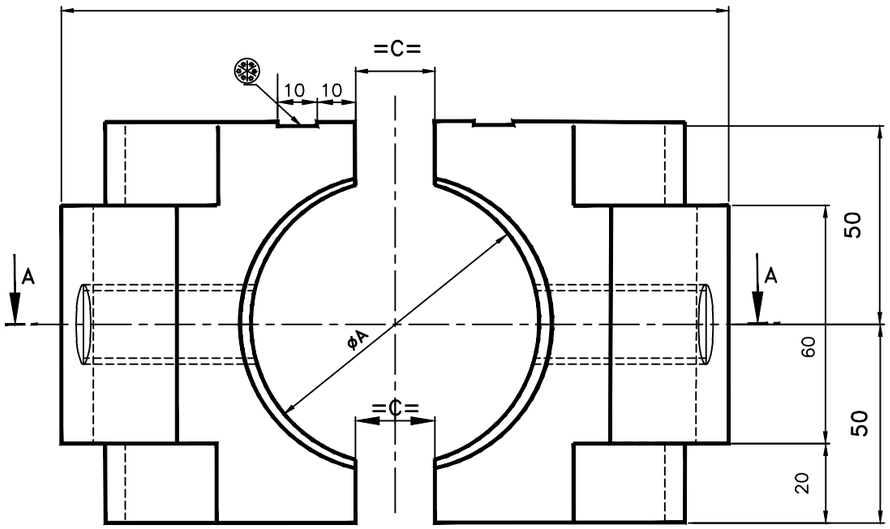
CAUTION: THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LTD
IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANYWAYDETERMINTAL TO INTEREST OF THE COMPANY

ALL DIMENSIONS ARE IN MILLIMETERS

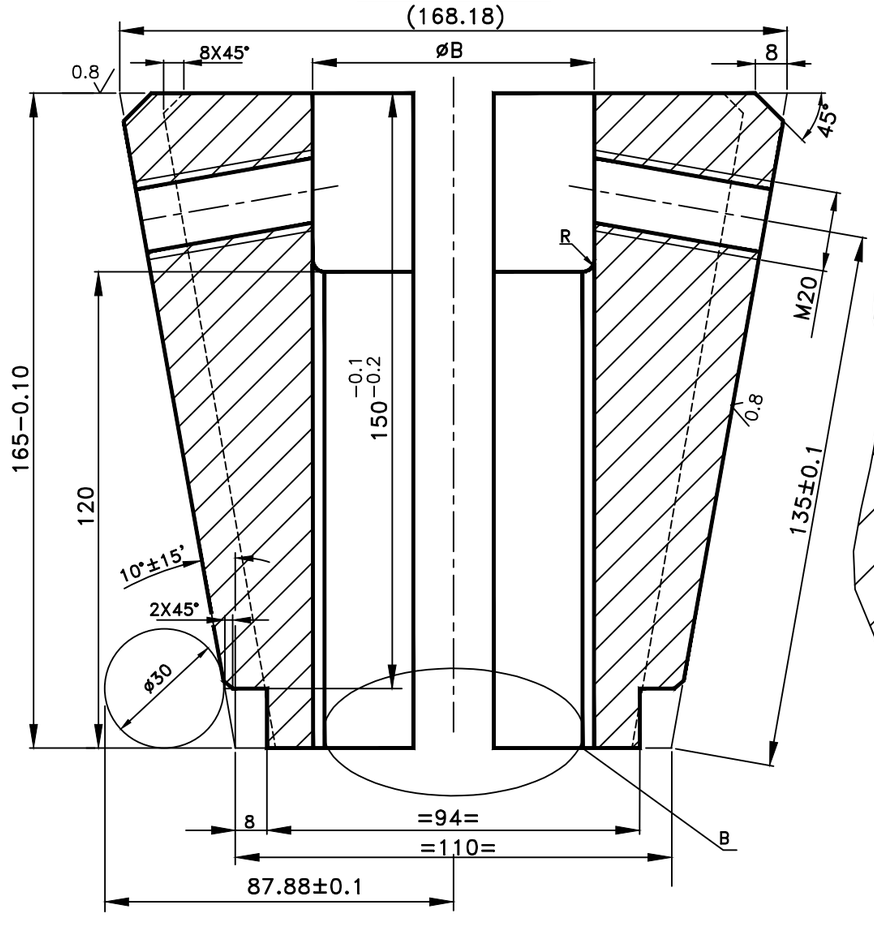


1.6 0.8

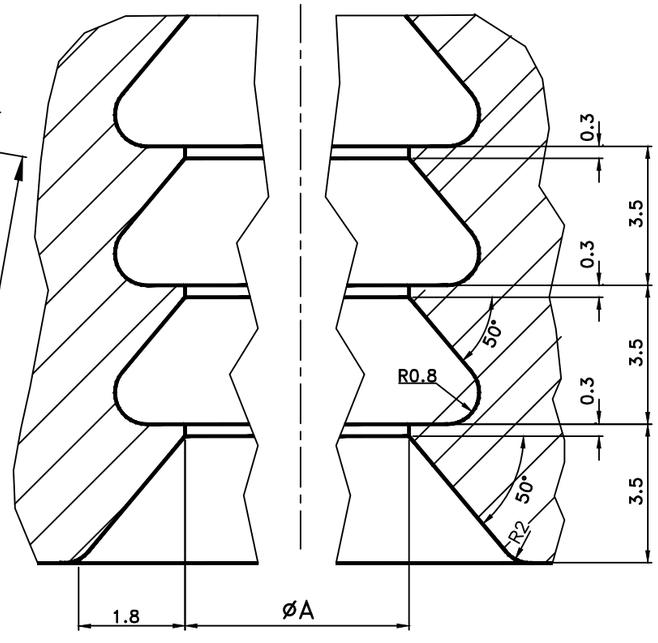
DEVIATIONS OF UNTOLERANCED DIMENSIONS TO BE AS PER IS:2102–1969 MEDIUM

SL No.	MATERIAL CODE No	øA	B	C
01	69 23 42 005 9	41	47	6
02	69 23 42 006 7	45	51	9
03	69 23 42 007 5	49	55	10
04	69 23 42 008 3	54	60	11
05	69 23 42 010 5	61	67	13
06	69 23 42 012 1	69	73	18
07	69 23 42 013 0	73	79	23
08	69 23 42 001 6	30	36	4
09	69 23 42 002 4	35	41	6
10	69 23 42 003 2	36	42	6
11	69 23 42 004 0	39	45	6
12	69 23 42 009 1	57	63	12
13	69 23 42 011 3	65	71	16
14	69 23 42 014 8	42.5	48.5	10
15	69 23 42 015 6	29	35	4
16	69 23 42 016 4	31	37	4
17	69 23 42 017 2	17	23	6
18	69 23 42 018 0	19	25	6
19	69 23 42 019 9	24	30	6

SECTION–AA
(168.18)



DETAIL B
(SCALE 10:1)



MATERIAL: IS:3748–1990 T90Mn6WCr2(ROLLED OR FORGED STEEL)

CHEMICAL COMPOSITION

C	Si	Mn	Cr	V	W	P	S
0.85	0.10	1.25	0.30	max.0.25	0.40	max.0.035	max.0.035
0.95	0.35	1.75	0.60		0.60		

HARDENED AND TEMPERED TO 55–58 HRC

SUPPLY TO BE ASPER TDC/TE/MFG:25

MARK MATERIAL CODE No &øA VALUE,FIRMS NAME& P O No.

Note:– CHAMFER THE SHARP EDGES TO 0.5X45°

REV	DATE	ALTERED / APPROVED
18	30.12.16	R.Kumar / N A Nainar
ZONE	100 WAS 115, C VALUE MODIFIED	
	STEP ADDED	

Bharat Heavy Electricals Ltd
SEAMLESS STEEL TUBE PLANT
TIRUCHIRAPALLI – 620014

	NAME	SIGNATURE	DATE
DRN	R.KUMAR	R.Kumar	21.10.14
CHD	N ARUMUGANAINAR	N A Nainar	
APPD	M MARUDHAVANAN	M Marudhavanan	

DEPT	GRADE OF UNTOL DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM NO
T E	C/M/F	1:1,10:1		10.ST.221.02.086	02
CODE				REF TO OLD DWG No0202063–69.008–043 20.ST.221.02.099/REV.16	

TITLE: GRIPPER JAWS (TAPER DESIGN)

CARD CODE: U 01

DRAWING NO : 20–ST–221–02–099

REV: 18