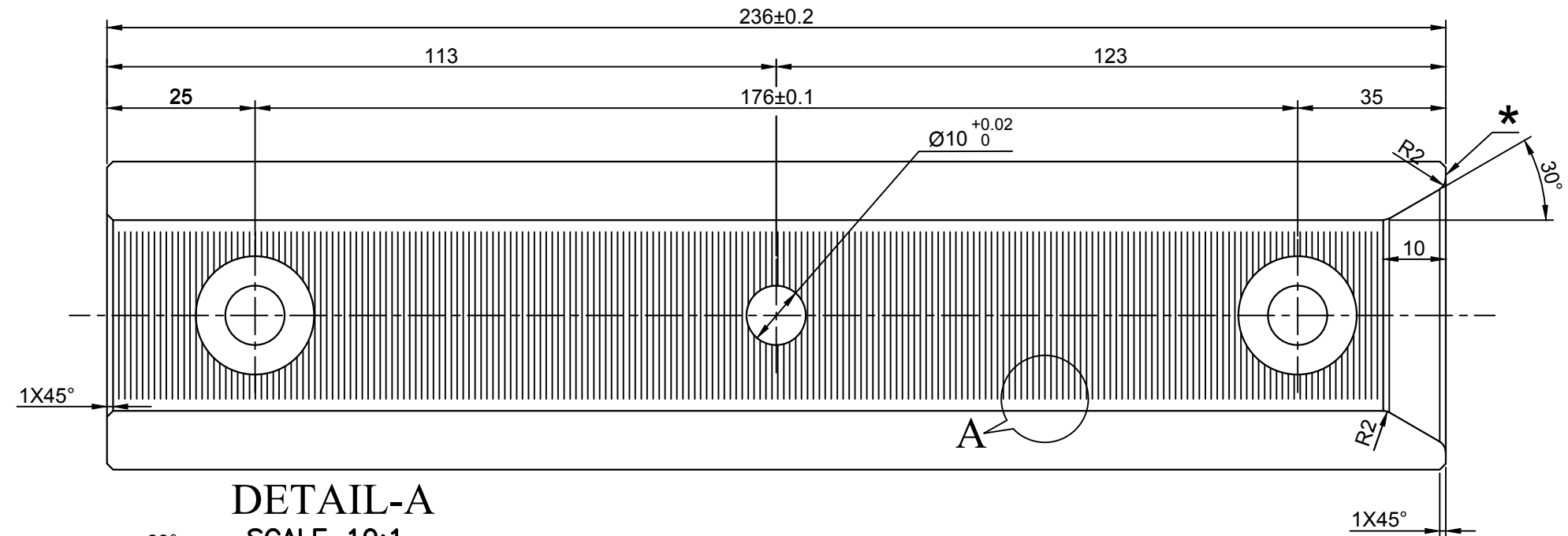
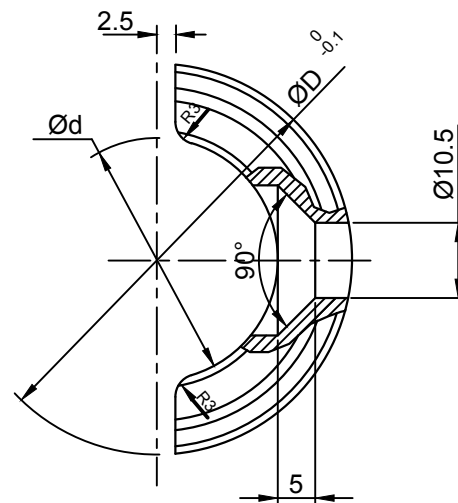
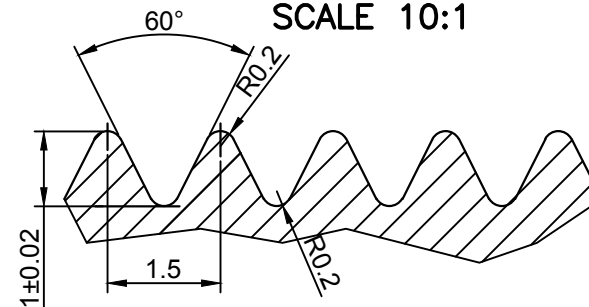


ALL DIMENSIONS ARE IN MILLIMETRES

DEVIATIONS OF UNTOLERANCED
DIMENSIONS TO BE AS PER
IS: 2102-1969 MEDIUM.

1.6/

DRAWING NO: 30-ST-212-01-522

DETAIL-A
SCALE 10:1

SL. No.	JAW SIZE	d	D	MATERIAL CODE No.	Wt/Kg
01	21.3	21.5	42	69 26 12 2130	0.82
02	26.7	26.9	47	69 26 12 2670	0.85
03	31.8	32	52	69 26 12 3180	0.87
04	32	32.2	52	69 26 12 3200	0.9
05	33.4	33.6	54	69 26 12 3340	0.92
06	36	36.2	56	69 26 12 3600	0.95
07	38.1	38.3	58	69 26 12 3810	1.0

ANY ONE OF THE FOLLOWING MATERIAL SHALL BE USED

SL No.	MATERIAL	CHEMICAL COMPOSITION							
		C	Si	Mn	Cr	P	S	Mo	V
01	XT215Cr12 (IS:3748-1990)	2.0	0.10	0.25	11.0	0.035MAX.	0.035MAX.	0.80MAX.	0.080MAX.
		2.3	0.35	0.50	13.0			OPTIONAL	OPTIONAL
02	X210Cr12 (DIN 1.2080)	1.9	0.2	0.2	11.0	0.035MAX.	0.035MAX.	-	-
		2.0	0.4	0.4	12.0				

HARDEN & TEMPER TO 50-55 HRC

REV 01	DATE 04.02.2015	ALTERED CHECKED APPROVED	<i>R. Kumar</i> <i>N. A. Kumar</i>
DIMN.35 WAS 25, DIMN.123 WAS 113 DIMN.236 WAS 226,			

NOTE TO SUPPLIER

- 01) MATERIAL CHEMISTRY-NABL ACCREDITED LAB TEST CERTIFICATE IS TO BE PROVIDED
- 02) HARDNESS & HEAT TREATMENT CERTIFICATE OBTAINED FROM THE HEAT TREATERS IS TO BE PROVIDED
- 03) LIQUID PENETRANT TEST TO BE CONDUCTED ON ENTIRE SURFACE AND SHALL BE CERTIFIED BY NDT LEVEL-2 QUALIFIED PERSONNEL AS PER SNT-TC-1A

* MARK :P O No.& FIRM NAME, AND JAW SIZE WITH 10mm METAL PUNCH

CAUTION: THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT
			MATL SPEC	QTY
EQPT:				
Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME R.KUMAR	SIGNATURE <i>R. Kumar</i>
		CHD	N ARUMUGANAINAR	DATE 17.06.14
		APPD	S KARUPPASAMY	
DEPT SSTP	GRADE OF UNTOL. DIM φ/M/℄	SCALE 1:1	WEIGHT (Kg) SEE IN TABLE	REF TO ASSY DWG NO 30-ST-21-01-520
CODE 456	IS: 2102			REF TO OLD DWG NO PPM 150_T_08_02 TO 14_02
TITLE P P SLEEVE FOR NEW POINTING M/C (DIA 21.30-38.10)			CARD CODE U 01	DRAWING NO : 30-ST-212-01-522
				REV 01

A3-SIZE

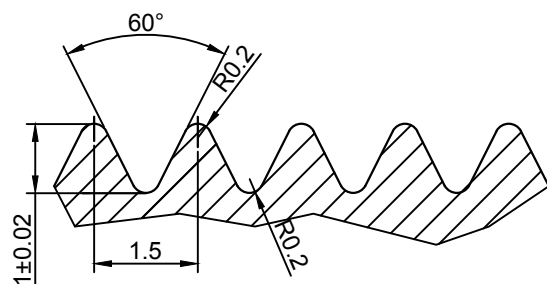
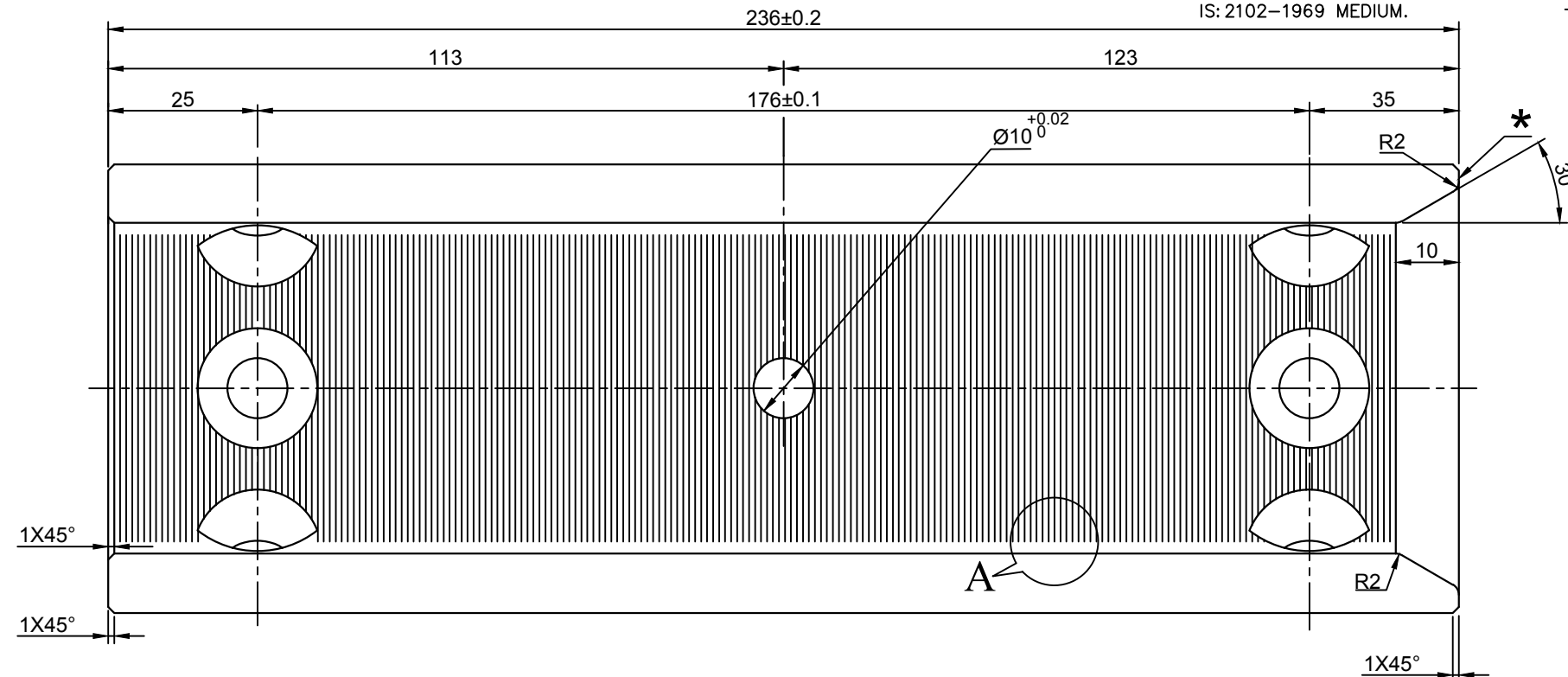
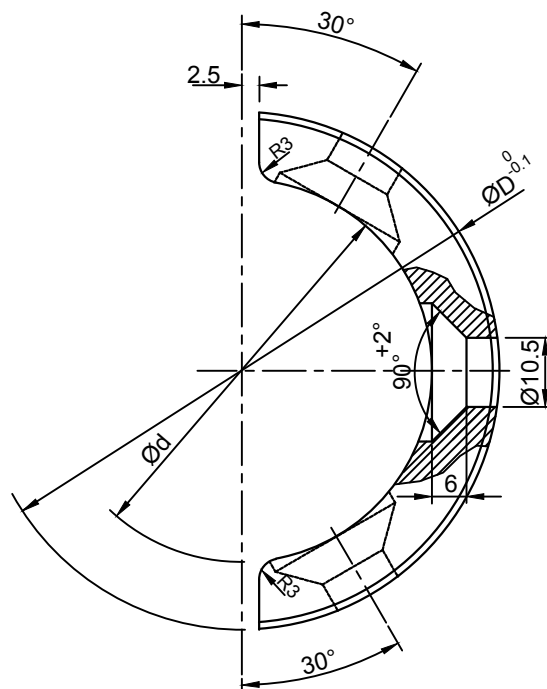
30-ST-212-01-525

DRAWING NO:

ALL DIMENSIONS ARE IN MILLIMETRES

DEVIATIONS OF UNTOLERANCED
DIMENSIONS TO BE AS PER
IS: 2102-1969 MEDIUM.

1.6



DETAIL-A
SCALE 10:1

NOTE TO SUPPLIER

- 01) MATERIAL CHEMISTRY-NABL ACCREDITED LAB TEST CERTIFICATE IS TO BE PROVIDED
- 02) HARDNESS & HEAT TREATMENT CERTIFICATE OBTAINED FROM THE HEAT TREATERS IS TO BE PROVIDED
- 03) LIQUID PENETRANT TEST TO BE CONDUCTED ON ENTIRE SURFACE AND SHALL BE CERTIFIED BY NDT LEVEL-2 QUALIFIED PERSONNEL AS PER SNT-TC-1A

* MARK :P O No.& FIRM NAME, AND JAW SIZE WITH 10mm METAL PUNCH

SL. No.	JAW SIZE	d	D	MATERIAL CODE No.	Wt/Kg
01	42.4	42.8	63	69 26 12 4240	1.25
02	44.5	44.9	65	69 26 12 4450	1.5
03	47.63	48.1	68	69 26 12 4763	1.7
04	48.3	48.7	68	69 26 12 4830	1.85
05	51	51.4	71	69 26 12 5100	2.0
06	54	54.4	74	69 26 12 5400	2.2
07	55	55.4	75	69 26 12 5500	2.5
08	57	57.4	77	69 26 12 5700	2.6
09	60.3	60.7	81	69 26 12 6030	2.8
10	63.5	63.9	84	69 26 12 6350	2.85
11	70	70.4	90	69 26 12 7000	3.0
12	73	73.4	93	69 26 12 7300	3.1
13	76.1	76.5	91	69 26 12 7610	3.2
14	82.5	82.9	95	69 26 12 8250	3.5
15	88.9	89.3	101	69 26 12 8890	3.8

ANY ONE OF THE FOLLOWING MATERIAL SHALL BE USED

SL No.	MATERIAL	CHEMICAL COMPOSITION							
		C	Si	Mn	Cr	P	S	Mo	V
01	XT215Cr12 (IS:3748-1990)	2.0 2.3	0.10 0.35	0.25 0.50	11.0 13.0	0.035MAX.	0.035MAX.	0.80MAX. OPTIONAL	0.080MAX. OPTIONAL
02	X210Cr12 (DIN 1.2080)	1.9 2.0	0.2 0.4	0.2 0.4	11.0 12.0	0.035MAX.	0.035MAX.	-	-

HARDEN & TEMPER TO 50-55 HRC

REV	DATE	ALTERED
01	09.08.13	APPROVED
SL.No. 15 ADDED(Ø88.9)		
02	04.02.2015	APPROVED
DIMN.236 WAS 226, DIMN.123 WAS 113 DIMN.35 WAS 25.		

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ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT
			MATL SPEC	QTY
EQPT:				
Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME R.KUMAR	
DEPT SSTP		CHD	SIGNATURE N. Arumuganainar	
CODE 456		APPD	DATE 17.06.14	
GRADE OF UNTOL. DIM φ/M/£ IS: 2102		SCALE 1:1	WEIGHT (Kg) SEE IN TABLE	
TITLE PP SLEEVE FOR NEW POINTING M/C (DIA 42.40-88.90)		CARD CODE U 01	REF TO ASSY DWG NO 30-ST-212-01-523	
			REF TO OLD DWG NO PPM 150_T_15_02 TO 28_02	
			DRAWING NO : 30-ST-212-01-525	
			ITEM 02	
			REV 02	

A3-SIZE