

ANNEXURE TO PI 240132006

1. Bearing shell is to Re-Babbitted as per DRG. 0-11818-18010 Rev. 03.
2. Babbiting of bearing to be done by centrifugal process with virgin white metal Confirming to BHEL spec. HW12897 / ORGO V – 738.
3. Final bore size shall be furnished on placement of order.
4. Ultrasonic testing as per HW 0850195, DP test on surface and joint as per BHEL. Spec. HW 0850195 to ensure surface, free pin holes, inclusions and cracks if any.
5. Quality plan shall be furnished for approval before start of manufacturing of bearing. Material TC, NDT test report & inspection test report shall be furnished before dispatch of bearing.
6. Prior approval on any kind of deviation shall be obtained.
7. Inspection call shall be given well in advance notice of 7 days.



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