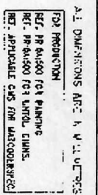




-

TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT

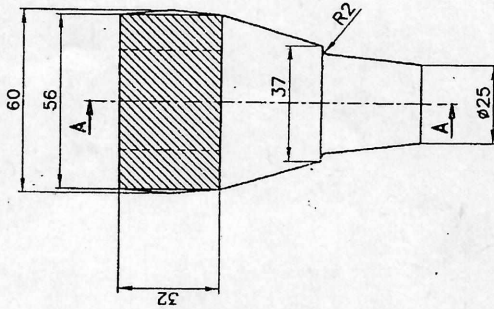
CODE	DESCRIPTION	SCALE	WEIGHT
864	CRANK OF UNION DIA FR. CANKER	N.T.S.	83.000

2-55-335-01605 02

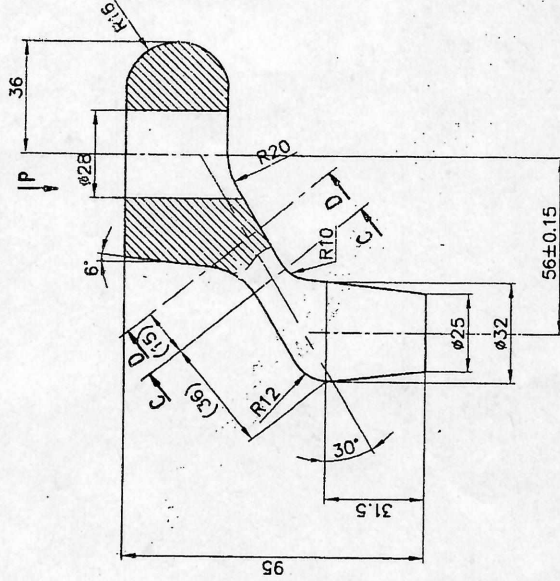
62810-512-55-5

ON 01/01/2014

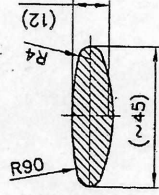
SECTION-BB



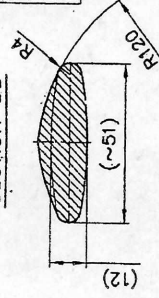
SECTION-AA



SECTION-CC



SECTION-DD

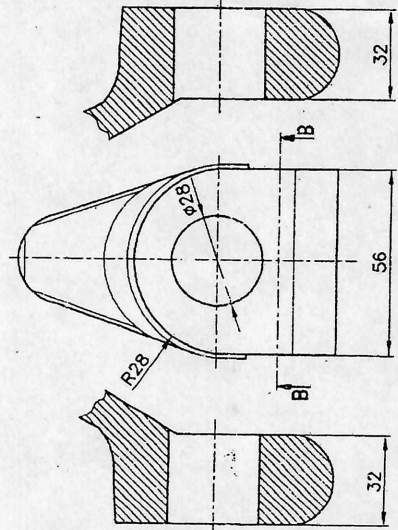


MATERIAL	41 Cr S4+QT	MATERIAL NO: 1.7035+QT
MATERIAL PROPERTIES	ACC. TO DIN EN 10083 (MINIMUM VALUES)	
YIELD POINT	R_e	560 N/mm ²
TENSILE STRENGTH	R_m	800-950 N/mm ²
ELONGATION AT FRACTURE	A (Min.)	14%
IMPACT VALUE	KV	35J ISO-V-PROBE (ISO-V-NOTCH TEST SPECIMEN)

NOTES:-

01. NON-DIMENSIONED EDGES ARE TO BE CHAMFERED BY 0.3x45°
02. TECHNICAL DELIVERY CONDITIONS ACC. TO DIN 10254: 2000-04.
03. PERMISSIBLE DEVIATIONS FOR THE DIMENSIONS OF FORGED PIECE: QUALITY GRADE OF FORGING F ACC. TO DIN EN 10243-1: 2000-06 & DIN EN 10243-2: 2000-06.
04. MATERIAL : 41 Cr S4, QUENCHED AND TEMPERED MATERIAL NO, 1.7039.
05. ADJUSTING LEVER R100 IS TO BE SUPPLIED IN PROOF MACHINED CONDITION.

VIEW-P



VAR NO	ITEM NO	DESCRIPTION	DRAWING NO.	ITEM NO	UNIT WT	QTY
01		ADJUSTING LEVER R56 (FORGING)		920374740300	1.000	
				41CrS4+QT		
				A		
				B		
				C		
				D		
				E		
				F		
				G		
				H		
				I		
				J		
				K		
				L		
				M		
				N		
				O		
				P		
				Q		
				R		
				S		
				T		
				U		
				V		
				W		
				X		
				Y		
				Z		

TYPE OF PRODUCT

OR NAME OF CUSTOMER/PROJECT

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DEPT. FMS CODE 864
GRADE OF INTOL.DIM PR:QA-500
SCALE NTS
WEIGHT (KG) 1.000
REF. TO ASSY/OLD DRG. V7000624
SIGN A.SAMU.O/L
NAME MAHESH
DATE 26.10.12
NO OF VAR. 01

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

ADJUSTING LEVER R56
(FORGING)

DRAWING NO. 3-55-215-01839
REV 01

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REV	DATE	ALTERED
		CHECKED

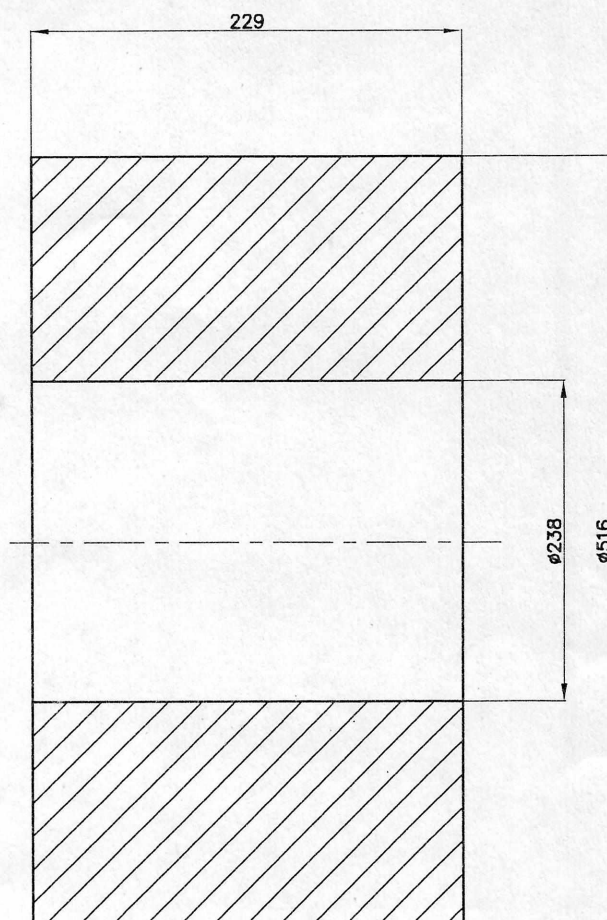
ALL DIMENSIONS ARE IN MILLIMETRES

FOR PRODUCTION

REF. PR:QA:590 FOR PAINTING

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

REF. APPLICABLE GMS FOR MATCODE&SPEC.



01	HUB FORGING	920374810200	P	295.900
		P500 NH		1
ITEM NO.	DESCRIPTION	MATL. CODE	A	UNIT WT.
		MATL. SPECN.	C	QTY



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

DRN	NAME	SIGN	DATE	NO. OF
CHD	SRINATH.S	Sd/-	4.5.15	VAR
APPD	MAHESH	Sd/-	4.5.15	
	A.V.N	Sd/-	4.5.15	

DEPT	FANS	GRADE OF	SCALE	WEIGHT (KG).	REF. TO ASSY./OLD DRG.	ITEM NO.	NO. OF
CODE	864	UNTOL. DIM	N.T.S.	295.900	V7015553		ITEMS
TITLE	WELD IN HUB (RAW PART)				DRAWING NO.	REV	
					4-55-328-02950		
					U 01		

Size A4

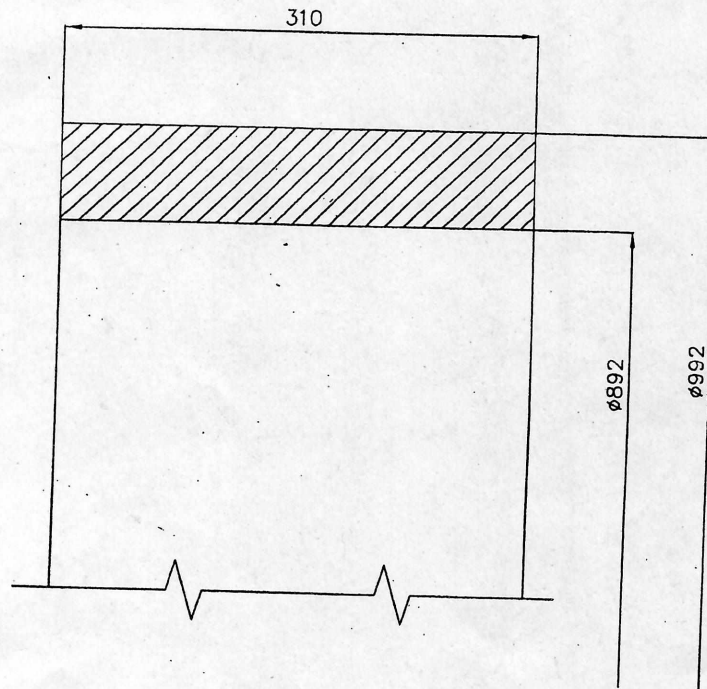
61

2

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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	FORGING				365.900
			P355NH		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	MAHESH					
		APPD	P.M.J					
DEPT	FANS	GRADE OF UNTOL. DIM		SCALE	WEIGHT (KG).	REF. TO ASSY./OLD DRG.		ITEM NO.
CODE	864	PR:QA:500		N.T.S.	365.900	V7013253		
TITLE				CARD CODE	DRAWING NO.			REV
SUPPORT RING (FORGING)				U 01	4-55-227-02962			

Size A4

REV	DATE	ALTERED
		CHECKED

ALL DIMENSIONS ARE IN MILLIMETRES

FOR PRODUCTION

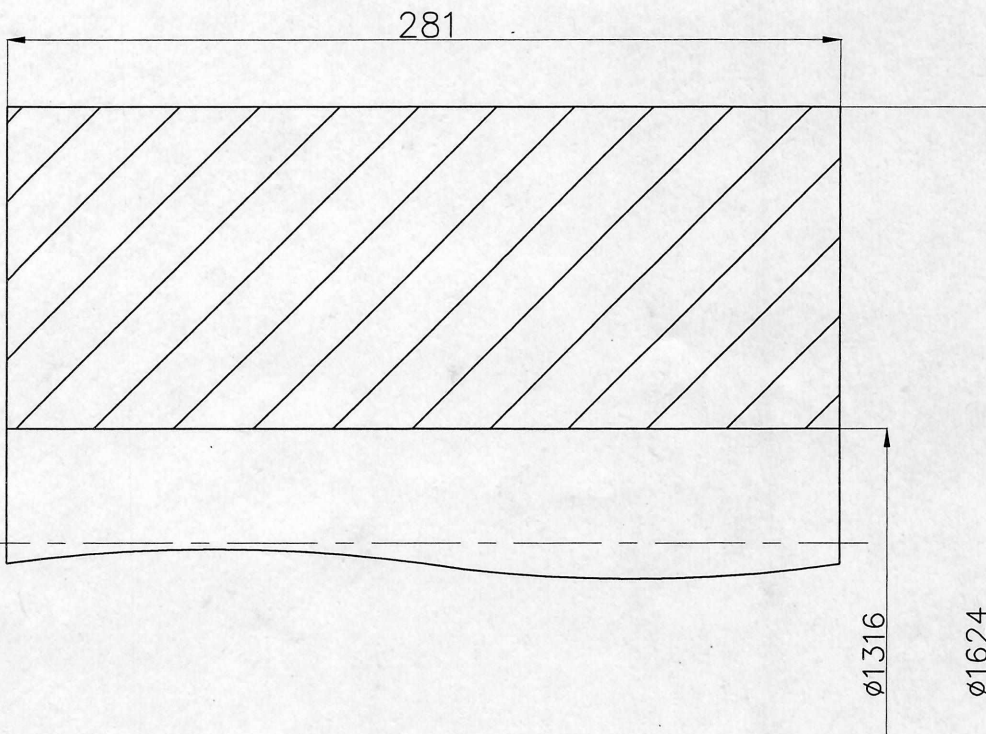
REF. PR:QA:590 FOR PAINTING

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

REF. APPLICABLE GMS FOR MATCODE&SPEC.

6.3

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01	LOAD RING									1568.8		
VAR NO	ITEM NO	DESCRIPTION	CAT	DRAWING No.	NO VAR NO	MATL CODE	MATL SPECN	A P C	UNIT	UNIT WT	QTY	CS ZONE

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	UNIT: BOILER AUXILIARIES PLANT.		CHD		CABRIEL		04.02.17	
	RANIPET - 632 406.		APPD		A.V.N			
	REF. TO ASSY/OLD DRG.		V7019268		ITEM NO.		NO. OF ITEMS	
DEPT	FANS	GRADE OF UNTOL. DIM	SCALE	WEIGHT (KG).				
CODE	864	PR: QA: 500	N.T.S	1568.8				
TITLE					CARD CODE	DRAWING NO.		
LOAD RING					U 01	4-55-328-03150		
					REV			

Size A4

REV	DATE	ALTERED
		CHECKED

ALL DIMENSIONS ARE IN MILLIMETRES

FOR PRODUCTION

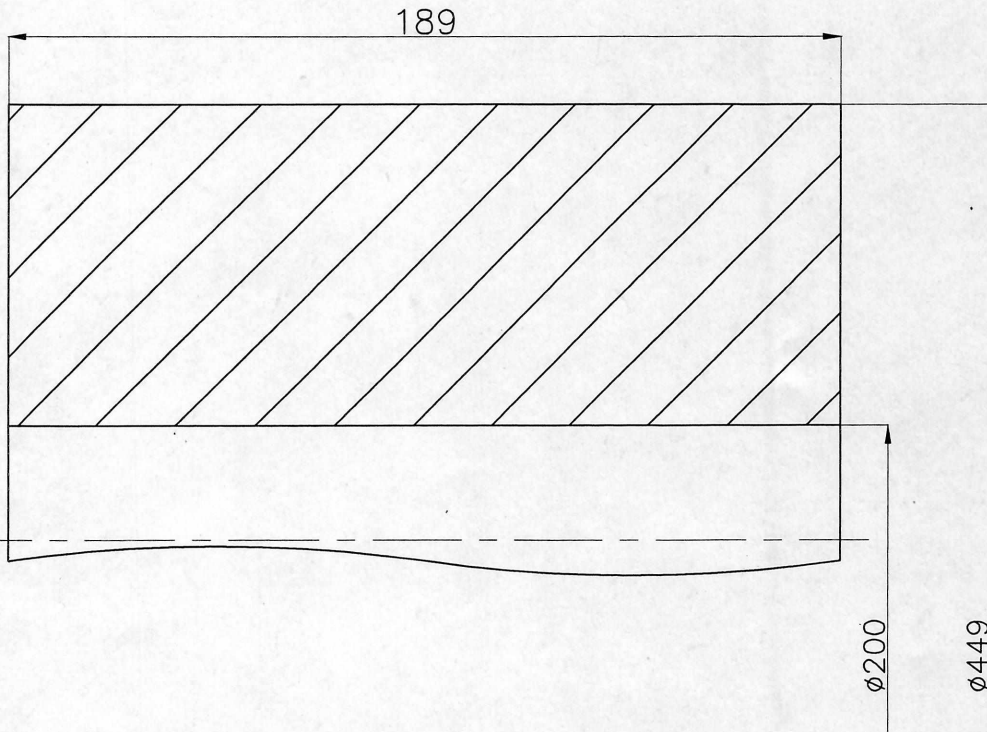
REF. PR:QA:590 FOR PAINTING

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

REF. APPLICABLE GMS FOR MATCODE&SPEC.

6.3

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01		HUB				188.300	
VAR NO	ITEM NO	DESCRIPTION	CAT	DRAWING No.	NO VAR NO	MATL CODE	UNIT
						P500 NH	1
						MATL SPECN	QTY
DEPT FANS		GRADE OF UNTOL.DIM	SCALE	WEIGHT (KG).	REF. TO ASSY/OLD DRG.		ITEM NO.
864		PR:QA:500	N.T.S	188.3	V7019305		
TITLE				CARD CODE	DRAWING NO.		REV
HUB (WELD)				U 01	4-55-328-03153		

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

DRN **CABRIEL** SIGN **04.02.17** NO.OF VAR.
CHD **RATNABABU**
APPD **A.V.N**



Size A4

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REV	DATE	ALTERED
		CHECKED

ALL DIMENSIONS ARE IN MILLIMETRES

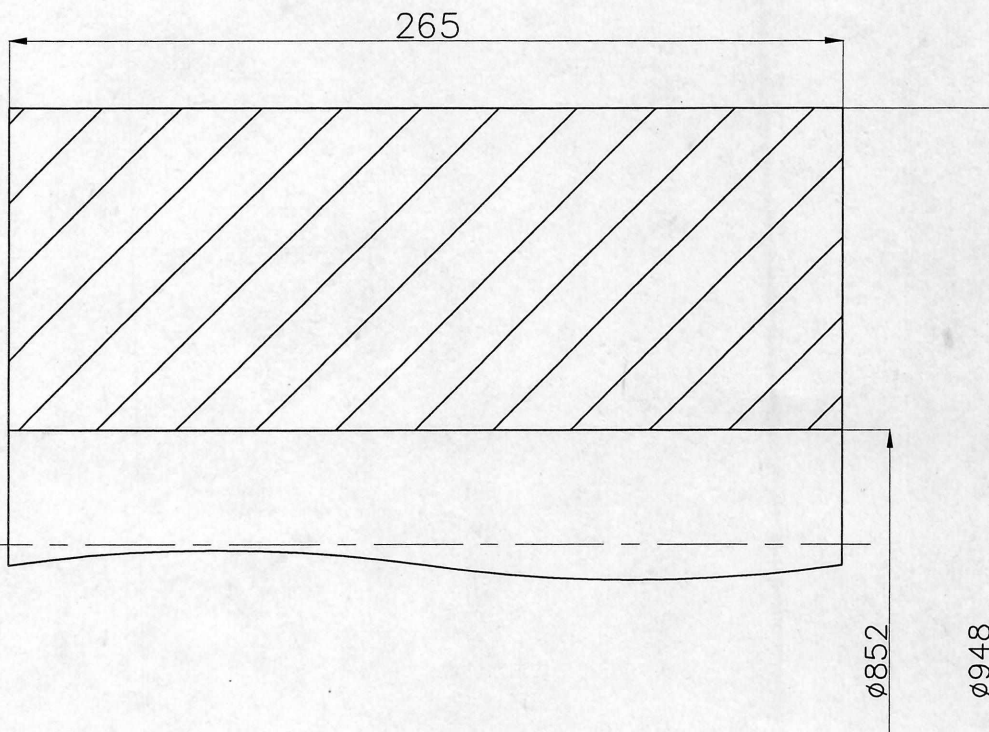
FOR PRODUCTION

REF. PR:QA:590 FOR PAINTING

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

REF. APPLICABLE GMS FOR MATCODE&SPEC.

6.3



01		SUPPORT RING				P355 NH		282.3		1	
VAR NO	ITEM NO	DESCRIPTION	CAT	DRAWING No.	NO VAR NO	MATL CODE	A CTD DI	UNIT	UNIT WT	CS	ZONE
						MATL SPECN			QTY		
DEPT FANS		GRADE OF UNTOL.DIM	SCALE		WEIGHT (KG).		NAME		SIGN		DATE
864		PR:QA:500	N.T.S		282.3		CABRIEL				04.02.17
TITLE		SUPPORT RING		CARD CODE		DRAWING NO.		REV		NO. OF VAR.	
				U 01		4-55-328-03152					

CAUTION: The information on this drawing 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.

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

DRN: CABRIEL
CHD: RATNABABU
APPD: A.V.N

REF. TO ASSY/OLD DRG. V7019308

ITEM NO. NO. OF ITEMS

Size A4

REV	DATE	ALTERED
		CHECKED

ALL DIMENSIONS ARE IN MILLIMETRES

FOR PRODUCTION

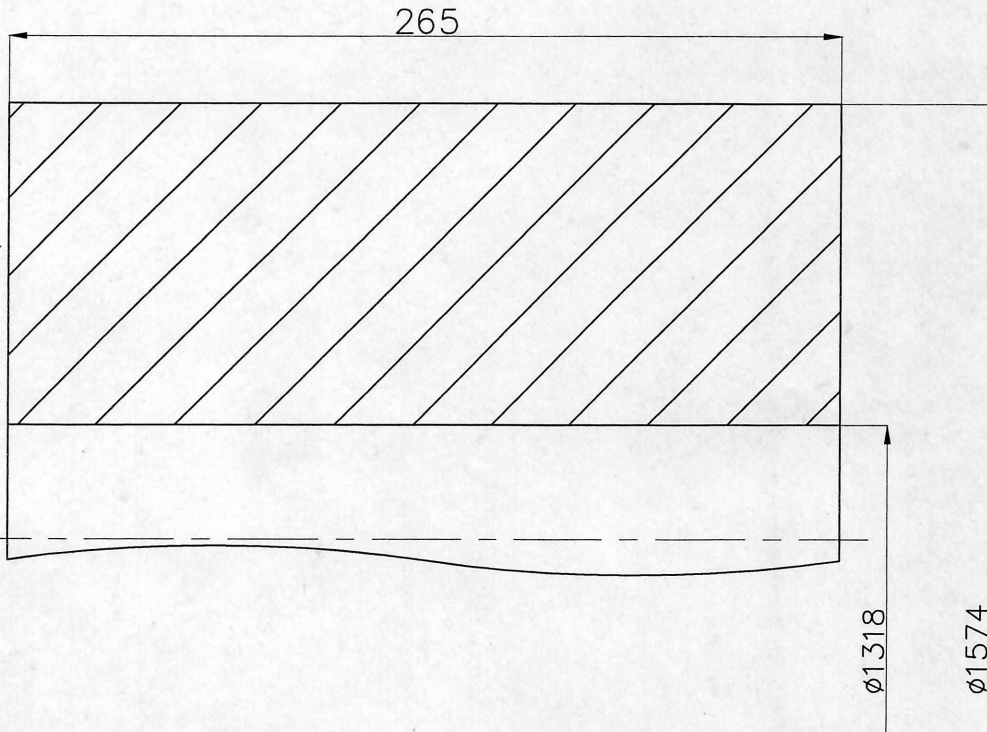
REF. PR:QA:590 FOR PAINTING

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

REF. APPLICABLE GMS FOR MATCODE&SPEC.

6.3

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01		LOAD RING				1209.6			
VAR NO	ITEM NO	DESCRIPTION	CAT	DRAWING No.	NO	MATL CODE	UNIT	UNIT WT	ZONE
					NO	MATL SPECN	DI	QTY	
BHARAT HEAVY ELECTRICALS LTD., UNIT: BOILER AUXILIARIES PLANT. RANIPET - 632 406.					DRN	NAME	SIGN	DATE	NO. OF VAR.
					CHD	RATNABABU		04.02.17	
					APPD	A.V.N			
DEPT	FANS	GRADE OF UNTOL.DIM	SCALE	WEIGHT (KG).	REF. TO ASSY/OLD DRG.			ITEM NO.	NO. OF ITEMS
864	864	PR:QA:500	N.T.S	1209.6	V7019307				
TITLE					CARD CODE	DRAWING NO.			REV
LOAD RING					U 01	4-55-328-03151			

Size A4