



PLANT STANDARD

HPBP TIRUCHIRAPPALLI

BPS 419027

Rev. No. 02

PAGE 01 OF 03

HANDWHEEL WITH CIRCULAR HOLE AND KEYWAY (Dia 250 mm AND ABOVE)

0.0 SCOPE

0.1 This standard covers the requirements of handwheels with circular hole for dia 250 mm and above.

1.0 SPECIFICATION AND REFERENCE STANDARDS

Dimensions and preferred sizes	Fig 1 and Table 1 of this standard
Unspecified tolerance	As per relevant QWI
Material	Malleable Iron castings conforming to IS:14329 or S.G.Iron conforming to GR. 450/10 of IS:1865
Surface finish	The surface should be smooth. Should be free from sharp edges and unevenness.
Marking (by embossing)	As shown in figure 1.
Manuufacture, workmanship, Packing, Preservation and other requirements	As per relevant quality procedures.

2.0 REFERRED STANDARDS (Only current versions are applicable)

IS : 14329 - Malleable iron castings.

IS : 1865 - Iron castings with spheroidal or nodular graphite - specification.

3.0 DESIGNATION

3.1 A hand wheel of rim diameter 250 mm shall be designated as :

- i) Material spec column : -----
- ii) Description column : **HAND WHEEL 250**
- iii) Drawing No. column : **BPS 419027**
- iv) Material code column : -----

4.0 ORDERING DESCRIPTION

4.1 For placing indents, issuing enquiries and on purchase order, ordering description given below shall be followed.

HAND WHEEL 250 TO BPS 419027

Revisions 02 Brought upto date			Approved STANDARDS SECTION PRODUCT ENGINEERING/ FOSSILE BOILER HPBP. TIRUCHIRAPPALLI		
Rev. No. 02	Amd. No.	Reaffirmed	Prepared	Issued	Dt of 1st Issue
Dt. 30-06-2000	Dt.	Year	STANDARDS	STANDARDS	1978



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PAGE 02 OF 03

5.0 ADDITIONAL INFORMATION

5.1 Copies of this standard shall be sent along with purchase order.

Table - 1

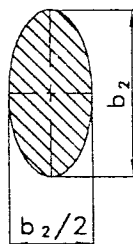
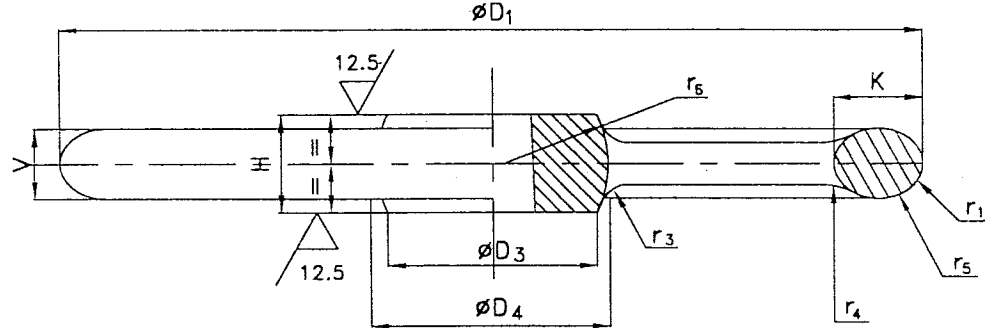
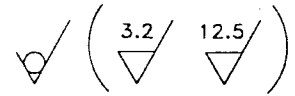
(All dimensions are in millimetres)

Rim of hand wheel	ϕD_1	250	315	400	450	500	560	710
Dia of corresponding stem		20 & 24	26 & 28	32	36 & 40	40	44	52
Hub	H	28	32	37	42	47	52	62
		40	45	52	60	65	70	80
	ϕD_2	+0.16 0.0		+ 0.190 0.0				
	ϕD_3	60	68	75	90	100	110	130
	ϕD_4	66	75	88	105	115	125	150
	r_6	28	30					40
Key Way	L_1	12	14	16	18	20	20	22
		- 0.018 - 0.061				- 0.022 - 0.074		
	L_2	43.3	48.8	56.3	64.4	69.9	74.9	85.9
		+ 0.1		+ 0.2				
Rim	V	20	22	23	24	24	26	40
	K	26	30	34	36	36	38	60
	r_1	7	7	8	9	9	9	15
	r_5	18	20	24	27	30	30	36
	L_3	60	60	68	72	72	72	80
Arm	b_1	20	22	26	30	30	30	38
	b_2	26	28	34	36	36	36	46
	r_2	8	10	11	12	12	12	15
	r_3	12		15				
	r_4	16	18	20	22	24	24	26
	θ	120°	120°	72°	72°	72°	72°	≈51.43°
Number of arms		3	3'	5	5	5	5	7
Letter size (height)	L_4	8	10	10	12	12	12	15
Weight in Kg/piece (approx)		3.8	5.7	9.18	11.57	16.3	18.00	65.00

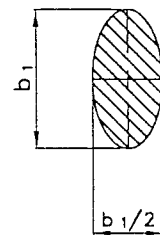
Figure-1

(ALL DIMENSIONS ARE IN MILLIMETRES)

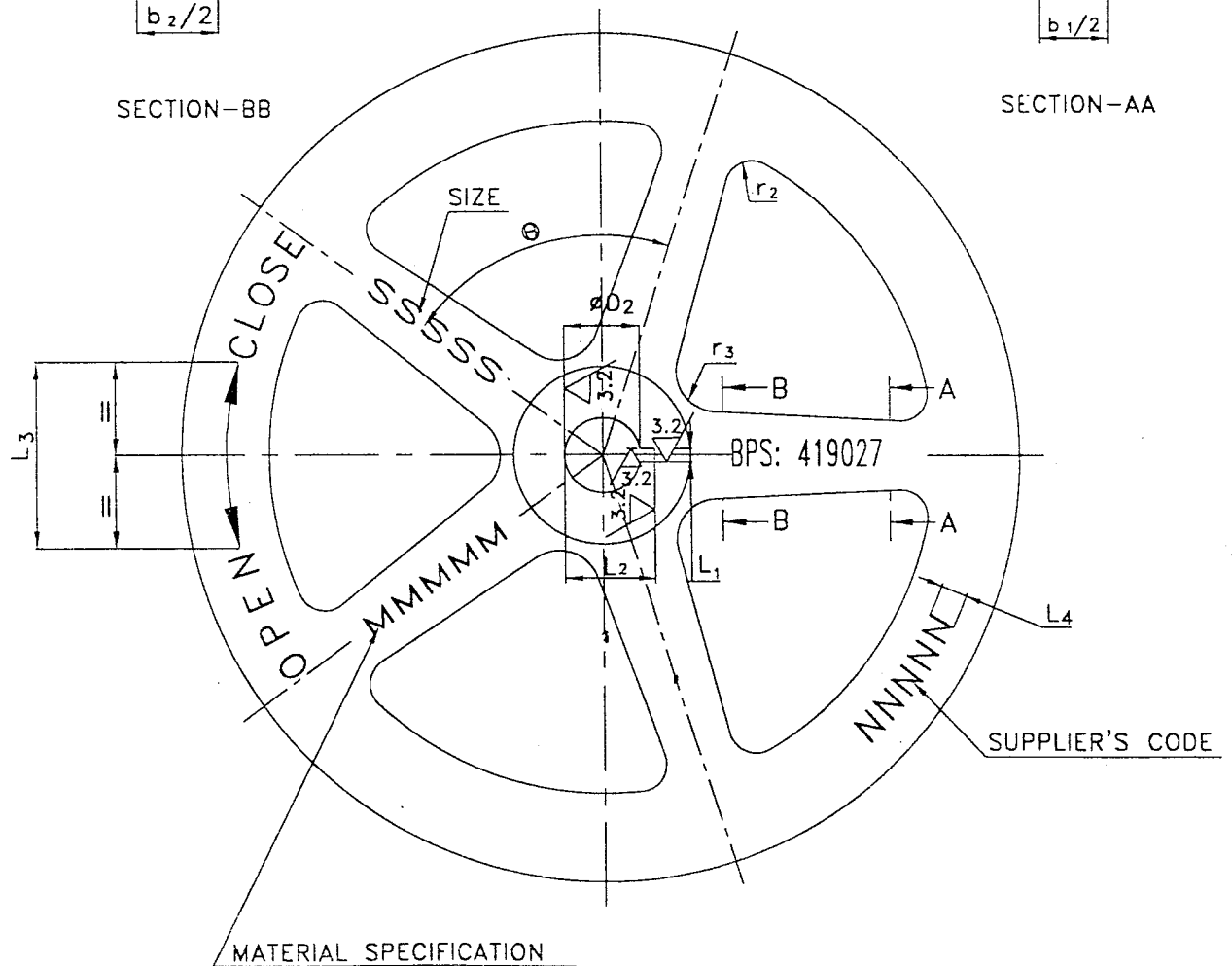
(First Angle Projection)



SECTION-BB



SECTION-AA



Note : Size, Material spec. and supplier's code are to be given in the purchase order for embossing.