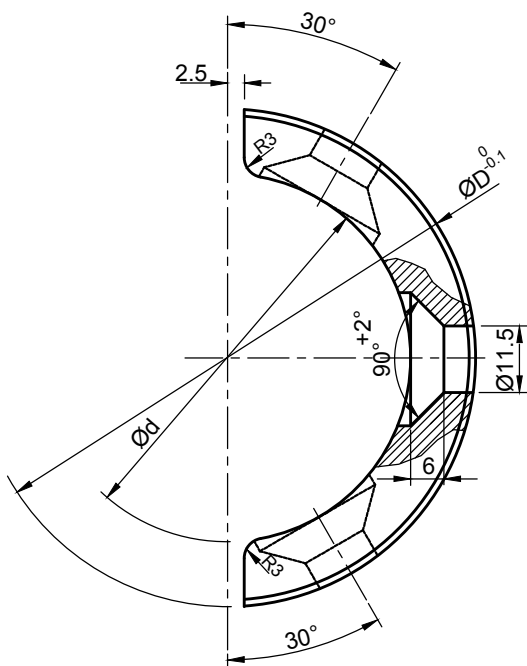


30-ST-212-01-525

DRAWING NO:



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

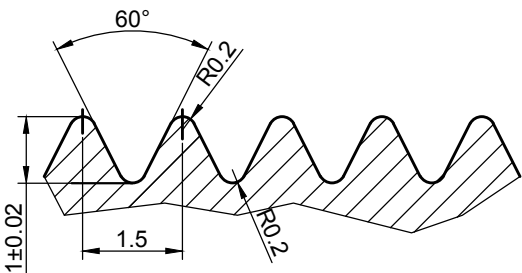
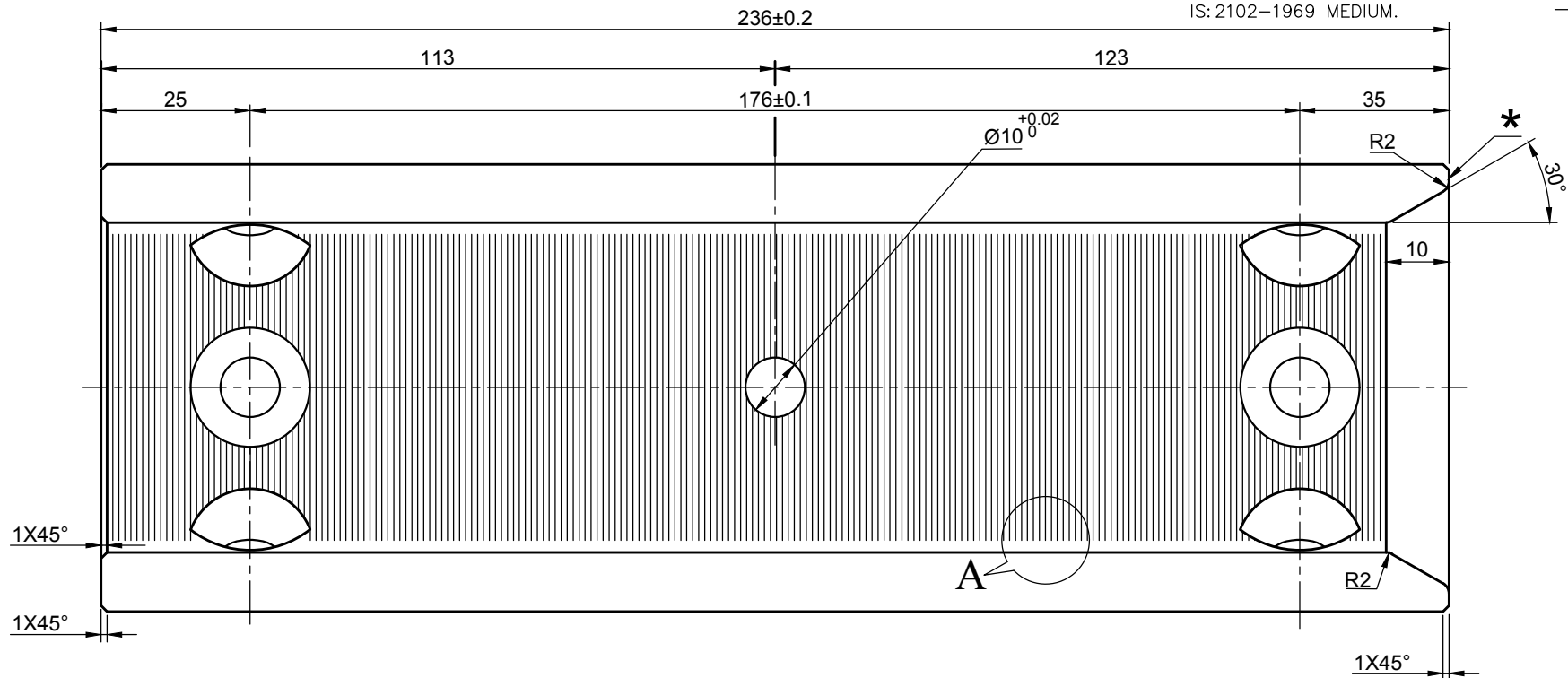
SL No.	MATERIAL	CHEMICAL COMPOSITION							
		C	Si	Mn	Cr	P	S	Mo	V
01	XT215Cr12 (IS:3748-1990)	2.0 2.3	0.10 0.35	0.25 0.50	11.0 13.0	0.035MAX.	0.035MAX.	0.80MAX. OPTIONAL	0.080MAX. OPTIONAL
02	X210Cr12 (DIN 1.2080)	1.9 2.0	0.2 0.4	0.2 0.4	11.0 12.0	0.035MAX.	0.035MAX.	-	-

HARDEN & TEMPER TO 50-55 HRC

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

REV	DATE	ALTERED
01	09.08.13	APPROVED
02	04.02.2015	APPROVED

SL.No. 15 ADDED(Ø88.9)

DIMN.236 WAS 226, DIMN.123 WAS 113
DIMN.35 WAS 25.

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	
DEPT SSTP		CHD	SIGNATURE R.Kumar	
CODE 456		APPD	DATE 17.06.14	
GRADE OF UNTOL. DIM φ/M/F IS: 2102		SCALE 1:1	REF TO ASSY DWG NO 30-ST-212-01-523	
TITLE PP SLEEVE FOR NEW POINTING M/C (DIA 42.40-88.90)		WEIGHT (Kg) SEE IN TABLE	REF TO OLD DWG NO PPM 150_T_15_02 TO 28_02	
CARD CODE U 01		DRAWING NO : 30-ST-212-01-525		ITEM 02
				REV 02

A3-SIZE