

CAUTION: THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LTD
IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANYWAY DETERMINAL TO INTEREST OF THE COMPANY

ALL DIMENSIONS ARE IN MM

REV	DATE	ALTERD BY
03	12.05.11	CHECKED BY
		APPROVED

IN MATERIAL C-10/K20 WAS SANDVIK CG60
IN SL.No.06 DIMN.D32.99 WAS 31.99
IN SL.No.07 DIMN.D33.00 WAS 32.00
IN SL.No.07 DIMN.d12.4 WAS 14.5
IN TABLE 'F'VALUES 2.0, 2.5, 3.0, 4.0
WERE 1.5, 2.0, 2.5, 3.0, RESPECTIVELY

REV	DATE	ALTERD BY
04	09/10/13	CHECKED BY
		APPROVED

DIMN.'L' IN SL.No.01 30 WAS 26
DIMN.'L' IN SL.No.02&03 30 WAS 28
DIMN.'L' IN SL.No.05&06 35 WAS 32
DIMN.'L' IN SL.No.07&08 35 WAS 34
DIMN.'L' IN SL.No.09 40 WAS 36
DIMN.'L' IN SL.No.10&11 40 WAS 38
DIMN.'L' IN SL.No.13&14 45 WAS 42
DIMN.'L' IN SL.No.15 45 WAS 44
DIMN.'L' IN SL.No.16 50 WAS 46
DIMN.'L' IN SL.No.17 50 WAS 48
DIMN.'L' IN SL.No.19 50 WAS 52

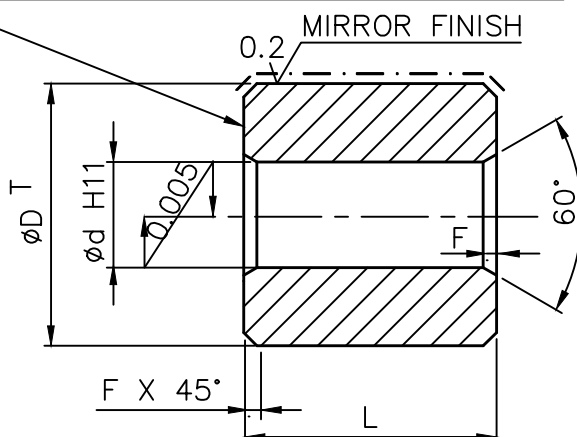
0.8/0.2/

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

10.3	H 11	+0.110
12.4		0
14.5		
16.5		
20.5		+0.130
24.5		0
32.5		+0.160
36.5		0

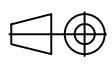
SL.No	D	T	d	L	F			
01	20.00 TO 20.99	+0.01	10.3	30	2.0			
02	21.00 TO 22.99							
03	23.00 TO 25.99							
04	26.00 TO 29.99							
05	30.00 TO 30.99		12.4	35	2.5			
06	31.00 TO 32.99							
07	33.00 TO 34.99							
08	35.00 TO 36.99							
09	37.00 TO 39.99							
10	40.00 TO 40.99		16.5	40	3.0			
11	41.00 TO 42.99	+0.02						
12	43.00 TO 45.99							
13	46.00 TO 46.99	20.5	45					
14	47.00 TO 49.99							
15	50.00 TO 54.99							
16	55.00 TO 60.99	24.5	50	4.0				
17	61.00 TO 70.99							
18	71.00 TO 80.99							
19	81.00 TO 90.99	36.5	50	5.0				

MARK : Ø'D'VALUE, FIRMS NAME, P □ No.



MATERIAL : TUNGSTON CARBIDE
TUNGSTON(W) : 85%
COBALT(Co) : 15%
HARDNESS : 1200 HV

TEST CERTIFICATE IS REQUIRED FOR
CHEMICAL COMPOSITION & MECHANICAL
PROPERTIES INCLUDING HARDNESS AS PER SPECIFICATION.

		Bharat Heavy Electricals Ltd		DRN	NAME R.KUMAR	SIGNATURE <i>R.Kumar</i>	DATE 09/10/13
		SEAMLESS STEEL TUBE PLANT		CHD	N ARUMUGANAINAR	<i>N. A. Nainar</i>	
		TIRUCHIRAPALLI - 620014		APPD	M MARUDHAVANAN	<i>M. Marudhavanan</i>	
DEPT T E	GRADE OF UNTOL. DIM C/M/F		SCALE N T S	WEIGHT (Kg) /	REF TO ASSY DRG		ITEM NO
CODE					REF TO OLD DRG 0202070-06.801-859		
TITLE PLUGS (DIA20&ABOVE)				CARD CODE U 01	DRAWING NO : 40-ST-221-03-338		REV 04