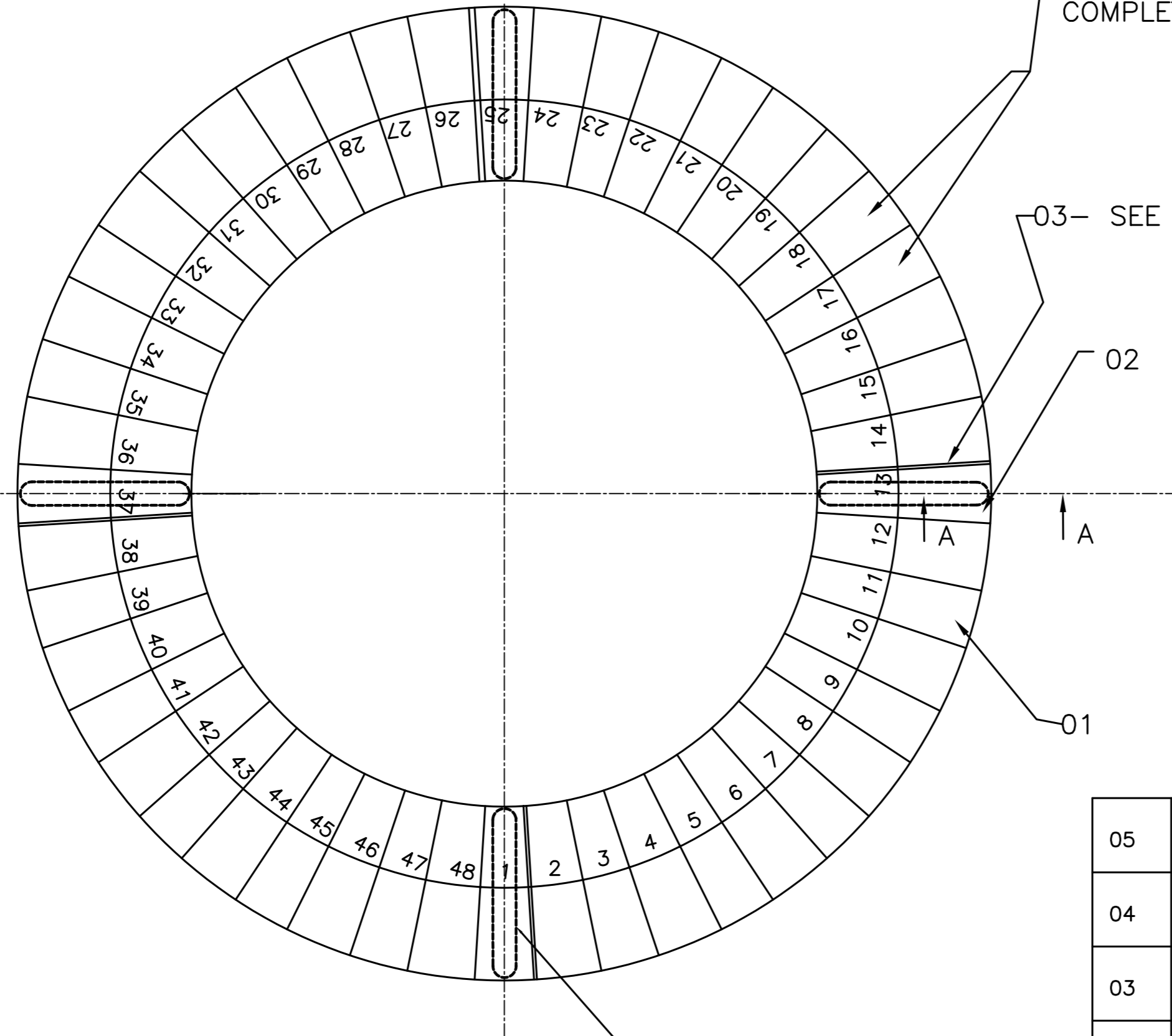


DRG. NO. 2-61-104-02603

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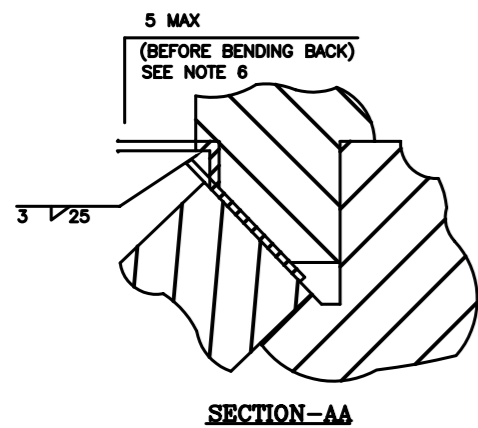


1.5 MAX MISMATCH IS ALLOWED BETWEEN THESE SURFACES OF ANY PAIR AND 3 MAX. MISMATCH ALLOWED IN COMPLETE ASSEMBLY

ACCEPTANCE CRITERION ON CHECK BOWL.

1. GAP BETWEEN THE FIRST AND THE LAST SEGMENT SHALL BE LESS THAN 6 MM BEFORE SHIM FITTING.
2. USE REQUIRED QUANTITY OF QUARTER SEGMENTS TO ACHIEVE THIS.
3. GAP TO BE CLOSED WITH ONE NO. OF 3.15 (VAR 01) OR 6 (VAR 02) SHIM.
4. GAP LESS THAN 3 MM MAY BE LEFT AS IT IS.

- NOTE:
1. ONLY ONE BULL RING SEGMENT SIDE SHIM IS PERMITTED BETWEEN EACH KEYED SEGMENT. SHIM TO BE LOCATED AS SHOWN. DRIVE ALL SEGMENTS COUNTER CLOCK WISE TO SEAT KEY SURFACE 'X' BEFORE GAUGING SHIM GAP. ALL (4) KEYED SEGMENTS MUST BEAR ON BOWL KEYWAY AT SURFACE 'X'. MARK ALL SEGMENTS WITH SEQUENCE NUMBERS WITH A KEYED SEGMENT AS #1.
 2. FURNISH FOLLOWING WITH EACH ASSEMBLY SECURELY WRAPPED, WIRED AND MARKED WITH THICKNESS, DRG NO & VAR. NO
 1. 4 SETS OF B.R.SIDE SHIM ITEM NO. 3
 2. ONE SET OF B.R.S. END SHIM ITEM NO. 4
 3. 2 NOS OF QUARTER SEGMENTS (ITEM NO.05)



SURFACE 'X'. SEE NOTE 1

| ITEM NO. | DESCRIPTION | DRAWING NO. | VAR. NO. | RAW MATERIAL SIZE OR CASTING DRG. NO. OR FORGING DRG. NO. | MATERIAL SPECN. | NET WT. | GROSS WT. |
|----------|---------------------------------|----------------|------------|---|-----------------|---------|-----------|
| 05 | BULL RING SEGMENT QUARTER | 2-61-104-02341 | | | | 10.00 | |
| 04 | BULL RING SEGMENT END SHIM SET | 4-61-104-01026 | VAR 1 TO 5 | | | 11.00 | 1 |
| 03 | BULL RING SEGMENT SIDE SHIM SET | 3-61-104-01020 | VAR 1 TO 3 | | | 9.00 | 4 |
| 02 | BULL RING SEGMENT KEYED | 1-61-104-02340 | | | | 48.00 | 4 |
| 01 | BULL RING SEGMENT PLAIN | 1-61-104-02339 | | | | 43.00 | 44 |
| | | | | | | | 44 |

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

NAME OF CUSTOMER/PROJECT

| | | | | | |
|---|------|---------|------|---------|------------|
| BHARAT HEAVY ELECTRICALS LIMITED HYDERABAD | DRN. | NAME | SIG. | DATE | NO.OF VAR. |
| | | PARTHA | | 5.08.03 | |
| | CHD. | RAMANNA | | 5.08.03 | |
| APPD. | | | | | |

| | | | | | | |
|--------------------------|--------------------------------|-----------|--------------------|-------------------|----------|-------------|
| DEPT. PULV ENGG CODE 446 | UNTOL. DIMS. GR. $\phi/M/\phi$ | SCALE NTS | WEIGHT (KG) 1852.0 | REF. TO ASSY DRG. | ITEM NO. | NO.OF ITEMS |
|--------------------------|--------------------------------|-----------|--------------------|-------------------|----------|-------------|

| | | |
|--------------------|----------------|-----------------|
| TITLE | DRAWING NO. | REV. |
| BULL RING ASSEMBLY | 2-61-104-02603 | 00 |
| | SHEET NO. 01 | NO OF SHEETS 01 |

| REV. | DATE | ALTERED CHD. | APPD. | REV. | DATE | ALTERED CHD. | APPD. | REV. | DATE | ALTERED CHD. | APPD. |
|------|------|--------------|-------|------|------|--------------|-------|------|------|--------------|-------|
| | | | | | | | | | | | |