

DRG.NO. 2-61-100-90116

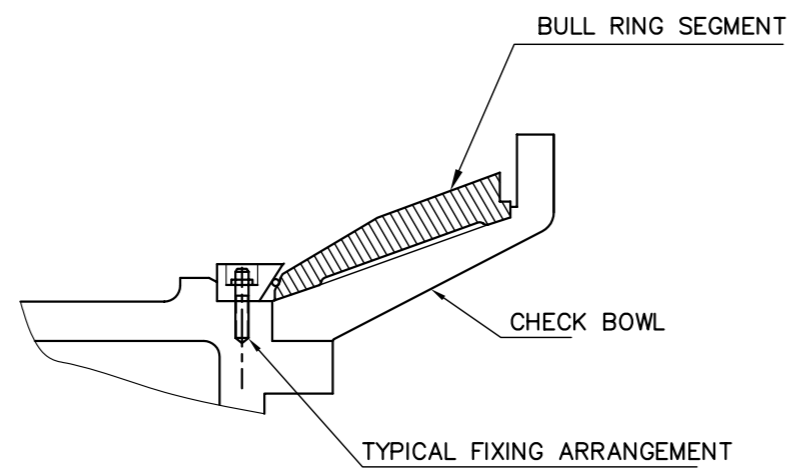
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INVENTORY NO.

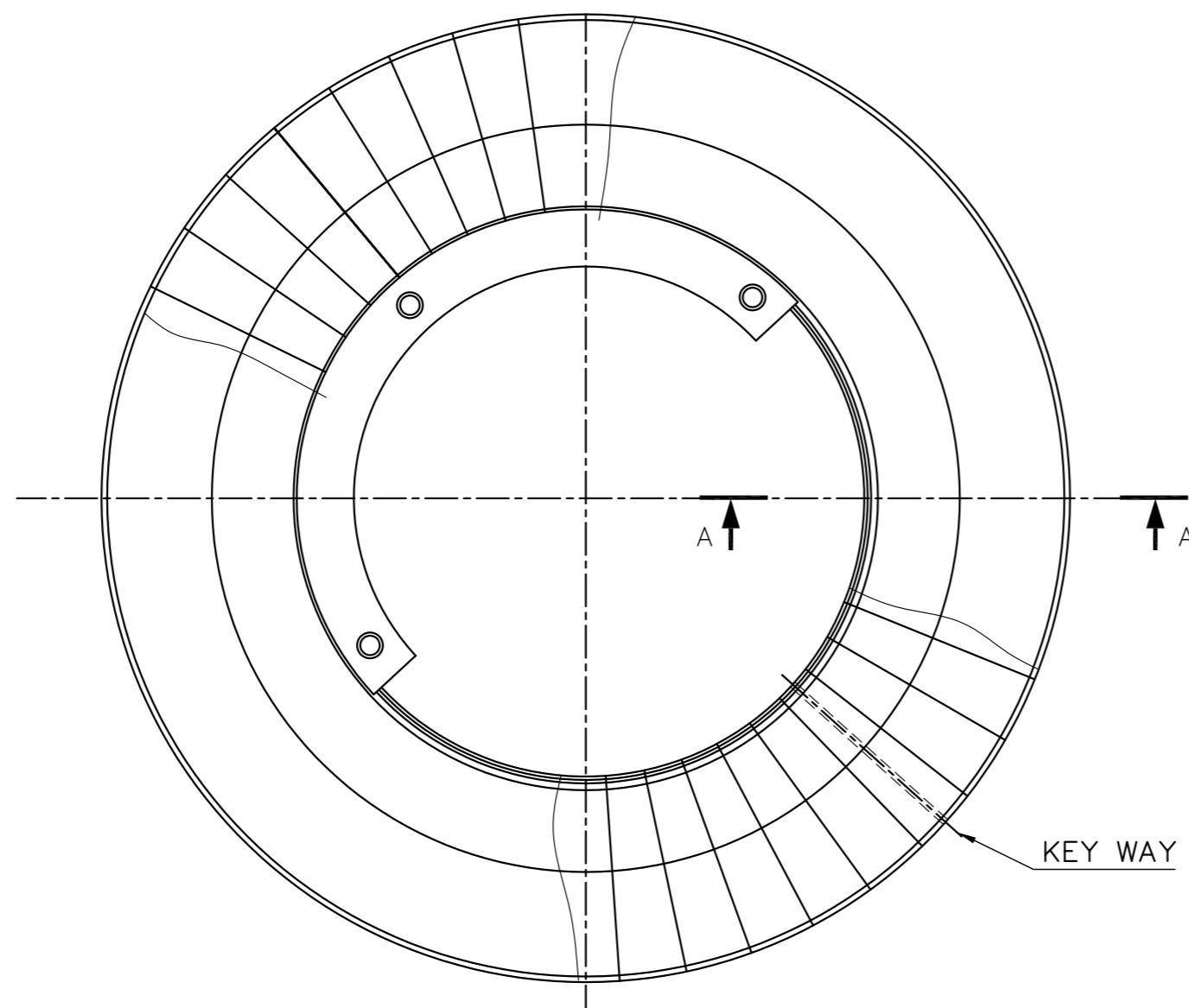
REF.DRG.NO.

COMP. FILE NAME

26190116.DWG



SECTION - AA



ONE SET OF BULL RING ASSEMBLY ON CHECK BOWL CONSISTS OF

| SEGMENT TYPE | DRAWING NO.                     | QTY.REQD.                                   |
|--------------|---------------------------------|---|
| KEY WAY      | 2-61-100-90114                  | 1   |
| PLAIN        | 2-61-100-90113                  | 44±1  |
| QUARTER      | 2-61-100-90115                  | AS REQUIRED TO ACHIEVE LESS THAN 21 mm GAP. |
| SHIM SET     | 3-61-100-90151 VARIANT 01 OR 02 | ONE PIECE ONLY IN ASSY                      |

ACCEPTANCE CRITERION ON CHECK BOWL

- GAP BETWEEN THE FIRST AND THE LAST SEGMENT SHALL BE LESS THAN 21 MM BEFORE SHIM FITTING.
- USE REQUIRED QUANTITY OF QUARTER SEGMENTS TO ACHIEVE THIS.
- USE REQUIRED QTY OF SHIMS (3.15,6, 12) TO FILL THE GAP AT SITE.

| ITEM NO | DESCRIPTION                  | DRAWING NO.    | VAR. NO. | RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO. | MATERIAL CODE           | NET WT.     | GROSS WT. |
|---------|------------------------------|----------------|----------|---|-------------------------|-------------|-----------|
| 06      | BULL RING SEG. QUARTER       | 2-61-100-90115 |          |   | HY19772                 | 8.50        |           |
| 05      | SHIM BULL RING ASSY. 12 mm   | 3-61-100-90151 | 03       |   | AA1011819090<br>AA10119 | 2.7<br>2    |           |
| 04      | SHIM BULL RING ASSY. 6 mm    | 3-61-100-90151 | 02       |   | AA1011808030<br>AA10108 | 1.35<br>1   |           |
| 03      | SHIM BULL RING ASSY. 3.15 mm | 3-61-100-90151 | 01       |   | AA1011711133<br>AA10111 | 0.71<br>1   |           |
| 02      | BULL RING KEYED SEGMENT      | 2-61-100-90114 |          |   | HY19770                 | 33.00<br>1  |           |
| 01      | BULL RING SEG. MENT. PLAIN   | 2-61-100-90113 |          |   | HY19770                 | 33.80<br>44 |           |
|         |                              |                |          |   | MATERIAL SPECN.         | QUANTITY    |           |

- TOTAL WEIGHT INDICATED IS WITHOUT SHIMS
- INSTALL SHIM APPROXIMATELY 180° FROM KEY WAY SEGMENT
- FOLLOWING ADDITIONAL SHIM SET TO BE SHIPPED ALONG WITH CORRESPONDING BULL RING ASSY.

3.15 mm (1) ONE AS PER VARIANT 01 OF DRG No. 3-61-100-90151  
 6mm (1) ONE PER VARIANT 02 OF DRG No. 3-61-100-90151  
 12mm (2) TWO AS PER VARIANT 03 OF DRG No. 3-61-100-90151

SHIM SET TO BE SECURELY WRAPPED OR WIRED AND MARKED WITH THICKNESS VAR No.& DRG. No.

| REV. | DATE   | ALTERED                              | REV. | DATE   | ALTERED                              | REV. | DATE  | ALTERED                              | REV. | DATE                        | ALTERED                              |
|------|--|--------------------------------------|------|--|--------------------------------------|------|---|--------------------------------------|------|-----------------------------|--------------------------------------|
| 05   | 26.12.11   | CHECKED [Signature] APPD [Signature] | 04   | 16.07.02   | CHECKED [Signature] APPD [Signature] | 03   | 27.6.96   | CHECKED [Signature] APPD [Signature] | 02   | 22.9.94                     | CHECKED [Signature] APPD [Signature] |
| ZONE | ACCEPTANCE CRITERION ON CHECK BOWL MODIFIED AND NOTES 3 & 4 DELETED. |                                      | ZONE | ACCEPTANCE CRITERION ON CHECK BOWL ADDED. DRG REDRAWN. NOTES AMENDED. BOM CORRECTED. |                                      | ZONE | ITEM NO 2 WT WAS 26 KGS. TOTAL WT WAS 1513 KGS. WT CHANGED AS PER HY/FDY/TECH/96 DT 15.6.96 |                                      | ZONE | ITEM NO 6 AND NOTE 5 ADDED. |                                      |

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED...

- REF. TO HY0230261 FOR UNSPECIFIED TOLERANCES.
- CHAMFER M/CD SHARP EDGES 1.2 TO 1.0 AT 45°.
- INTERNAL M/CD CORNER RADII 1 TO 0.7.
- 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  
**XRP 1003 BOWL MILL**

| DRN.      | NAME | SIGN. | DATE    | NO.OF VAR. |
|-----------|------|-------|---------|------------|
| E.M.ASHOK |      |       | 30.5.02 |            |
| N.D.S     |      |       | 30.5.02 |            |
| S.G       |      |       | 30.5.02 |            |

| DEPT.     | SCALE                  | WEIGHT(Kg) | REF. TO ASSY DRG. | ITEM NO.              | NO.OF ITEMS    |
|-----------|------------------------|------------|-------------------|-----------------------|----------------|
| PULV/ENGG | N.T.S                  | 1538.00    | ----              | ---                   | ---            |
| CODE      | 446                    |            |                   |                       |                |
| TITLE     | <b>BULL RING ASSY.</b> |            | DRAWING NO.       | <b>2-61-100-90116</b> | REV. <b>05</b> |
|           |                        |            | SHEET NO.         |                       | NO OF SHEETS   |