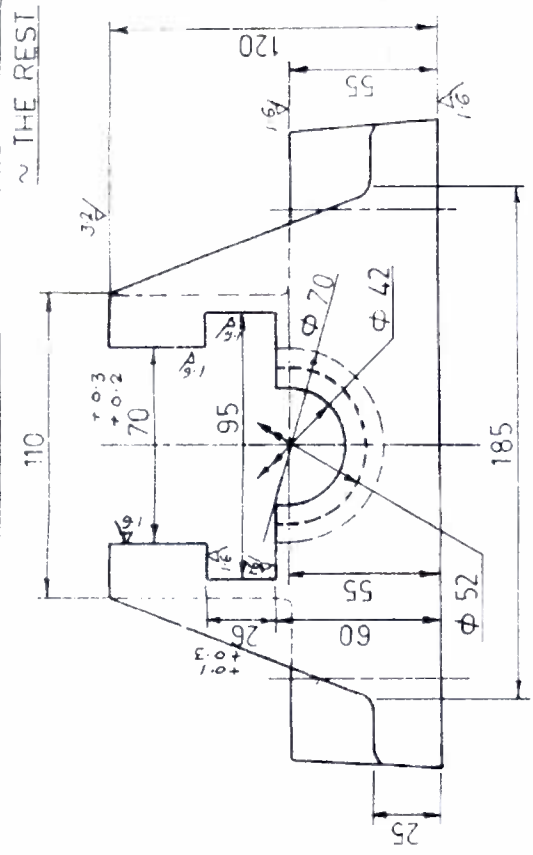


15

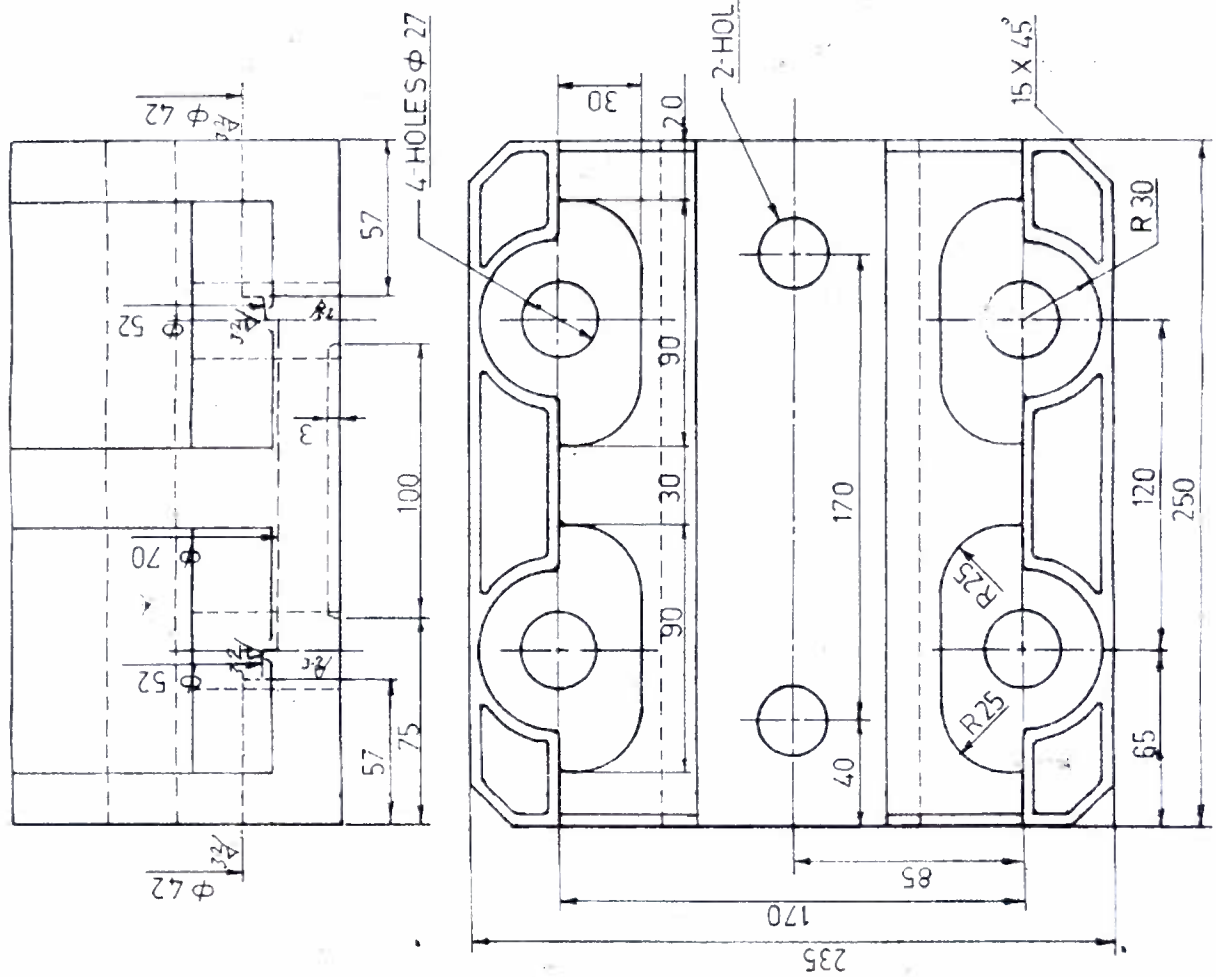


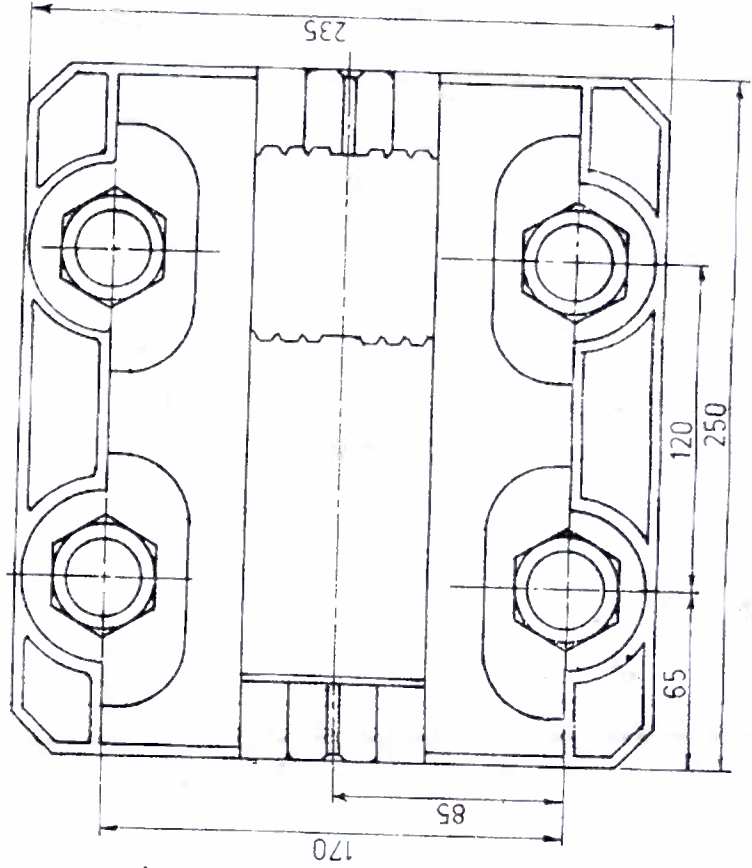
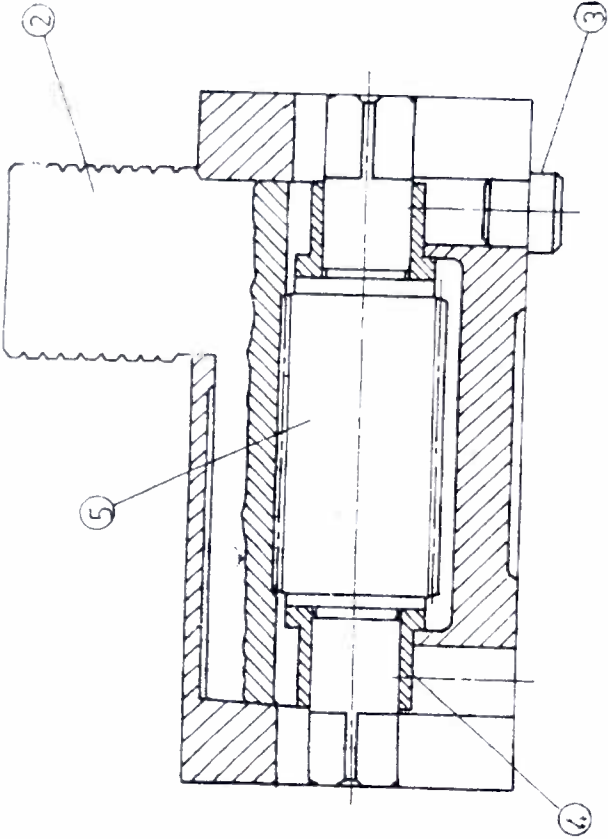
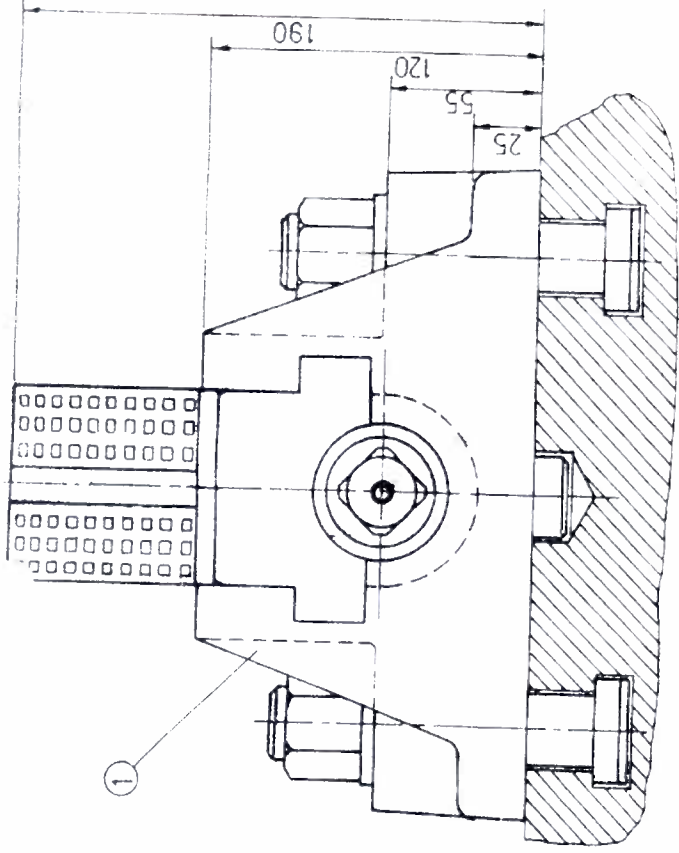
MATERIAL: CAST IRON GRADE C-20

BHARAT HEAVY ELECTRICALS LTD.
 UNIT: CENTRAL FOUNDRY FORGE PLANT.
 HARDWAR.



DEPTT M/C SHOP	SCALE 1:2	WEIGHT (KGS)	DRAWN DK MISHRA	SIGN S	DATE
TITLE BODY FOR JAW FOR VTB 2.1 m			WORKED	CHECKED SR KASHYAP	DATE
			APPROVED	R MEHRA	DATE
			DRAWING NO. 04-05-070		
			SHEET NO. 1	NO OF SHEETS 5	





BHARAT HEAVY ELECTRICALS LTD.
 UNIT : CENTRAL FOUNDRY FORGE PLANT.
 HARDWAR.

DEPT. M/C SHOP
 TITLE

SCALE 1:2

WEIGHTS

JAW FOR VTB 2.1m
 (ASSEY.)

DATE

NAME
 DK MISHRA
 S.P. KASIMVA

SIG.

APPROVED
 R. MEHRA

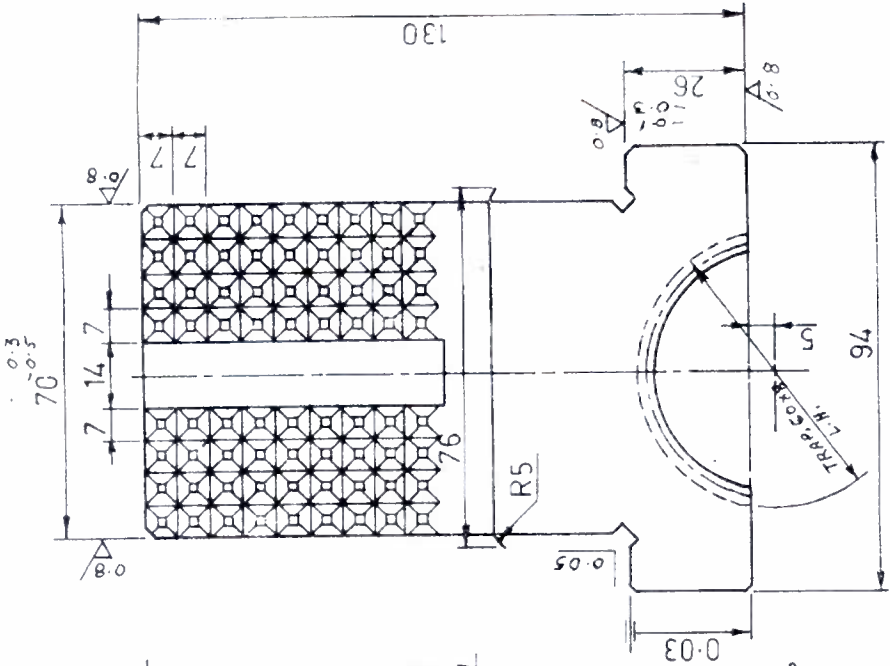
DRAWING NO. 04-05-070

SHEET NO. 1

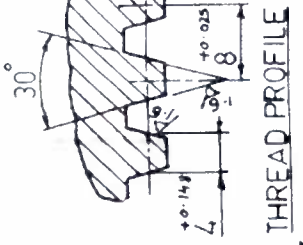
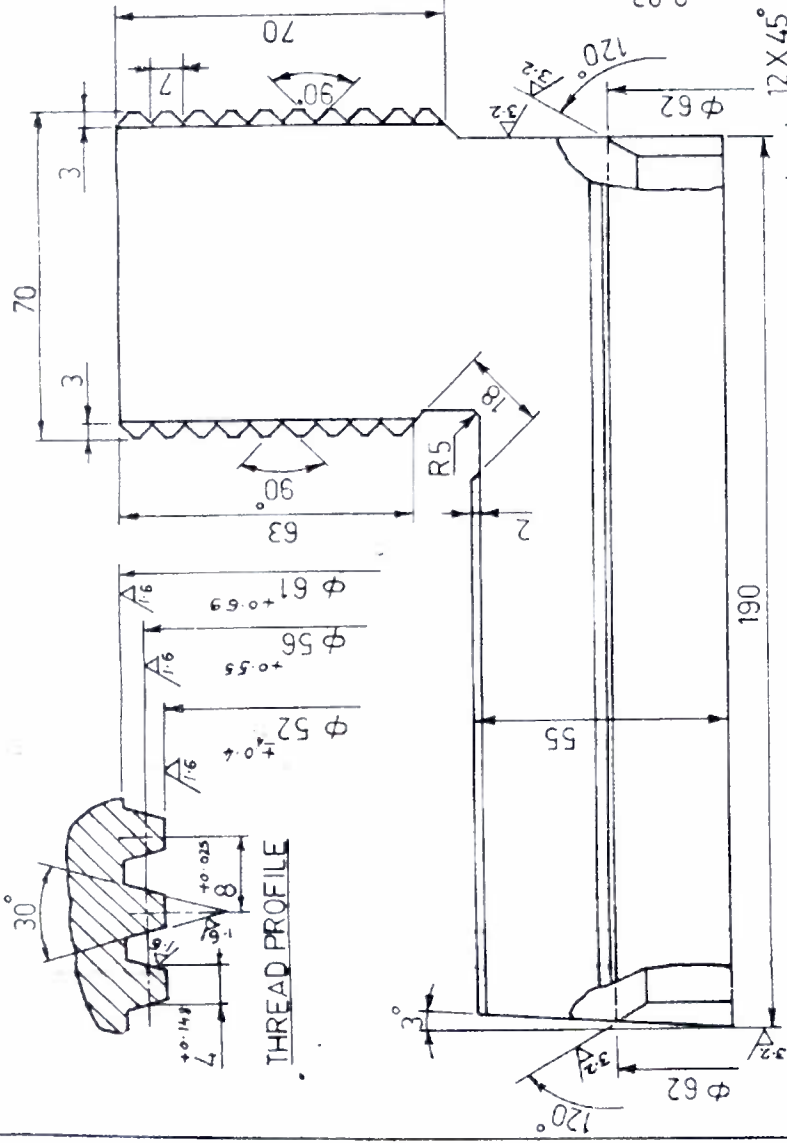
NO. OF SHEETS 5



5

6.3 THE REST



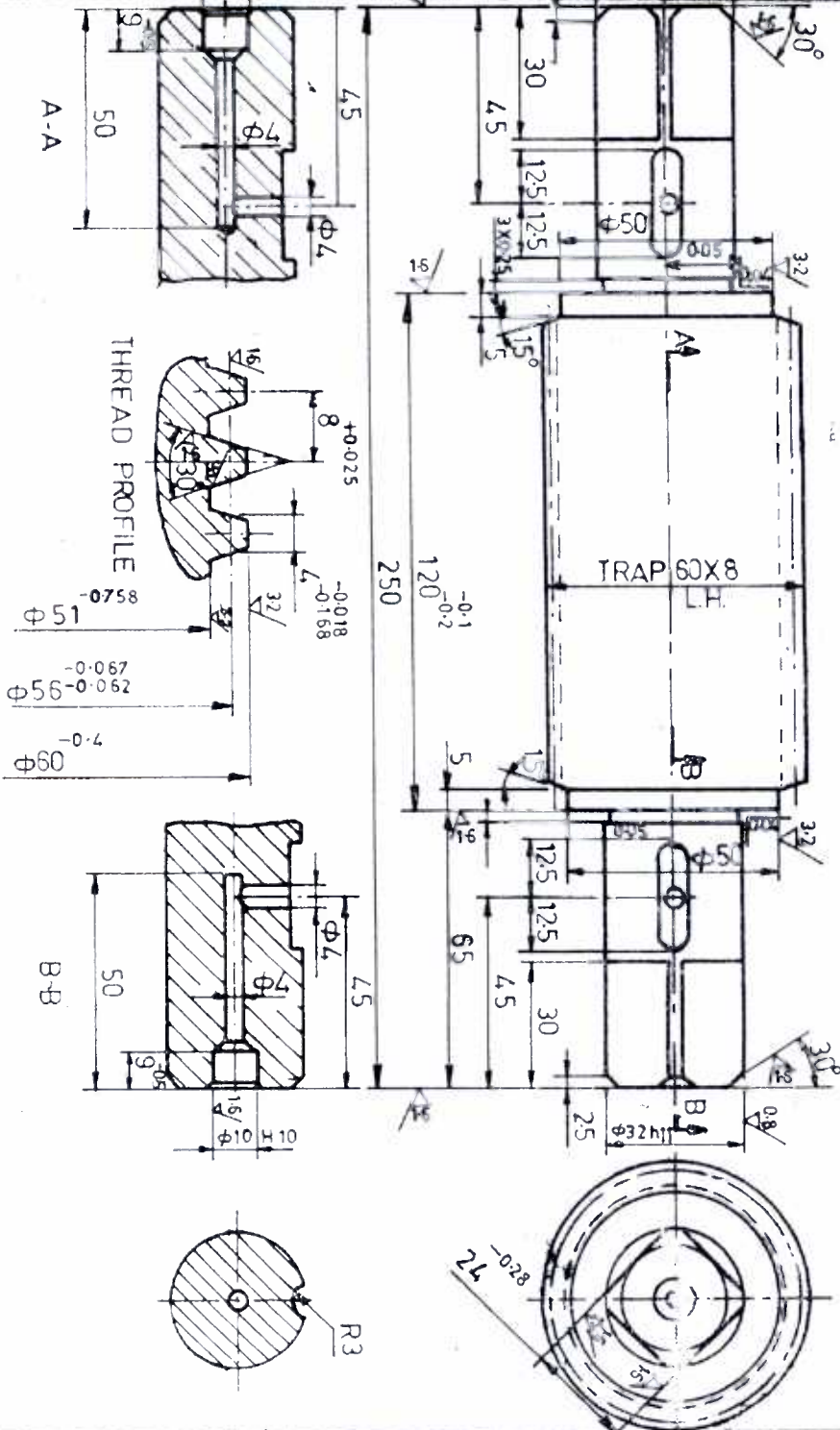
MATERIAL- C-45
HEAT TREATMENT HRC-45
BLUNT ALL SHARP CORNERS



		BHARAT HEAVY ELECTRICALS LTD. UNIT : CENTRAL FOUNDRY FORGE PLANT. HARDWAR.		NAME D.K. MISHRA	SIGN 	DATE 11/05/16
		DEPT RMS	SCALE NTS	WEIGHT (KGS)	DRAWN D.K. MISHRA	CHECKED S. K. MEHRA
TITLE JAW (FOR BV 21 M)		DRAWING NO. 04-05-070		SHEET NO. 2		NO OF SHEETS 5

13

2



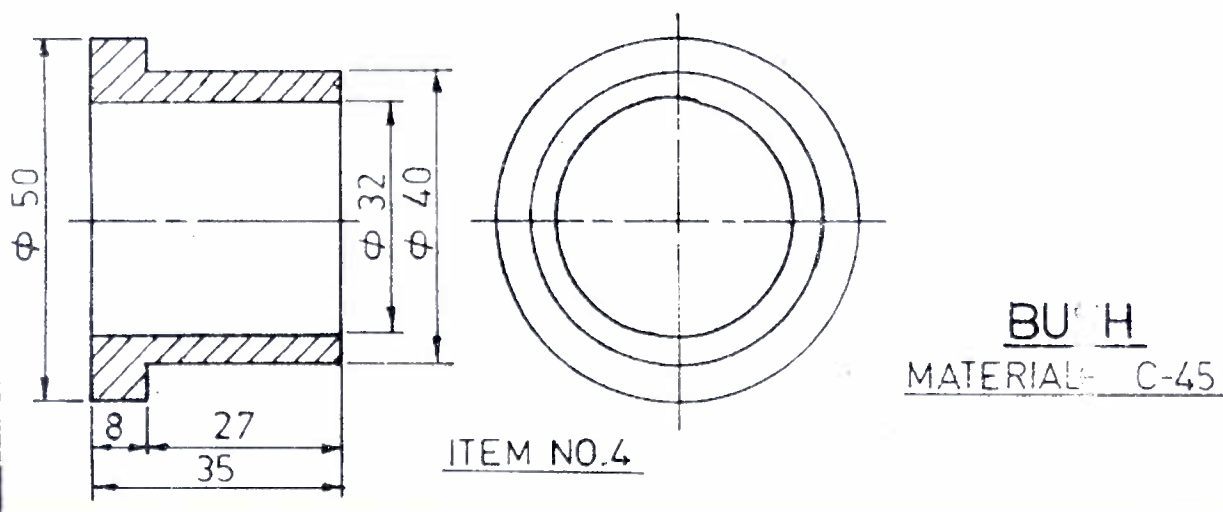
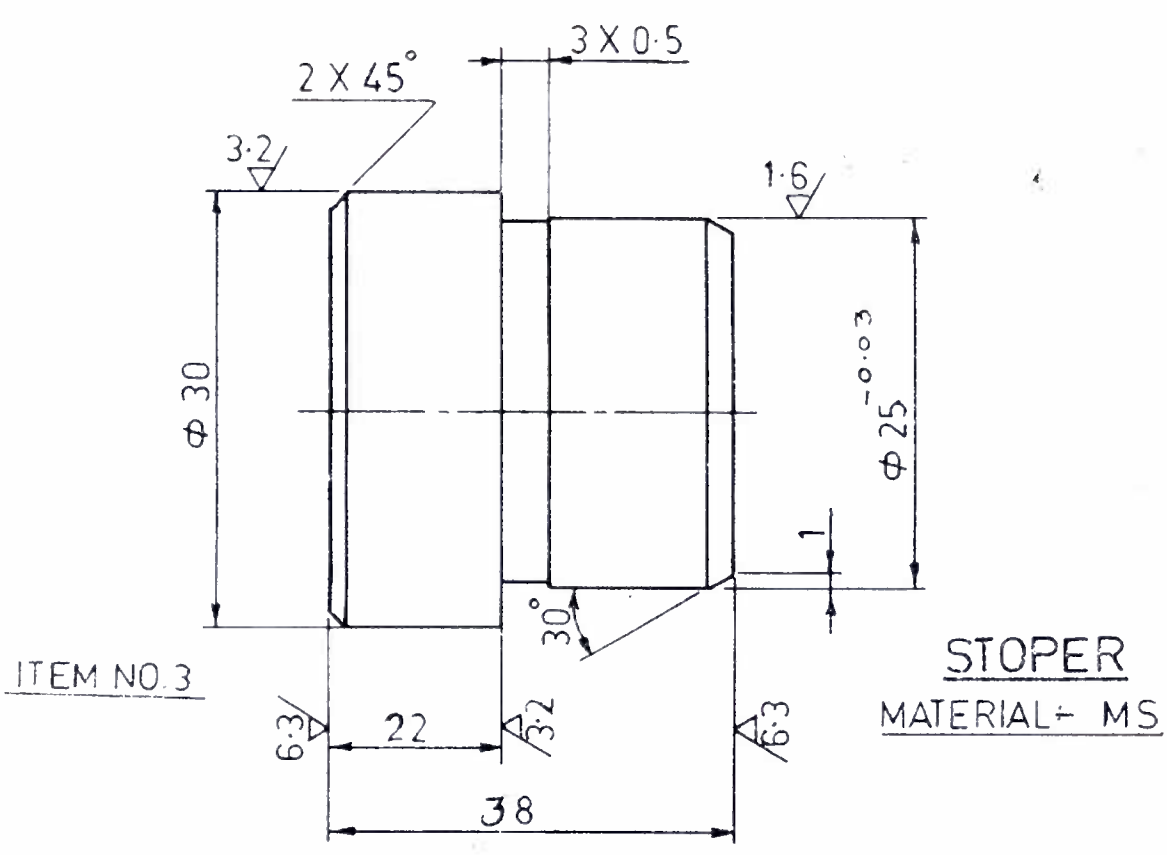
NOTE—
 1- BLUNT ALL SHARP CORNERS.
 2- HEAT TREATMENT HRC-40

MATERIAL—
 C-45



BHARAT HEAVY ELECTRICALS LTD.
 UNIT : CENTRAL FOUNDRY FORGE PLANT.
 HARDWAR.

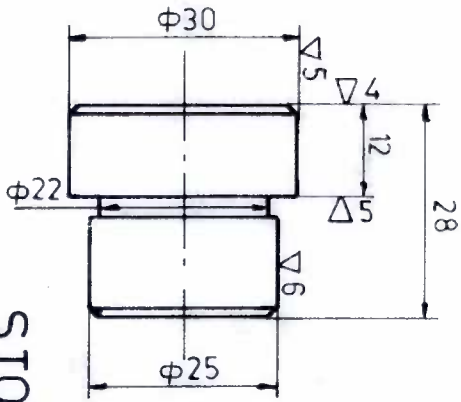
DEPTT. M/C SHOP	SCALE NTS.	WEIGHT (KGS)			
TITLE SCREW FOR VTB 2.1 m			DRAWN	N. LAL	SIGN. <i>N. Lal</i> DATE 25/5/90
			WORKED		
			CHECKED	R. MEHRA	SIGN. <i>R. Mehra</i> DATE 25/5/90
			APPROVED		
			DRAWING NO.	04-05-070	



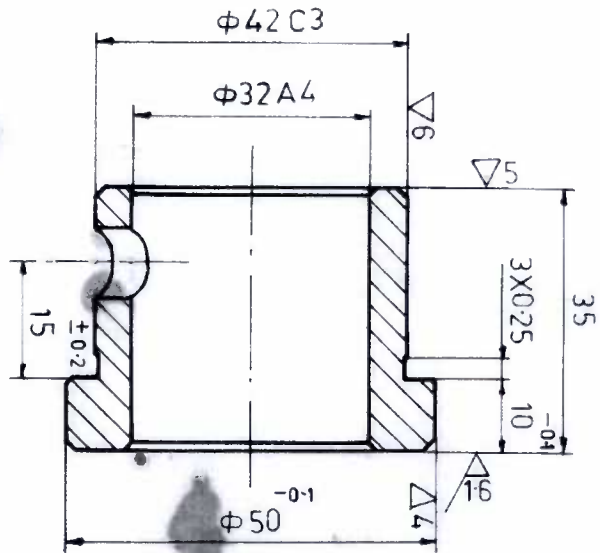
BHARAT HEAVY ELECTRICALS LTD.
UNIT : CENTRAL FOUNDRY FORCE PLANT.
HARDWAR.

DEPTT	RMS	SCALE	NTS	WEIGHT (KGS)				
TITLE STOPER & BUSH					DRAWN	NAME	SIGN	DATE
					WORKED	D.K. MISHRA	<i>[Signature]</i>	
					CHECKED	S.P. KASHIWA	<i>[Signature]</i>	5/16/96
					APPROVED	R. MEHRA		
					DRAWING NO	04-05-070		

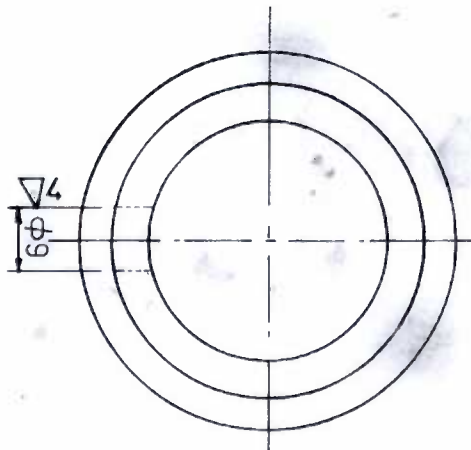
10



STOPPER



INSERT



MATERIAL:-

C-40
HRC-35

NOTE:-

- SHARP EDGES TO HAVE CHAM. 1X45°
- TOL. ±0.25 UNLESS OTHERWISE STATED.



BHARAT HEAVY ELECTRICALS LTD.
 UNIT : CENTRAL FOUNDRY FORGE PLANT.
 HARDWAR.

DEPT. M/C SHOP SCALE 1:1 WEIGHT (KGS.)

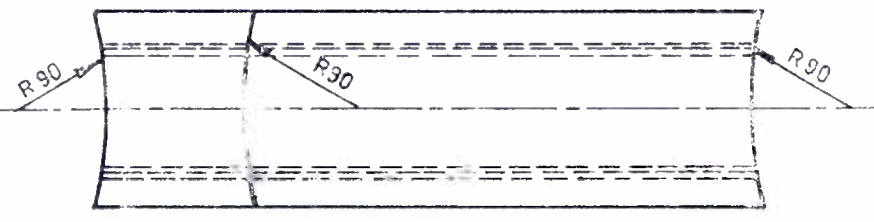
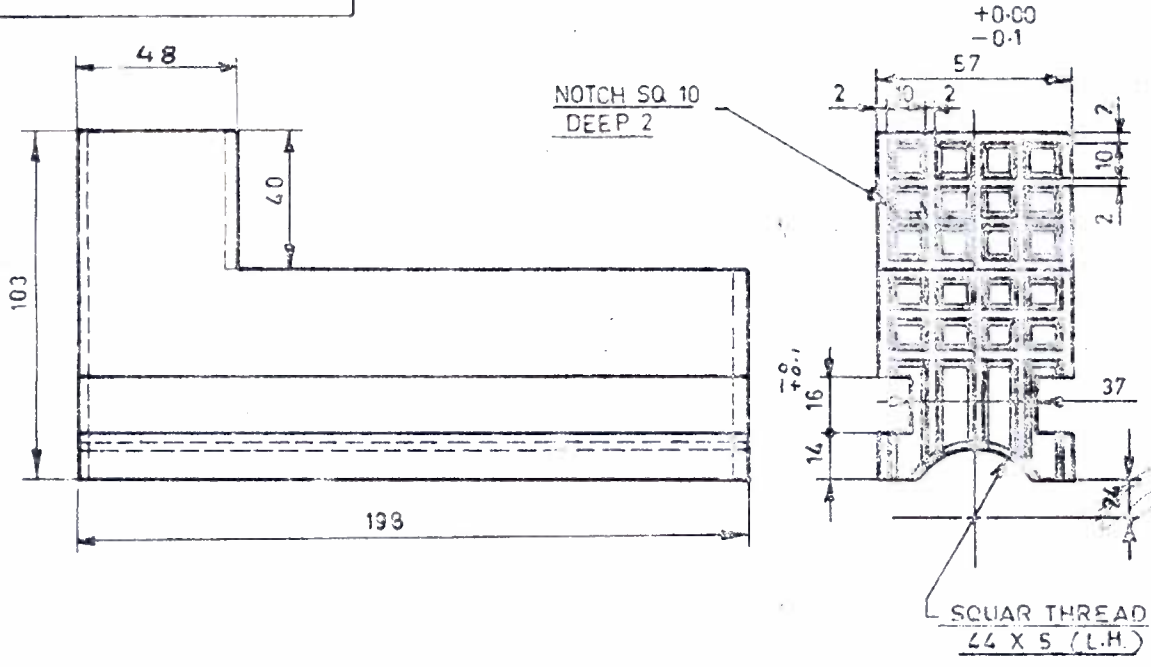
TITLE
 PARTS OF BV 2.1
 JAW ASSEMBLY

DRAWN	NAME H.LAL	SIGN. <i>H.Lal</i>	DATE 30.5.98
WORKED			
CHECKED	R. MEHRA	<i>R</i>	12.6.98
APPROVED			
DRAWING NO.		04-05-044	
SHEET NO.	1	NO. OF SHEETS	1

9

04-05-022

▽6 ALL OVER



MATERIAL: C-40
HARDNESS TO HRC 30-35

ALL SHARP EDGES TO HAVE CHAM. 5 X 45°
TOLERANCES ±0.25
UNLESS OTHERWISE STATED.



JAW

04-05-022

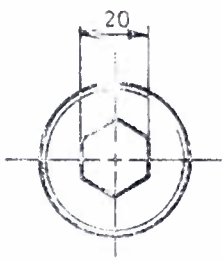
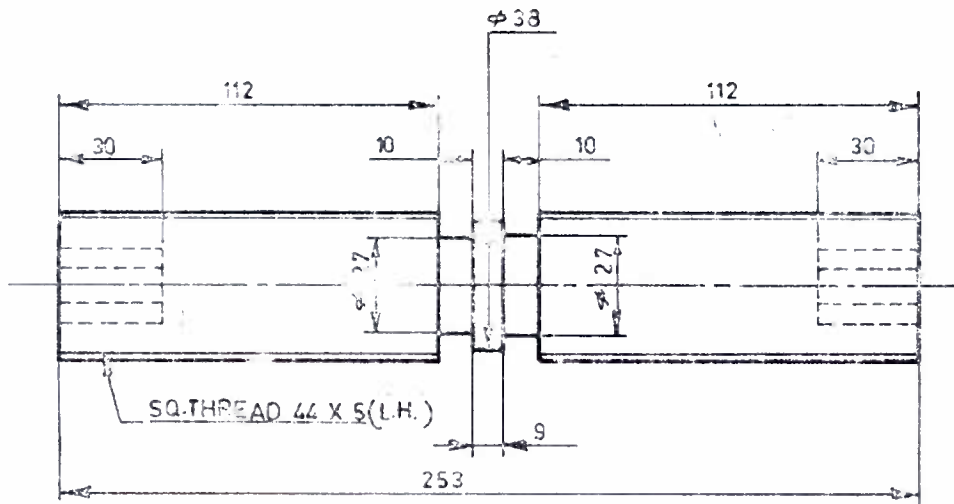
	NAME	SIGN	DATE
DRAWN	MISHRA		15.12.83
CHECKED	K A RAO		15.12.83
APPROVED			

CODE	WEIGHT	QTY
		1
SHEET 2	TOTAL SHEETS 5	
C.F.P.P.	M/C S/O	

3

220-50-70

▽6 ALL OVER



MATERIAL: C-40
 HARDNESS TO HRC 25-30

ALL SHARP EDGES TO BE ROUNDED OFF.

TOLERANCES ± 0.25
 UNLESS OTHERWISE STATED.



LEAD SCREW

04-05-022

	NAME	SIGN	DATE
DRAWN	MISHRA	<i>[Signature]</i>	16.12.88
CHECKED	K.A.R.SO	<i>[Signature]</i>	
APPROVED			

CODE	WEIGHT	SCALE
		1:2
SHEET 3	TOTAL SHEETS 5	
C.F.F.P.	N/C SHOP	

220 - 50 - 70

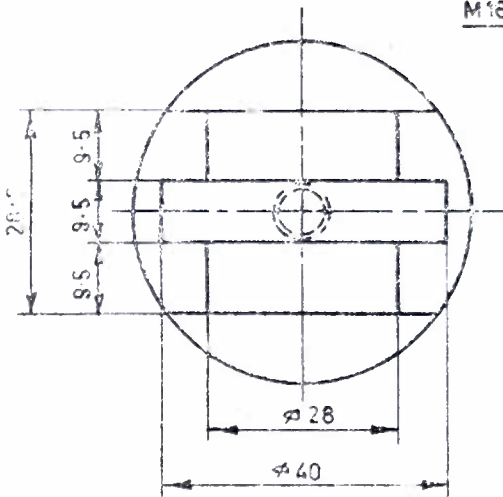
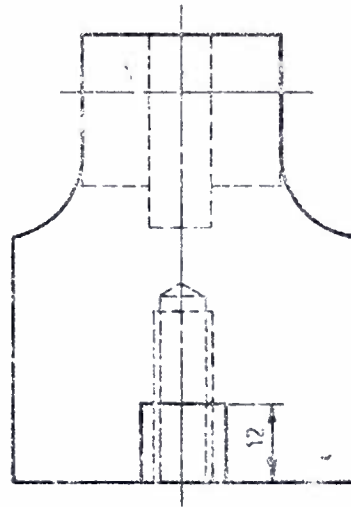
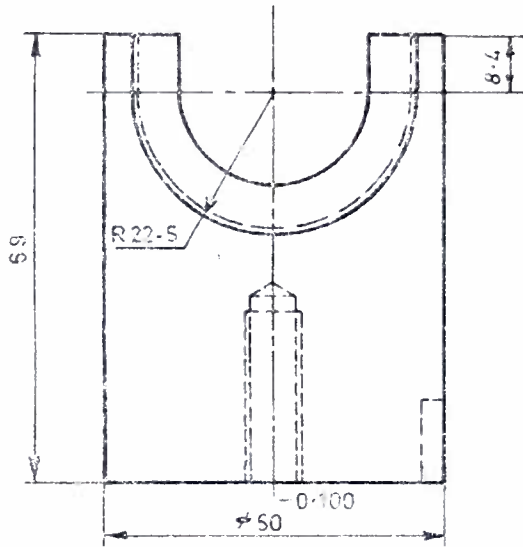
CTX@

⊕▲-S ▶

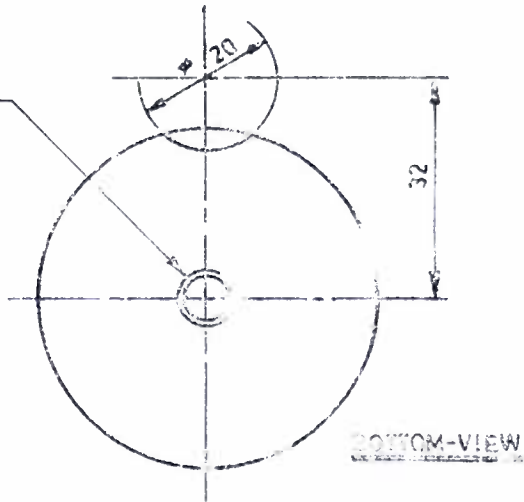
▽5 ALL OVER

▶409 ≡⊙ ▶410⊙(

?φ?φ+



M16, DEEP 25



BOTTOM-VIEW

MATERIAL: C-40
HARDNESS TO HRC 40-45

ALL SHARP EDGES TO BE FOUNDED OFF.

TOLERANCES ± 0.25
UNLESS OTHERWISE STATED.



LOCKING LIVER

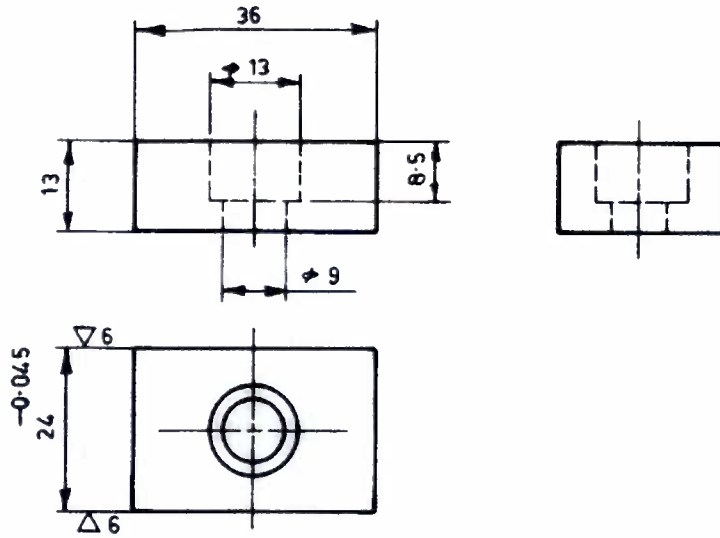
04-05-022

	NAME	SIGN	DATE
DESIGNED	MISHRA	<i>[Signature]</i>	5.12.88
CHECKED	K.A.RAO	<i>[Signature]</i>	
APPROVED			

CODE	WEIGHT	SCALE
		1:1
SHEET 4	TOTAL SHEETS 5	
C.F.F.P.	M/C SHOP	

220 - 50 - 70

∇4 THE REST



MATERIAL :- C-40, IS : 1570
HARDEN TO HRC 40-45

SHARP EDGES TO HAVE CHAM. 2 X 45°
TOLERANCES ± 0.25
UNLESS OTHERWISE STATED.



KEY

04 - 05 - 022

CODE	WEIGHT	SCALE
		1:1

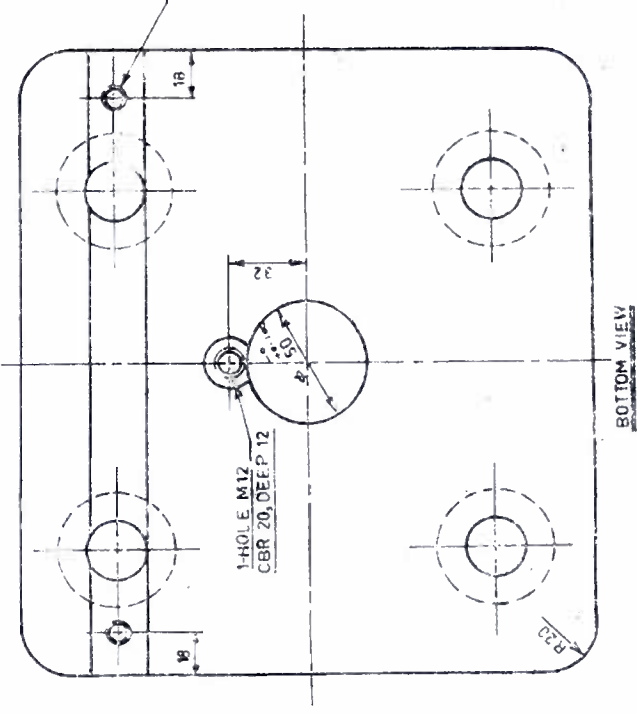
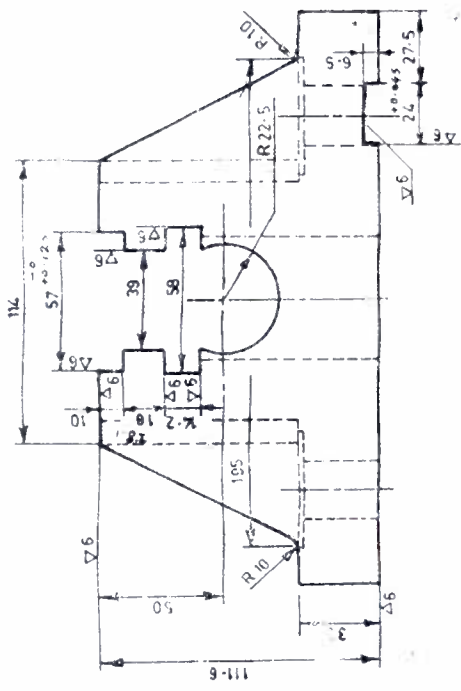
1:1

	NAME	SIGN	DATE
DRAWN	MISHRA	<i>[Signature]</i>	16.12.73
CHECKED	K.A. RAO	<i>[Signature]</i>	
APPROVED			

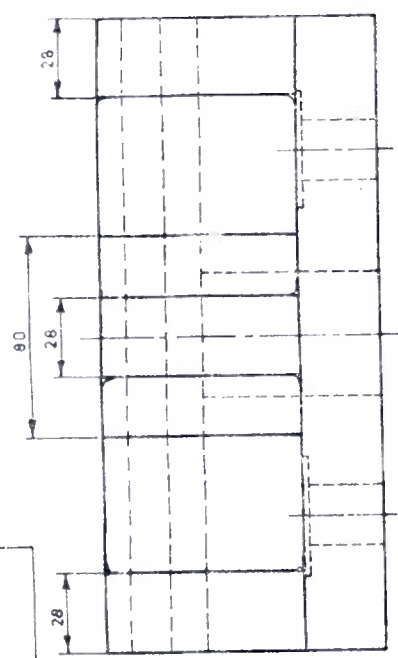
SHEET 5 TOTAL SHEETS 5

C.F.F.P. M/C SHOP

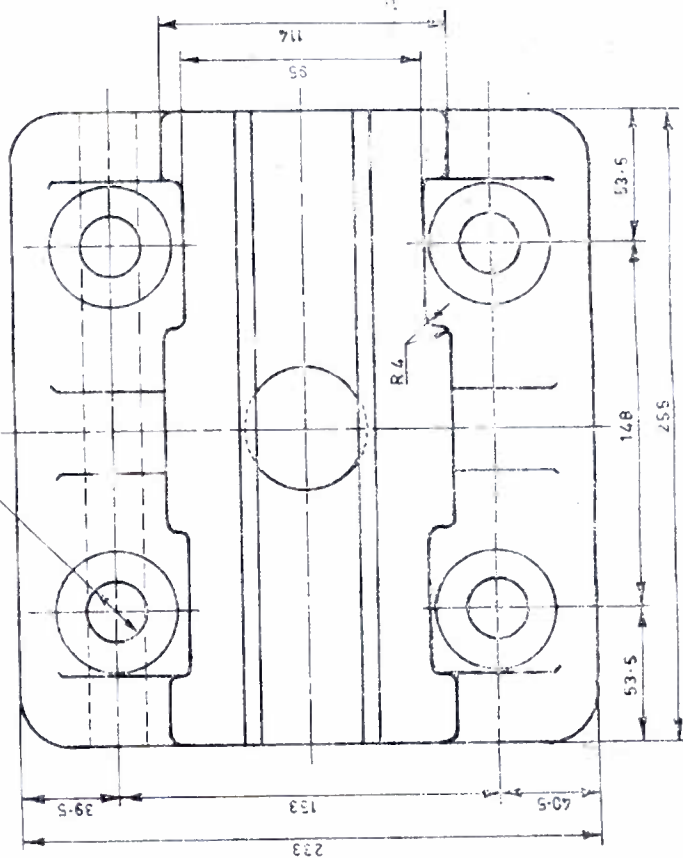
~ THE REST



BOTTOM VIEW



4 HOLES φ23
CBR 47, DEEP 2

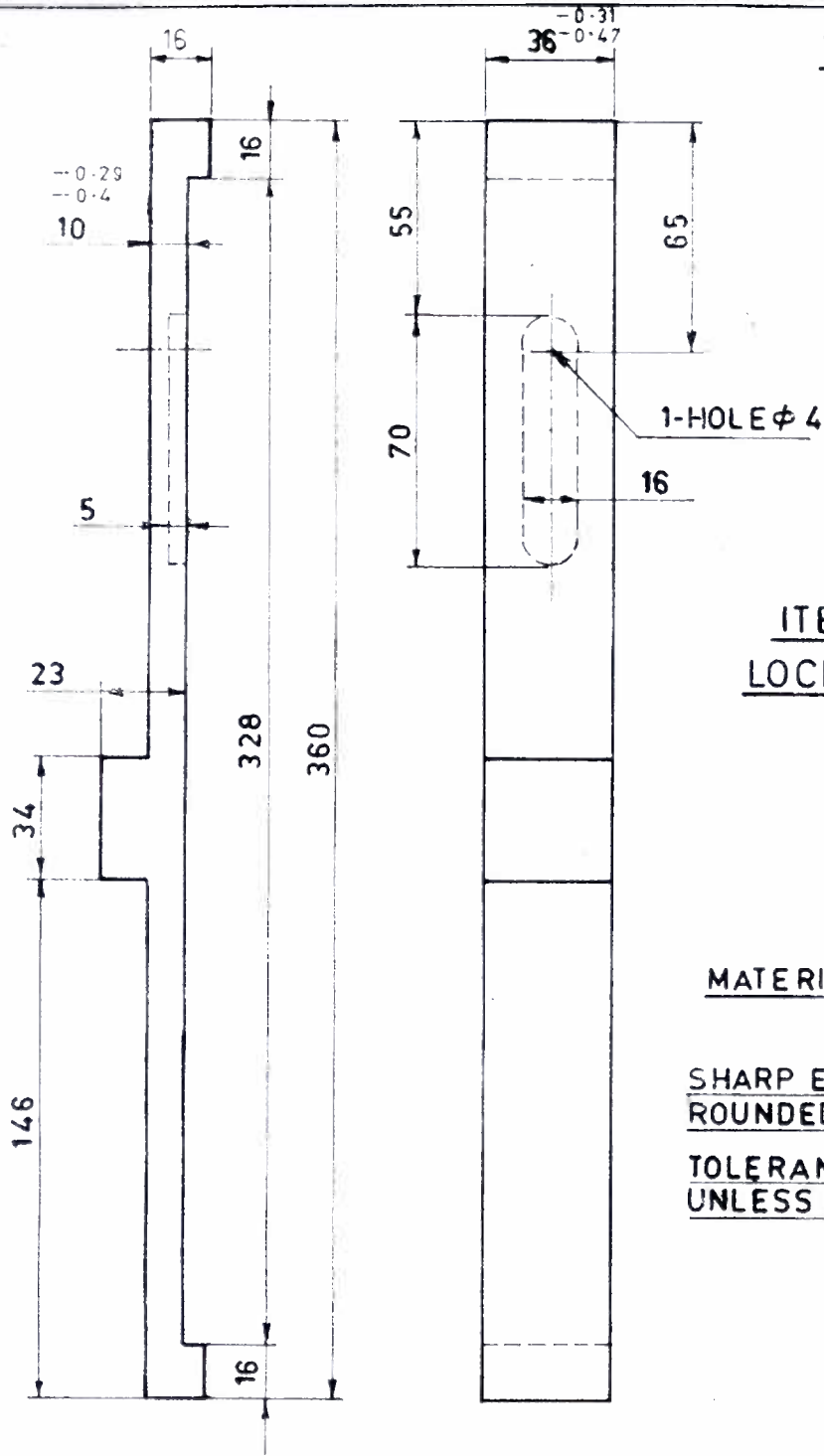


04 - 05 - 022		CODE	WEIGHT	SCALE
BODY OF JAW FOR VT B 1.5 M				1:2
DATE		DATE	TOTAL SHEETS 5	
DRW. BY	CHK. BY	DATE	C.F.F.P. M/C SHOP	
APPROVED				

MATERIAL: CAST IRON GRADE C-20

ALL SHARP EDGES TO HAVE CHAM 2 X 45°
DIMENSIONS ± 0.20 UNLESS OTHERWISE STATED.

220 - 50 - 70



▽5 ALL OVER (4)

ITEM NO.5
LOCKING PLATE

MATERIAL - M.S.

SHARP EDGES TO BE
ROUNDED OFF.

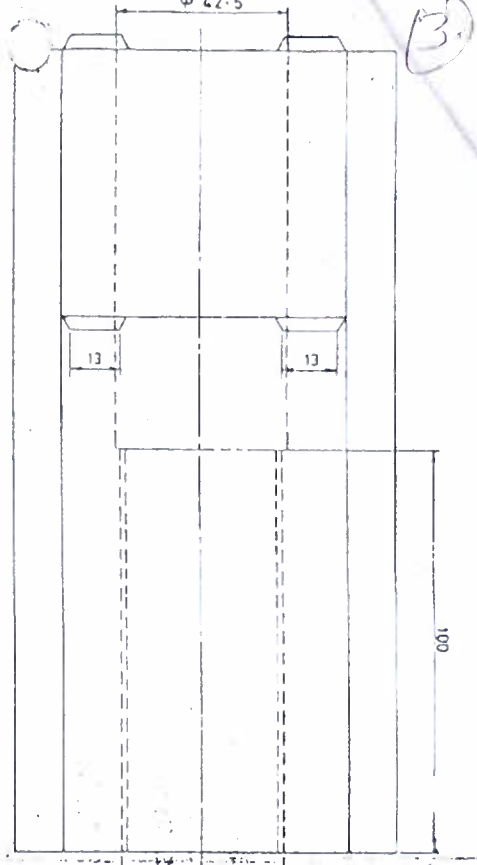
TOLERANCES ± 0.25
UNLESS OTHERWISE STATED



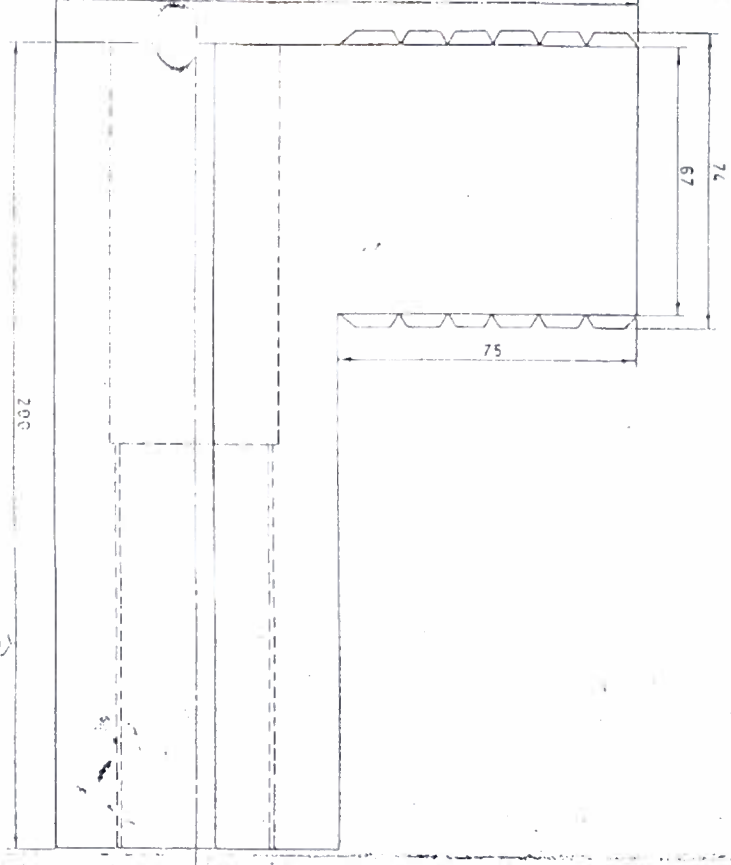
BHARAT HEAVY ELECTRICALS LTD.
UNIT : CENTRAL FOUNDRY FORGE PLANT.
HARDWAR.

DEPTT	M/C SHOP	SCALE	1:2	WEIGHT (KGS)				
TITLE	CHUCK - JAWS FOR VTB 2.5 M				DRAWN	D.K. MISHRA	SIGN	DATE
					WORKED			
					CHECKED	R.C. SHARMA		
					APPROVED	K.A. RAO		15/7/50
					DRAWING NO	04-05-048		
					SHEET NO	3	NO OF SHEETS	3

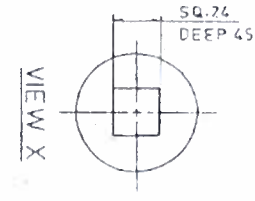
3



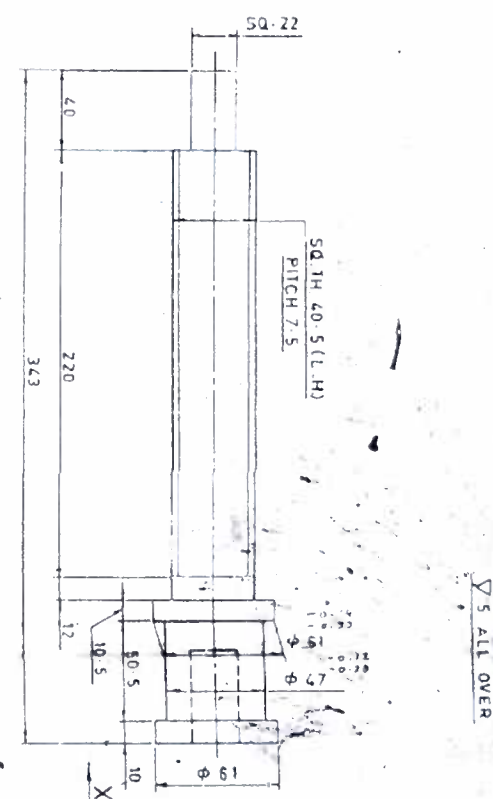
SQ. TH. 40-5(L.H.)
PITCH 7.5



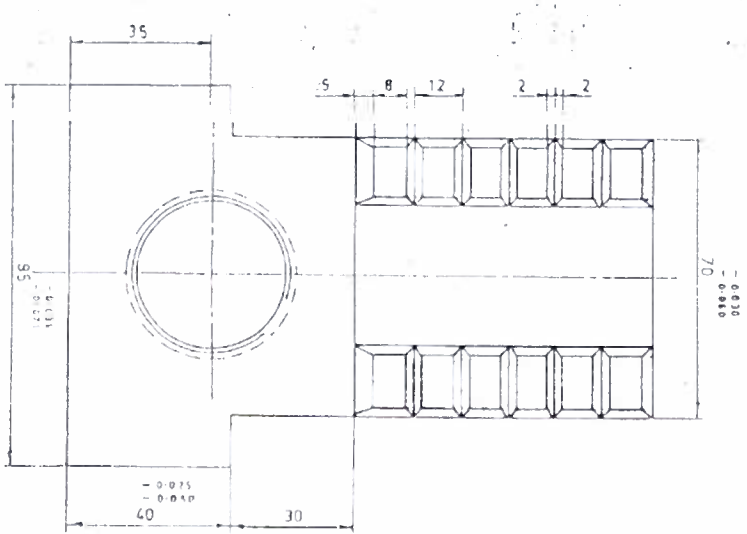
ITEM NO. 1
JAW



VIEW X



ITEM NO. 2
LEAD SCREW



MATERIAL

- 1 C-40
HARDNESS HRC 30-35
 - 2 C-40
HARDNESS HRC 25-30
- ALL SHARP EDGES TO BE ROUNDED OFF.

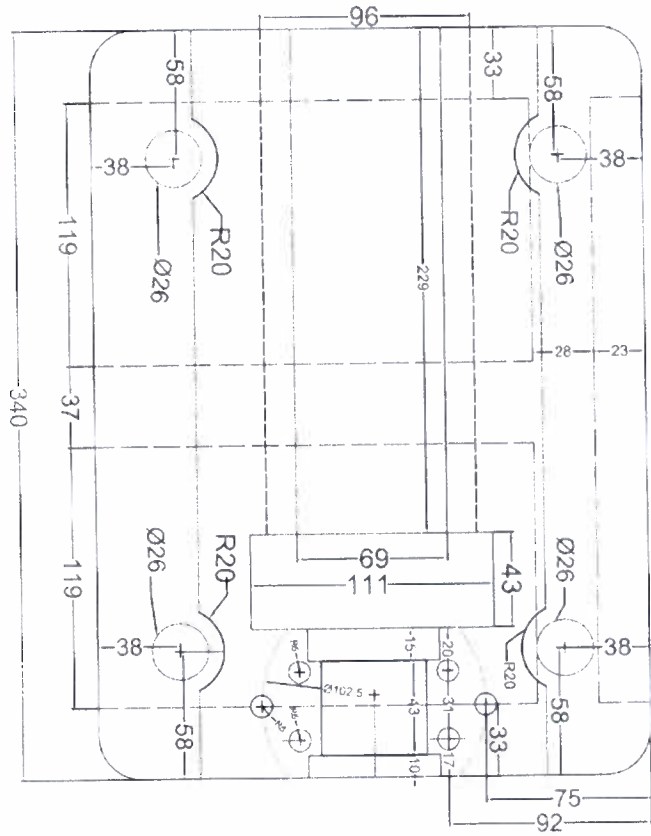
▽ 5 ALL OVER

		BHARAT HEAVY ELECTRICALS LTD. UNIT : CENTRAL FOUNDRY FORGE PLANT. HARDWAR.	
DATE	Q.P.T.	SCALE	WEIGHT (KGS)
07/05/07	RMS	1:1, 1:2	
CHUCK JAW FOR VTB 2.5			
DESIGNER	CHECKED	APPROVED	
K. S. BHARATI	K. S. BHARATI	K. S. BHARATI	
DATE	DATE	DATE	
07/05/07	07/05/07	07/05/07	

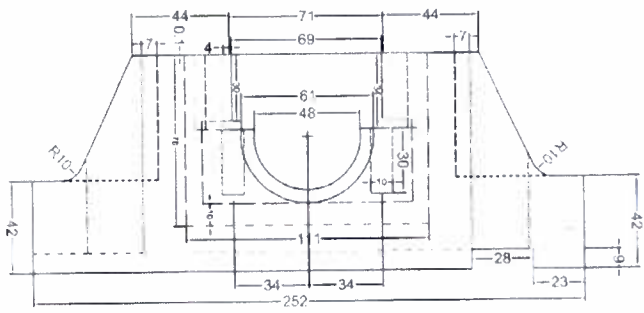
50-40

DRAWING NO.

ALL DIMENSIONS ARE IN mm



TOP VIEW



VIEW A

NOTE :- BODY SHOULD FIT THE OTHER COMPONENTS

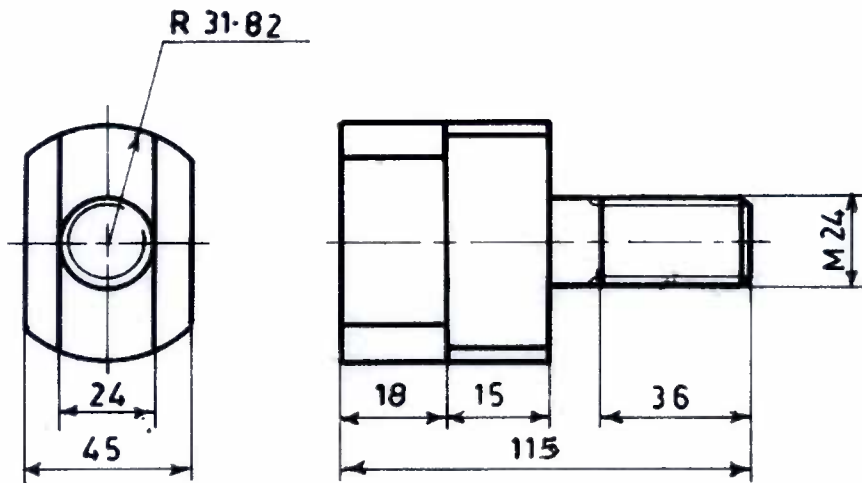
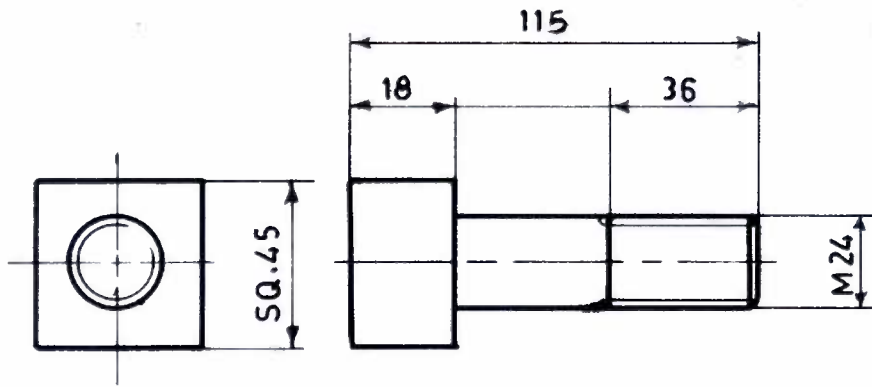


BHARAT HEAVY ELECTRICALS. LTD.
CENTRAL FOUNDRY FORGE PLANT
RANIPUR HARDWAR

DEPTT. -M/C SHOP	WEIGHT IN KG	NAME	SIGN	DATE
TITLE		DRN S.S. HEMBRAM		
BODY OF VICE (VTB 2.5 M)		CHD M. ASAD		
		Appr R.K. SINGH		

ALL DIMENSIONS ARE IN mm

CFFP DRAWING NO. 04-05-048
 SHEET NO. 4A



TOLERANCE ± 0.25

UNLESS OTHERWISE STATED.

SHARP EDGES TO HAVE 1.5 X 45 CHAMFER

MATERIAL: EN 9

HARDNESS 45-50 HRC



JAWS BOLT
FOR
V B - 25

04-05-008

CODE	WEIGHT	SCALE
		NTS

	NAME	SIGN	DATE
DRAWN	MISHRA		
CHECKED	RAWAT		
APPROVED	SSA		

SHEET 1	TOTAL SHEETS 1
C.F.F.P.	M/C SHOP