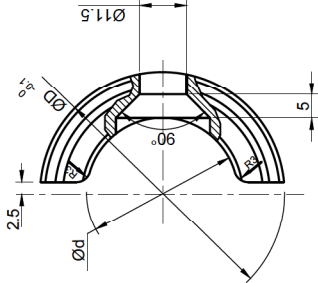


222-10-212-1S-03

ON DRAWING



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	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	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				

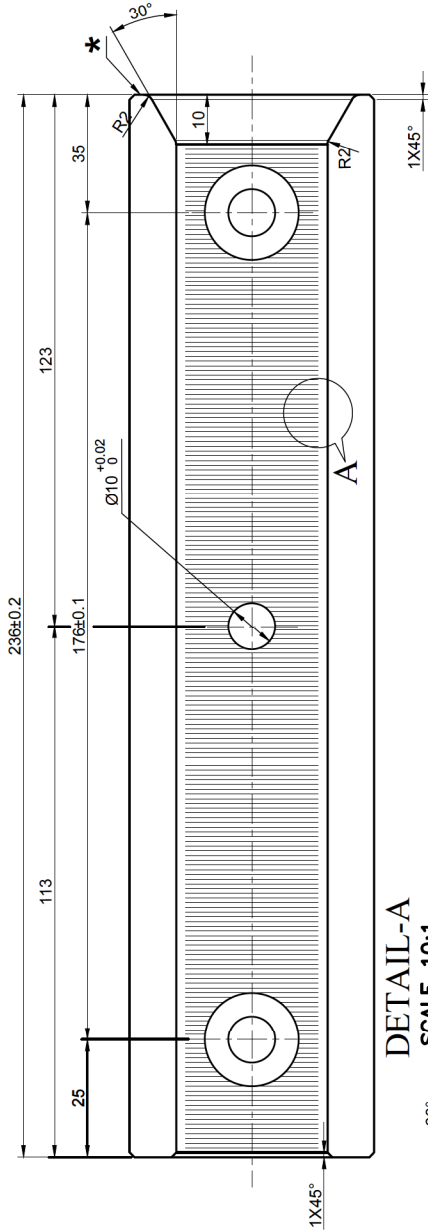
HARDEN & TEMPER TO 50-55 HRC

REV	DATE	ALTERED	APPROVED
01	04.02.2015		
DIMN.35 WAS 25, DIMN.123 WAS 113			
DIMN.236 WAS 226.			

ALL DIMENSIONS ARE IN MILLIMETRES

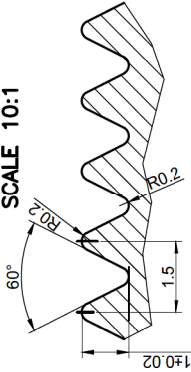
DEVIATIONS OF UNTOLERANCED DIMENSIONS TO BE AS PER IS:2102-1969 MEDIUM.

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

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
				QTY
EQUIPMENT				
Bharat Heavy Electricals Ltd		DRN	NAME	DATE
SEAMLESS STEEL TUBE PLANT		C-D	R.KUMAR	17.06.14
TIRUCHIRAPALLI - 620014		APPD	N. ARUMUGANANAR	
GRADE OF UNTOL. DIM		SCALE	WEIGHT (Kg)	ITEM
Ø/M/f	1:1	SEE IN TABLE	30-ST-21-01-520	02
SS/TIP	1:1	SEE IN TABLE	PPM 150.T.08.02 TO 14.02	
CODE	156			
TITLE		CARD CODE	DRAWING NO :	REV
P P SLEEVE FOR NEW POINTING M/C (DIA 21.30-38.10)		U 01	30-ST-212-01-522	01

A3-SIZE