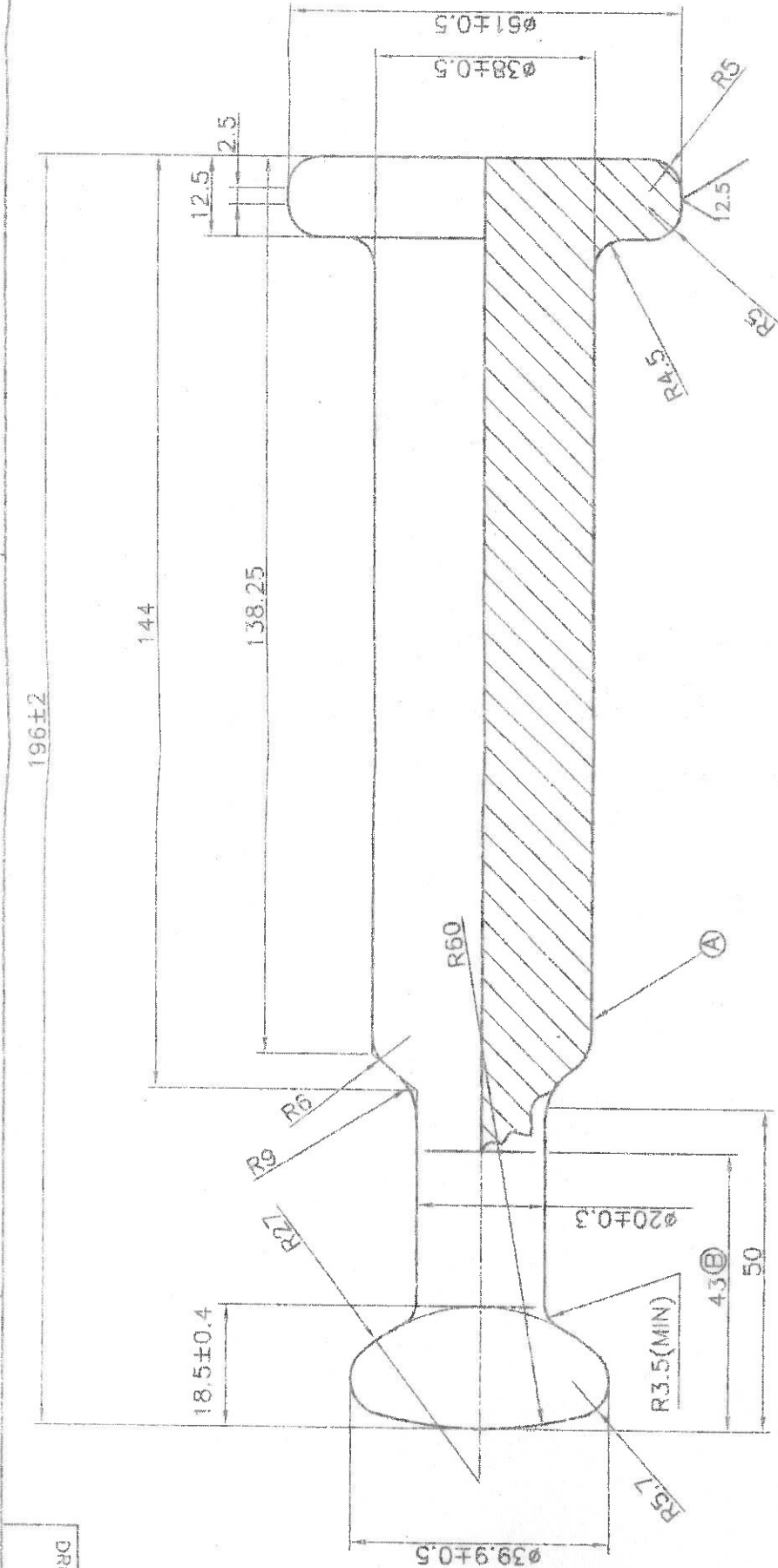


00	REV	00	15332	60	786	2	DRG No.
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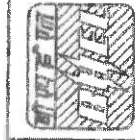


NOTES :

- 1 BALL FITTINGS ARE TO BE MADE BY FORGING PROCESS ONLY
- 2 MATERIAL TO CONFORM TO PURCHASING SPEC. EL:PS:3600103
- 3 SUPPLIER'S IDENTIFICATION MARK & RATING SHALL BE PROVIDED IN DEPRESSED FORM IN 6 mm LETTER SIZE AT PLACE SHOWN AS **A**
- 4 SEQUENCE OF OPERATIONS :
 - A) BALL FITTINGS ARE NORMALISED AFTER FORING
 - B) HARDENING & TEMPERING AND SHOT BLASTING
- 5 BEFORE GALVANISING THE BALL PORTION SHOULD ANSWER TO "GO AND NO GO" GAUGES TO DRG. No. 4 SK 0260 LATEST REVISION
- 4 SK 0261 LATEST REVISION AND CLAUSES B7,B8 & B9 OF IEC Pub. 60120 (20 mm DESIGNATION) UPTO PORTION **B**
- 6 BALL FITTING SHALL WITHSTAND A MINIMUM TENSILE STRENGTH OF 200 kN
- 7 MPI TEST TO BE CARRIED OUT ON ALL FORGED FITTINGS

CONTROLLED COPY

FERROUS PARTS ARE HOT-DIP GALVANIZED (EXCEPT FEMALE THREADS) AS PER IS:2629 AND TESTS CONFORM TO IS:2633



BHARAT HEAVY ELECTRICALS LTD.
ELECTROPORCELAIN'S DIVISION
BANGALORE 560 012

SIGN AND DATE		NAME		SIGN		DATE	
		DRN		N.CHIKKANNA		13.09.07	
		CHD					
		APPD		A K S		13.09.07	
INVENTORY No.		DEPT		GRADE OF TOL DIM C/M/F		SCALE N T S	
		CODE					
		WEIGHT (kg)		REF TO ASSY.DRG		ITEM No.	
		1.6 (Approx)				No. OF ITEMS	
TITLE		CARD CODE		DRAWING No.		REV.	
BALL FITTING PRE BORING STAGE FOR 160kN COMPOSITE LONG ROD INSULATOR				3 987 09 15332		00	
						No. OF SHEETS	
						SHT.24 SIZE A3 420 x 297	