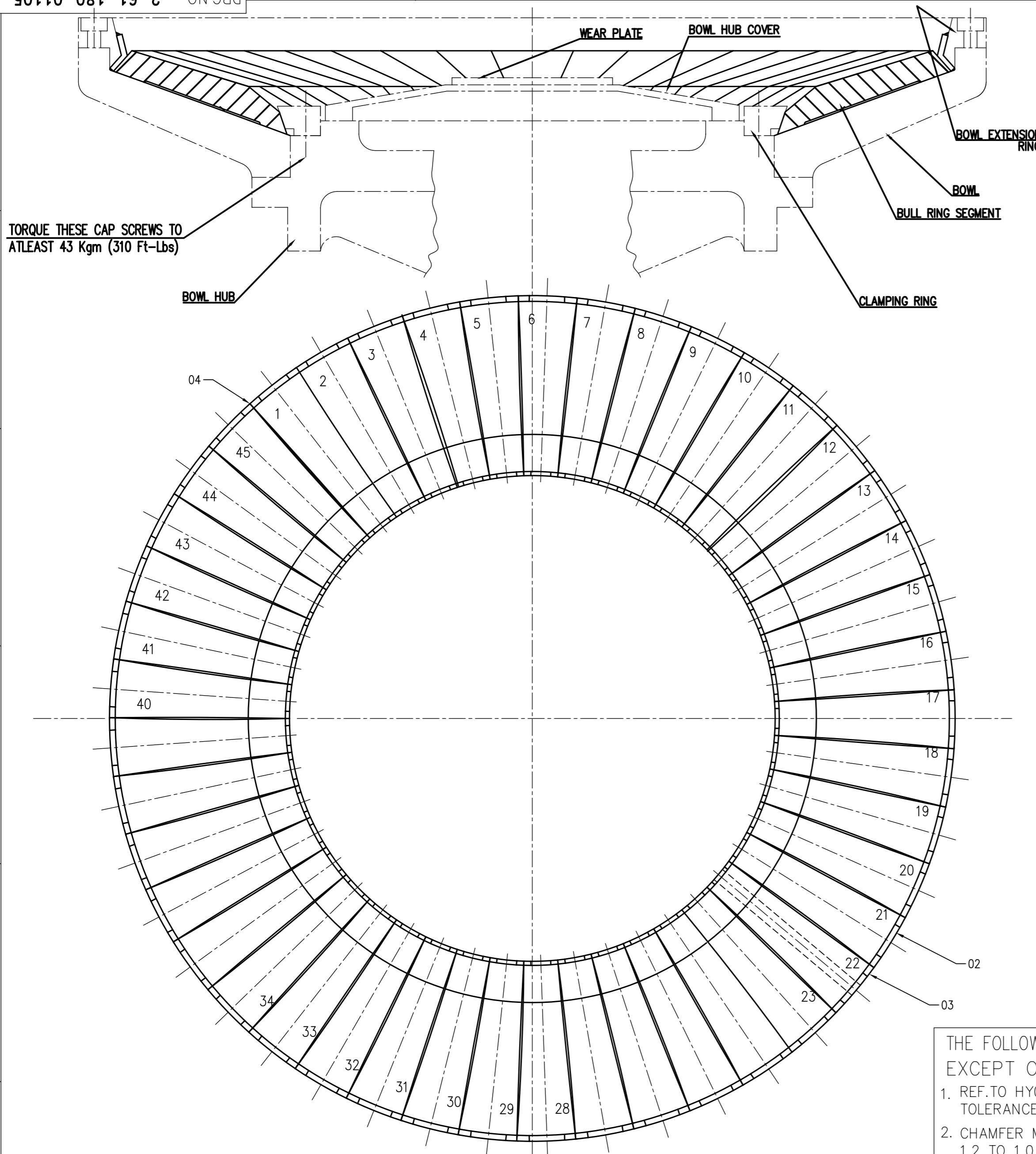


50110-081-19-2 DRG. NO.

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NOTES FOR ASSEMBLY ON MILL:-

01. INSTALL SHIMS (3.15 mm Thk .) AFTER INSTALLING LAST BULL RING SEGMENT DURING ASSY
02. THE BULL RING SEGMENTS SHOULD BE IN LEVEL WITH EACH OTHER WITHIN 5 mm.
03. 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
04. THE QTY OF ITEM No. 04 DEPENDS ON THE FINAL GAP DURING ASSY.

ACCEPTANCE CRITERION ON CHECK BOWL-

01. ALL THE SEGMENTS SHOULD BE ASSEMBLED AND MATCHED AS A SET IN CHECK BOWL & NUMBERED SERIALLY
02. THE BULL RING SEGMENTS SHOULD BE IN LEVEL WITH EACH OTHER WITHIN 5 mm.
03. GAP BETWEEN THE FIRST AND THE LAST SEGMENT SHALL BE 8±2 MM WITHOUT SHIM (ITEM NO.04)
04. USE REQUIRED QUANTITY OF QUARTER SEGMENTS TO ACHIEVE THIS.
05. THE GAP BETWEEN ADJACENT SEGMENTS SHOULD BE LIMITED TO LESS THAN 1.6MM. NO GAP IS ALLOWED AT THE INNER & OUTER RADIUS

VARIANT No.	ITEM No.	DESCRIPTION	STD.	DRAWING No.	ITEM No.	MATL. CODE	A/C	UNIT	UNIT WT.	CS	ZONE
					VAR. No.	MATL. SPEC.		D	QTY.		
03	06	BULL RING SEGMENT (HALF)		3-61-180-90126		BA9117053269			11.00		
					01	HY19770			1		
03	05	BULL RING SEGMENT (QUARTER)		3-61-180-90135		BA9117053277			7.90		
					01	HY19770			1		
03	04	BULL RING SEGMENT SHIM SET		4-61-180-00926					7.90		
					01-03				1		
03	03	BULL RING SEGMENT KEYED		3-61-180-00869		BA9117053250			24.50		
					03	HY19770			1		
03	02	BULL RING SEGMENT-PLAIN		3-61-180-00867		BA9117053242			22.00		
					03	HY19770			44		
03	01	BULL RING SEGMENT END SHIM SET		4-61-180-00924					13.78		
					01-06				1		
02	04	BULL RING SEGMENT SHIM SET		4-61-180-00926					7.90		
					01-03				1		
02	03	BULL RING SEGMENT KEYED		3-61-180-00869		COMBALLOY N			24.50		
					01				1		
02	02	BULL RING SEGMENT-PLAIN		3-61-180-00867		COMBALLOY N			22.00		
					01				44		
02	01	BULL RING SEGMENT END SHIM SET		4-61-180-00924					13.78		
					01-06				1		
01	04	BULL RING SEGMENT SHIM SET		4-61-180-00926					7.90		
					01-03				1		
01	03	BULL RING SEGMENT KEYED		3-61-180-00869		COMBALLOY N			24.50		
					02				1		
01	02	BULL RING SEGMENT-PLAIN		3-61-180-00867		COMBALLOY N			22.00		
					02				44		
01	01	BULL RING SEGMENT END SHIM SET		4-61-180-00924					13.78		
					01-06				1		

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED...

1. REF. TO HY0230261 FOR UNSPECIFIED TOLERANCES.
2. CHAMFER M/CD SHARP EDGES 1.2 TO 1.0 AT 45°.
3. INTERNAL M/CD CORNER RADII 1 TO 0.7.
4. 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 **HP 803**

DRN.	AMAN	SIGN.	DATE	NO. OF VAR.
CHD.	N.D.SAMUEL		09.09.04	NA
APPD.	S.GHATGE		09.09.04	NA
DEPT.	PULVE ENGG	SCALE	WEIGHT(Kg)	REF. TO ASSY DRG.
CODE	446	NTS	997.00	NA
TITLE	BULL RING ASSY		ITEM NO.	NO. OF ITEMS
			NA	NA
			DRAWING NO.	REV.
			2-61-180-01105	03
			SHEET NO. 01	NO OF SHEETS 01

REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED
		CHECKED			CHECKED			CHECKED			CHECKED
									03	09.09.04	
ZONE		APPD.	ZONE		APPD.	ZONE		APPD.	ZONE		APPD.
1			2			3			4		