

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.			

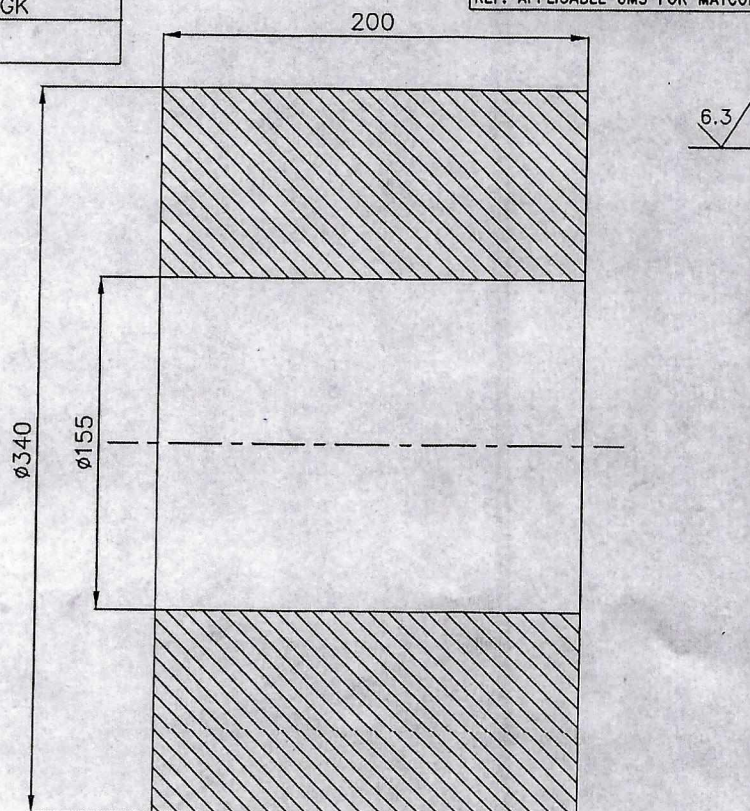
ALL DIMENSIONS ARE IN MILLIMETRES

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	UNIT WT.
		MATL. SPECN.	C DI	QTY



BHARAT HEAVY ELECTRICALS LTD.,

UNIT: BOILER AUXILIARIES PLANT,
RANIPET - 632 406.

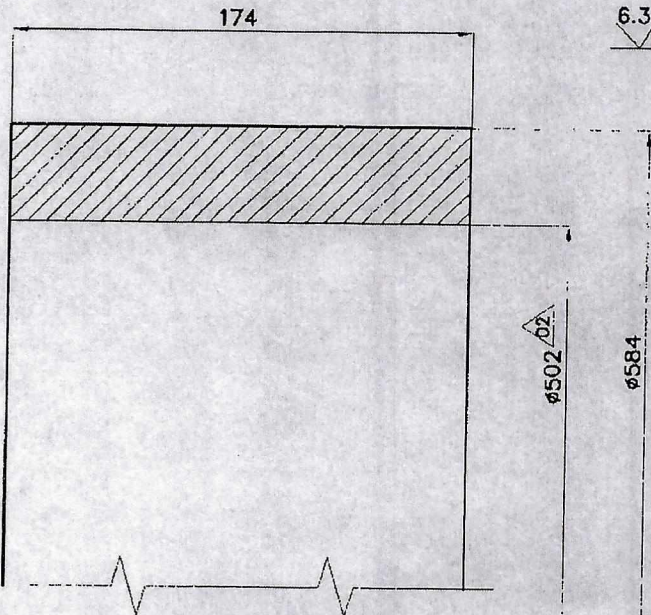
DRN	NAME	SIGN	DATE	NO.OF VAR
CHD	P.SHAKI.O/L		31/01/12	
APPD	C.MANOJ		04/02/12	
	K.K.N.		06/02/12	

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	RSBK
DIMENSION ALTERED.			
REV	DATE	ALTERED	P.SHAKI.O/L
03	07.05.13	CHECKED	RSBK
NOTES CORRECT.			

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

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

01

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 CHD APPD	NAME P.SHAKI.O/L C.MANOJ K.K.N.	SIGN 	DATE 31/01/12 04/02/12 06/02/12	NO.OF VAR
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.	51.200	V7009247			
TITLE				CARD CODE	DRAWING NO.		REV	
SUPPORT RING (FORGING)				U 01	4-55-216-02389		03	

Size A4

REV	DATE	ALTERED	SARAVANAN
01	030312	CHECKED	KKN

NOTE IS ADDED AS SHOWN IN DRG.

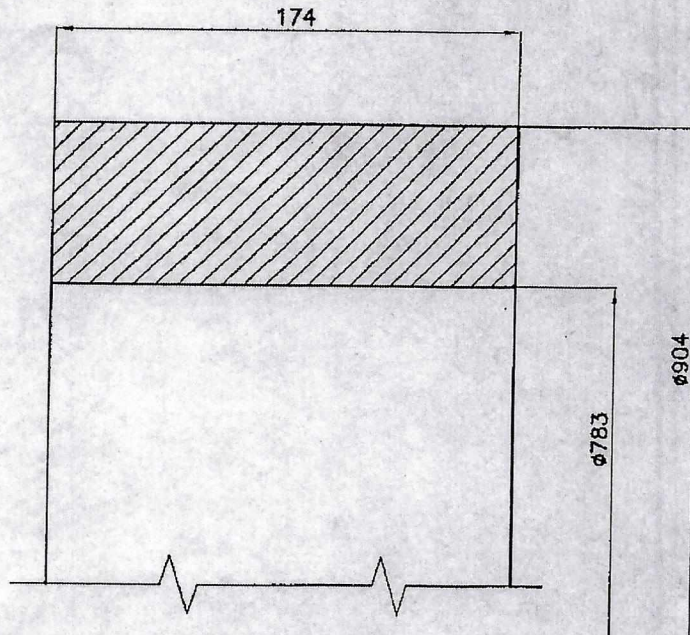
ALL DIMENSIONS ARE IN MILLIMETRES

FDR PRODUCTION

REF. PR:QA:590 FOR PAINTING

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

REF. APPLICABLE GWS 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 - 632 406.

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.	156.400	V7009246		
TITLE	LOAD RING (FORGING)			CARD CODE	DRAWING NO.	REV	
				U D1	4-55-216-02388	01	

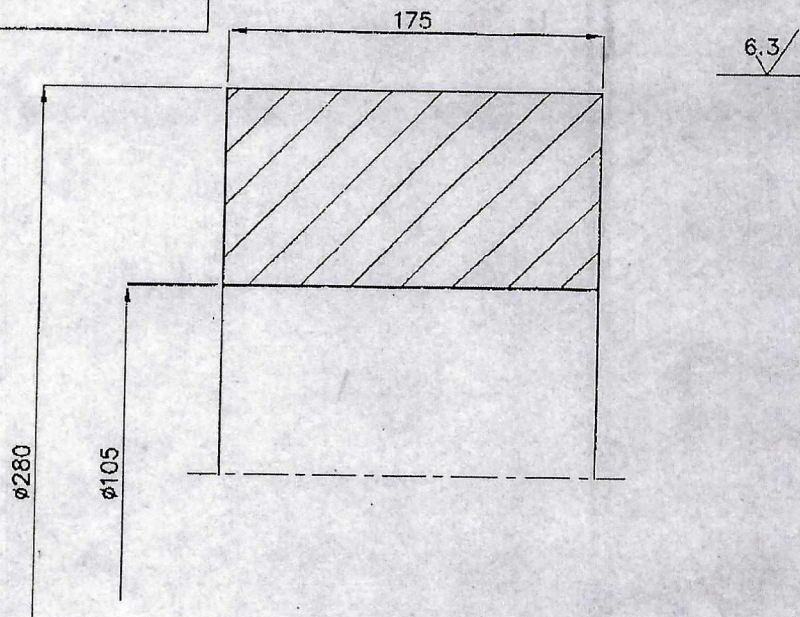
Size A4

ELECTRICALS LTD. it must not be used directly or indirectly in any way detrimental to the interest of the company.

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 TEN NO:359 DELIVERY CONDITIONS

01	FORGING	920374860000	72.700
		P460 NH	1
ITEM NO.	DESCRIPTION	MATL. CODE	UNIT WT.
		MATL. SPECV.	QTY

		BHARAT HEAVY ELECTRICALS LTD.,		DRN	NAME	SIGN	DATE	NO. OF VAR
		UNIT: BOILER AUXILIARIES PLANT, RANIPET - 632 406.		CHD	P.SHAKI.O./			
				APPO	MAHESH			
					P.M.J			
DEPT	GRADE OF UN TOL. DIM	SCALE	WEIGHT (KG).	REF. TO ASSY./OLD DRG.		ITEM NO.	NO. OF ITEMS	
FANS	PR: QA: 500	N.T.S.	72.700	V7009327				
CODE								
864								
TITLE				CARD CODE	DRAWING NO.			REV
FORGED HUB				U 01	4-55-215-02474			

Size A4

ELECTRICALS LTD. It must not be used directly or indirectly in any way detrimental to the interest of the company.

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

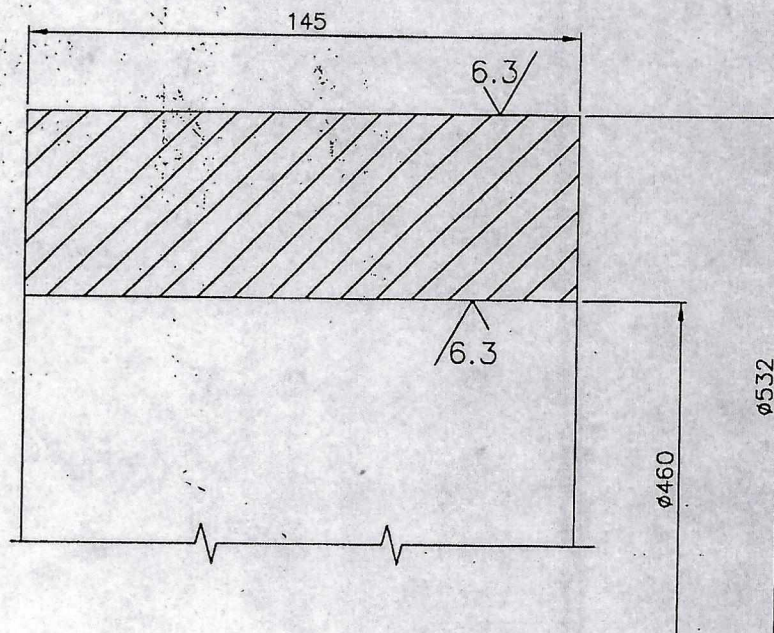
ALL DIMENSIONS ARE IN MILLIMETRES

FOR PRODUCTION

REF. PR:QA:590 FOR PAINTING

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

REF. APPLICABLE GWS 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 CHD APPD	NAME Off-Loading G.Sundarm G.Sundarm	SIGN 	DATE 	NO. OF VAR
DEPT CODE 864	FANS GRADE OF UNTOL. DIM PR: QA: 500		SCALE N.T.S	WEIGHT (KG) 35.100	REF. TO ASSY./OLD DRG. V7000094	ITEM NO.	NO. OF ITEMS	
TITLE SUPPORT RING				CARD CODE U 01	DRAWING NO. 4-55-334-01984		REV 01	

Size A4

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REV	DATE	ALTERED
		CHECKED

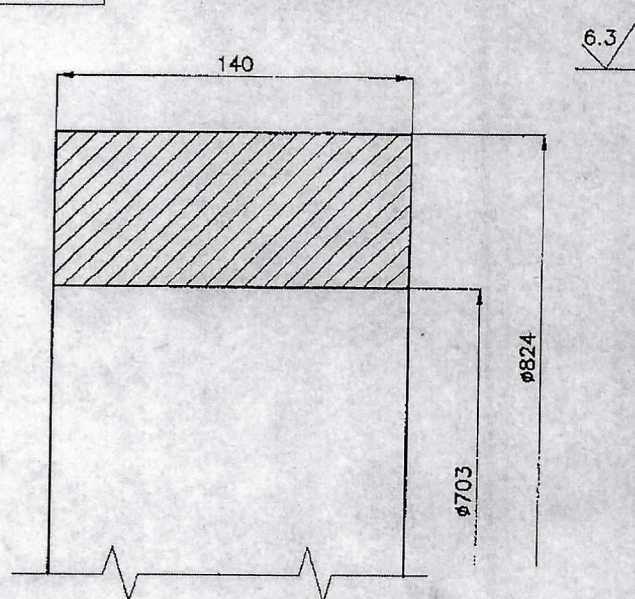
ALL DIMENSIONS ARE IN MILLIMETRES

FOR PRODUCTION

REF. PR:QA:590 FOR PAINTING

REF. PR:QA:500 FOR UNTDL. QIMNS.

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
		MATL SPECN.	C	QTY

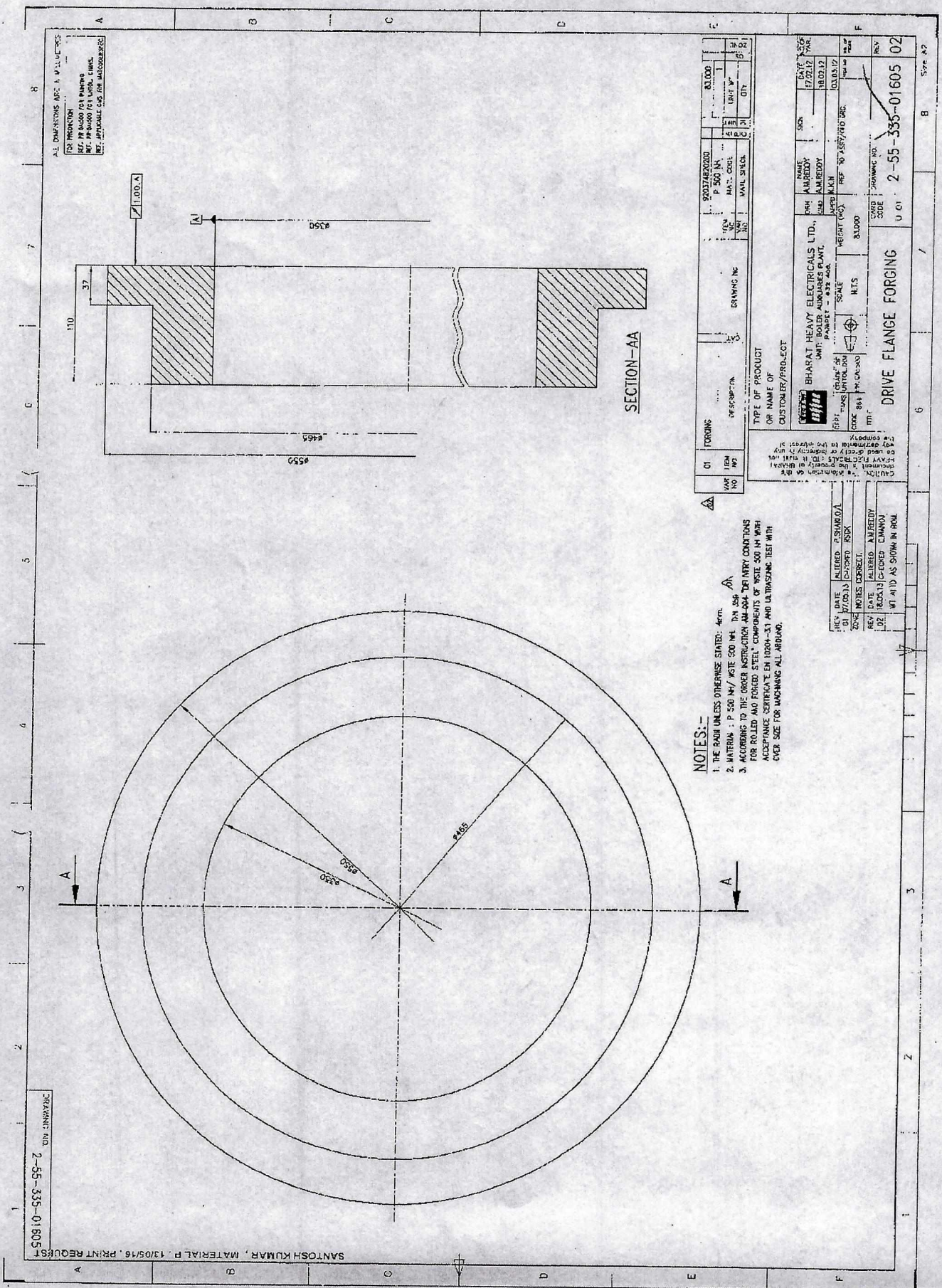


BHARAT HEAVY ELECTRICALS LTD.,
UNIT: BOILER AUXILIARIES PLANT,
RANIPET - 632 406.

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	LOAD RING			CARD CODE	DRAWING NO.	REV	
				U 01	4-55-335-02417		

Size A4



2-55-335-01605

ALL DIMENSIONS ARE IN MILLIMETERS
 (1) PROVISION
 REF. TO 8000 FOR PARTS
 REF. TO 8000 FOR PARTS
 REF. TO 8000 FOR PARTS

NOTES:-

1. THE PART UNLESS OTHERWISE STATED, 4mm.
2. MATERIAL : P 500 MH / STEEL 500 MH.
3. ACCORDING TO THE ORDER INSTRUCTION AND ALL DELIVERY CONDITIONS FOR ROLL AND FORGED STEEL COMPONENTS OF 500 MM WITH ACCEPTANCE SERVICE IN 100% UTI AND ULTIMATE TEST WITH OVER SIZE FOR WORKING ALL AROUND.

ITEM NO.	Q1	FORGING	ITEM NO.	Q1	FORGING	ITEM NO.	Q1	FORGING	ITEM NO.	Q1	FORGING
DESCRIPTION			DESCRIPTION			DESCRIPTION			DESCRIPTION		
QUANTITY			QUANTITY			QUANTITY			QUANTITY		
UNIT			UNIT			UNIT			UNIT		
PRICE			PRICE			PRICE			PRICE		
TOTAL			TOTAL			TOTAL			TOTAL		

TYPE OF PRODUCT
 CUSTOMER/PROJECT

DATE: 17/02/12
 BY: AMREDDY
 CHECKED: AMREDDY
 APPROVED: AMREDDY

SCALE: 1:1
 NTS

DRIVE FLANGE FORGING

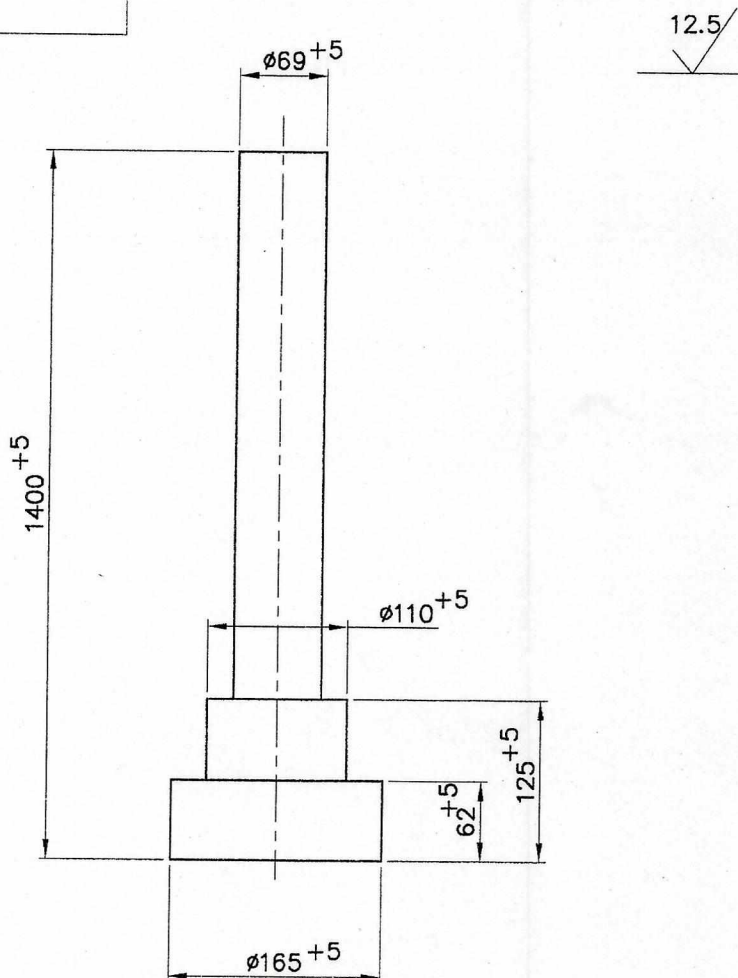
2-55-335-01605 02

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REV	DATE	ALTERED A.M.REDDY
01	18.05.13	CHECKED C.MANOJ

MATLCODE IS ALTD AS SHOWN IN BOM.

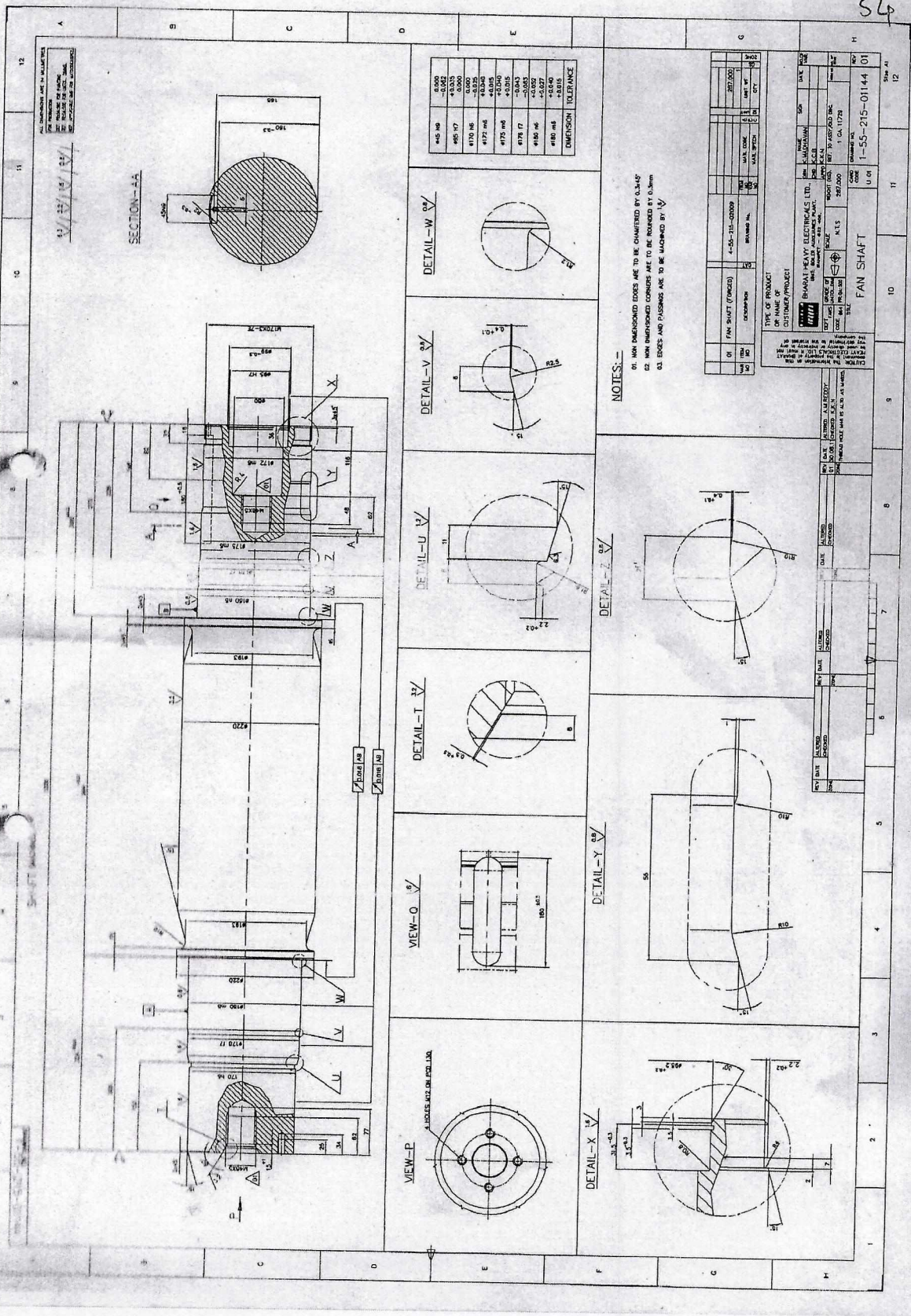
ALL DIMENSIONS ARE IN MILLIMETRES
FOR PRODUCTION
REF. PR:QA:590 FOR PAINTING
REF. PR:QA:500 FOR UNTOL. DIMNS.
REF. APPLICABLE GMS FOR MATCODE&SPEC.



01	ROD D165; L-1400	920374720200	55.500
		42CrMo4V	
ITEM NO.	DESCRIPTION	MATL. CODE	UNIT
		MATL. SPECN.	QTY

 BHARAT HEAVY ELECTRICALS LTD., UNIT: BOILER AUXILIARIES PLANT, RANIPET - 632 406.		DRN	NAME	SIGN	DATE	NO. OF VAR
		CHD	G.SUNDARAM		MAY'06	
		APPD	G.SUNDARAM		22.05.06	
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	55.500	V7000140		
TITLE			CARD CODE	DRAWING NO.	REV	
PUSH ROD (ROUGH)			U 01	4-55-334-02005	01	

Size A4

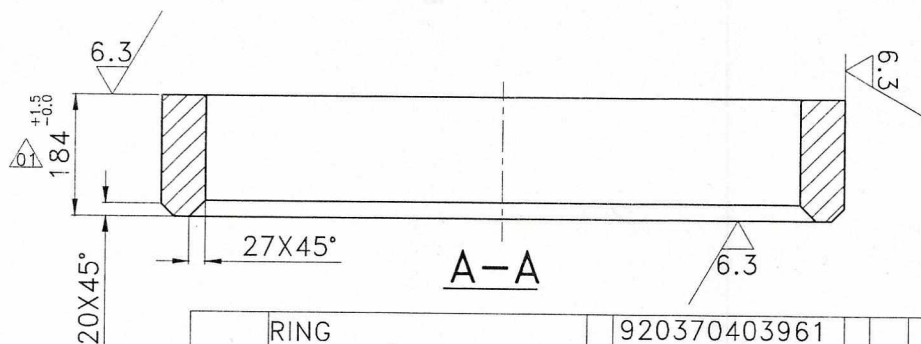
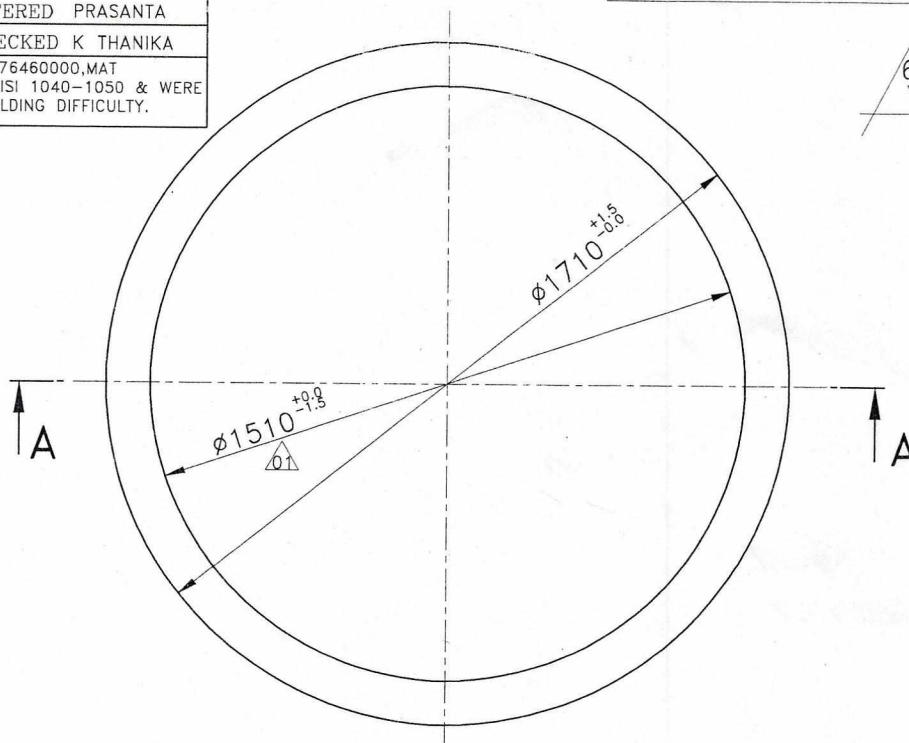


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REV	DATE	ALTERED PRASANTA
01	17.01.17	CHECKED K THANIKA
DIMENSIONS CORRECTED.1510 WAS 1595,184 WAS 189		
REV	DATE	ALTERED PRASANTA
02	03.04.17	CHECKED K THANIKA
MAT CODE WAS 920376460000,MAT SPECIFICATION WAS AISI 1040-1050 & WERE CHANGED DUE TO WELDING DIFFICULTY.		

ALL DIMENSIONS ARE IN MILLIMETRES

FOR PRODUCTION
REF.: PRQA : 590 FOR PAINTING
REF.: PRQA : 500 FOR UNTOL. DIMNS.



	RING OD1710/ID1510; 184		920370403961			709.00
			P355NH/QH			
VAR 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	PRASANTA	06/02/16	NO. OF VAR.
CHD	RS BALAJI		
APPD	RS BALAJI		

DEPT AP	GRADE OF UNTOL.DIM PR:QA:500	SCALE NTS	WEIGHT (KG). 709.00	REF. TO ASSY/OLD DRG. ----	ITEM NO	NO. OF ITEMS
CODE						
TITLE SUPPORT RING 294/900 BEARING			CARD CODE U 01	DRAWING NO. 4-52-262-03961	REV 02	

Size A4