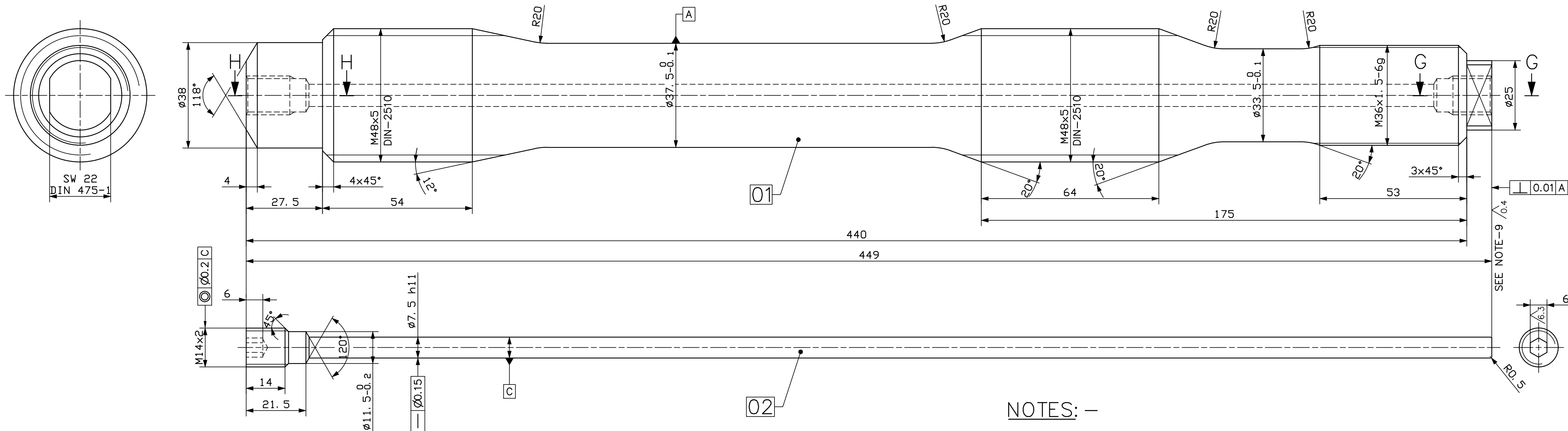


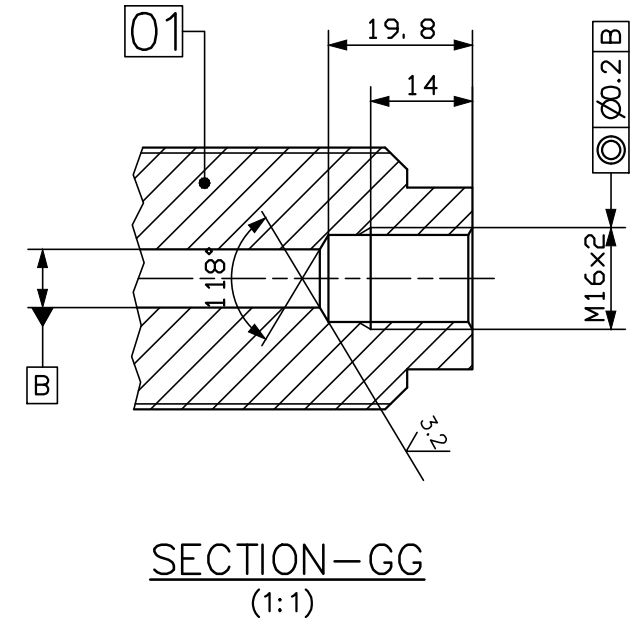
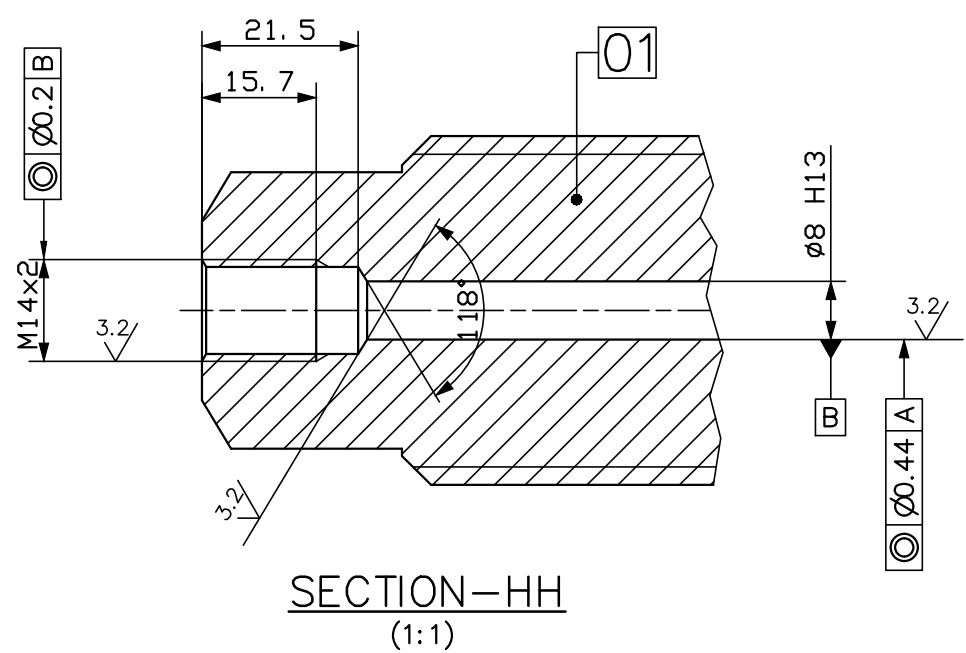
ALL DIMENSIONS ARE IN MILLIMETERS



ITEM NO.	DESCRIPTION	SPECN.
01	STUD	20NiCrMo14.5 II
02	MEASURING PIN	24CrMo5

NOTES: –

1. APPLICABLE SPECIFICATIONS:
PC-M-965
PC-P-979
2. UNLESS OTHERWISE SPECIFIED SURFACE FINISH SHALL BE $\sqrt{3.2}$ OR FINER.
3. THE STUD SHALL BE SUPPLIED IN FINISH MACHINED CONDITION AS SHOWN.
4. ~~THE COMPONENT SHALL BE FORGED AS CLOSE TO THE FINISHED SHAPE-
AS POSSIBLE.~~
5. THE BAR SHALL BE SUBJECTED TO M.T. AS PER PC-P-979
6. THE BAR SHALL BE SUBJECTED TO U.T. AS PER PC-M-965
7. THE THREADS SHALL BE SUITABLY COATED WITH EASILY REMOVABLE RUST PREVENTIVE COATING TO ENSURE SEA-WORTHINESS. THE FASTENERS SHALL BE TROPICAL PACKING TO PREVENT THE THREADED SURFACES FROM COMING IN CONTACT WITH ANY FOREIGN OBJECTS DURING TRANSPORTATION AND HANDLING.
8. THE THREADS SHALL BE SUBJECTED TO P.T. AS PER PC-P-979
9. ITEM NO.01 (STUD) AND ITEM NO.02 (MEASURING PIN) TO BE SURFACE GROUND AFTER ASSEMBLING.
10. THE THREADINGS OTHERWISE SPECIFIED SHALL BE AS PER DIN-13
11. THE THREAD END SHALL BE AS PER DIN 78-K
12. THE RUNOUT SHALL BE AS PER DIN 76 PART-1



TOLERANCE DIMENSIONS	ALLOWANCE	
	OVER	UNDER
ø8 H13	0.22	0
ø7.5 h11	0	0.09

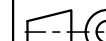
TOLERANCE IF NOT SPECIFIED SHALL BE AS BELOW (REFER IS 2102-m)

LINEAR				ANGULAR	
0.5 TO 3	± 0.1	400 TO 1000	± 0.8	0 TO 10	± 1°
3 TO 6	± 0.1	1000 TO 2000	± 1.2	10 TO 50	± 30'
6 TO 30	± 0.2	2000 TO 4000	± 2.0	50 TO 120	± 20"
30 TO 120	± 0.3	—	—	120 TO 400	± 10'
120 TO 400	± 0.5	—	—	OVER 400	± 5"

REV 01	DATE 081018	ALTERED : <i>[Signature]</i>
		CHD&APPD : <i>[Signature]</i>
NOTE-4 DELETED		

CAUTION: The information on this document is the property of BHARAT HEAVY ELECTRICALS LTD. It must not be used directly or indirectly in any way detrimental to the interest of the company.

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT	700MWe/GHAVP-1&2
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 05-228/JD		Bharat Heavy Electricals Ltd UNIT: HIGH PRESSURE BOILER PLANT TIRUCHIRAPALLI - 620014		NAME N.K.	SIGNATURE 	DATE 120814	NO. OF VAR		
				DRN	MAK/RRV	140814			
				CHD	A.S.	160814			
				APPD					
CPT NC DE 150		GRADE OF UNTOL DIM C/M/F		SCALE 1:1	WEIGHT (Kg) 4.400	REF TO ASSY / OLD DWG GHAVP-1&2/33111/4031/DD/ROO		ITEM NO	NO OF ITEMS
TITLE STUD ASSY. FOR MANHOLE COVER						CARD CODE U 01	DRAWING NO : 2-93-170-05242		REV 01