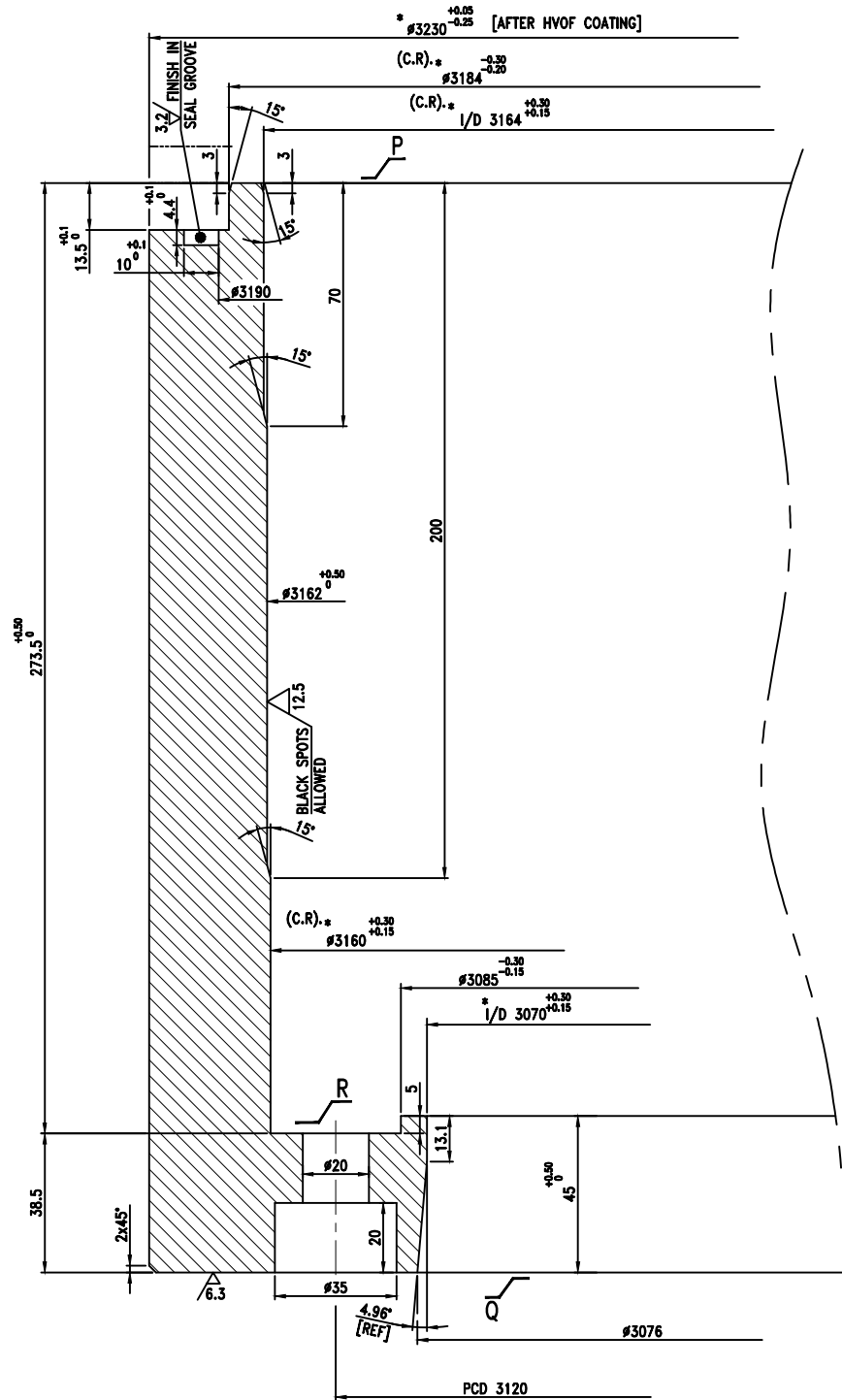


FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

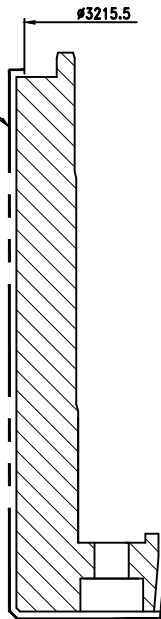
DRG. NO. 1 22301 178 04

ALL OVER UNLESS OTHERWISE STATED.

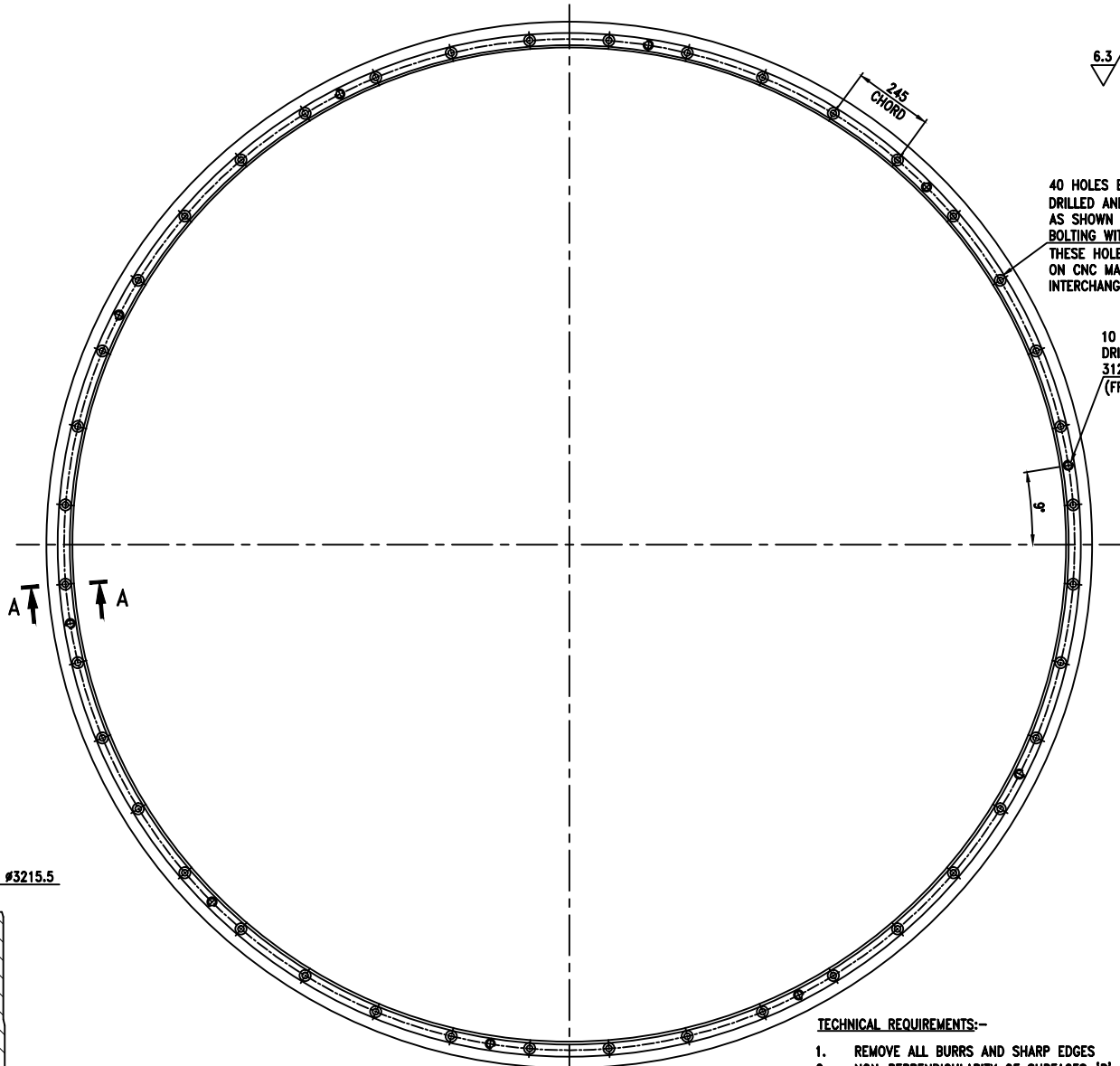


SECTION-AA
(SCALE-1:1)

MINIMUM 500 MICRON HVOF COATING DEPOSITION



EXTENT OF HVOF COATING



TOP VIEW
(SCALE-NTS)

TECHNICAL REQUIREMENTS:-

1. REMOVE ALL BURRS AND SHARP EDGES
- 2a. NON-PERPENDICULARITY OF SURFACES-'P', 'Q' & 'R' w.r.t. DIAMETERS NOT TO EXCEED 0.10
- 2b. OVALITY OF DIAMETERS MARKED ϕ NOT TO EXCEED 0.02
- 3a. * MARKED DIAMETERS TO BE CONCENTRIC WITHIN 0.02
- 3b. DIAMETERS MARKED THUS ϕ ARE CRITICAL FOR INSPECTION RE-VALIDATION DURING MEASUREMENT AT SHOP. ALSO THESE DIAMETERS SHOULD BE STRICTLY MAINTAINED FOR INTERCHANGEABILITY.
- 3c. DIAMETERS MARKED ϕ ARE TO BE MEASURED IN CLAMP FREE CONDITION AT 8 ANGULAR POSITION EQUISPACED AND RECORD TO BE MAINTAINED.
4. LABYRINTH TO BE DISPATCHED ASSEMBLED IN A SUITABLE FIXTURE TO PREVENT DISTORTION/DAMAGE OF HVOF COATED AND MACHINED SURFACES DURING TRANSPORT & HANDLING.
5. NDT SHALL BE CARRIED OUT AS MENTIONED IN SPECIFICATION
6. REFER PURCHASE SPECIFICATION FOR MATERIAL, HVOF COATING, OTHER TECHNICAL DETAILS & INSPECTION
7. PAINT AND PROTECT TO HT00005 AS FOLLOWS- ALL SURFACES (WITHOUT HVOF COATING) TO CAT.-G

VAR.00	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	DRAWING NO.	MATL. CODE	UNIT WT.	ZONE
28	CARD TYPE-3	28	CARD TYPE-1	28	CARD TYPE-2	28	CARD TYPE-2	28

DRAWING REVIEW				ADDITIONAL INFORMATION				TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT			
DEPT.	NAME	SIGN.	DATE	STATUS OF DRAWING U				RAMPUR HEP			
DISTRIBUTION OF PRINTS				Bharat Heavy Electricals Ltd. Bhopal				NAME SIGN DATE NO. OF			
				DRN CKD APPD				ANUJ 12.09.12 12.09.12 12.09.12			
				DEPT. H.T.E. CODE 402				UNTO. DIMS. GR. SCALE WEIGHT(K.G.) REF. TO ASSY. DRG. ITEM NO. NO. OF			
				32000049014 1:1 & AS STATED 957.00 0 20407 178 01 04				TITLE LOWER LABYRINTH DRAWING NO. 1 22301 178 04 REV. 00			
				SHT. NO. 01 NO. OF SHT. 01							