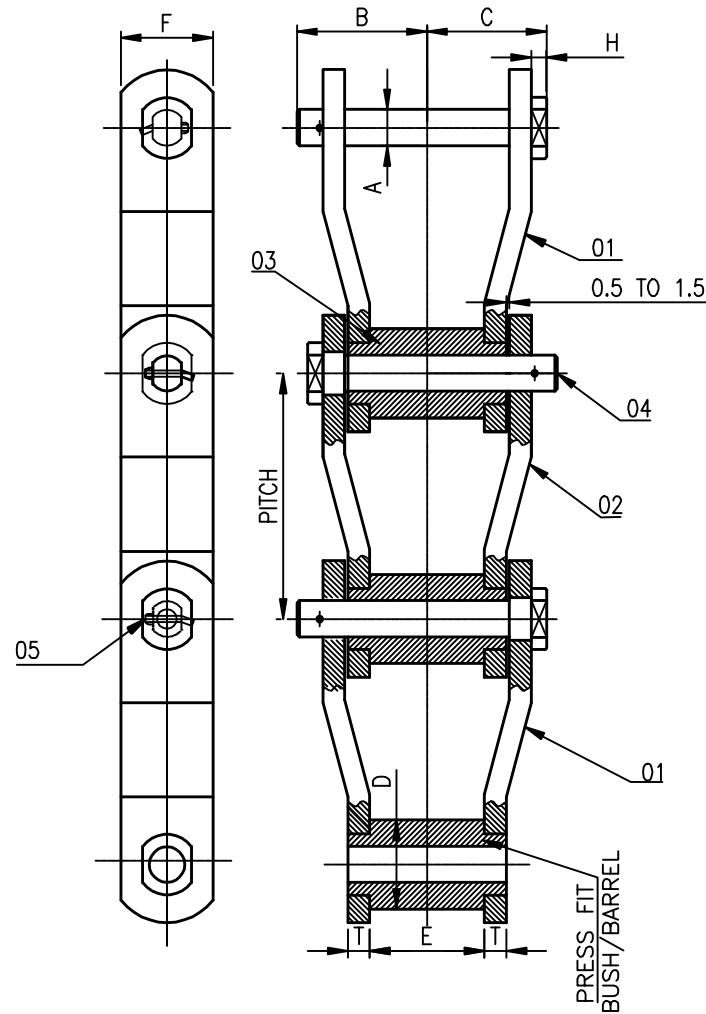


ALL DIMENSIONS ARE IN MM



**NOTES:-**

01. THIS STAGGERED ARRANGEMENT OF CHAIN HAS TO COPE UP WITH THE SHOCK LOADS, IN THE ABRASIVE, HOT AND DIRTY ENVIRONMENT. THESE CHAIN ARE USED FOR LIFTING GUILLOTINE GATE BLADES IN THE AIR/HOT AIR & FLUE GAS PATH OF COAL / OIL FIRED POWER PLANTS
02. MATERIAL AND CONSTRUCTION:- SHOULD MEET THE LOADING AND WORKING REQUIREMENTS.
03. THE DIMENSIONS PITCH, D, E, & F ARE TO BE MAINTAINED BY THE VENDOR.
04. THE DIMENSIONS "A, B, C, H & T" ARE GIVEN FOR REFERENCE ONLY, AND VENDOR HAS TO PROVIDE THE DIMENSIONAL DETAILS FOR ENGINEERING APPROVAL WITH MINIMUM BREAKING LOAD, CHAIN PRE-LOAD AND CHAIN LENGTH MEASUREMENT LOAD.
05. THE BLOCK END CLEARANCE SHOULD BE UNIFORM BETWEEN LINKS TO ASSURE FREE ARTICULATION. TOTAL BLOCK END CLEARANCE FOR BOTH SIDES TOGETHER SHOULD BE MINIMUM 1.0MM AND MAXIMUM 3.0MM.
06. MAXIMUM SIDE BOW SHOULD NOT EXCEED 3MM FOR 10 FEET LENGTH OF CHAIN
07. SIDE BAR PITCH ARE TO ACCURATELY SPACED TO ASSURE UNIFORM PITCH CONTROL HOLES ARE TO BE CAREFULLY SIZED BAR CONTROLLED PRESS FIT TO PREVENT PIN ROTATION. SIDE BARS AND BARRELS ARE TO BE HELD IN ACCURATE ALIGNMENT TO PREVENT CHAMFER OR TWIST IN ASSEMBLED STRANDS.
08. PINS, SIDEBARS, ROLLER & BUSH ARE TO BE HEAT TREATED TO WITHSTAND SHOCK, WEAR LOAD AND ENSURE HIGH STRENGTH & FATIGUE.
09. SUPPLIER HAS TO ENSURE GUARANTEE WITH TEST CERTIFICATE FOR THE ALLOWABLE CHAIN PRELOAD PULL & MINIMUM BREAKING LOAD /ULTIMATE TENSILE STRENGTH.
10. SUPPLY BITS OF CHAINS EQUIVALENT TO 10 FEET LONG AND REQUIRED PIN ACCESSORIES TO CONNECT WITH EACH BITS.
11. MARKING :- THE CHAIN NUMBER AND VENDOR'S NAME ARE TO BE PUNCHED IN THE SIDEBAR & PINHEAD.
12. PACKING :- CHAIN SHALL BE NEATLY PACKED TIGHTLY IN SEPARATE POLYTHENE BAGS AND STACKED IN A WOODEN BOX AS PER FIG 78 OF ASTM A 700-05(LATEST REV). WEIGHT OF EACH BOX SHOULD NOT EXCEED 500KGS. PACKING SLIP SHOULD CONTAIN P.O.NO, TC.NO & QUANTITY
13. THE INSPECTION & TESTING REQUIREMENT SHALL BE AS PER BHEL QUALITY PLAN NO: SQP:DAM:501 (REFER LATEST REVISION)
14. CHAIN LENGTH MEASURING LOAD 1/50 KGF OF MINIMUM BREAKING LOAD
15. CHAIN PRELOAD 1/3 OF MINIMUM BREAKING LOAD
16. INWARD INSPECTION:- VERIFY THE CORRECTNESS OF CHAIN NUMBER AND CONNECTING ACCESSORIES, APART FROM THE GENERAL INSPECTION AS PER P.O.

SL NO	CHAIN NUMBER	PITCH (MM)	CHAIN LENGTH MEASURING LOAD (KGF)	CHAIN PRELOAD (KGF)	MINIMUM BREAKING LOAD (KGF)	AVERAGE ULTIMATE STRENGTH (KGF)	DIMENSIONS (MM)						MATL. CODE		
							A	B	C	D (+0.0/-0.1)	E (+0.4/-0.0)	F (±0.5)		T	H
1.	W78	66.3 (+0.16/-0.00)	208	3467	10400	10900	12.7	41.9	36.8	22.3	28.7	28.7	6.3	6	96145123
2.	W82	78.1 (+0.19/-0.00)	225	3753	11260	11800	14.3	45.2	40.6	31.0	31.8	31.8	6.3	6	96145126
3.	W124	101.6 (+0.25/-0.00)	384	6400	19200	20900	19.0	58.7	51.8	36.6	41.4	38.1	9.1	8	96145155
4.	W132	153.7 (+0.38/-0.00)	700	11667	35000	38100	25.4	83.3	78.5	44.5	76.2	50.8	12.7	10	96145156

05	SPLIT PIN (φ )	MILD STEEL		
04	CONNECTING PIN	EN-19 OR BETTER MATERIAL		
03	BUSH	EN-9 OR BETTER MATERIAL		
02	OFFSET PLATE (TYPE-II)	EN-19 OR BETTER MATERIAL		
01	OFFSET PLATE (TYPE-I)	EN-19 OR BETTER MATERIAL		
SL NO	DESCRIPTION	MATERIAL SPECIFICATION	METHOD OF HEATTREATMENT	HADRNESS

**BILL OF MATERIALS**

REV	DATE	ALTERED : B.S
02	29.09.10	CHD & APPD: V.K
ZONE BOM TABLE ADDED		

REV	DATE	ALTERED : B.S	Bharat Heavy Electricals Ltd UNIT: BOILER AUXILIARIES PLANT RANIPET - 632 406	DRW	NAME	SIGN	DATE	No. OF	
01	9.03.09	CHD & APPD: V.K		CHKD.	L.KUPPAN		09.03.09	VAR.	
ZONE		WELDED TYPE CHAIN IS REPLACED WITH BUSHED TYPE CHAIN AND DIMENSIONS B, C & W ARE REMOVED	DEPT.	DP	GRADE OF UNTOLOM. PRDGA	SCALE	WEIGHT (KG.)	REF. TO ASSY. / OLD DRG.	ITEM No.
		NOTES REVISED	CODE.	877	500	SCALE	WEIGHT	REFDRG	REV.
		GATE CHAIN ( BUSH )	TITLE	DRAWING No.		3-48-003-59763		02	
			CARD CODE	U 01					