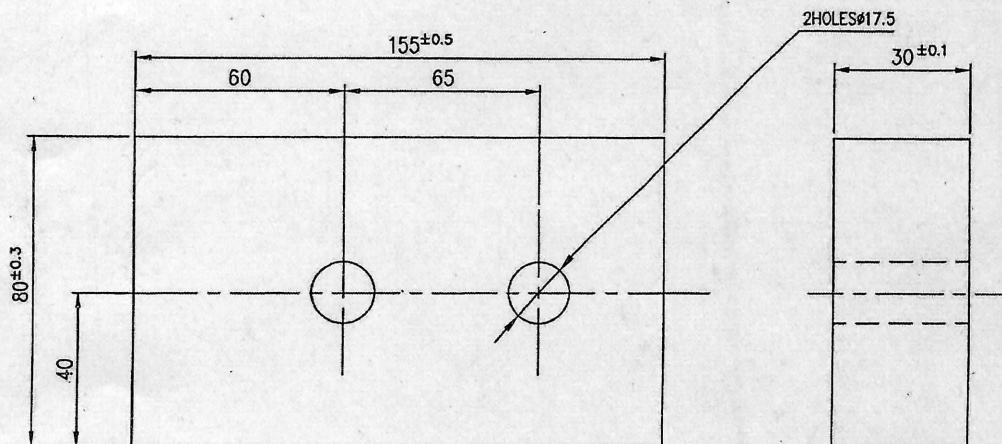


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REV 01	DATE 8.9.1986	ALTERED: -SD- CHECKED: -SD-	REV 02	DATE 4.5.2008	ALTERED: Rg CHECKED: M.Hari	REV 03	DATE 23.07.13	ALTERED: G.SATHISH CHECKED: M.K.NAHAK
MATL SPEC CHANGED FROM BMCQ-10 TO BMCQ-45			MATL SPEC CHANGED AS IS 2073/70 Gr.C-45			DIMENSIONAL TOLERANCE INCORPORATED.		



TO BE FORGED

NOTES:-

* THE MATERIAL CAN BE OF ANY ONE OF THE FOLLEQUIVALENT SPECN.

△ IS 2073/70 Gr.C-45

BS-970/Pr.1/Gr.080.M46

DIN 17200/69 Gr./C45

VARIANT NO	01	DESCRIPTION	STD	DRAWING NO.	96150266	2.807	1	CS	ZONE
ITEM NO					△ BMCQ 45 *				
					MATL. CODE	A	UNIT	UNIT WT.	
					MATL. SPEC	C	DI	QUANTITY	
				DRN	M.MADHAVAN	SIGN	-SD-	DATE	21.12.84
				CHD	D.D.SAHAYAM	-SD-		21.12.84	
				APPD	M.K.LUXMAN	-SD-		21.12.84	
DEPT	AQCS	GRADE OF UNTOLO DIM	SCALE	WEIGHT (KG).	REF. TO ASSY./OLD DRG.			ITEM NO.	NO. OF ITEMS
CODE	862	C / M / F	1:2	2.807					
TITLE				CARD CODE	DRAWING NO.				REV
SHOCK PAD				U 01	4-79-024-00348				03

Size A4

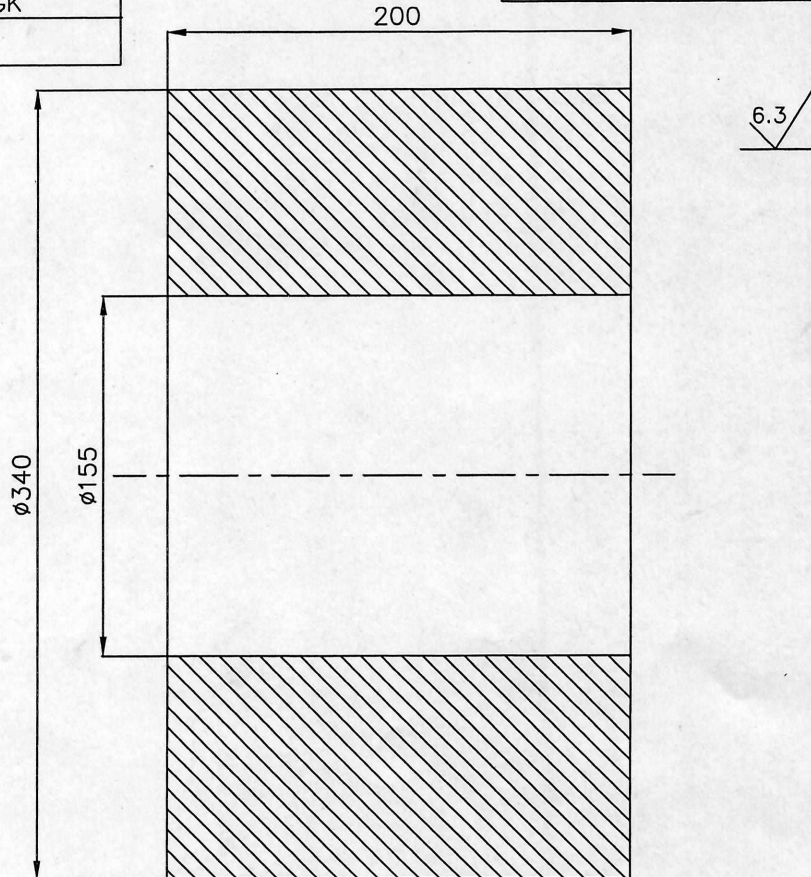
CAUTION: The information on this document is the property of BHARAT HEAVY ELECTRICALS LTD. It must not be used directly or indirectly in any way detrimental to the interest of the company.

REV	DATE	ALTERED	SARAVANAN
01	03.03.12	CHECKED	KKN
NOTE IS ADDED AS SHOWN IN DRG.			
REV	DATE	ALTERED	P.SHAKI.O/L
02	07.05.13	CHECKED	RSGK
NOTES CORRECT.			

ALL DIMENSIONS ARE IN MILLIMETRES

FOR PRODUCTION

REF. PR:QA:590 FOR PAINTING
REF. PR:QA:500 FOR UNTOL. DIMNS.
REF. APPLICABLE GMS FOR MATCODE&SPEC.



NOTES:

01).DELIVERY

02 TFN 359



ACCORDING TO THE ORDER INSTRUCTION ~~AM-004~~ " DELIVERY CONDITIONS FOR ROLLED AND FORGED STEEL COMPONENTS OF WSTE 500-NH/P500NH" WITH ACCEPTANCE TEST CERTIFICATE EN 10204-3.1B AND ULTRASONIC TEST WITH OVER SIZE FOR MACHINING ALL ROUND.

02).THIS ITEM IS TO BE FURTHER MACHINED IN IMPELLER ASSY.

01	HUB FORGING	920374810500		112.900
		P500 NH		1
ITEM NO.	DESCRIPTION	MATL. CODE	A	UNIT WT.
		MATL. SPECN.	C	QTY



BHARAT HEAVY ELECTRICALS LTD.,
UNIT: BOILER AUXILIARIES PLANT,
RANIPET - 632 406.

DRN	NAME	SIGN	DATE	NO.OF VAR
CHD	P.SHAKI.O/L		31/01/12	
APPD	C.MANOJ		04/02/12	
	K.K.N.		06/02/12	

DEPT FANS	GRADE OF UNTOL.DIM	SCALE	WEIGHT (KG).	REF. TO ASSY./OLD DRG.	ITEM NO.	NO. OF ITEMS
CODE 864	PR: QA: 500	N.T.S.	112.900	3 GA 14194 B		
TITLE	CARD CODE	DRAWING NO.	REV			
HUB (FORGING)	U 01	4-55-216-02397	02			

Size A4

REV	DATE	ALTERED	SARAVANAN
01	03.03.12	CHECKED	KKN
NOTE IS ADDED AS SHOWN IN DRG.			
REV	DATE	ALTERED	S.AGARWAL
02	02.04.13	CHECKED	RSGK
DIMENSION ALTERED.			
REV	DATE	ALTERED	P.SHAKI.O/L
03	07.05.13	CHECKED	RSGK
NOTES CORRECT.			

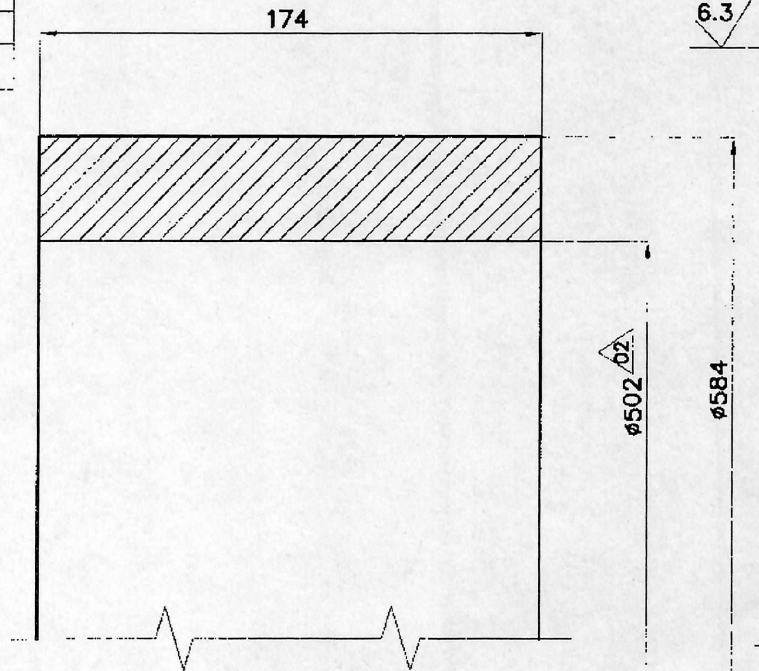
ALL DIMENSIONS ARE IN MILLIMETRES

FOR PRODUCTION

REF. PR:QA:590 FOR PAINTING

REF. PR:QA:500 FOR UNTOL. DIMNS.

REF. APPLICABLE GMS FOR MATCODE&SPEC.

**NOTES:****01).DELIVERY**

03 TFN 359
 ACCORDING TO THE ORDER INSTRUCTION ~~AM-004~~ " DELIVERY CONDITIONS
 FOR ROLLED AND FORGED STEEL COMPONENTS OF WSTE 500-NH/P500NH"
 WITH ACCEPTANCE TEST CERTIFICATE EN 10204-3.1B AND ULTRASONIC
 TEST WITH OVER SIZE FOR MACHINING ALL ROUND.

02).THIS ITEM IS TO BE FURTHER MACHINED IN IMPELLER ASSY.

01	FORGING	920374850400	51.200
		P500 NH	1
ITEM NO.	DESCRIPTION	MATL. CODE	UNIT WT.
		MATL. SPECN.	QTY



BHARAT HEAVY ELECTRICALS LTD.,
 UNIT: BOILER AUXILIARIES PLANT,
 RANIPET - 632 406.

DRN	NAME	SIGN	DATE	NO. OF
CHD	P.SHAKI.O/L		31/01/12	VAR
APPD	C.MANOJ		04/02/12	
	K.K.N.		06/02/12	

DEPT	FANS	GRADE OF	SCALE	WEIGHT (KG).	REF. TO ASSY./OLD DRG.	ITEM NO.	NO. OF
CODE	664	UNTOL. DIM	N.T.S.	51.200	V7009247		ITEMS
TITLE		CARD		DRAWING NO.		REV	
SUPPORT RING (FORGING)		CODE		4-55-216-02389		03	
		U 01					

Size A4

REV 01	DATE 030312	ALTERED SARAVANAN
		CHECKED KKN

NOTE IS ADDED AS SHOWN IN DRG.

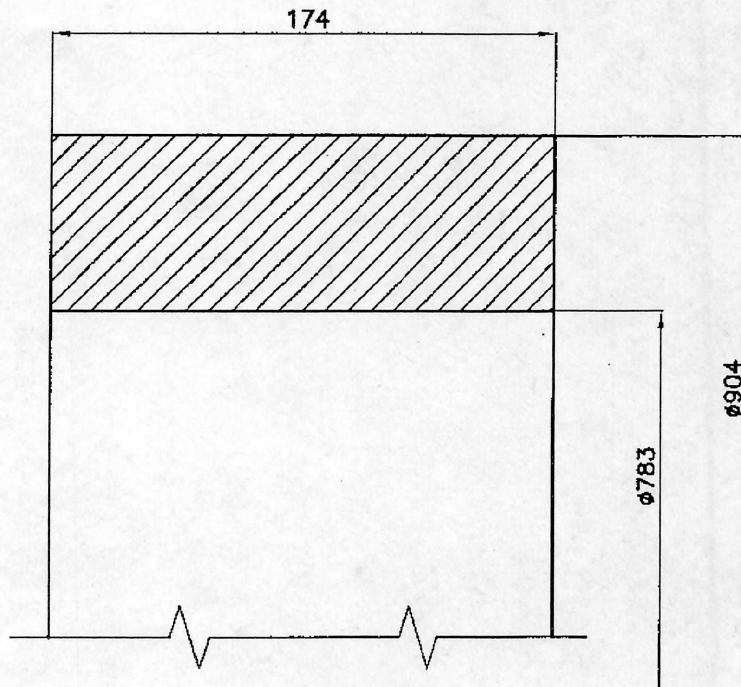
ALL DIMENSIONS ARE IN MILLIMETRES

FOR PRODUCTION

REF. PR:QA:590 FOR PAINTING

REF. PR:QA:500 FOR UNTOL. DIMNS.

REF. APPLICABLE GMS FOR MATCODE&SPEC.

**NOTES:****01).DELIVERY**

ACCORDING TO THE ORDER INSTRUCTION AM 004 " DELIVERY CONDITIONS FOR ROLLED AND FORGED STEEL COMPONENTS OF WSTE 500-NH/P500NH" WITH ACCEPTANCE TEST CERTIFICATE EN 10204-3.1B AND ULTRASONIC TEST WITH OVER SIZE FOR MACHINING ALL ROUND.

02).THIS ITEM IS TO BE FURTHER MACHINED IN IMPELLER ASSY.

01	FORGING	920374950000	P500 NH	156.400
ITEM NO.	DESCRIPTION	STD	MATL CODE	UNIT WT.
			MATL SPECN.	QTY



BHARAT HEAVY ELECTRICALS LTD.,
UNIT: BOILER AUXILIARIES PLANT,
RANIPET - 632 408.

DRN	NAME	SIGN	DATE	NO. OF VAR
CHD	P. SHAKI.O/L		31/01/12	
APPD	C.MANOJ		04/02/12	
	K.K.N.		06/02/12	

DEPT FANS	GRADE DF UNTOL.DIM		SCALE	WEIGHT (KG).	REF. TO ASSY./OLD DRG.	ITEM NO.	NO. OF ITEMS
CODE 864	PR: QA: 500		N.T.S.	156.400	V7009246		
TITLE LOAD RING (FORGING)				CARD CODE U D1	DRAWING NO. 4-55-216-02388		REV 01

Size A4

REV	DATE	ALTERED
		CHECKED

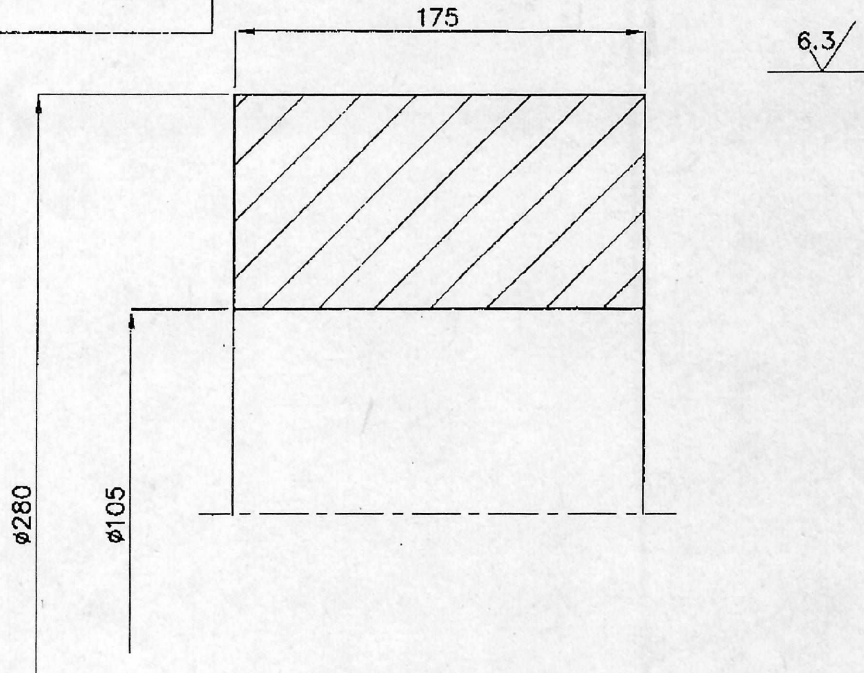
ALL DIMENSIONS ARE IN MILLIMETRES

FOR PRODUCTION

REF. PR:QA:590 FOR PAINTING

REF. PR:QA:500 FOR UNTOL. DIMNS.

REF. APPLICABLE GMS FOR MATCODE&SPEC.



01).DELIVERY NOTE:--

ACCORDING TO THE ORDER INSTRUCTION TFN NO: 359 DELIVERY CONDITIONS

01	FORGING	920374860000		72.700
		P460 NH		1
ITEM NO.	DESCRIPTION	MATL. CODE	A UNIT	JNIT WT.
		MATL. SPECN.	C DI	QTY



BHARAT HEAVY ELECTRICALS LTD.,

UNIT: BOILER AUXILIARIES PLANT,

RANIPET - 632 406.

DRN

P.SHAKI.O/

SIGN

DATE

NO.OF VAR

CHD

MAHESH

APPD

P.M.J

DEPT FANS

GRADE OF

UNTOL.DIM

SCALE

WEIGHT (KG).

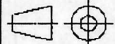
REF. TO ASSY./OLD DRG.

ITEM NO.

NO. OF

CODE

PR: QA: 500



N.T.S.

72.700

V7009327

TITLE

FORGED HUB

CARD

CODE

U 01

DRAWING NO.

4-55-215-02474

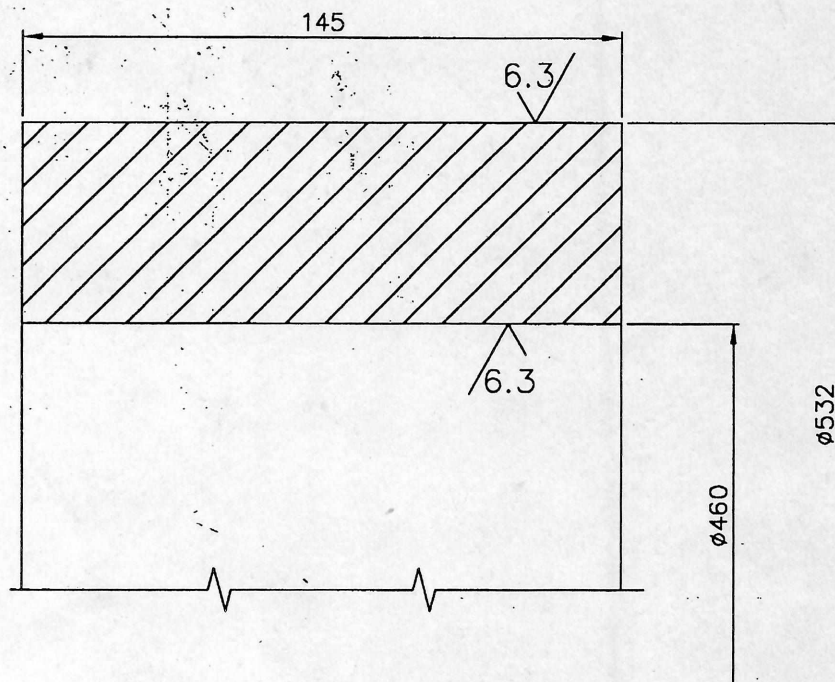
REV

Size A4

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REV	DATE	ALTERED	NIRANJAN
01	04/2012	CHECKED	RSGK
DESCRIPTION ALTERED.			

ALL DIMENSIONS ARE IN MILLIMETRES
FOR PRODUCTION
REF. PR:QA:590 FOR PAINTING
REF. PR:QA:500 FOR UNTOL. DIMNS.
REF. APPLICABLE GMS FOR MATCODE&SPEC.



01. THIS ITEM HAS TO BE FURTHER MACHINED IN IMPELLER ASSY.
02. RAW MATL. WEIGHT-59.400 Kg

01	01	FORGING $\phi 532/\phi 460$ L 145	920374850000			35.100
			P 355 NH			1
ITEM NO.	DESCRIPTION	STD	MATL. CODE	A	UNIT	UNIT WT.
			MATL. SPECN.	C	DI	QTY

		BHARAT HEAVY ELECTRICALS LTD., UNIT: BOILER AUXILIARIES PLANT, RANIPET - 632 406.		DRN	NAME	SIGN	DATE	NO. OF VAR
				CHD	G.Sundarm			
				APPD	G.Sundarm			
DEPT	FANS	GRADE OF UNTOL. DIM	SCALE	WEIGHT (KG).	REF. TO ASSY./OLD DRG.		ITEM NO.	NO. OF ITEMS
CODE	864	PR: QA: 500	N.T.S	35.100	V7000094			
TITLE				CARD CODE	DRAWING NO.		REV	
SUPPORT RING				U 01	4-55-334-01984		01	

Size A4

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REV	DATE	ALTERED
		CHECKED

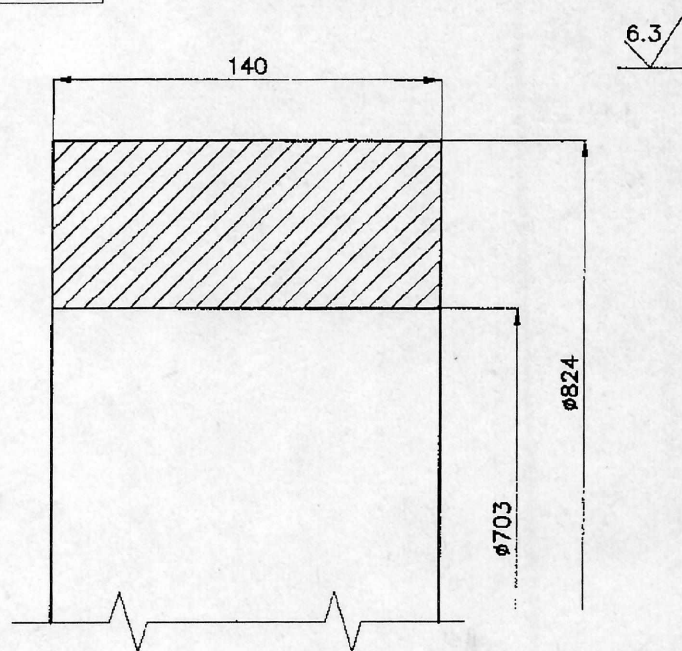
ALL DIMENSIONS ARE IN MILLIMETRES

FOR PRODUCTION

REF. PR:QA:590 FOR PAINTING

REF. PR:QA:SDD FOR UNTDL DIMNS.

REF. APPLICABLE GWS FOR MATCODE&SPEC.

**NOTES:**

01. THIS ITEM IS TO BE FURTHER MACHINED IN IMPELLER HUB ASSY.
02. MATERIAL :P 500 NH/ WSTE 500 NH.
03. WEIGHT OF LOAD RING (ROUGH FORGING)=159.482 Kgs.
04. ACCORDING TO THE ORDER INSTRUCTION AM 004 "DELIVERY CONDITIONS FOR IMPELLER COMPONENTS OF FORGED STEEL" WITH ACCEPTANCE CERTIFICATE EN 10204-3.1 AND ULTRASONIC TEST WITH OVERSIZE FOR MACHINING ALL ROUND.

01	FORGING	920374930100		106.70D
		P 500 NH		1
ITEM NO.	DESCRIPTION	MATL CODE	A	UNIT WT.
		MATL SPECN.	C	QTY



BHARAT HEAVY ELECTRICALS LTD.,
UNIT: BOILER AUXILIARIES PLANT,
RANIPET - 632 406.

DRN	NAME	SIGN	DATE	NO. OF VAR
CHD	P.SHAKI.O/L		13.02.12	
APPD	A.M.REDDY		18.02.12	
	K.K.N.		03.03.12	

DEPT	FANS	GRADE OF UNTOL.DIM	SCALE	WEIGHT (KG).	REF. TO ASSY./OLD DRG.	ITEM NO.	NO. OF ITEMS
CODE	864	PR:QA:50D	N.T.S.	106.700	V7009577		
TITLE				CARD CODE	DRAWING NO.	REV	
LOAD RING				U 01	4-55-335-02417		

Size A4