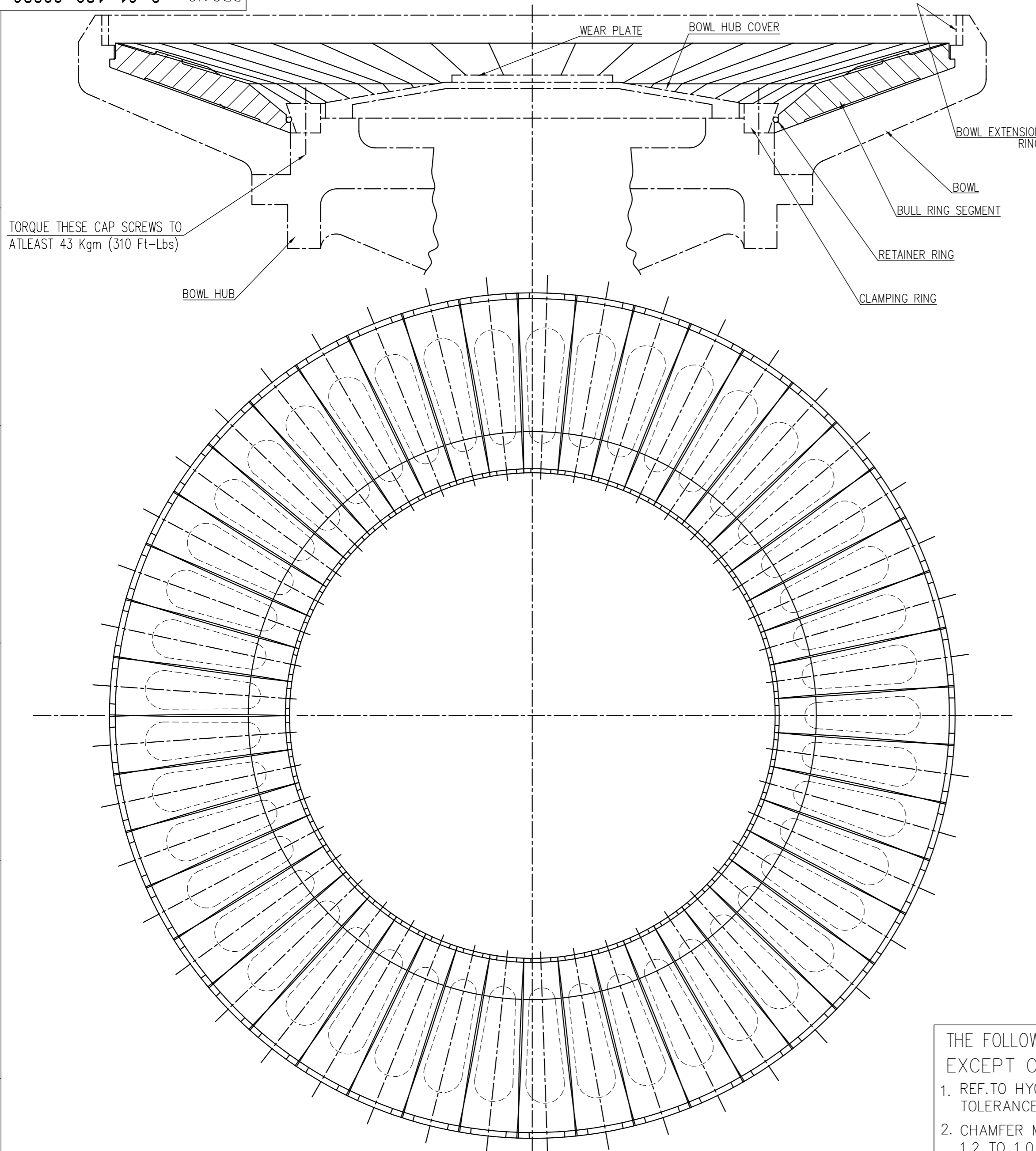


98700-081-19-2 DRG. NO.

INVENTORY NO. REF. DRG. NO. COMP. FILE NAME 26100286.DWG 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 INTEREST OF THE COMPANY.



NOTES:-

- INSTALL SHIMS (3.15 mm Thk .) AFTER INSTALLING LAST BULL RING SEGMENT DURING ASSY
- THE BULL RING SEGMENTS SHOULD BE IN LEVEL WITH EACH OTHER WITHIN 5 mm.
- THE GAP BETWEEN THE SEGMENTS SHOULD BE LIMITED TO LESS THAN 1.6 mm AFTER SHIMMING. NO GAP IS ALLOWED AT THE INNER & OUTER RADIUS
- THE QTY OF ITEM No. 02 DEPENDS ON THE FINAL GAP DURING ASSY.
- ALL THE SEGMENTS SHOULD BE ASSEMBLED AND MATCHED AS A SET IN CHECK BOWL & NUMBERED SERIALLY
- VARIANT 01 IS HY19770 , Type-M MATL CODE : BA9616612042
- VARIANT 02 IS HY19769 , Type-II MATL CODE : BA9616612271
- VARIANT 03 IS HY19769 , Type-IV MATL CODE : BA9616612280

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.

03	03	SHIM	3-61-176-00361	AA10108	4.6	2	
	02	BULL RING SEGMENT-QUARTER	2-61-180-90125	BA9116953495	7.00		
				HY19769	3		
				BA9116953487	25.50		
01	BULL RING SEGMENT-PLAIN	2-61-180-90122	HY19769	45			

02	03	SHIM	3-61-176-00361	AA10108	4.6	2	
	02	BULL RING SEGMENT-QUARTER	2-61-180-90125	BA9116953533	7.00		
				HY19769	3		
				BA9116953509	25.50		
01	BULL RING SEGMENT-PLAIN	2-61-180-90122	HY19769	45			

01	03	SHIM	3-61-176-00361	AA10108	4.6	2	
	02	BULL RING SEGMENT-QUARTER	2-61-180-90125	BA9117053404	7.00		
				HY19770	3		
				BA9117053390	25.50		
01	BULL RING SEGMENT-PLAIN	2-61-180-90122	HY19770	45			

VARIANT No.	ITEM No.	DESCRIPTION	STD.	DRAWING No.	ITEM No. VAR. No.	MATL. CODE	MATL. SPEC.	A/C	UNIT	UNIT WT.	CS	ZONE
-------------	----------	-------------	------	-------------	-------------------	------------	-------------	-----	------	----------	----	------

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 **763/783/803 XRP BM**

DRN.	B M R	SIGN.	DATE	NO. OF VAR.
CHD.	N.D.SAMUEL		2K.07.18	NA
APPD.	S.GHATGE		2K.07.18	NA

DEPT.	PULVE ENGG	SCALE	1:2	WEIGHT(Kg)	1158.00	REF. TO ASSY DRG.	NA	ITEM NO.	NA	NO. OF ITEMS	NA
CODE	446	TITLE	BULL RING ASSY (WITH PLAIN)		DRAWING NO.	2-61-180-00286		REV.	09		
				SHEET NO.	01	NO OF SHEETS		01			

REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED
		CHECKED	09	26.12.11	CHECKED	08	18.09.02	CHECKED	07	2K.07.18	CHECKED
		APPD.			APPD.			APPD.			APPD.
ZONE			ZONE	ACCEPTANCE CRITERION ON CHECK BOWL MODIFIED AND NOTE 4 DELETED.	ZONE	ACCEPTANCE CRITERION ON CHECK BOWL ADDED.	ZONE	DRG CONVERTED INTO VARIANTS DRG REDRAWN BY INCORPORATING ALL PREVIOUS REV.			