

20020-90911-2
DRAWING NO.

B.CONTINUED FROM SHEET NO.1.

TECHNICAL REQUIREMENTS: -

1.0 MATERIAL:

1.1 PROPERTIES:

ITEM	MAT GRADE IS: 1570, PT II	HEAT TREATMENT	AFTER HEAT TREATMENT					
			Y.S. N/MM ²	UTS N/MM ²	HARDNESS BHN	IMPACT J (ISO-V NOTCH)	% AREA RED.	%ELONG.
HUB	55C8 (C55MN75)	HARDENED & TEMPERED	≥432	690-830	200-250	≥22	≥32	≥12
CASING	55C8 (C55MN75)	NORMALISED	≥380	680-830	200-250	≥22	≥35	≥12

- 1.2 HEAT NO. OF SHALL BE MAINTAINED FROM FORGING STAGE TILL FINAL STAGE TO AVOID MIX UP OF MATERIAL.
 1.3 FOR MECHANICAL TESTING OF FORGING, SAMPLES SHALL BE DRAWN RANDOMLY FROM EACH HEAT & HEAT TREATMENT BATCH. FOR THIS PROPOSE REQUIRED EXTRA FORGING SHALL BE PROCESSED BY THE VENDOR.

2.0 NDT:

- 2.1 ULTRASONIC TESTING SHALL BE CARRIED OUT AFTER HEAT TREATMENT. ACCEPTANCE NORMS SHALL BE AS PER AA0850118 CATEGORY II.
 2.2 DPT SHALL BE CARRIED OUT ON FINISH MACHINED HUB & CASINGS. NO LINEAR INDICATION IS PERMITTED.

3.0 SURFACE FINISH:

- BORE RA VALUE 0.8
 TEETH RA VALUE 1.6

4.0 DYNAMIC BALANCING: DYNAMIC BALANCING OF CASING & HUB SHALL BE CARRIED OUT AS PER ISO 1940 GRADE 2.5.

5.0 FASTENERS: FASTNERS USED IN GEAR COUPLING SHALL BE OF PROPERTY CLASS 8.8. THE COUPLING BOLTS SHALL BE CHECKED FOR SURFACE CRACK EXAMINATION BY DPT.

6.0 IDENTIFICATION: a) DRG.NO., b) P.O.NO., c) YEAR OF MANUFACTURE, d) NAME/TRADEMARK OF MANUFACTURER

7.0 TEST CERTIFICATES: THE MANUFACTURING AND TESTING SHALL BE DONE AS PER APPROVED QP. THE FOLLOWING TEST CERTIFICATES SHALL BE FURNISHED ALONGWITH SUPPLY.
 a) MATERIAL TEST CERTIFICATE OF FORGINGS INCLUDING CHEMICAL AND MECHANICAL.
 b) BALANCING REPORT
 c) NDT REPORT (UT, DPT)
 d) DIM. REPORT

8.0 CONSERVATION: ALL SURFACE OF THE GEAR COUPLING ARE TO BE CLEANED BEFORE APPLYING ANTICORROSIVE OIL/GREASE.

9.0 PACKAGING: THE GEAR COUPLING SHALL BE SUITABLY PACKED TO AVOID DAMAGE DURING TRANSPORT & HANDLING.

NOTE:

1. BHEL MATERIAL CODE W90311605010
 2. SIEMENS TIN NO. A58D83J52

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Inventory No. Sign & Date Ref. Drawing No.

REV	DATE	ALTERED CHECKED	REV	DATE	ALTERED CHECKED	REV	DATE	ALTERED CHECKED	REV	DATE	ALTERED CHECKED	REV	DATE	ALTERED CHECKED	REV	DATE	ALTERED CHECKED
05	30.01.14								04	18.07.03							

GRADE OF UNTOL.DIM				GMS No./ CBOM No.		STATUS OF DRG	
M/CG.-Ø/M/Ø AA0230208				01160501000(00)		APPROVED	
WELDING-Ø/B/Ø/Ø AA0621104				DEPT		NAME	
GAS CUTTING-'T3'AA0621101				SIGN		DATE	
NO CHANGE IN SHEET NO.2 AS PER CHANGE ADVICE NO. STE-14-F0036				NEW SHEET 02 HAS BEEN ADDED & DEPOSITED ON WRENCH SERVER C/A. NO. STE-03-F1093			

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT				STEAM TURBINE							
BHARAT HEAVY ELECTRICALS LTD. RANIPUR, HARDWAR				NAME		SIGN		DATE		NO. OF VAR	
DEPT STE				SCALE NTS		WEIGHT (KG)		REF. TO ASSY. DRG.		ITEM NO. OF SHEETS	
CODE 4011				12.50		12.50		0-11605-02000		011 22,23,24	
TITLE : GEAR COUPLING				DRAWING NO. 2-11605-02002		SHEET No. 02		No. OF SHEETS 02		SIZE A2	