

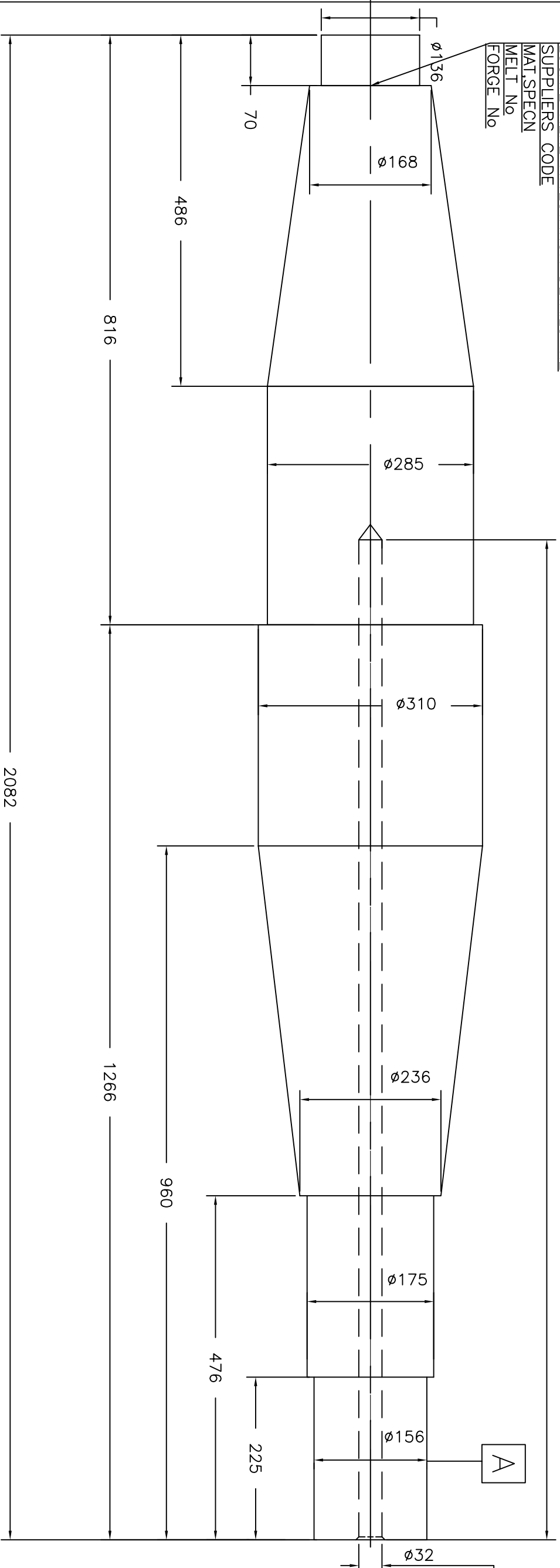
DRG.NO.3-61-176-90012

LOCATE HERE ATTESTATION DETAILS VIZ
SUPPLIERS CODE
MAT.SPECN
MELT No
FORCE No

1396

12.5

A 0.5 A



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FILE NAME

REF.DRG.NO.

INVENTORY NO.


NOTE:-

- 1.FORGING SHALL BE ROUGH MACHINED TO DIMENSIONS INDICATED IN THE DRAWING (EXTRA ALLOWANCES ARE NOT REQUIRED)
2.CORNER CHAMFERS-R3,FILET RADIUS-R3.
3.FORGING SHALL BE TESTED ULTRASONICALLY AS PER BHEL CORP.STD AA0850118 CAT-2
INSTEAD OF CLAUSE 13 OF HY19369.BACK WALL ECHO SHOULD BE 80%
4.FORGING SHALL BE SUPPLIED AS PER SPECN.
HY19369
5.EACH FORGING SHALL BE TESTED FOR HARDNESS AND THE VALUES SHALL BE 269-330 BHN

02

	FORGING			BA9516953018						
					HY19369,REV,01					
ITEM NO	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	MATERIAL CODE	NET WT.	GROSS WT.			
					MATERIAL SPECN.	QUANTITY				

TYPE OF PRODUCT 'MATERIAL ATTEST'
OR
NAME OF CUSTOMER/PROJECT 76" BOWL MILL

				NO.OF VAR.	
NAME		SIGN.	DATE		
DRN. NARAYANA			15.11.03		
CHD. N.D.S			15.11.03		
APPD. S.GHATGE					

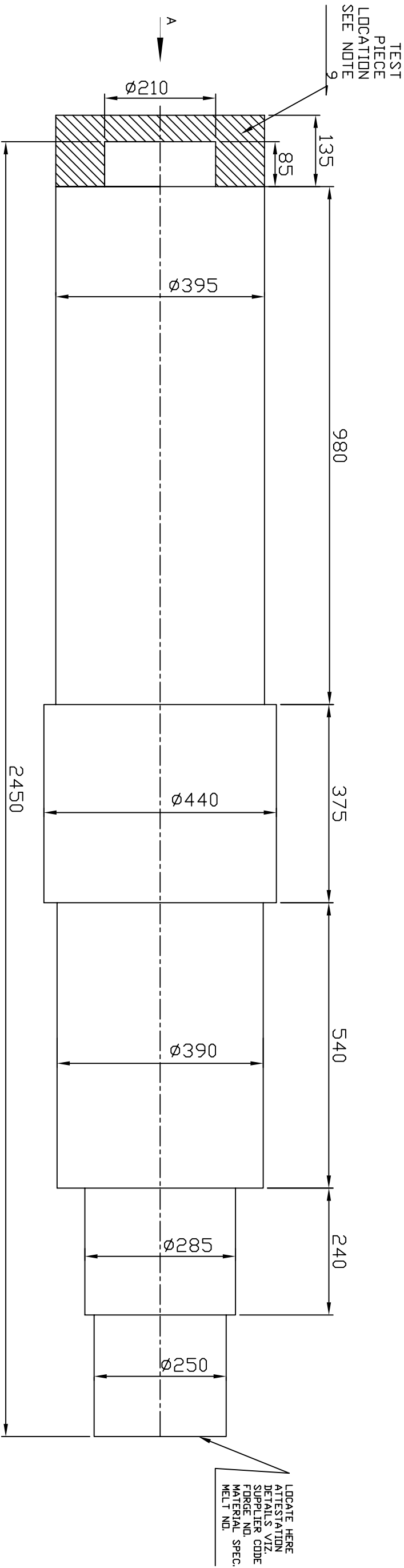
DEPT.	PULVE.ENGCG	SCALE	WEIGHT (KG)	REF. TO ASSY DRG.	ITEM NO.	NO.OF ITEMS
CODE	446	NTS	802.00	—		

FILE
MAIN VERTICAL SHAFT
(ROUGH MACHINED)

DRAWING NO.	REV.
3-61-176-90012	03
SHEET NO. 01	NO OF SHEETS 01

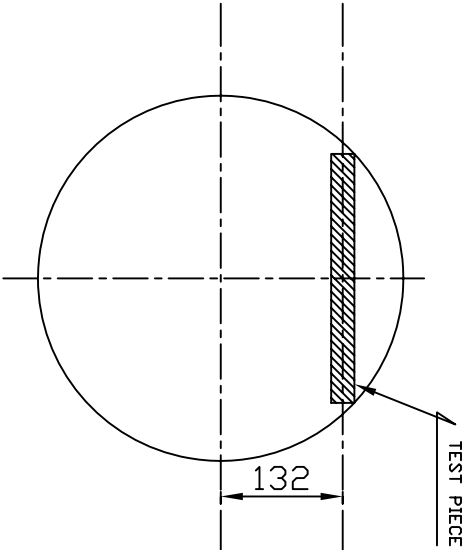
TD-151/REV. 03 SIZE A3

DRG.NO. 3-61-100-90172



NOTES:

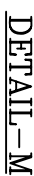
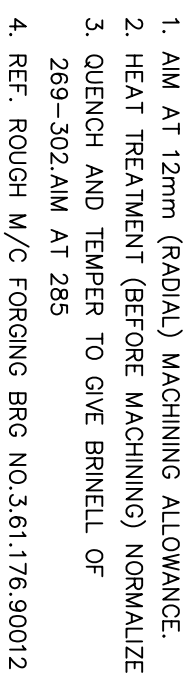
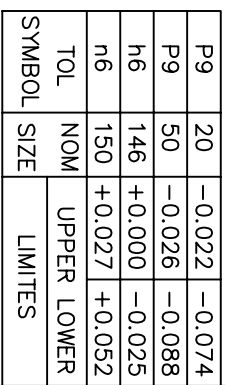
1. FORGING TO BE ROUGH MACHINED TO THE DIMENSIONS INDICATED IN THE DRAWING.
2. CHAMFER SHARP CORNERS TO R2 AND ALL FILLET RADIA TO R3.
3. TEST ULTRASONICALLY AS PER SPEC. AA0850118 CAT. 2
4. FORGING SHOULD BE AS PER THE SPEC HY19369.
5. FOR FINISH MACHINING REF. 1-61-100-00239.
6. TOLERANCES ON DIAMETER AND LENGTH $\pm 1\text{mm}$.
7. INTEGRAL TEST PIECE SHALL BE KEPT AS SHOWN FOR ONE(1) SHAFT REPRESENTATING ONE(1) MELT AND HEAT TREATMENT BATCH.
8. TEST PIECE SHALL BE PARTED FROM THE SHAFT AFTER HEAT TREATMENT IS COMPLETED.
9. THE HATCHED AREA IS SHOWN FOR TEST PIECE LOCATION. R/M SHAFT TO BE SUPPLIED AFTER REMOVING THE HATCHED AREA.
10. NORMALIZE, QUENCH & TEMPER TO 269-302 BHN, AIM AT 285 BHN.



VIEW-A

[illegible]

8



THE FOLLOWING CONDITIONS
EXCEPT OTHERWISE STATED.

भारतीय
BAHAI

MAIN VERTICAL SHAFT

DRAWING REDRAWN BY
INCORPORATING ALL
PREVIOUS REVISIONS.

INVENTORY NO	SIGN. AND DATE	REF. DRG. NO.	COMPUTER FILE NAME	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
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