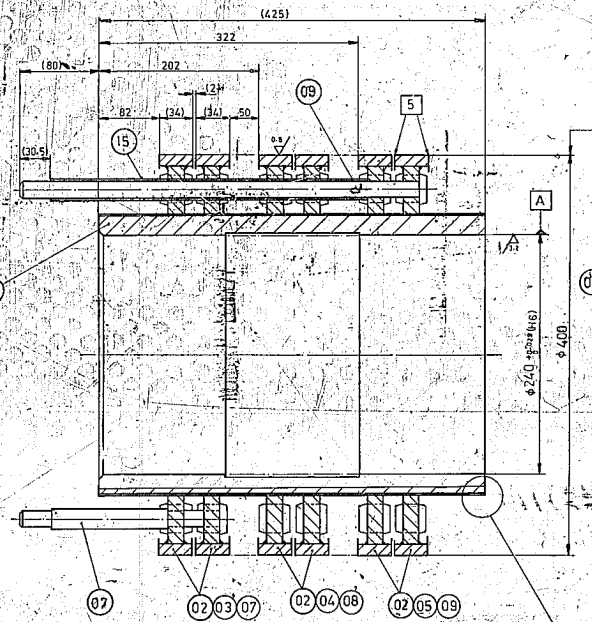
DRG NO 1402844 0024

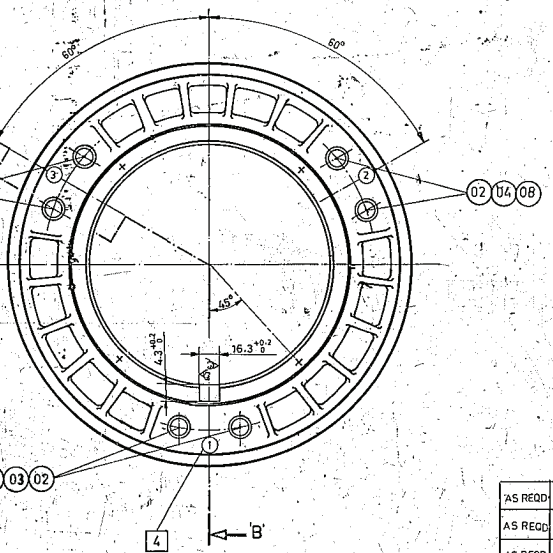
(ALL DIMENSIONS ARE IN mm)

STYLE LIST	
VAR	STYLE NO
00	BP908031900

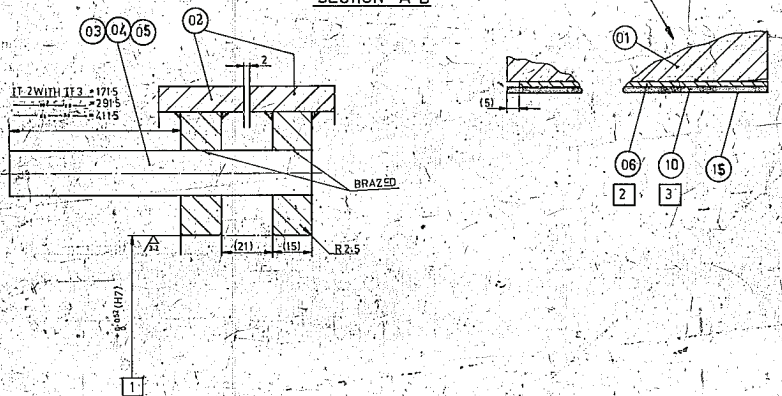
TOOL LIST		
ITEM	TOOL	DESCRIPTION
	1516851	END MILL φ17 x 115 LG
	1516778	FIXTURE FOR ASSY. OF SLIPRING WITH INSUL. CYLENDER



SECTION A-B



VIEW-NDE



TECHNICAL REQUIREMENTS :—

1. RING INNER DIAMETER = ACTUAL φ ITEM 1 + 2 x ACTUAL TK OF ITEM 6 + 2 x ACTUAL THICKNESS OF ITEM 10 − SHRINK DIMENSION OF 0.5 mm
   NOMINAL VOLTAGE — 2500 V
   * TEST VOLTAGE — 8500 V AC FOR 1 MIN.)
   CURRENT MAXIMUM — 1400 A)
   # ON EACH STUD WITH OTHER STUDS & HUB CONNECTED TO EARTH
2. ITEM 6 INNER φ 282 ROLLED, BUTT JOINT 2 mm OPEN, JOINT EDGES DEBURRED
3. JOINT OF ITEM 1 ARE STAGGERED AGAINST EACH OTHER BY APPROX 90°
4. HERE RADIALLY ABOVE THE BOLT NUMBER OF THE CORRESPONDING SLIPRING IS STAMPED.
5. EDGES ROUNDED AND SLITS IN SLIPRINGS DEBURRED
6. FOR BRAZING REF TEX/393123
7. IR (1 MIN.) BEFORE & AFTER HV TEST = MIN 50 Mega-ohm.
8. REFER QA PLAN BHEL QA/MT/MOTORS STD 318 FOR TECHNICAL & INSPECTION REQUIREMENTS

GES. NO 464828549

VAR DO	REMARKS	WAR NO.	ITEM NO	DESCRIPTION	STD	DRAWING NO.	QTY	MATL CODE	MATL SPECN.	UNIT WT.	QTY
AS REQD			17	INSULATING VARNISH					ISL 897		
AS REQD			16	EPOXY RESIN					EG 882		
AS REQD			15	PUTTY					KITT 888.4		
01			14	INSULATION 0·4					HGW 692·1		
03			13	INSULATION 0·48X900					BP 25296		
AS REQD			12	INSULATION 0·09X30					AA 25611		
AS REQD			11	INSULATION 0·09X50					AA 25611		
01	MADE OF IT 11 & 14		10	INSULATION BUTT JOINT OFFSET		WIV 150					
02	USE OFF CUT OF IT 7		09	INSULATION SLEEVE 381 LG.		4402844 6002	01	BP 9063026471			
02	"		08	INSULATION SLEEVE 261 LG.		4402844 6002	01	BP 9063026471			
02	CUT TO LG.		07	INSULATION SLEEVE 141 LG.		4402844 6002	01	BP 9063026471			
01	SEE NOTE 2		06	STEEL COVERING 2 TK 420 X 890		"		AA 1011715112 AA 30115		5·8	
02			05	SLIPRING STUD φ18 X 463				AA 12026		0·95	
02			04	SLIPRING STUD φ18 X 343				AA 12026		0·71	
02			03	SLIPRING STUD φ18 X 223				AA 12026		0·47	
06			02	SLIPRING ASSY.		2402844 0013	00			9·00	
01			01	SLIPRING HUB		3402844 0036	00			46·00	

CARD TYPE 3 — CARD TYPE 1 — CARD TYPE 2

	ISE	TEX(PLM)	HRP
NAME			
SIGN			
DATE			

ADDITIONAL INFORMATION
W 0·42047 A422-11
STATUS OF DRAWING
DISTRIBUTION OF PRINTS
OC-1 CIM-4
PLM-2
TCX(PLM)-1

TYPE OF PRODUCT 1LS 7302-8
OR
NAME OF CUSTOMER/PROJECT TCL MITHAPUR

BHARAT HEAVY ELECTRICALS LIMITED
BHOPAL

REV	DATE	ALT	ALTERED / CHECKED
03	19/10/05	CHD	TR. 1 UPDATED TR. 7 & 8 ADDED
02	28/6/2000	CHD	ITS. 5, 6, 8, 11, 17 & 15 MATL. SPECN. UPDATED. ITS. 7, 9, 10, 12, 13, 14 & 16 DO ST. NO. UPDATED AND ITS. 8 UPDATED. SLIPRING IN SIDE VIEW KEYWAY (100) NOT SHOWN
01	24/7/98		STYLE LIST ADDED

	NAME	SIGN & DATE
DSN	D. Samuel	
CHK	AKB	
APPD	SG	

REV NO	DATE
03	19/10/05

DEPT. AME
CODE 005
CANCELLATION NO. DATE
SCALE 1 : 1
WEIGHT (Kg) 110·00
REF. TO ASSY. DRG.
ITEM NO.
NO OF ITEMS

TITLE
SLIPRING ASSY. (M/C)

CARD CODE 1402844 0024
DRAWING NO. 1402844 0024 03
SHEET NO 01 OF 01 SHEETS

SIZE-A1

ACC NO 30.0186
INVENTORY NO. 1206 160-259987
SIGN. & DATE
REF. DRG. NO.

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