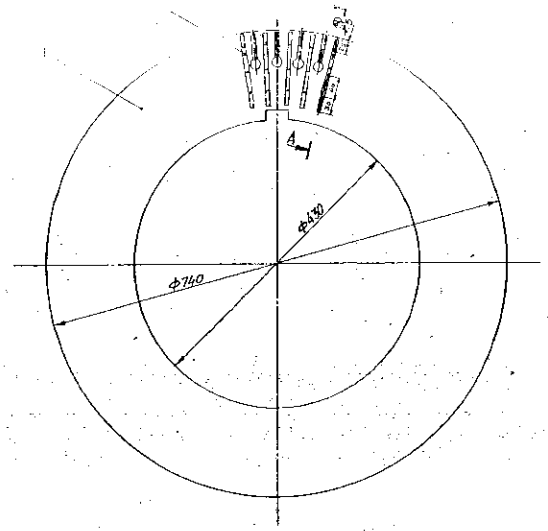
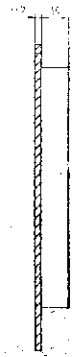




SECTION A-A

TECH. REQUIREMENTS.

1. STAMPING (ITEM 1) TO BE CLEANED OFF FOR DIRT AND DEGREASED BEFORE WELDING THE SPACER (ITEM 2)
2. THE PROJECTION WELDING OF SPACERS TO STAMPING SHALL BE CARRIED OUT AS PER TL 30002 AT THREE PLACES AS SHOWN.
3. SPACER SHALL LIE ON TOOTH AXIS. DISPLACEMENT OF SPACERS FROM THEIR NOMINAL POSITION SHALL NOT BE MORE THAN 0.5 mm.
4. AFTER WELDING THE SPACERS, THE STAMPING SHALL BE COATED ON BOTH SIDES WITH INSULATING ENAMEL IE 82, AA 27513

COATED SURFACE AREA — 7220 cm²

SUPERSEDES OLD TRACING UNDER SAME NUMBER.

Note:- spacers to be used as per dwg no. 410.100.00642. i.e spot welding instead of projection welding.

ENGINEERING DIVISION EMRP BHEL, MUMBAI-400 093.

VAR. 00	REMARKS	ITEM NO	DESCRIPTION	DRAWING NO	MATERIAL CODE / MATERIAL SPECN	UNIT WEIGHT
64		002	SPACER	1402.62.32.005		0.02 kg per
1		001	ROTOR STAMPING VENT.	2401.81.32.081	0.1	1.548

CARD TYPE 3 — CARD TYPE 1 — CARD TYPE 2

GMS NO. 04018130014-00

TYPE OF PRODUCE OR NAME OF CUSTOMER / PROJECT: AC 14316 H4/8C

	NAME	SIGN	DATE
EMT	N.L. MAJI		17.11.79
APPD	V.K.K.		18.11.79

GRADE OF UNTOL. DIM. —
M/CG-B/H/F. AA 0230206
WELDING-K/B/K AA 0621104
GAS CUTTING AA 0621101

REV	DATE	ALTERED	CHECKED
04			
03		SUPERSEDES OLD TRACING UNDER SAME NUMBER C.A. No. AME 39-290	
02		2 NOS. OF CHANGES AS PER C.A. NO. AME-01-291	

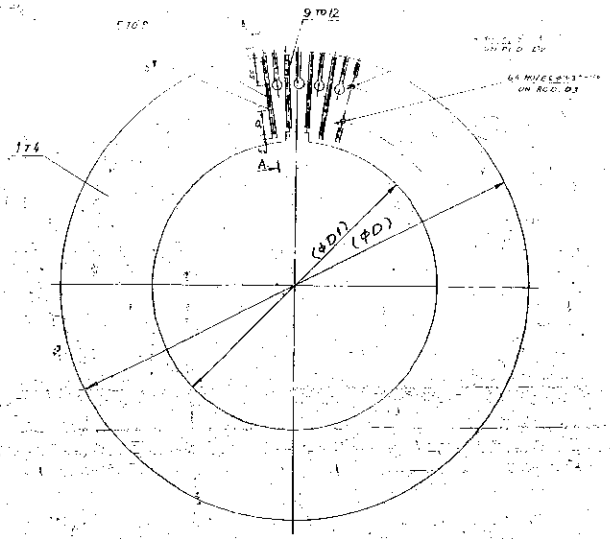
BHARAT HEAVY ELECTRICALS LTD. HARDWAR

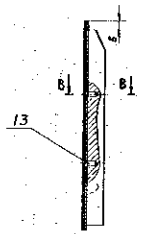
	NAME	SIGN	DATE
DRN	V.P. MAINI		8.11.79
CHD	D.R.M.		31.5.79
APD	D.N.M.S.		17.11.79

DEPT. AME — CODE 4237 — SCALE N.T.S — WEIGHT (kg) 2.91 — REF. TO ASSY. DRG. 04018130014-00 — ITEM NO 008

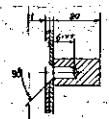
TITLE: ROTOR STAMPING (VENT.)

DRAWING NO 1-401-81-30096 — SHEET NO. 001 — NO. OF SHEETS 001 — SIZE A1





SECTION A-A



SECTION B-B

DRAWING No & VAR		DIMENSIONS				TOTAL WT.	REF TO ASSY DRG & VAR		TYPE OF PRODUCT	GMS NO & VAR	
DRAWING No	VAR	D	D1	D2	D3		DRG No	VAR		GMS No.	VAR
1401813010 2	00	740	430	650	400	17.3	0401813001 4	00	AC 1431 6 H 4/DC	GMS 0401813001 4	00

TECH REQUIREMENTS

1. STAMPING ROTOR SHALL BE CLEANED OFF OF DIRT AND DEGREASED BEFORE ISTOT WELDING THE FINGERS.
2. IN NO CASE RIVET HEAD SHALL PROJECT ABOVE THE STAMPING SURFACE.
3. AFTER WELDING, THE TOOTH SUPPORT STAMPING TO BE GASKETED ON BOTH SIDES WITH ~~NE BONDE~~ FEB BONDEL GRADE IE 323 BANT 313. (R3) ~~& 3.2 MM REQ FOR BONDING OVER DURING CHEP BONDING BRIDGE~~
4. FINGER AXIS SHOULD LIE ON TOOTH AXIS.

128		013	RIVET FLAT C'SK 3X8 MT	1			AA 7174 075 010 / AA 9174 015								
–		012	FINGER												
–		011	FINGER												
–		010	FINGER												
2		009	FINGER	L-136	2401813201 1	41	AA 1010306491 / AA 1010 8					21			
–		008	FINGER												
–		007	FINGER												
–		006	FINGER												
62		005	FINGER	L-136	2401813201 1	12	AA 1010306491 / AA 1010 8					22			
–		004	STAMPING ROTOR												
–		003	STAMPING ROTOR												
–		002	STAMPING ROTOR												
2		001	STAMPING ROTOR		2401813208 1	0.1	[illegible]					1432			
VARDO	REMARKS	ITEM NO.	DESCRIPTION		DRAWING NO.	VAR	MATERIAL SPECIF.								

CARD TYPE-1 23 — CARD TYPE-2 — CARD TYPE-3

GMS/DRG NO: SEE TABLE

STATUS OF DRG: B

	NAME	SIGN.	DATE
ASS	KANT		21/4/89
CHK	CHAUHAN		21/4/89
SUP	K.K.PAPOR		21/4/89

TYPE OF PRODUCT OR NAME OF CUSTOMER / PROJECT: SEE TABLE

BHARAT HEAVY ELECTRICALS LTD. RANIPUR - HARDWAR

	NAME	SIGN.	DATE
DRN	S.S.S.		21/4/89
CH	N.K.G		21/4/89
APPD	V.P.G		21/4/89

MATERIAL OF PRODUCT	SCALE	WEIGHT (Kg)	REF. TO ASSY. DRG.
2/M17	N.T.S.	SEE TABLE	SEE TABLE

ROTOR STAMPING END

DRAWING NO. 1-401-81-30102 REV. 02

CARD CODE 1

SHEET NO. 1 NO. OF SHEETS 1

SIZE A1

ENGINEERING DIVISION EMTP BHEL MUMBAI-400 093.

REV.	DATE	ALTERED	CHECKED
00	21/4/89		
		NO. OF CHANGES AS PER DRNO. AME 88-290	

REV.	DATE	ALTERED	CHECKED
01	7.5.94		
		NO. CHANGES AS PER CHANGE ADVICE NO AME 89-1	

REV.	DATE	ALTERED	CHECKED
02	2.4.97		
		NO. CHANGES AS PER CHANGE ADVICE NO AME 89-1	

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REF. DRG. NO.

ENGINEER

PURCHASE NO. 42964