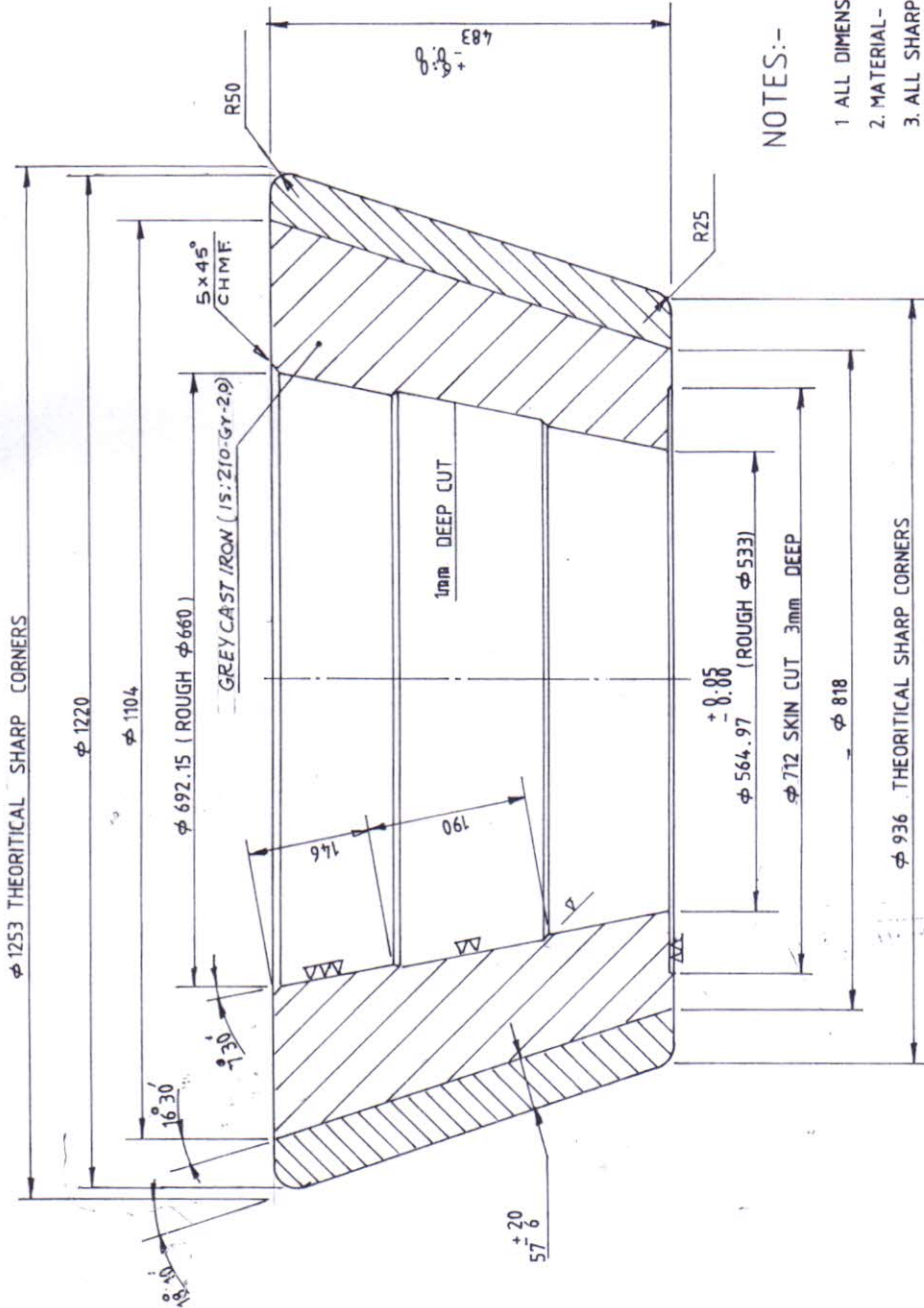


WHEN EVER IN DOUBT, ASK, DO NOT SCALE

DN DNMW50



NOTES:-

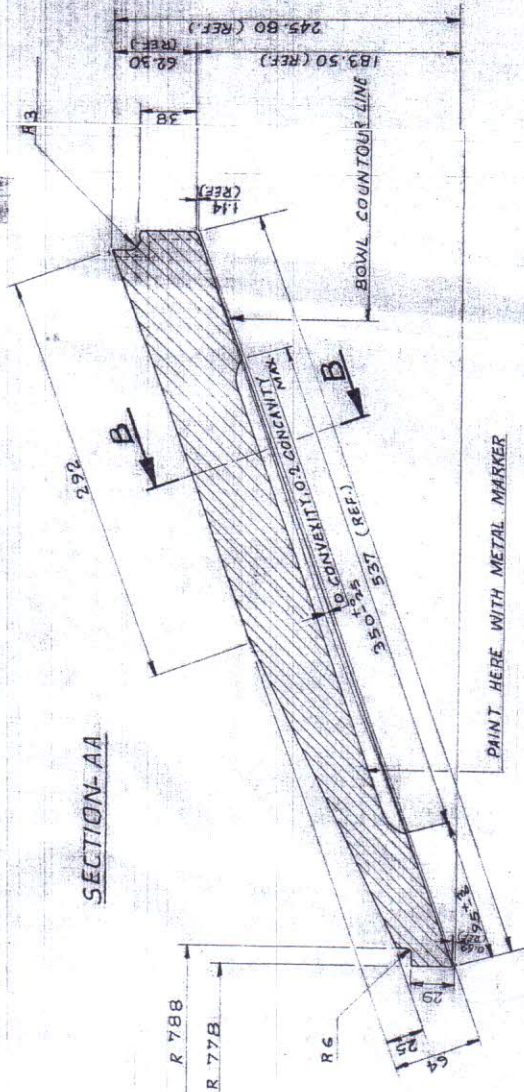
- 1 ALL DIMENSIONS ARE IN mm
2. MATERIAL- NI HARD Gr- II
3. ALL SHARP CORNERS TO BE REMOVED AS PER 1x45°
4. HARDNESS- 550 BHN. (MIN^M)
5. 80/100 BLUE MATCHING WITH PLUG TYPE/PLATE TYPE GAUGE.
6. EMBOSIS/PUNCHING ON INNER CORE FOR VENDOR NAME & ROLL NO.
7. TOLERANCES FOR UNMACHINED SURFACE NI-HARD SURFACE AS PER IS- 5519.

| | | | |
|-----------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-----------------------|
| <p>NTPC National Thermal Power Corporation Ltd. (A Government of India Enterprise)</p> | | <p>SINGRAULI SUPER THERMAL POWER STATION</p> | |
| <p>DATE: 4/27/99</p> | <p>DRAWN: [Signature]</p> | <p>CHECKED: [Signature]</p> | <p>SCALE: 1:6</p> |
| <p>ADDITIONAL INFORMATION</p> | | <p>TOLERANCES FOR DIMENSIONS WITHOUT SPECIFIED TOLERANCES: MEDIUM-IS: 2102-1989</p> | |
| <p>ROUGHNESS</p> | <p>50 μm 25-12.5 μm 6.3-3.1 μm 0.8-0.2 μm 0.1-0.025 μm</p> | <p>TOLERANCE</p> | |
| <p>3. GRINDING ROLL HIGHT TOLERANCE CHANGED $\phi 483^{+0.15}$ TO $\phi 483^{+0.05}$ NOTE- 5, 6 & 7 ADDED</p> | <p>1) MATL- CAST STEEL CHANGED AS GREY CAST IRON (15: 210-GY-20)</p> | <p>2) HARDNESS- 500-800 BHN CHANGED AS 550 BHN. MIN.</p> | <p>DATE: 05/05/99</p> |
| <p>2</p> | <p>DESCRIPTION</p> | <p>DRAWN APPD: [Signature]</p> | <p>REV: 3</p> |
| <p>DRG NO: 472630050 M</p> | | <p>TITLE: GRINDING ROLL OF BOWL MILL ST-II</p> | |

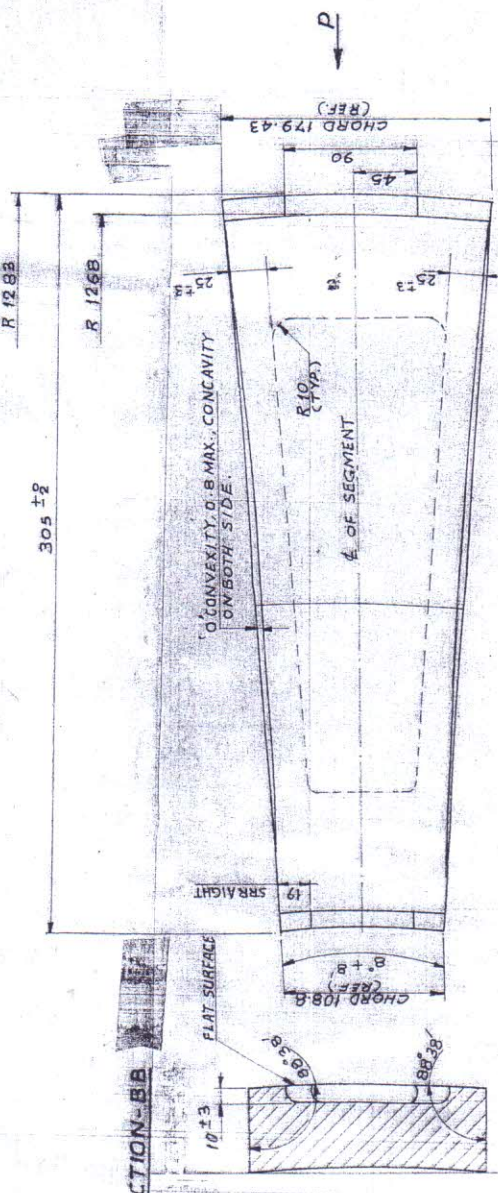
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472620253M

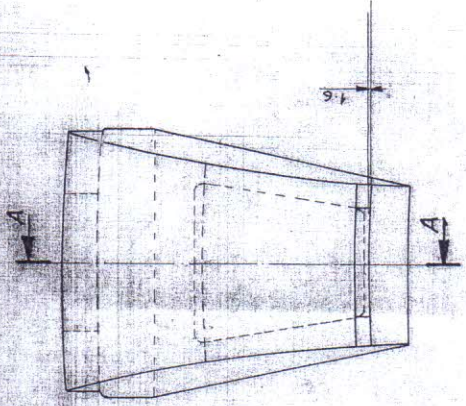
WHEN EVER IN DOUBT, ASK DO NOT SCALE.



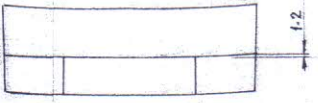
SECTION-AA



SECTION-BB



VIEW-P



NOTE

- 1- ALL DIMENSIONS ARE IN MM. UNLESS OTHERWISE STATED.
- 2- MATERIAL - NIT. HARD-Gr.12
- 3- BHN IS TO BE 550 TO 650
- 4- BULL RING SEGMENTS PLAIN, RIBBED AND KEYS SHOULD BE ASSEMBLED AND MATCHED AS A SET IN THE CHECK BOWL AND NUMBERED SERIALLY.
- 5- THIS DRS. AND DRGN. 032-02M-MB-A2-300 WILL MAKE ONE SET.

NTPC नॅशनल थर्मल पावर कॉर्पोरेशन्
 National Thermal Power Corporation
 (A GOVT. OF INDIA ENTERPRISE)

SINGRAULI SUPER THERMAL POWER, STATIC
 TITLE (MODIFIED)
BULL RING SEGMENT (PLAIN)

| | | | | | |
|---------|-------|---------|---------|-------|-------------------|
| DATE | DRAWN | CHECKED | APPROV. | SCALE | DRAWING NO. |
| 27.9.98 | MSA | | | 1:2 | 032.02M-MB-A2-308 |