

**IMPORTANT NOTE:-**  
8 HOLES M10 SHOWN IN SECTION B-B TO BE DRILLED IN NDE END STAND OF STATOR FRAME BEFORE WELDING SLIPRING HOUSING ITEM 02 TO STATOR FRAME.

- TECHNICAL REQUIREMENTS :-**
1. STATOR FRAME AND SLIP RING HOUSING MUST BE PLACED CONCENTRICALLY AND THEN WELDED.
  2. TO BE LEFT AS PER TOOL RUN OUT.
  3. LOCATION OF KEY IN THE MIDDLE OF RIBS SHALL BE PUNCH MARKED AT NDE.
  4. THIS REGION BETWEEN RINGS TO BE FREE FROM PAINT.
  5. IN BOTTOM WRAPPER PLATE (SEE SECTION-EE) A BAND OF 30 mm. WIDTH AROUND THE CUTOUT TO BE FREE FROM PAINT.
  6. KEY ITEM 03 TO BE ALIGNED BETWEEN THE RIBS AND WELDED AT NDE END AS SHOWN.
  7. STATOR FRAME TO BE PAINTED AS PER BP 0674177.
  8. FOR UNSPECIFIED TOLERANCES REF. DRG. 3403 0040011.
  9. DIMENSION MARKED WITH \* ARE CRUCIAL DIMENSION FOR THIS REF. PRODUCT STD. AM. 54168.

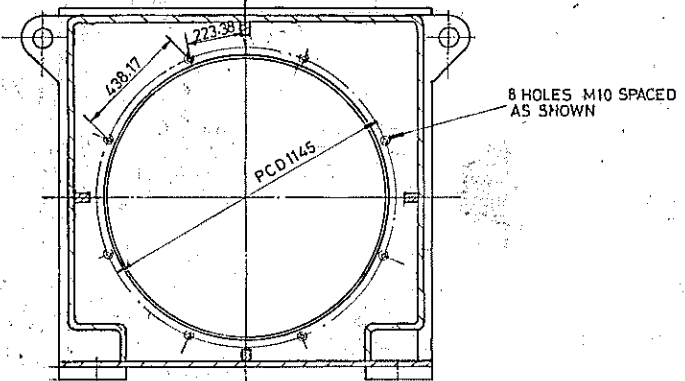
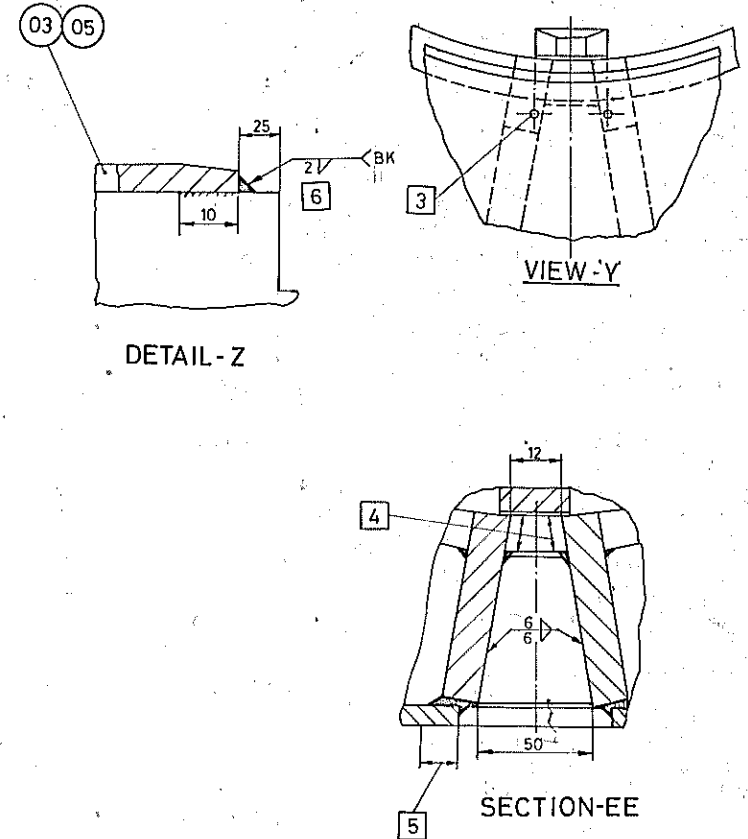
**TOOL LIST**

IT.	TOOL	DESCRIPTION
	1516503	DRILL PLATE TO LOCATE ON 1125

**WEIGHT (KG)**

VAR	FAB:	M/C
00	3795	3715
01	3495	3425
02	3795	3715

GES NO. 404836597 FOR VAR 00  
 GES NO. 404836598 FOR VAR 01  
 GES NO. 404866518 VAR. 02



VAR	ITEM NO.	DESCRIPTION	DRAWING NO.	MATL. CODE	UNIT WT.	QTY.	ZONE
01	-	STATOR FRAME WELDING	04027140121	00	-	3050	
-	01	KEY 900 LG.		900302749			
-	01	STATOR FRAME WELDING	04027140073	00		2750.00	
01	-	KEY 1120 LG.		900302749			
01	01	SLIPRING HOUSING WELDING	14027140193	00		740.00	
-	-	STATOR FRAME WELDING	04027140074	00		3050.00	

**ADDITIONAL INFORMATION**  
 WO 43080-A-422-31821  
 STATUS OF DRAWING

**DISTRIBUTION OF PRINTS**  
 OC - 1 FBM - 4  
 PLM - 4  
 TCX (PLM) - 1

**TYPE OF PRODUCT** 1 RB 7718 / 1 RB 7714  
**NAME OF CUSTOMER / PROJECT** M/S HIMACHAL AMBUJA

**BHARAT HEAVY ELECTRICALS LTD.**  
 Bhopal

**DRN. NAME** L. DATEL  
**CHD.** P.K.S.  
**APPD.** S.B.K.
**DATE** 24/9/93  
**NO. OF VAR.** 24/9/93

**SCALE** N.T.S.  
**WEIGHT (KG)** SEE TABLE  
**REF. TO ASSY. DRG.**

**TITLE** COMBINED STATOR FRAME WELDING & MACHINING

**DRAWING NO.** 14027140194  
**SHEET NO. OF SHEETS** 01

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