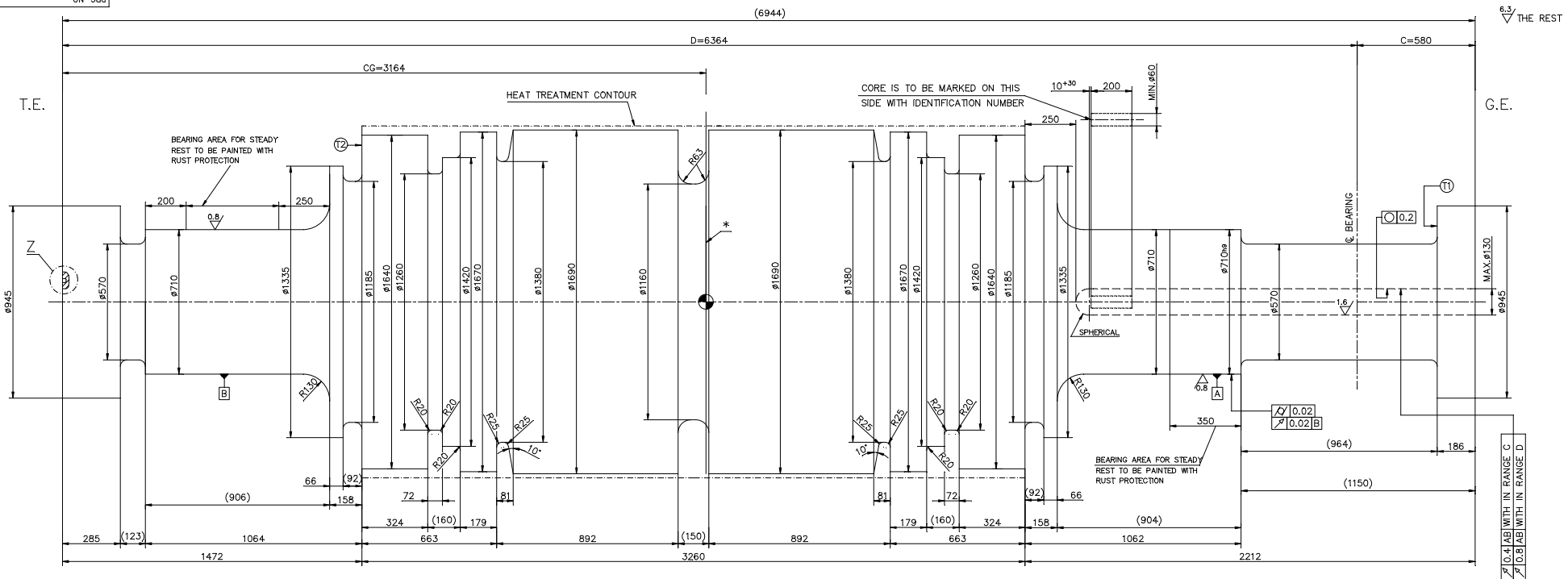


6667C-10301-1 ON DRG



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TECHNICAL REQUIREMENTS: -

1. FORGING SHALL BE SUPPLIED AS PER SPECIFICATION NO. HW19208.
2. FORGING SHALL BE SUPPLIED IN ROUGH MACHINED CONDITION, PERMISSIBLE TOLERANCE: ON OUTSIDE DIMENSION +2 ON INSIDE DIMENSION -2
3. UNSPECIFIED RADII SHALL BE TAKEN AS R32.
4. BRACKETED DIMENSION ARE FOR REFERENCE ONLY.
5. AT THE PLACE MARKED (T1) AND (T2), SUPPLIER SHALL LOCATE THE TANGENTIAL TEST SAMPLE FOR MECH. TESTING. PART OF THE TEST SAMPLE ($\approx 40\text{mm}$) SHALL BE LEFT INTEGRAL WITH THE SHAFT.
6. AXIAL CORE SHALL BE TREPANED AFTER SATISFACTORY TESTING OF T1, T2 AND ULTRASONIC TEST. TESTING OF AXIAL CORE SHALL BE CARRIED OUT AS PER SPECIFICATION AA0850155. BALANCE OF AXIAL CORE DULY MARKED WITH IDENTIFICATION NUMBER SHALL BE SENT TO BHEL ALONG WITH FORGING.
7. PERMISSIBLE RADIAL RUN OUT OF SHAFT IS 1mm WITH RESPECT TO STEADY REST BEARING.
8. AXIAL BORES AFTER TESTING SHALL BE PLUGGED BY SUPPLIER AS PER DRG. 2-10305-18000, CARE IS TO BE TAKEN DURING PLUGGING TO AVOID MOISTURE ENTRAPMENT.
9. THE IDENTIFICATION NUMBER MUST BE STAMPED AT THE PLACE MARKED IN AS PER ORDERING SPECIFICATION.

WEIGHT:	
THEORETICAL	MAXIMUM
65900KG	68600KG

FORGING FOR L.P. SHAFT (R/m)		1-10301-32999	W95310301216	65900 00
VAR 00	REMARKS	ITEM No.	DESCRIPTION	DRAWING No.
59	64 65	75 25 27 29	58	67
CARD TYPE-3		28	CARD TYPE-1	
GMS No./ C.B.D.M. - NO. 01030132000		STATUS OF DRG	TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT	
GRADE OF UNTO.LDIM	STE	P.K.KANAUJIA -S4-	06.01.17	STEAM TURBINE BHARAT HEAVY ELECTRICALS LTD. RANIPUR, HARDWAR
M/CC. - C/M/F AA0230208	TTX	S.S.GRAN -S4-	06.01.17	
WELDING - A/B/C/D AA0621104	NCT	V.K.SHORE -S4-	10.01.17	
GAS CUTTING - T3 AA0621101				
DRP	NAME	SIGN	DATE	NO. OF
CHD	ARUNJAN	-sd-	02.01.2017	VAR
APPD	TSG	-sd-	10.01.2017	73 74
DEPT	MTE	SCALE	WEIGHT (KG)	REF. TO ASSY. DRG.
CODE	4300	1:10	65900.00	ITEM No.
TITLE: FORGING FOR L.P.SHAFT (ROUGH MACHINED)		CARD CODE	DRAWING NO. 1-10301-32999	
			SHEET No. 01 No. OF SHEETS 01	

REV	DATE	ALTERED CHECKED	REV	DATE	ALTERED CHECKED