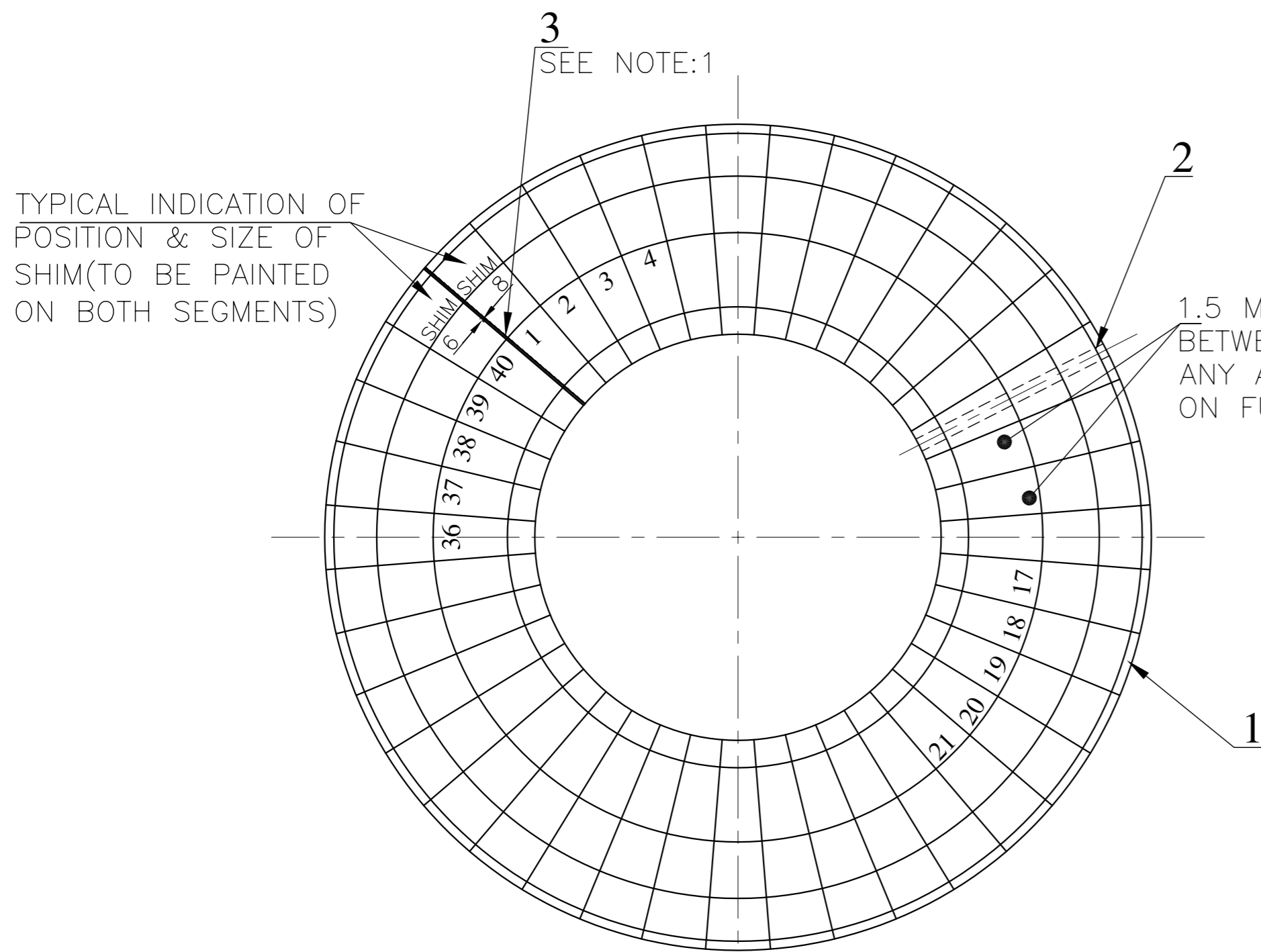
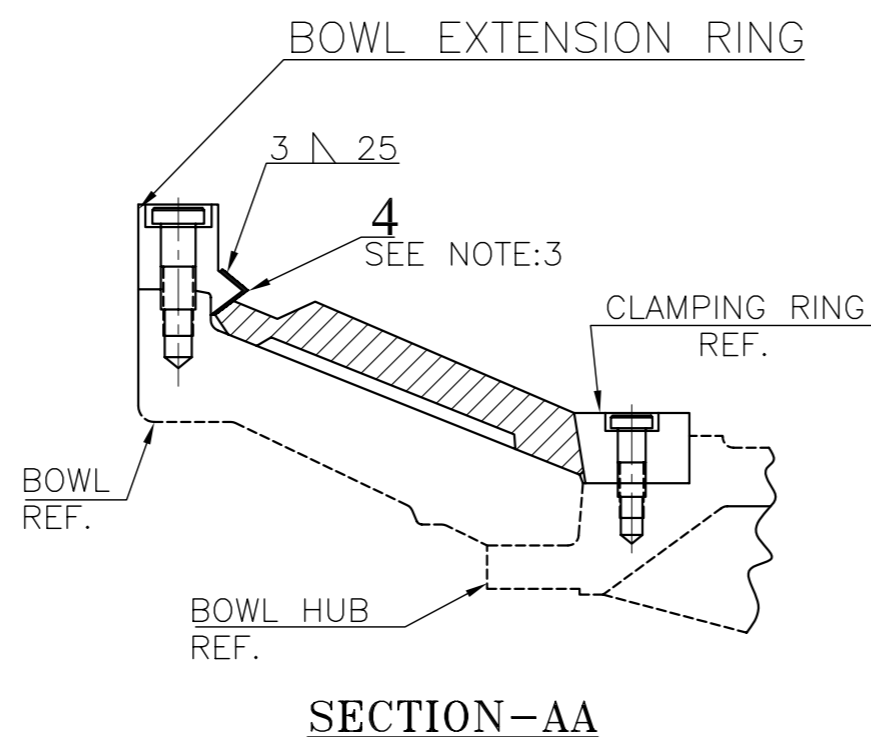


DRG. NO. 2-61-170-90134

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BULL RING ASSY. PLAN VIEW WITH BOWL EXTENSION AND CLAMPING RING REMOVED.



SECTION-AA

ACCEPTANCE CRITERION ON CHECK BOWL-

01. GAP BETWEEN THE FIRST AND THE LAST SEGMENT SHALL BE LESS THAN 21 MM BEFORE SHIM FITTING.
02. USE REQUIRED QUANTITY OF QUARTER AND HALF SEGMENTS TO ACHIEVE THIS.
03. USE REQUIRED QTY OF SHIMS (3,15,6, 12) TO FILL THE GAP AT SITE.

NOTES:

1. IF MORE THAN ONE SIDE SHIM IS NEEDED, SHIM AT POINTS APPROXIMATELY EQUAL SPACED AROUND PERIPHERY. NO MORE THAT ONE SHIM TO BE INSTALLED BETWEEN ANY TWO ADJACENT SEGMENTS.
2. USE BULL RING SEGMENT HALF 2-61-170-90132. BULL RING SEGMENT QUARTER 2-61-170-90133. IF REQUIRED.
3. IF MORE THAT ONE END SHIM IS NEEDED PER SEGMENT TACK WELD SHIMS TOGETHER AFTER BENDING.
4. FOR ASSEMBLY PROCEDURE REFER DRG. 2-61-170-01104.

ITEM NO.	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG. NO. OR FORGING DRG. NO.	MATERIAL CODE	NET WT.	GROSS WT.	QUANTITY
06	BULL RING SEGMENT QUARTER	2-61-170-90133			BA9117053234	4.8		1
05	BULL RING SEGMENT HALF	2-61-170-90132			BA9117053226	9.60		1
04	BULL RING SEGMENT END SHIM SET	4-61-180-00924				13.78		1
03	BULL RING SEGMENT SHIM SET	3-61-170-00880			REFER TABLE	6.0		1
02	BULL RING SEGMENT KEYED	2-61-170-90131			BA9117053218 HY19770	22.63		1
01	BULL RING SEGMENT PLAIN	2-61-170-90130			BA9117053200 HY19770	24.0		39

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 RADIUS 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 **HP-703 BOWL MILL**

NAME OF CUSTOMER/PROJECT

DRN.	NAME	DATE	NO.OF VAR.
CHD.	SATISH	10.01.11	
APPD.	AMAN	10.01.11	
	S GHATA	10.01.11	

BHARAT HEAVY ELECTRICALS LIMITED
HYDERABAD

DEPT. PULV ENGG. CODE 446	UNTO. DIMS. GR. 4/M/Y	SCALE N.T.S.	WEIGHT (KG) 992.81
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REF. TO ASSY DRG. ITEM NO. NO.OF ITEMS

TITLE **BULL RING ASSY**

DRAWING NO. 2-61-170-90134 REV. 01

SHEET NO. 01 NO OF SHEETS 01

REV.	DATE	ALTERED CHD.	APPD.	REV.	DATE	ALTERED CHD.	APPD.
01	26.12.11						

ACCEPTANCE CRITERION ON CHECK BOWL ADDED.