

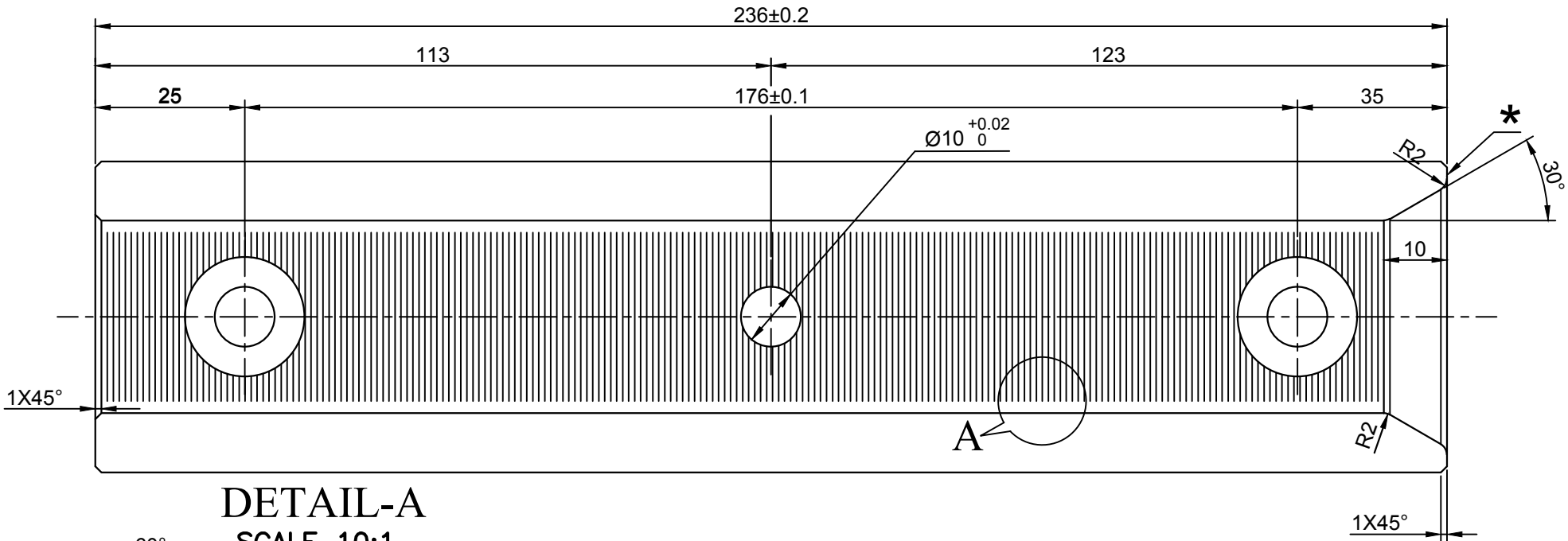
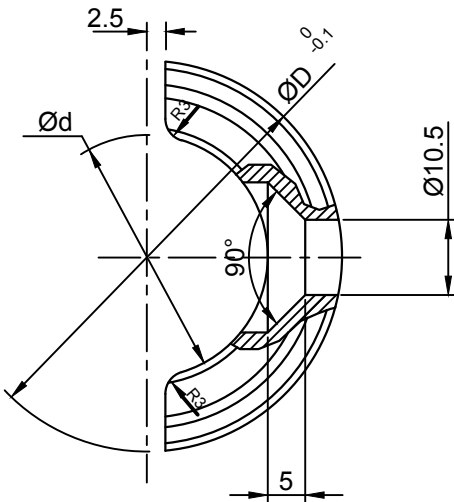
ALL DIMENSIONS ARE IN MILLIMETRES

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

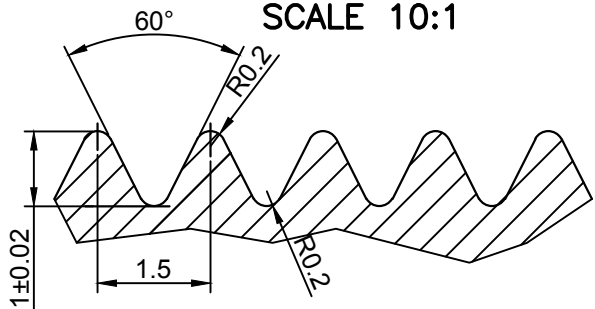
1.6

30-ST-212-01-522

DRAWING NO:



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 	DATE 17.06.14
				CHD	N ARUMUGANAINAR			
				APPD	S KARUPPASAMY			
DEPT SSTP	GRADE OF UNTOL. DIM		SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO 30-ST-21-01-520			ITEM 02
CODE 456	φ/M/℄ IS: 2102		1:1	SEE IN TABLE	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