

ALL DIMENSIONS ARE IN mm.

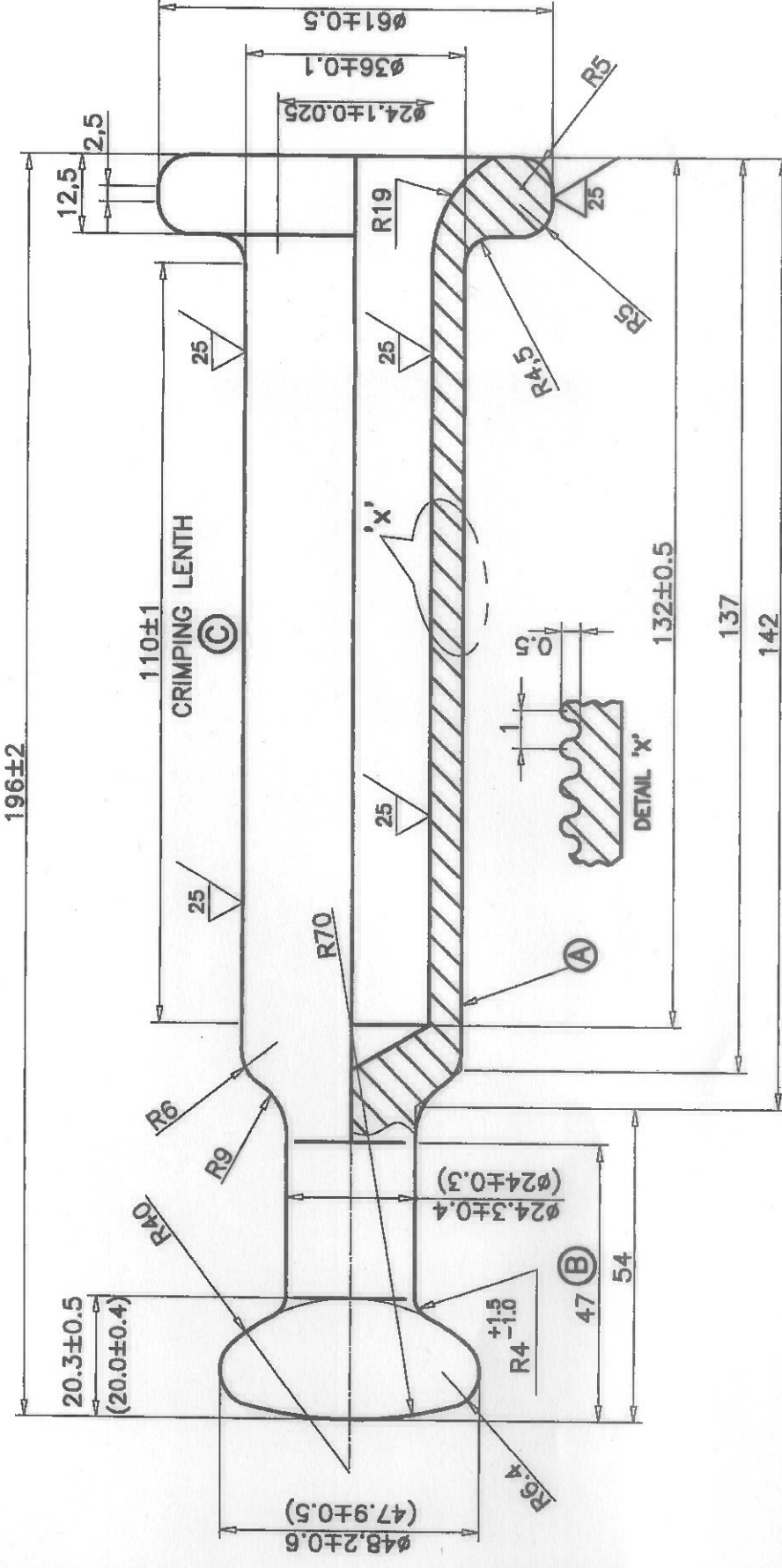
DRG No.	3 987 18 30422 01	REV
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REF. DRG. No.

SIGN AND DATE

INVENTORY NO.



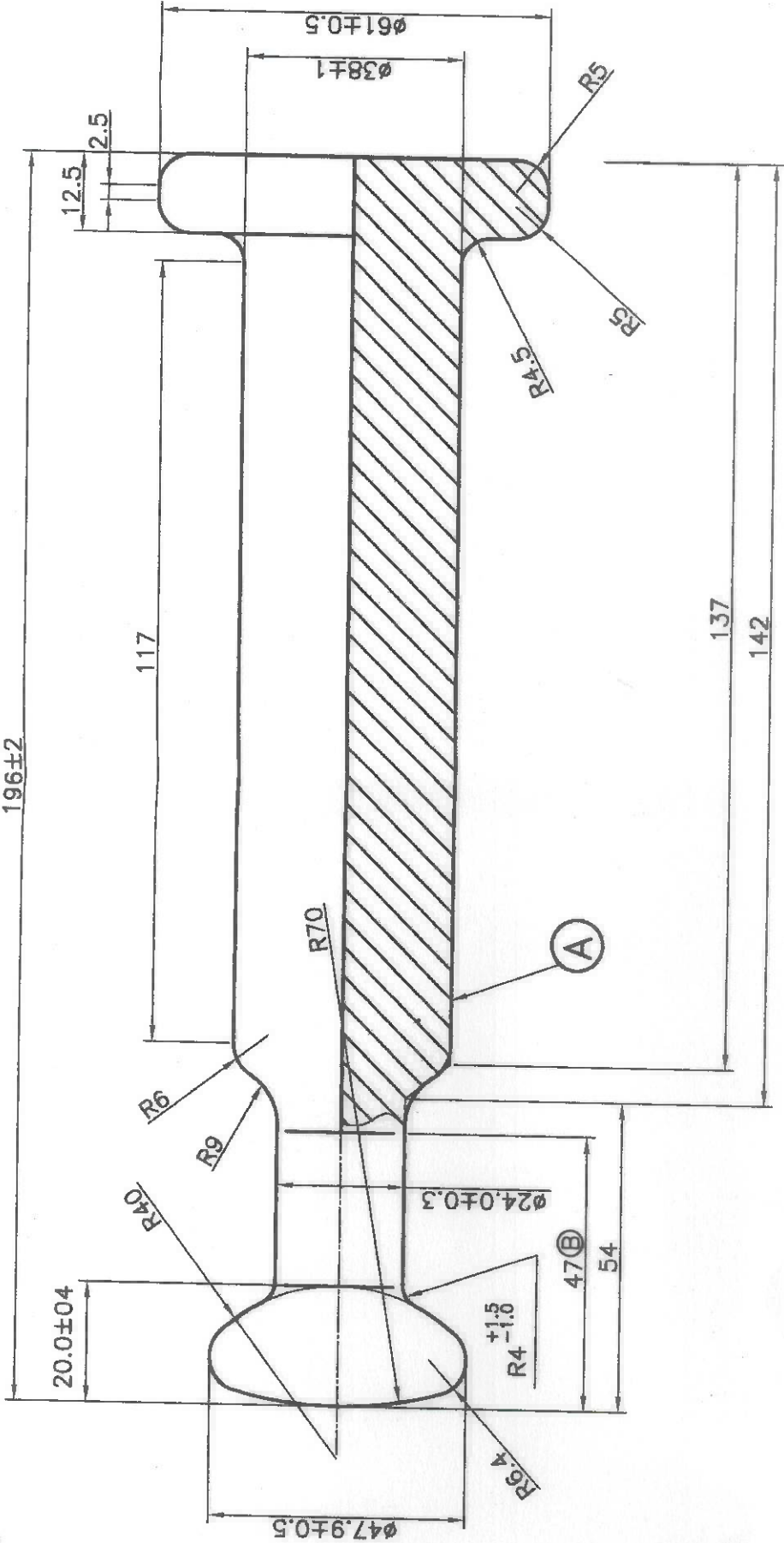
NOTES:

- 1 ALL DIMENSIONS ARE AFTER HOT-DIP GALVANISING.
A THICKNESS OF 0.15 mm MAY BE ASSUMED FOR GALVANISING.
- 2 DIMENSIONS INDICATED IN BRACKETS REFER TO BEFORE GALVANISING STAGE
- 3 BALL FITTINGS ARE TO BE MADE BY FORGING PROCESS ONLY
- 4 MATERIAL TO CONFORM TO GRADE 080M40 OF BS EN:10083-1:1991 (EN-8)
- 5 IF THE FORGED SURFACE IS NOT SMOOTH AT THE PORTION (B) & (C) BALL FITTINGS ARE TO BE MACHINED AT THAT PLACE WITH THE HELP OF A 'FORM TOOL' TO GET A SMOOTH SURFACE.
- 6 AFTER GALVANIZING THE BALL PORTION SHOULD ANSWER TO ALL THE RELEVANT "GO AND NO GO" GAUGES RECOMMENDED BY IEC Pub.60120 OR LATEST (24 mm DESIGNATION) UP TO PORTION (B)
- 7 SUPPLIER'S IDENTIFICATION MARK & RATING SHALL BE PROVIDED IN DEPRESSED FORM IN 6 mm LETTER SIZE AT PLACE SHOWN AS (A)
- 8 SEQUENCE OF OPERATIONS :
 - A) BALL FITTINGS ARE NORMALISED AFTER FORGING
 - B) MACHINING (IF NECESSARY - SEE NOTE No.5)
 - C) SHOT BLASTING.
 - D) GALVANISING.
 - E) BORING.
- 9 BEFORE GALVANISING THE BALL PORTION SHOULD ANSWER TO "GO AND NO GO" GAUGES TO DRG. No. 4 SK 1201 LATEST REVISION, 4 SK 1202 LATEST REVISION AND CLAUSES B7,B8 & B9 OF IEC Pub.60120 (24 mm DESIGNATION) UPTO PORTION (B)
- 10 BALL FITTING SHALL WITHSTAND A MINIMUM TENSILE STRENGTH OF 252 kN
- 11 MPI TEST TO BE CARRIED OUT ON ALL FORGED FITTINGS
- 12 BORE HAS TO BE DONE ONLY AFTER GALVANISING
- 13 DIM $\phi 24.1 \pm 0.025$ TO BE CHECKED BY "GO & NO GO" GAUGES. 4SK 2330
- 14 DIM 110 TO BE CHECKED BY "GO" "NOGO" GAUGES OF DRG NO 4 SK 2844
- 15 THE WEIGHT OF FORGED BALL FITTING AT BLACK STAGE IS 1.65 kg.(APPROX)

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FERROUS PARTS ARE HOT-DIP GALVANIZED (EXCEPT FEMALE THREADS) AS PER IS:2629 AND TESTS CONFORM TO IS:2633										BHARAT HEAVY ELECTRICALS LTD; ELECTROPORCELAINS DIVISION BANGALORE 560 012										NAME SUDHARSHAN.G SIGN <i>[Signature]</i> DATE 01.03.18																			
DRN CHD APPD										B P D S S P										REF TO ASSY.DRG																			
DEPT CODE										GRADE OF TOL DIM C/M/F										SCALE N T S										WEIGHT (kg) 1.13									
ITEM No.										ITEM No. OF ITEMS										REV. 01																			
TITLE										DRAWING No. 3 987 18 30422										CARD CODE																			
1) DRAWING REDRAWN & REVISED										2) IN NOTE No.8 SHOT BLASTING ADDED										BALL FITTING FOR 210kN COMPOSITE LONG ROD INSULATOR																			

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30432		18 786 3



NOTES :

- 1 BALL FITTINGS ARE TO BE MADE BY FORGING PROCESS ONLY
- 2 MATERIAL TO CONFORM TO PURCHASING SPEC. EL:PS:3600103
- 3 SUPPLIER'S IDENTIFICATION MARK & RATING SHALL BE PROVIDED IN DEPRESSED FORM IN 6 mm LETTER SIZE AT PLACE SHOWN AS **(A)**
- 4 SEQUENCE OF OPERATIONS :
A) BALL FITTINGS ARE NORMALISED AFTER FORGING
- 5 BEFORE GALVANISING THE BALL PORTION SHOULD ANSWER TO "GO AND NO GO" GAUGES TO DRG. No. 4 SK 1201 LATEST REVISION,
4 SK 1202 LATEST REVISION AND CLAUSES B7,B8 & B9 OF IEC Pub.60120 (24 mm DESIGNATION) UPTO PORTION **(B)**
- 6 BALL FITTING SHALL WITHSTAND A MINIMUM TENSILE STRENGTH OF 252 kN
- 7 MPI TEST TO BE CARRIED OUT ON ALL FORGED FITTINGS

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SIGN AND DATE

INVENTORY No.

REV	DATE	ALTERED	CHECKED

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FERROUS PARTS ARE HOT-DIP GALVANIZED (EXCEPT FEMALE THREADS) AS PER IS:2629 AND TESTS CONFORM TO IS:2633



BHARAT HEAVY ELECTRICALS LTD.
ELECTROPORCELAINS DIVISION
BANGALORE 560 012

DEPT	GRADE OF TOL DIM C/M/F	SCALE	WEIGHT (kg)

DEPT	GRADE OF TOL DIM C/M/F	SCALE	WEIGHT (kg)

DEPT	GRADE OF TOL DIM C/M/F	SCALE	WEIGHT (kg)

NAME	SIGN	DATE
C.MADIAH	25/9/2012	3/3/12

NAME	SIGN	DATE
S S P	27/1/12	3/3/12

NAME	SIGN	DATE
S S P	27/1/12	3/3/12

REF TO ASSY.DRG	ITEM No.	No. OF ITEMS

DRAWING No.	REV.
3 987 18 30432	00

TITLE
BALL FITTING FOR 210kN COMPOSITE LONG ROD INSULATOR

DRAWING No.	REV.
3 987 18 30432	00