

DRG. NO. 2-61-088-02325

13.1652mm TAPER PER 100mm PEP SIDE.
SEE NOTE $\phi 2.36$ A

SUPPLIERS ROLL No. TO BE CLEARLY STAMPED ON THIS FACE (5mm DEEP)
THE IDENTIFICATION SHOULD BE 3mm DEEP IMPRESSION OR 3mm LETTERS WELL WITHIN THE DEPRESSION

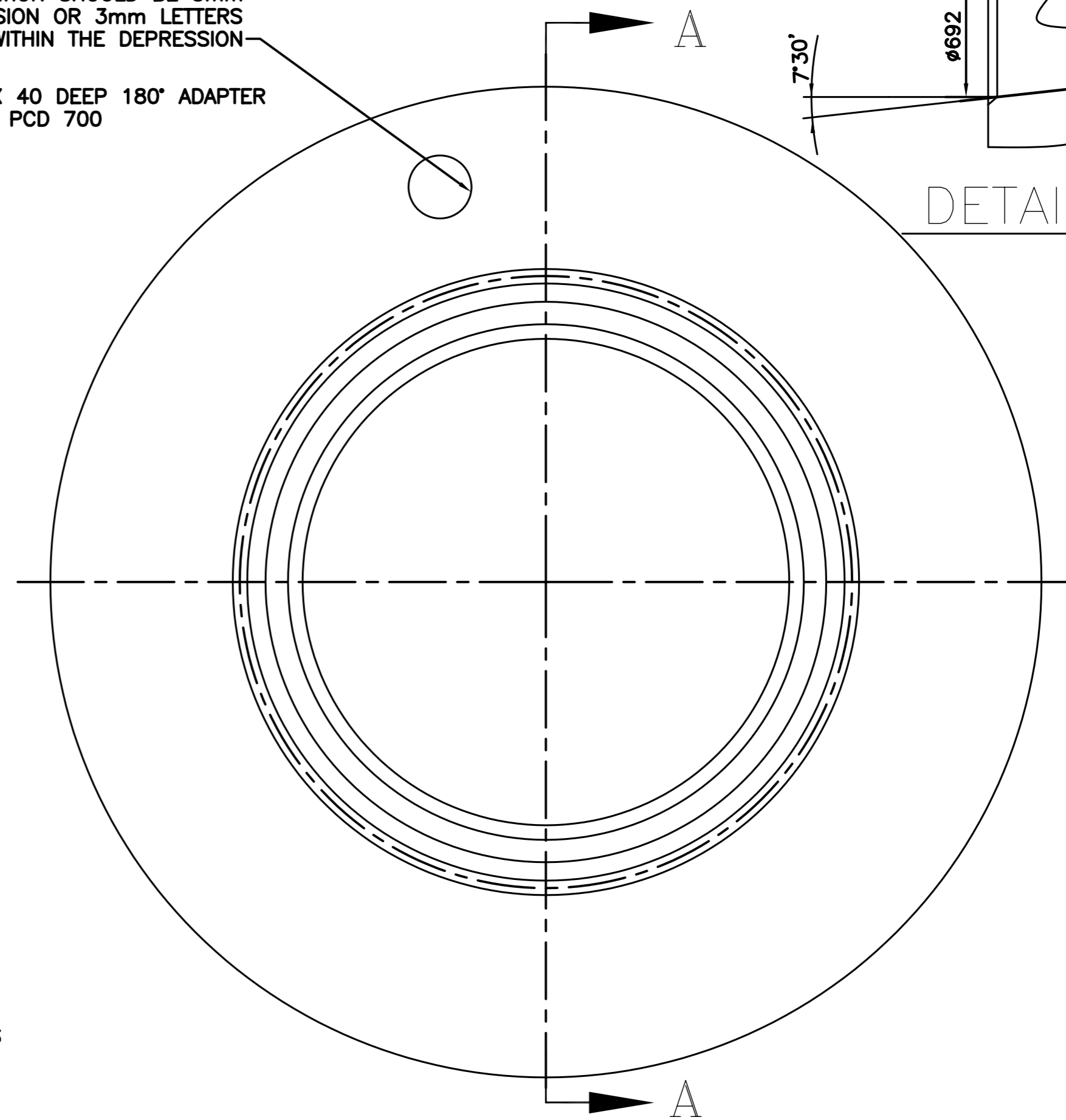
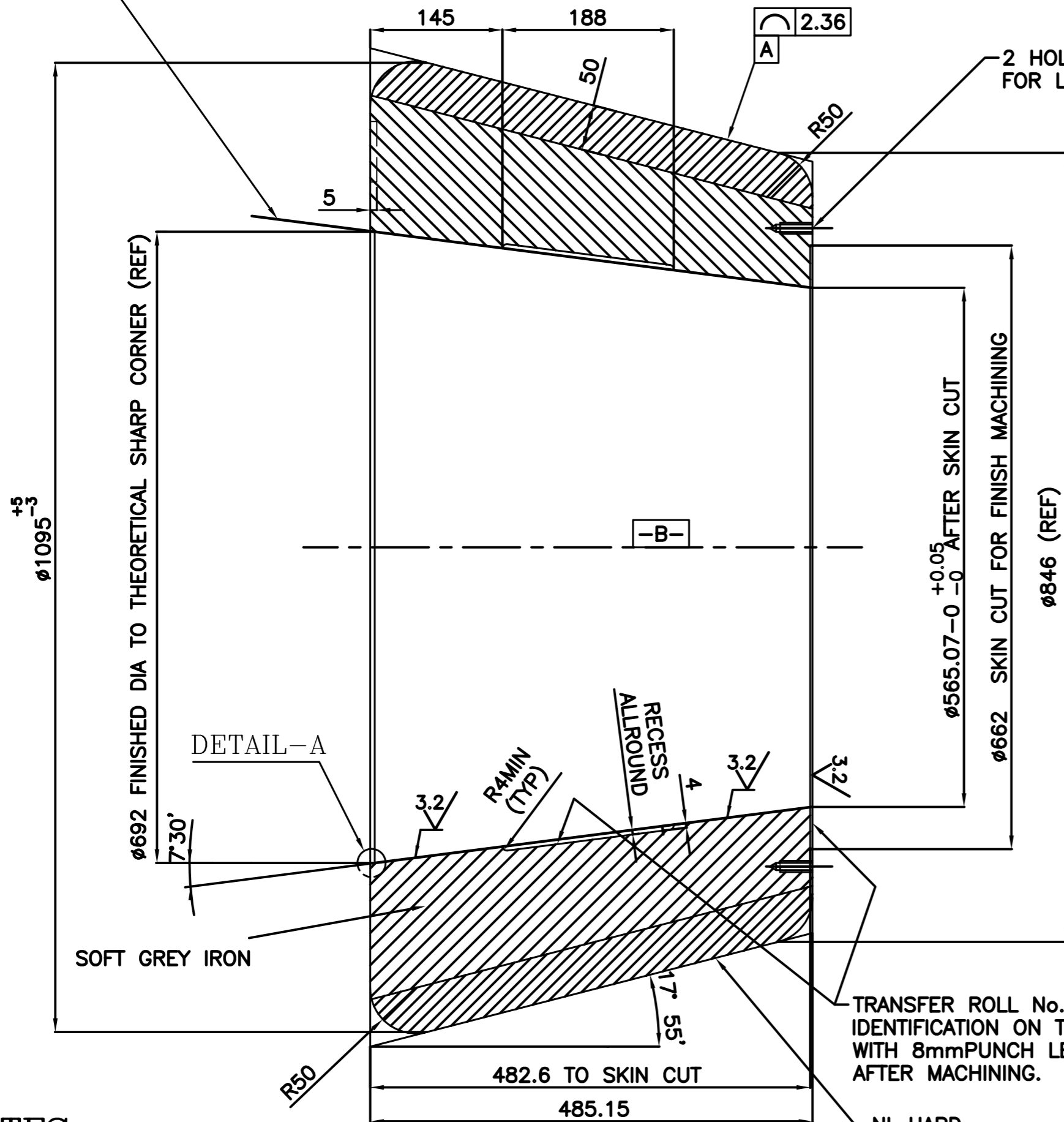
2 HOLES M20 X 40 DEEP 180° ADAPTER FOR LIFTING ON PCD 700

1x45° CHAMFER

DETAIL A

THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTERESTS OF THE COMPANY.

INVENTORY NO. SIGN. AND DATE REF. DRG. NO. 26102325



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.

SECTION A

TRANSFER ROLL No. SUPPLIERS IDENTIFICATION ON THIS FACE WITH 8mm PUNCH LETTERS AFTER MACHINING.

NI-HARD MINIMUM 550 BHN.

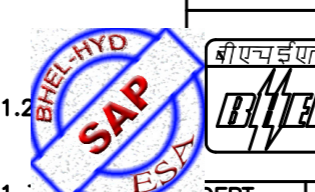
ITEM NO.	DESCRIPTION	DRAWING NO.	VAR. NO.	CASTING	PATTREN M-67-445	BA9116850106 HY19768	1612	1781
				RAW MATERIAL SIZE OR CASTING DRG. NO. OR FORGING DRG. NO.		MATERIAL SPECN.	NET WT.	GROSS WT.
							QUANTITY	

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED.

- REF. TO HY0230261 FOR UNSPECIFIED TOLERANCES.
- CHAMFER M/CD. SHARP EDGES 1. AT 45°.
- INTERNAL M/CD. CORNER RADII 1
- 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

883 XRP BOWL MILL



BHARAT HEAVY ELECTRICALS LIMITED
HYDERABAD

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

DEPT. 446	UNTO. DIMS. GR. G/M/F	SCALE 1:5	WEIGHT (KG) 1612	REF. TO ASSY DRG. 1.61.088.01019	ITEM NO. 28	NO. OF ITEMS 28
TITLE GRAINDING ROLL-43' BIMETALLIC (883XRP)				DRAWING NO. 2-61-088-02325	REV. 04	
SHEET NO. 01		NO OF SHEETS 01				

REV. 04	DATE 3.8.02	ALTERED E.M.S	CHD./APPD. N.D.S	B.R
DRG. REDRAWN ON AUTOCAD INCORPORATING ALL PREVIOUS REVISIONS. MAT CODE BA9116850106 WAS BA9616912062.				