

DRAWING NO: 2-93-170-05243

ALL DIMENSIONS ARE IN MILLIMETERS

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

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

TOLERANCE DIMENSIONS	ALLOWANCE	
	OVER	UNDER
Ø4 h11	0	0.075
Ø4.5 H13	0.18	0

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

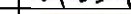
LINEAR				ANGULAR			
0.5 TO 3	± 0.1	400 TO 1000	± 0.8	0 TO 10	± 1°		
3 TO 6	± 0.1	1000 TO 2000	± 1.2	10 TO 50	± 30'		
6 TO 30	± 0.2	2000 TO 4000	± 2.0	50 TO 120	± 20'		
30 TO 120	± 0.3	-	-	120 TO 400	± 10'		
120 TO 400	± 0.5	-	-	OVER 400	± 5'		

REV	DATE	ALTERED
01	081018	CHD&APPD :

NOTE-4 DELETED

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TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT 700MWe/GHAVP-1&2

 05-228/D		Bharat Heavy Electricals Ltd		DRN	N.K.	SIGNATURE 	DATE 140814	NO. OF VAR	
		UNIT: HIGH PRESSURE BOILER PLANT		CHD	MAK/RRV		160814		
		TIRUCHIRAPALLI - 620014		APPD	A.S		180814		
DEPT NC	GRADE OF UNTOL DIM C/M/F		SCALE 1:1 2:1	WEIGHT (Kg) 0.893	REF TO ASSY / OLD DWG GHAVP-1&2/33111/4032/DD/ROO			ITEM NO	No OF ITEMS
CODE 150									
TITLE				CARD CODE U 01	DRAWING NO : 2-93-170-05243			REV 01	

Size A2