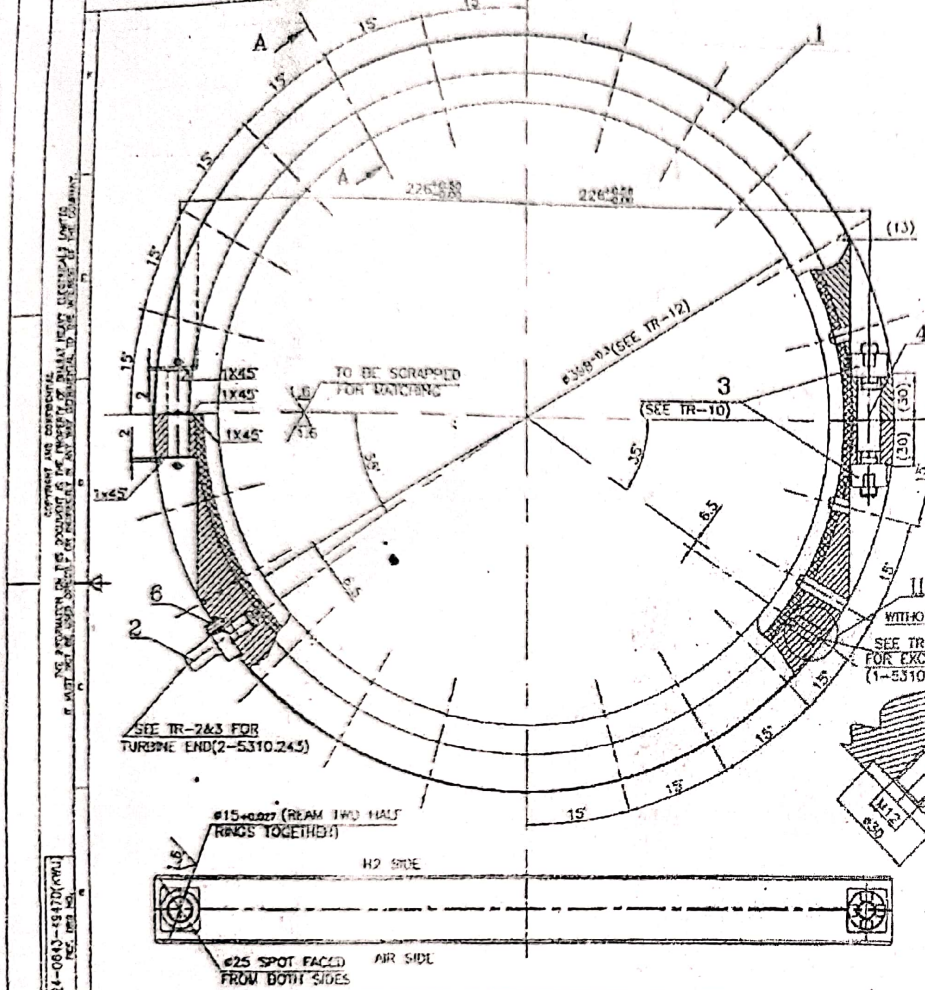
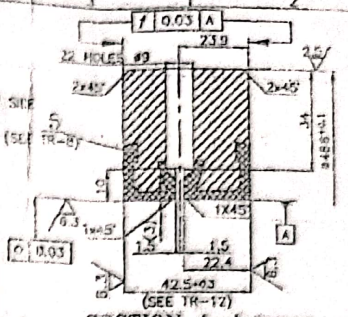
FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)





IMPROTANT CHECK Q.C
BORE OF SEAL RING TO BE MACHINED TO ACHIEVE A CLEARANCE OF 0.26 MAX ON THE MEASURED FINISH MACHINED SHAFT DIA.

TECHNICAL REQUIRMENTS

1. PUNCH MARKS AIR SIDE AND H2 SIDE MUST BE ENSURED BEFORE MACHINING.
2. STOPPER ITEM 2 IS TO BE SCREWED & TIGHTENED IN POSITION (TIGHTENING TORQUE 55–60Nm) THEN DRILL Ø4X2 DEEP FOR GRUB SCREW ITEM 6. LOCK ITEM 6 BY PRICK PUNCH.
3. STOPPER ITEM NO.2 OF T.E. RING IS ON THE LEFT VIEWED FROM THE AIR SIDE. STOPPER NO.2 OF E.E. RING IS ON THE RIGHT VIEWED FROM THE AIR SIDE.
4. ROUND OFF ALL SHARP EDGES TO RO.5.
5. NATURAL STRESS RELIEVING FOR 15 DAYS SHOULD BE DONE BEFORE BABBITING.
6. ONLY MINOR TEMPERATURE RISE IS ALLOWED DURING MACHINING BECAUSE OF DISTORTION HAZARDS.
7. ITEM NO.7 SHOULD NOT PROJECT OUT SIDE THE SURFACE OF SEAL RING.
8. PROTECT THE BABBITED SURFACE FROM DAMAGE AFTER MACHINING.
9. AFTER BABBITING, WHITE METAL BONDING IS TO BE TESTED AS PER HW0850195.
10. DIMENSIONS WITHIN BRACKETS ARE FOR REFERENCE ONLY.
11. TIGHTENING TORQUE OF 65 Nm MAY BE TAKEN AS REFERENCE VALUE WHILE ASSEMBLING THE SEAL RING HALVES.
12. SEALING RING TO BE DESPATCHED TO SITE WITH THESE DIMENSIONS. BORE AND END FACES TO BE FURTHER MACHINED AT SITE FOR FINAL DIMENSIONS. REFER SEAL RING MACHINING DRG. NO 0-5310.243.
13. ITEM NO.7 IS TO BE SENT LOOSE TO SITE. 4 HOLES AS PER DETAIL-I ARE TO BE DRILLED AT SITE AFTER FINAL MACHINING.

MAIN DRAWING NUMBER.	LOCATION.	DRG. NO OF ITEM NO 01
21540101001(VAR 00)	EXCITER END	5310.244
21540101001(VAR 01)	TURBINE END	5310.244

DRGN NO. 21540101001 | TYPE OF PRODUCT OR NAME OF CUSTOMER/ PROJECT: THW-210-2A

BHARAT HEAVY ELECTRICALS LTD. HARDWAR

	NAME	SIGN	DATE
DRN	RK	SD/-	
CHD	RCB	SD/-	
APD	P BALA	SD/-	

DEPT. TGE | SCALE 1:2 | WEIGHT(Kg.) 19.00

CODE 4133

TITLE: SEAL RING (MACHINING)(SPARE)

DRAWING NO. 21540101001

Assistant Executive Engineer
Electrical / Gen.Mtc / S.Din - V
Electrical Maintenance - I
NCTPS - I, Chennai - 120.

Assistant Engineer
Electrical / Gen.Mtc / S.Din - V
Electrical Maintenance - I
NCTPS - I, Chennai - 120

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