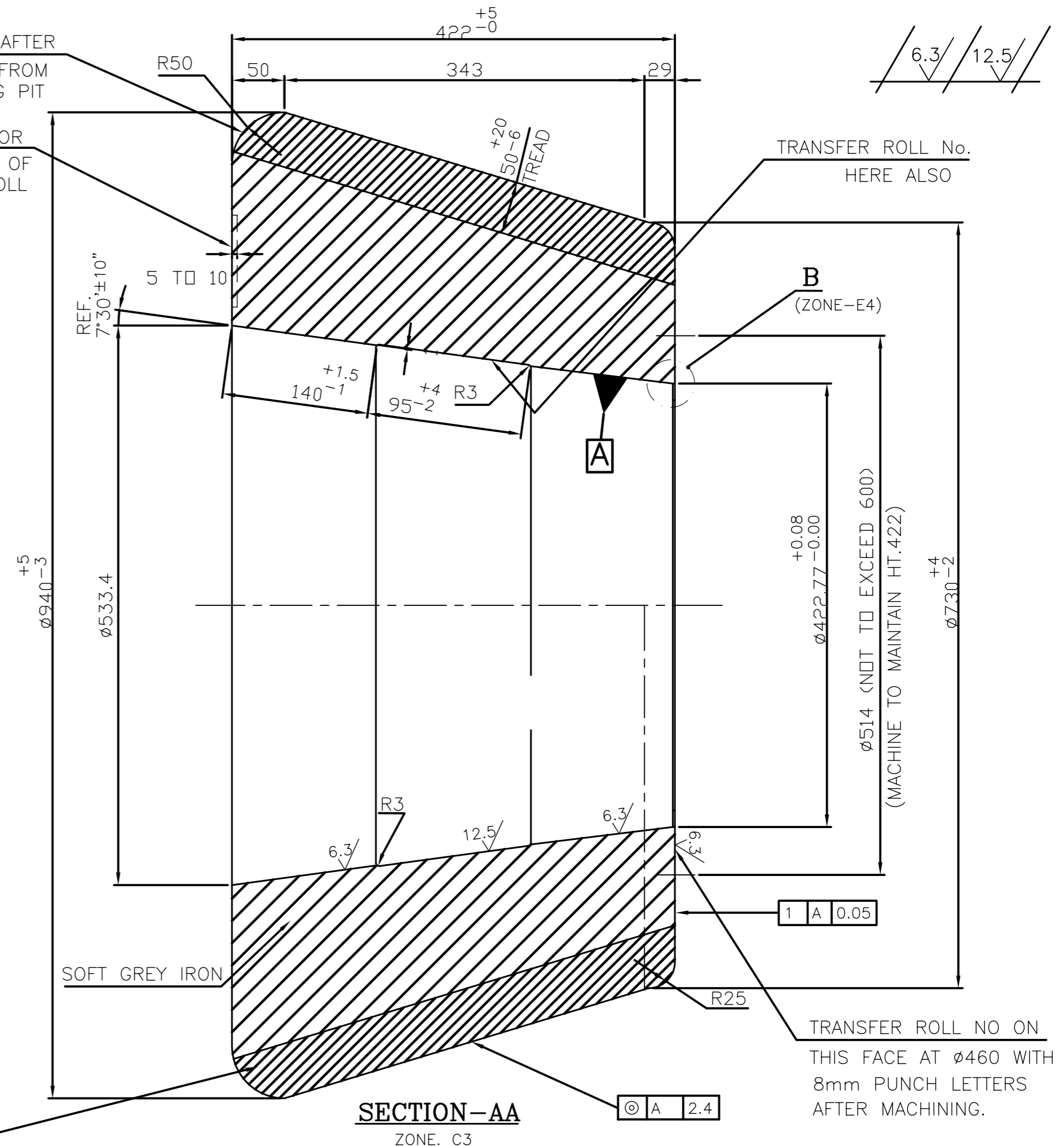
COMPUTER FILE NAME: 26100515.DWG
 SIGN AND DATE: REF. DRG. NO.
 INVENTORY NO.

DRG. NO. 2-61-080-00515
 SHT. 01 OF 01



PAINT ROLL NO. HERE SOON AFTER
 REMOVING THE ROLL FROM
 COOLING PIT

RECESS $\phi 20$ FOR
 IDENTIFICATION OF
 BHEL ROLL

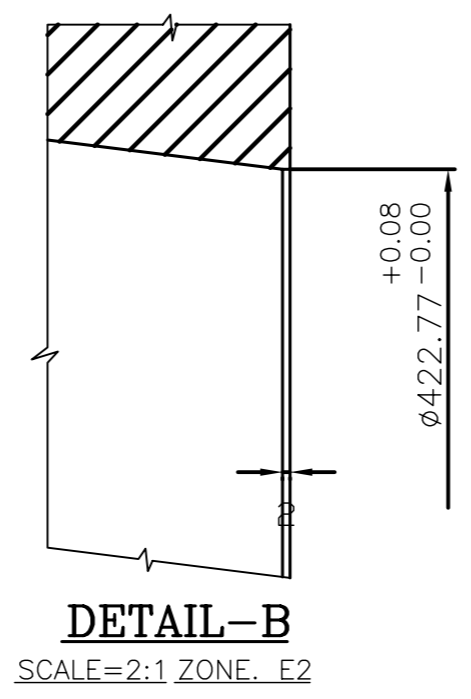
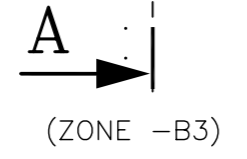


TRANSFER ROLL No.
 HERE ALSO

TRANSFER ROLL NO ON
 THIS FACE AT $\phi 460$ WITH
 8mm PUNCH LETTERS
 AFTER MACHINING.

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 GAUGE 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.



01	CASTING	HYD PATTERN NO M-67-319		BA 9116850033	1225	
				HY 19768		1
ITEM NO	DESCRIPTION	DRAWING NO.	VAR. NO.	MATERIAL CODE	NET WT.	GROSS WT.
				MATERIAL SPECN.	QUANTITY	

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED...

1. REF. TO HY0230261 FOR UN TOLERANCES.
2. CHAMFER M/CD SHARP EDG. 1.2 TO 1.0 AT 45°.
3. INTERNAL M/CD CORNER RADI 1 TO 0.7.
4. 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				NAME	SIG.	DATE	NO. OF VAR.
BHARAT HEAVY ELECTRICALS LTD. HYDERABAD				DRN.	E.M.A	06-08-02	-NA-
				CHD.	N.D.S	06-08-02	-NA-
				APPD.	RAMAN	06-08-02	-NA-
DEPT. PULVE	UNTOL. DIMS. GR. C/M/F	SCALE	WEIGHT (KG)	REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEMS	
446		1:4 2:1	1225	-NA-	-NA-	-NA-	
TITLE				CARD CODE	DRAWING NO.	REV.	
GRINDING ROLL (37")				-NA-	2-61-080-00515	04	
				SHT. No	01	NO. OF SHT.	01