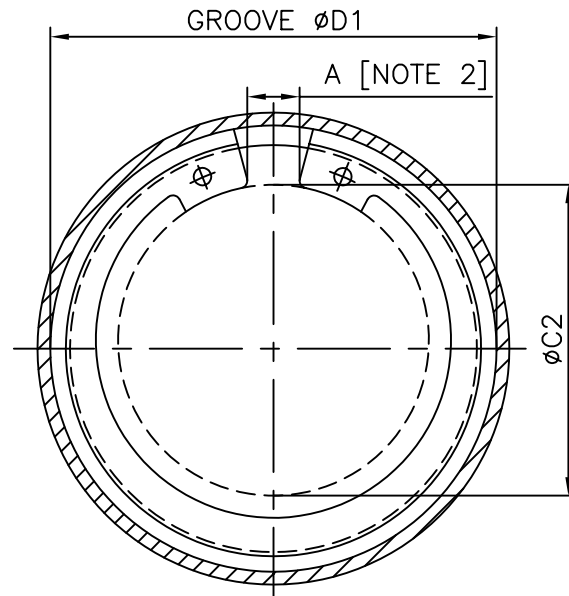
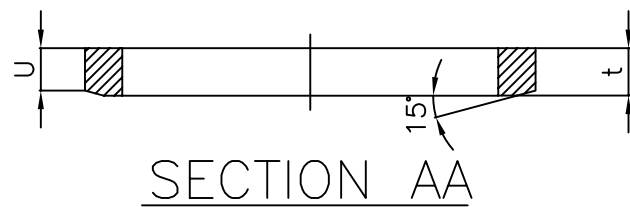
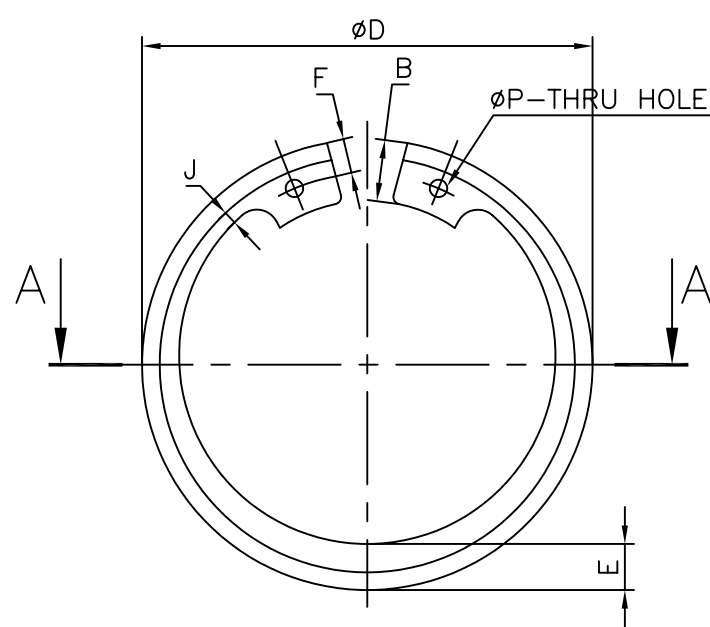
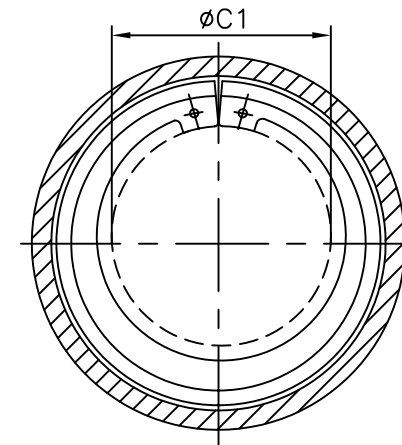
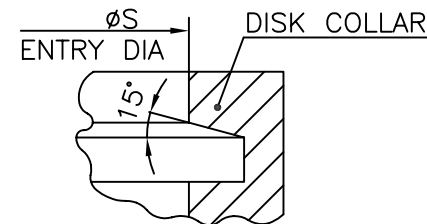


3-V-0000-13132
DRAWING NO.

SL. No.	DRAWING No.	MATERIAL		DIMENSIONS											DRESSER PART No.	TRUARC TYPE No. DIM.ØS	APPROX Wt/1000 Kgs.	
		CODE	SPECN	ØC1	ØC2	ØD	t	U	F	B	E	ØP	J	A				ØD1
1	3-V-9405-13132/04	97419975*	CARBON SPRING STEEL(SAE 1075) [NOTE-1]	39.1	40.9	57.912 ^{+1.016} -0.762	1.981±0.076	1.524±0.038	3.8	6.350±0.127	4.724±0.177	2.362 ^{+0.381} -0.050	2.311±0.177	8.9	56.134 ^{+0.152} 0	2090414	N5002-206 52.375 ^{+0.050} 0	8.2
2	3-V-9406-13132/04	97419976*	CARBON SPRING STEEL(SAE 1075) [NOTE-1]	48.5	50.8	70.485 ^{+1.016} -0.762	1.981±0.076	1.448±0.037	4.3	7.112±0.127	5.334±0.177	2.794 ^{+0.381} -0.050	2.616±0.177	10.1	68.174 ^{+0.152} 0	2090413	N5002-250 63.500 ^{+0.050} 0	11.4
3	3-V-9641-13132/03	96291014	CARBON SPRING STEEL(SAE 1075) [NOTE-1]	142.2	147.3	185.623±2.031	3.962±0.126	3.073±0.075	8.2	12.319±0.254	11.354±0.228	4.750 ^{+0.507} -0.127	5.613±0.228	27.0	178.867 ^{+0.152} 0	2090720	N5002-662 168.275 ^{+0.076} 0	138.5
4	3-V-9408-13132/04	96291016	CARBON SPRING STEEL(SAE 1075) [NOTE-1]	64.5	67.3	92.024±1.396	2.769±0.075	2.083±0.063	5.2	8.687±0.203	6.833±0.202	3.175 ^{+0.381} -0.050	3.429±0.203	12.9	88.621 ^{+0.152} 0	2090421	N5002-325 82.550 ^{+0.076} 0	27.2
5	3-V-9456-13132/03	96291015	CARBON SPRING STEEL(SAE 1075) [NOTE-1]	171.5	177.5	224.028±2.286	4.749±0.126	3.708±0.075	9.4	15.240±0.254	13.716±0.254	4.749 ^{+0.508} -0.126	6.654±0.253	31.4	216.078 ^{+0.203} 0	2090726	N5002-800 203.208 ^{+0.076} 0	251.6



AFTER INSTALLED IN GROOVE



WHEN SPRUNG INTO HOUSING

REVISION DETAILS

REV. NO.	DATE	DETAILS
01	03.12.79	1. SL.NO:5 ADDED.
02	26.05.80	1. DIMENSIONS 'F' & GROOVE ØD1 ADDED FOR SL.NO.S: 1 TO 5. 2. HOUSING PROFILE IS INCLUDED IN FIG. AFTER INSTALLED IN GROOVE.
03	16.04.87	1. DIM.ØC2 ADDED IN FIG. AFTER INSTALLED IN GROOVE 2. FIG.WHEN SPRING INTO HOUSING ADDED. 3. NOTE-4 ADDED.
04	27.07.91	1. CARBON SPRING STEEL (SAE 1075) WAS PH 15-7 MO ST.ST. FOR SL.NO.1,2&4
05	20.10.92	1. ENTRY DIA DIM. ØS & THE RELATIVE VIEW ADDED.DRG.REVISION NO 3 UPDATED.
06	30.03.94	1. IN NOTE-4,TDC 5:196 WAS TDC 5:138. DCN NO. SR:0061

NOTES:

- CADMIUM PLATING DICHROMATE DIP.
- DIMENSION AFTER INSTALLED IN GROOVE.
- * CODE FOR IMPORTED COMPONENT.
- FOLLOW THE TDC OF 5:196 WITH LATEST REVISION.

REV	DATE	ALTERED	G.V
07	08.10.05	CHD & APPD	E.A

REDRAWN IN CAD AND UPDATED.
DCP NO: 800514

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NO OFF	DESCRIPTION	MATLCODE	MATLSPEC	HEAT TREATMENT	SCARP SORT	NET Wt (Kg)	GROSS Wt (Kg)	DRAWINGNO.	ITEM NO		
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT											
BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI-620014.							DRN	G.VENKATESWARALU	DATE	08.10.05	NO.OF VAR.
							CHD	E.ATHIANNAVI		08.10.05	
							APPD	E.ATHIANNAVI		08.10.05	
DEPT	VL	SCALE		WEIGHT (KG).		REFERENCE INFORMATION					
CODE		NTS									
TITLE							CARD CODE	DRAWING NO.		REV	
RETAINER RING							U 01	3-V-0000-13132		07	

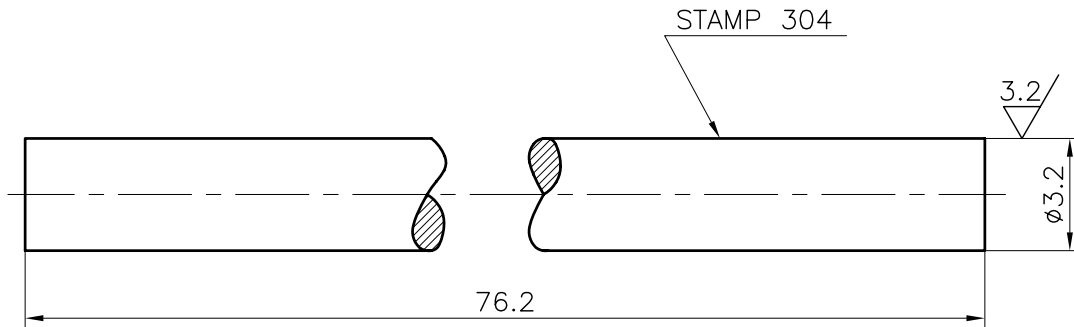
FOR TOLERANCES OF UNTOLERANCED DIMENSIONS

ALL DIMENSIONS ARE IN MILLIMETRES.
DURING MANUFACTURE REFER RELEVANT QCP/QP

REV	DATE	ALTERED	G.V
01	26.10.10	CHD & APPD	E.A

12.5 / 3.2


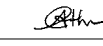
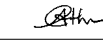
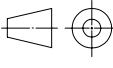
REDRAWN AND UPDATED
FOR SOFT COPY.
DCP NO: 800519



NOTE:

1. BREAK SHARP EDGES.
2. TOLERANCE FOR UNTOLERANCED DIMENSION IS ± 0.3 mm.

COMP.CODE:964155960000

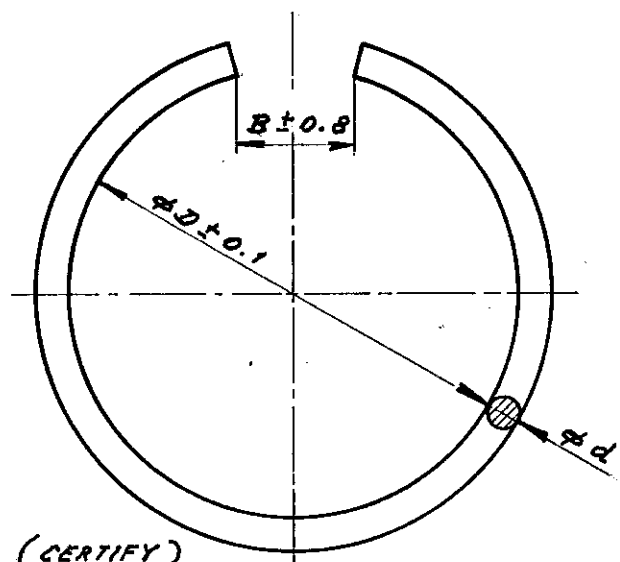
01	-	-	A182-F304 or AISI 304	SOLUTION ANNEALED	-	0.01	-	-	-
NO OFF	DESCRIPTION	MATL CODE	MATL SPECN (CERTIFY)	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
 BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI 620014.				DRN	NAME G.VENKATESWARALU		SIGN	DATE	NO.OF VAR
				CHD	E.ATHIANNAVI			27.03.06	
				APPD	E.ATHIANNAVI			27.03.06	
DEPT VL			SCALE	WEIGHT (KG).	REFERENCE INFORMATIONS				NO. OF ITEMS
CODE 340			NTS	0.01	DR.PART.NO:2110126,SL.NO:1343 REV:EC 855 REF.DRG.NO:4-V-8815-13066				
TITLE				CARD CODE	DRAWING NO.				REV
PIN				U 01	4-V-8815-13848 01				



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REV. DATE	ALT:	REV. DATE	ALT:	REV. DATE	ALT:
06 22.3.91	CHD: <i>[Signature]</i>	07 27.2.95	CHD & APPD: <i>[Signature]</i>	08 10.3.97	CHD & APPD: <i>[Signature]</i>
REDRAWN & UPDATED, MATL. INCONEL X750 WAS ARMCO 17-7 PH ST. ST.		ALTERNATE MATERIAL FOR SL No. 10 ADDED.		DIMENSIONAL ACCURACY UPDATED.	
DCH No. SAV: 90:44		DCH No. SR: 0109		DCH: SR: 0184	

SL. No.	DRG. No.	DRESSER PART No.	MATERIAL CODE	DIMENSIONS			WT./1000 PIECES [kg]
				φ D	φ d	B	
01	4-V-9001-13005	2410802	96291006 *97462395	8.3	1.14 ± 0.02	3.2	0.2
02	4-V-9008-13005	2410803	96291007 *97419855	19.9	1.8 ± 0.02	7.9	1.2
03	4-V-9011-13005	2410804	96291008 *97419854	14.2	1.3 ± 0.02	4.8	0.5
04	4-V-9009-13005	2410805	96291009 *97419856	12.8	1.14 ± 0.02	4.8	0.3
05	4-V-9013-13005	2410801	96291010 *97419857	22.6	2.16 ± 0.02	9.5	2.0
06	4-V-9015-13005	2410809	96291011 *97419858	17.7	1.5 ± 0.02	8.7	0.7
07	4-V-9023-13005	2410810	96291012 *97419859	25.0	2.16 ± 0.04	11.1	2.1
08	4-V-9025-13005	2410811	96291013 *97419860	42.4	2.54 ± 0.04	11.1	5.2
09	4-V-9145-13005	2410808	*97442605	10.4	0.89 ± 0.02	6.4	0.2
10	4-V-9866-13005 (DR)	2410812	*97462050 MATERIAL CODE: 54681080 COMP. CODE: -93176158. MATERIAL: INCONEL-82	6.1	0.74 ± 0.02	4.0	0.1



* - CODE FOR IMPORTED COMPONENT.

MATERIAL: (CERTIFY)
INCONEL X750

NO. OF PIECES	NAME - DIMENSIONS	SEMI - PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET Wt (kg)	GROSS Wt (kg)	DRAWING NO.	ITEM NO.
REMARKS				TOTAL NET Wt (kg)					
SCALE	DRAWN	M. RAJA	DRESSER	ALTERATIONS	DATE	SIGNATURE	ALTERATION INDEX		
	CHECKED	K. S. RAJU	DRG. NO.						
NTS	APPROVED	V. M	241 (2848)						
	STDS. OFFICER		TRANS. COPY NO.						
	DATE								
TYPE		GROUP		OLD DRG.		NEW DRG.			
TITLE		RETAINER RING		DRAWING NO.		4-V-0000-13005			



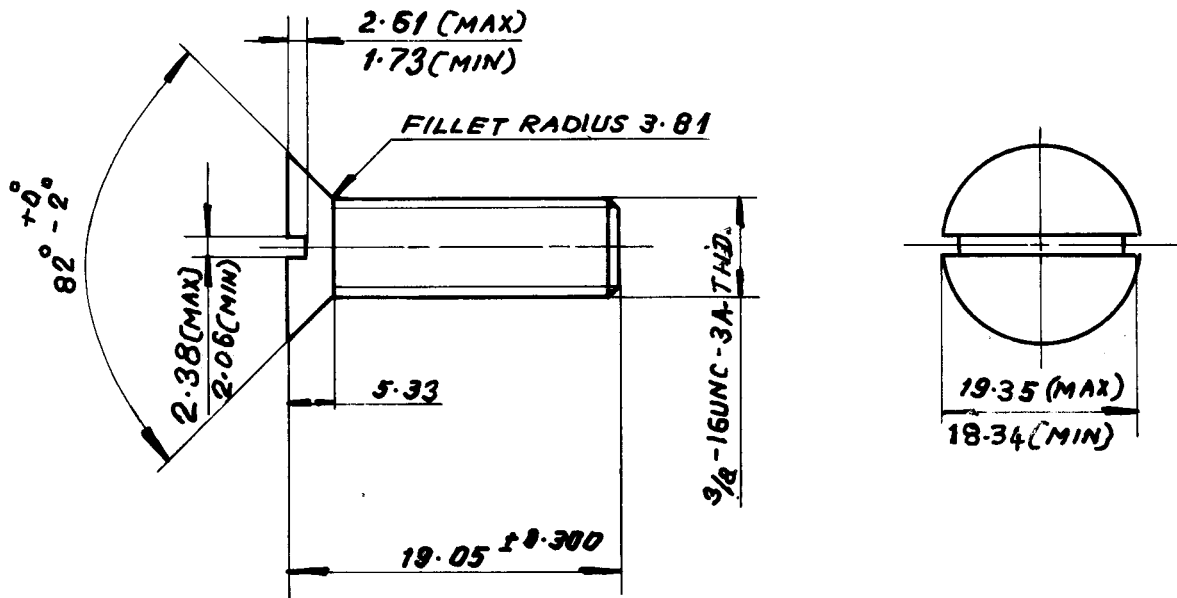
33-116

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REV 01	DATE 16-7-79	ALTERED	CHECKED
REV 02	DATE 20.6.97	ALTERED	CHECKED

NOTES UPDATED.
DEN. NO. SV: 0436

3.2



NOTE:-

1. SHARP CORNERS TO BE REMOVED.
2. 45° CHAMFER FIRST THREAD.
3. THIS DRG. AS PER STD. ANSI. B18.6.2 - 1972

MICROFILMED ON
ROLL 00523 FRAME 3781

No. OFF	DESCRIPTION	MATL. CODE	FINAL MATL.	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRG No.	ITEM No.
	φ 22 x 30	15 039 343	SA 105 CERTIFY	NORMALISED	10	0.01	0.09	—	237



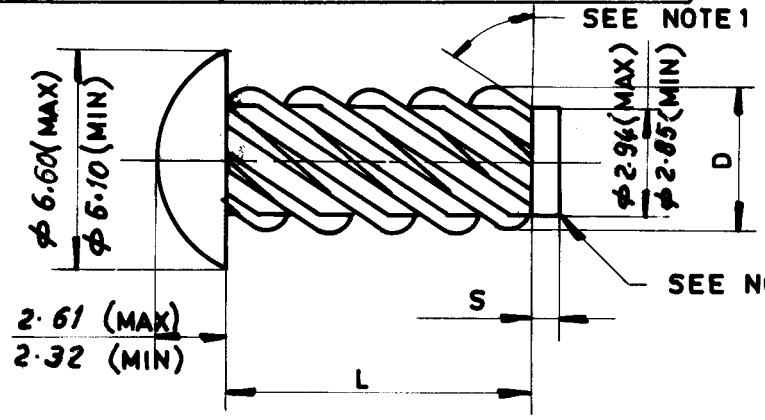
BHARAT HEAVY ELECTRICALS LIMITED
BOILER PLANT UNIT, TIRUCHIRAPALLI-620014

DEPT VL	CODE 340	SCALE NTS	WEIGHT (kg) —	PART No. 2420807	720
TITLE				DATE	
LOCKING SCREW				DRAWN	T.R.
				CHECKED	VR
				APPROVED	JA

DIMENSIONS TO BE CONTROLLED WITHIN LIMITS AS SHOWN. MACHINING TOLERANCE ± 0.25 mm. UNLESS OTHERWISE SHOWN NON-MACHINING TOLERANCE ±	CARD CODE	4 DRAWING NO. 4-V-7000-10008	15	16 REV 17
-------------------------------------------------------------------------------------------------------------------------------------	-----------	------------------------------	----	-----------

THIS DRG IS AS PER STD.
USAS B 18.6.4 - 1966

1) INCH UNITS ARE CHANGED
TO METRIC UNITS.



COMMERCIAL
DESIGNATION :-
TYPE 'U' DRIVE
SCREW

Sl. No.	SCREW SIZE	S	D		L	DRILL SIZE	DRESSER PART NO.	MATERIAL	WT/PIECE IN KG
			MAX.	MIN.					
1	6	1.57	3.55	3.46	12.7 ± 0.750	3.048 (# 31)	2240209	AISI 302 S.S AMENDED CERTIFY	0.0012

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MICROFILMED ON
ROLL 00223 FRAME 378

- NOTE :-**
1. THE LEAD ANGLE OF THE TYPE 'U' METALIC DRIVE SCREW SHALL BE 45° TO 55°
 2. THE BLUNT END OF THE PILOT MAY HAVE A SLIGHT ANGLE, AS ILLUSTRATED ABOVE, DUE TO THE NATURAL FLOW OF MATERIAL IN THE CUT OFF PROCESS.

No. OFF	DESCRIPTION	MATL.CODE	FINAL MATL.	HEAT TREATMENT	SCR AP SORT	NET WT KG	GROSS WT KG	DRAWING No.	ITEM No.
		96162 128			46				064

APPLICA-BLE TYPE NDS
1749 WA, 1775RWA, B, D.
1759 WA, 1775 WA
1785 WA, 1705RWD



BHARAT HEAVY ELECTRICALS LIMITED
BOILER PLANT UNIT, TIRUCHIRAPALLI-620014

DEPT	CODE	SCALE	WEIGHT (kg)	REF. TO ASSY. DRG.	CL	SL No	
		/		DRESSER DRG No. 224/153	153	721	
TITLE				DRAWN	NAME	SIGN	DATE
DRIVE SCREW					T.R		15-3-79
					VR		
					JA		

DIMENSIONS TO BE CONTROLLED WITHIN LIMITS AS SHOWN. MACHINING TOLERANCE ± 0.25 mm. UNLESS OTHERWISE SHOWN NON-MACHINING TOLERANCE ±

CARD CODE
DRAWING NO. 4-V-7000-10013
REV 15

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FOR CHANGES OF DIMENSIONS DURING MANUFACTURE REFER RELEVANT CDR/GR

FIRST ANGLE PROJECTION (ALL DIMENSIONS IN MILLIMETRES)

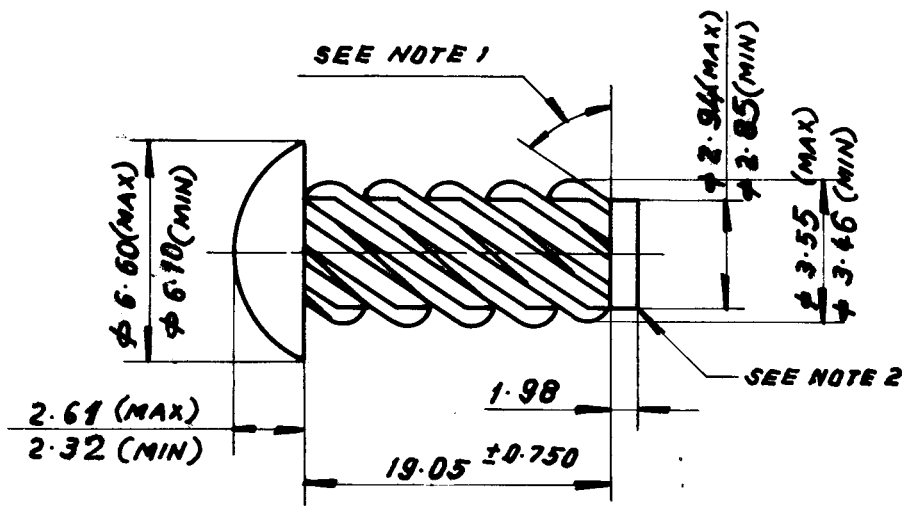
REV 01	DATE 28.6.97	ALTERED	CHECKED RAPPD: 1/2
REV 02	DATE 28.6.97	ALTERED	CHECKED RAPPD: 1/2

THIS DRG IS AS PER STD. USAS B 18.6.4 - 1966

1. INCH UNITS ARE CHANGED TO METRIC UNITS.
2. NOTES ADDED.

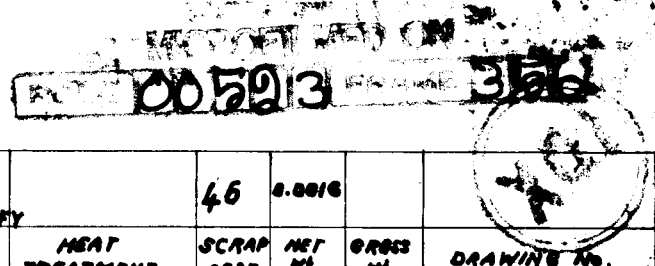
NOTES UPDATED.
DCN. NO. SV: 0438

COMMERCIAL DESIGNATION:-
TYPE 'U' DRIVE SCREW



NOTE:-

1. THE LEAD ANGLE OF THE TYPE 'U' METALIC DRIVE SCREW SHALL BE 45° TO 65°
2. THE BLUNT END OF THE PILOT MAY HAVE A SLIGHT ANGLE, AS ILLUSTRATED ABOVE, DUE TO THE NATURAL FLOW OF MATERIAL IN THE CUT OFF PROCESS.
3. RECOMMENDED DRILL SIZE 3.048 (DRILL. NO. # 31)
4. SCREW SIZE # 6.



No. OFF	DESCRIPTION	MATL. CODE	FINAL MATL.	HEAT TREATMENT	SCRAP SEAT	NET WT (kg)	GROSS WT (kg)	DRAWING No.	ITEM No.
		96 162 129	AISI 302 ST. STEEL CERTIFY		46	0.0016			059



BHARAT HEAVY ELECTRICALS LIMITED
BOILER PLANT UNIT, TIRUCHIRAPALLI-620014

DEPT VL	CODE 340	SCALE N.T.S.	WEIGHT (kg)	PART No. 2248210	SL No. 721
				DRESSER DRG No. 224/ CL 183	

TITLE DRIVE SCREW	DRAWN	NAME T.R	SIGN	DATE 29/4/79
	CHECKED	NAME VR	SIGN	DATE 25/4/79
	APPROVED	NAME JA	SIGN	DATE 25/4/79

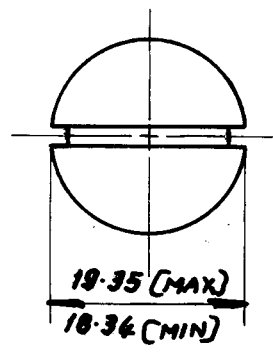
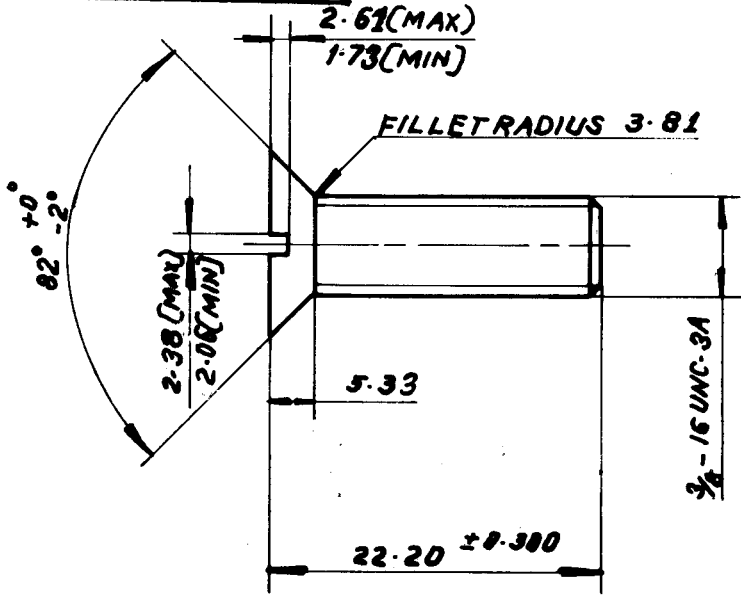
DIMENSIONS TO BE CONTROLLED WITHIN LIMITS AS SHOWN. MACHINING TOLERANCE ± 0.25 mm. UNLESS OTHERWISE SHOWN NON-MACHINING TOLERANCE \pm	CARD CODE	4 DRAWING No. 15 16 REV 17
		4-V-7000-10031 02

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REV	DATE	ALTERED	V.A.
01	15.7.77	CHECKED	<i>[Signature]</i>
1. INCH UNITS CHANGED TO METRIC UNITS EXCEPT THREAD DIM.			
2. NOTES ADDED			
3. RRM MATL SIZE, CODE ADDED			
REV	DATE	ALTD:	<i>[Signature]</i>
02	20-6-97	END APPD:	<i>[Signature]</i>
NOTES UPDATED.			
DCN. No. SV: 0436			

DATE	ALTERED
	CHECKED
4. MATL. CHANGED FROM STEEL CLASS 6 TO SA 105	

3.2



NOTE:-

1. SHARP CORNERS TO BE REMOVED.
2. 45° CHAMFER FIRST THREAD.
3. THIS DRG IS AS PER STD ANSI-B 18.6-2-1972.

MICROFILMED ON ROLL 105913 FRAME 3/10

φ 22 x 35	15 039 343	SA 105 CERTIFY	NORMALISED	10	8.02	0.11		237	
No. OFF	DESCRIPTION	MATL. CODE	FINAL MATL.	HEAT TREATMENT	SCRM SGRF	NET WT (kg)	GROSS WT (kg)	DRG No.	ITEM No.



BHARAT HEAVY ELECTRICALS LIMITED
BOILER PLANT UNIT, TIRUCHIRAPALLI-620014

DEPT VL	CODE 340	SCALE N.T.S	WEIGHT (kg)	PART No. 2420888	IT. NO. 720
TITLE				DRAWN T.R	DATE 26-3-79
LOCKING SCREW				CHECKED VR	DATE 26-3-79
				APPROVED JA	DATE 26-3-79

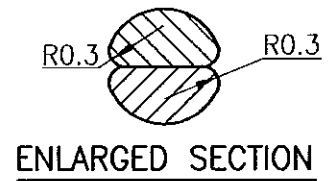
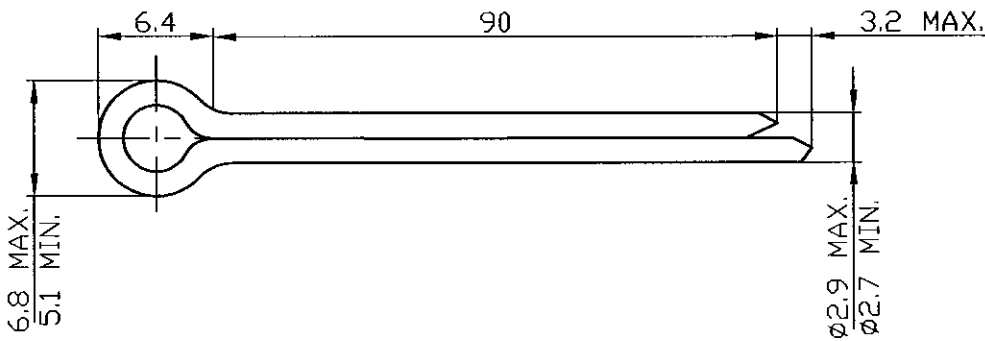
DIMENSIONS TO BE CONTROLLED WITHIN LIMITS AS SHOWN. MACHINING TOLERANCE ± 0.25 mm. UNLESS OTHERWISE SHOWN NON-MACHINING TOLERANCE ±

CARD CODE	4 DRAWING NO. 4-V-7002-10030	15	16 REV 17
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FOR TOLERANCES OF UNTOLERANCED DIMENSIONS


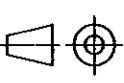
ALL DIMENSIONS ARE IN MILLIMETRES.
DURING MANUFACTURE REFER RELEVANT QCP/QP

REV	DATE	ALTERED
		CHD & APPD



NOTE:

1. STAINLESS STEEL WIRE OF HALF-ROUND SECTION WITH RADIUS CORNERS.
2. CUT THE PIN LENGTH TO SUIT ASSY.

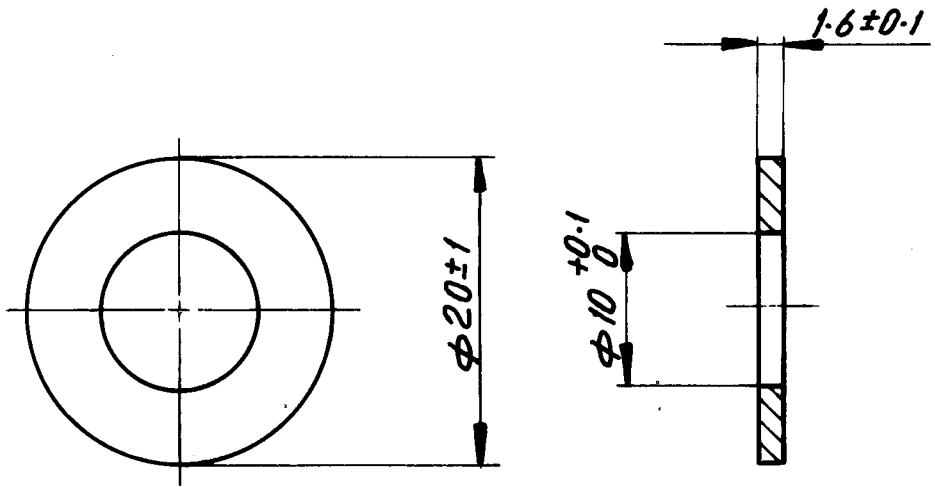
	PIN SIZE $\phi 3.2$	96415582	18-8 ST.ST. CERTIFY	-	46	0.02	-	-	181
NO OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
 365-122	BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI 620014.			DRN	L.RENGA SWAMY	SIGN	DATE	NO.OF VAR	
				CHD	V.PERUMAL PILLAI		10.07.03		
				APPD	E.ATHIANNAVI		10.07.03		
DEPT VL		 SCALE NTS	WEIGHT (KG).	REFERENCE INFORMATION				NO. OF ITEMS	
CODE 340				DR.DRG.No.:222/EX365 PART No.:2220219/SL.No:10504					
TITLE				CARD CODE	DRAWING NO.			REV	
COTTER PIN				U 01	4-V-7132-10512				

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6.3

NOTES UPDATED
 DCN. NO. SV: 0438


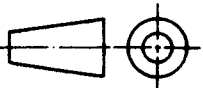
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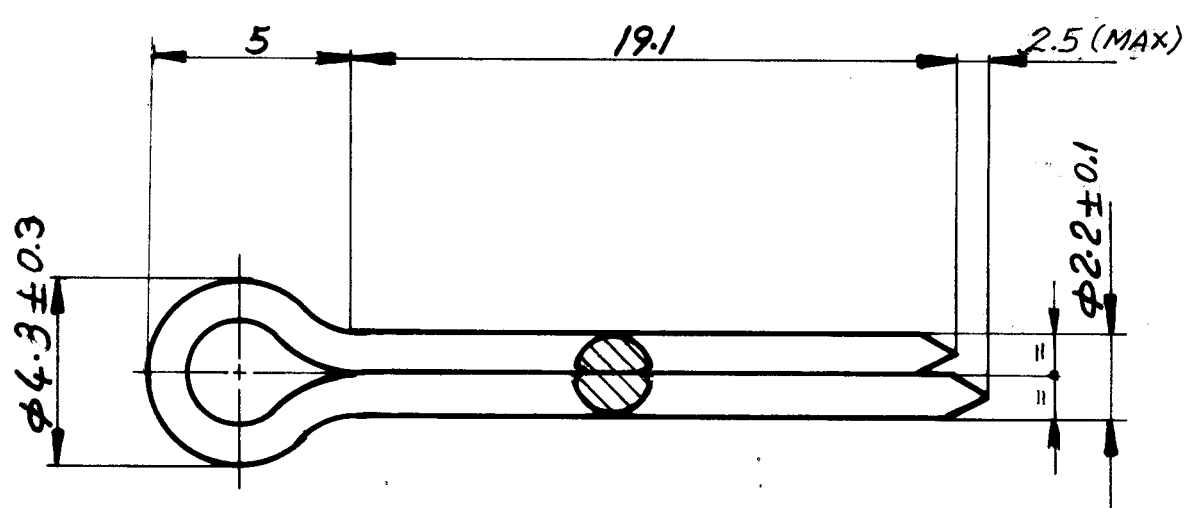
NOTES:-

1. MATERIAL:- IS:2016-67 MILD STEEL.
2. CADMIUM PLATED DICHROMATE DIPPED
3. SHARP EDGES TO BE REMOVED.
4. CODE No: 21 004 402

MANUFACTURED ON
 00523 FRAME 112

 Bharat Heavy Electricals Ltd., BOILER PLANT UNIT TIRUCHIRAPALLI-620 014		DRN	NAME N.R	SIGN N. Ramad.	DATE 5-3-81
		CHD	K. B	K. M	5-3-81
		APPD	S. R	S.R.	5-3-81
DEPT. VL	GRADE OF UN TOL. DIM C/M/F	SCALE 2:1	WEIGHT (kg) 2.95/1000 PIECES	DRG NO: VA 814 DRESSER PART NO: VA 814 B (REV: CE 600) (APPD: 577)	
CODE 340				TITLE WASHER	CARD CODE U 01
			DRAWING NO. 4-V-7501-10174/01	ITEM No 513	

REV	DATE	ALTERED	REV	DATE	ALTERED
01	28/07/75	7501-10188	02		
CHECKED			CHECKED		
NOTES UPDATED.					
DCN. No. SV: 0438					




NOTES:-

1. MATERIAL:- 18-8 ST. STEEL.
2. THIS COMPONENT CORRESPONDS TO IS:549. NOM. SIZE 2.3, EXCERPT MATL.
3. ST. STEEL WIRE OF HALF ROUND SECTION WITH RADIUSED CORNERS.
4. CUT THE PIN LENGTH TO SUIT ASSY.

CODE:- 96162165

MICROFILMED ON
 ROLL OVER 23 FRAME 203

 Bharat Heavy Electricals Ltd., BOILER PLANT UNIT TIRUCHIRAPALLI-620 014	DRN	NAME	SIGN	DATE
	CHD	K.B	K. K. K.	4-3-81
	APPD	J.A	A	4-3-81
DEPT. VL	GRADE OR UNTOQ DIM C/M/F	SCALE 5:1	WEIGHT (kg) 0.71/1000	DRESSER DRG No:- SEP-185-A
CODE 340			PIECES	PARTNO:- 12-185A-56606Z (REV:- CZ 372)
TITLE	CARD CODE	DRAWING NO.	ITEM NO.	
COTTER PIN	U 01	4-V-7501-10188/01	527	

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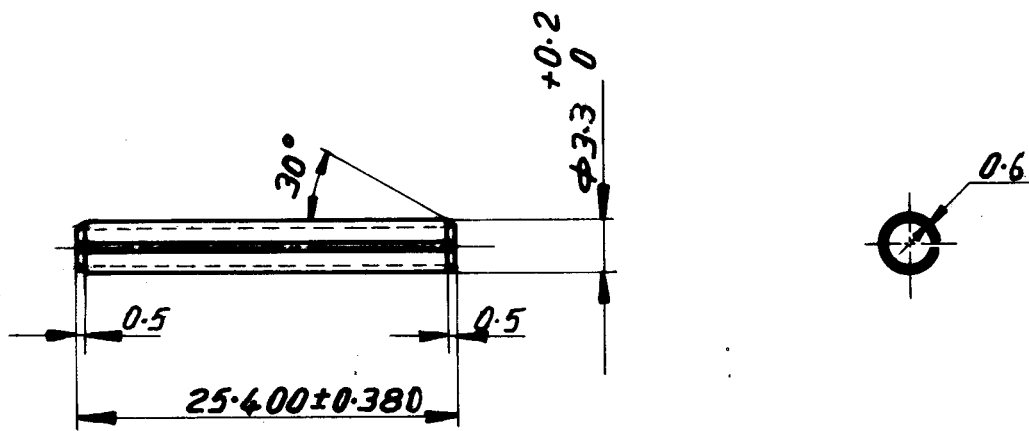
P-DG 40V-7501-10188 CORPORATE DRG ID

P-DG 40V-7501-10188 CORPORATE DRG ID

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DATE 01.28.81	ALTERED [Signature]	REV 02	DATE	ALTERED
CHECKED / APPD: [Signature]		CHECKED		

NOTES UPDATED.
 DCN. No. SV: 0438



NOTES:-

1. MATERIAL:- AISI 420
2. THIS COMPONENT CORRESPONDS TO IS 5988 HEAVY (NOM. SIZE 3mm) EXCEPT MATL.
3. CODE :- 96 162 166

MICROFILMED ON
 ROLL 00523 FRAME 202

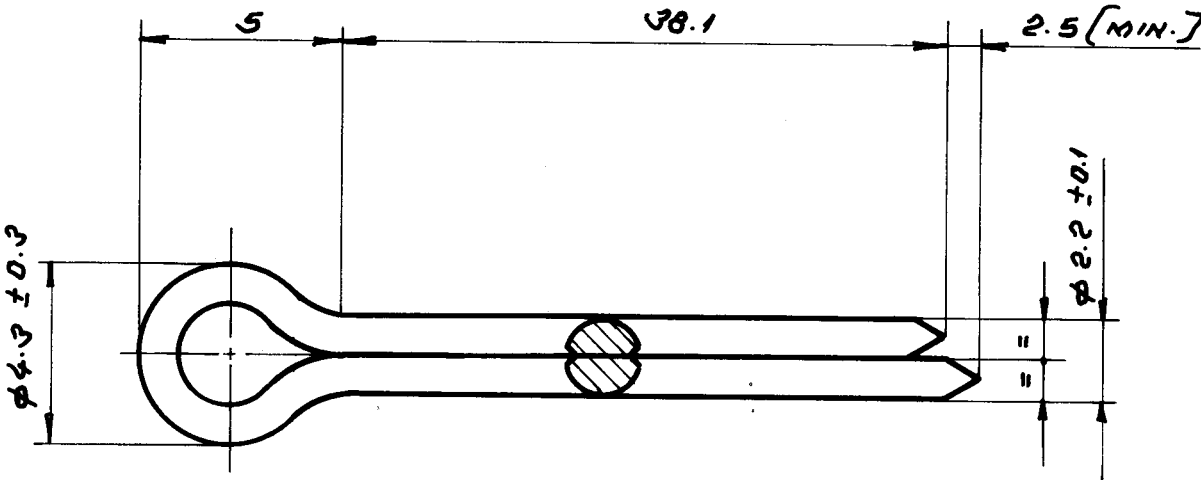
	Bharat Heavy Electricals Ltd., BOILER PLANT UNIT TIRUCHIRAPALLI-620 014		DRN	NAME N.R	SIGN [Signature]	DATE 5-3-81
			CHD	K.B	[Signature]	5-3-81
			APPD	J.A	[Signature]	5-3-81
DEPT. VL	TOL. FOR UNTOL. M/C		SCALE 2:1	WEIGHT (kg) 1.01 kg/1000 PIECES	DRG NO.: NL 814	
CODE 340					DRESSER PART NO.: [Stamp]	
TITLE SPRING DOWEL SLEEVE			CARD CODE U 01	DRAWING NO. 4-V-7501-10189/01		ITEM NO. 528

FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELATIVE DIMENSIONS

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REV	DATE	ALTERED
01	28-6-97	CHECKED (APPD. ✓/✓)
02		CHECKED

NOTES UPDATED.
DCN. NO. SV: 0438



NOTES:

1. MATERIAL 18-8 ST. STEEL
2. THIS COMPONENT CORRESPONDS TO IS 549. NOM SIZE 2.3. EXCEPT MATL.
3. ST. STEEL WIRE OF HALF ROUND SECTION WITH RADIUSED CORNERS.
4. CUT THE MIN LENGTH TO SUIT ASSY.
5. MATL. CODE 96 415 149

MF 758001



Bharat Heavy Electricals Ltd.,
BOILER PLANT UNIT
TIRUCHIRAPALLI-620 014

DRN	NAME	SIGN	DATE	ITEM NO.
CHD	V. PERUMAL	V. Peruma	21-2-85	536
APPD	D. K		2-5-85	

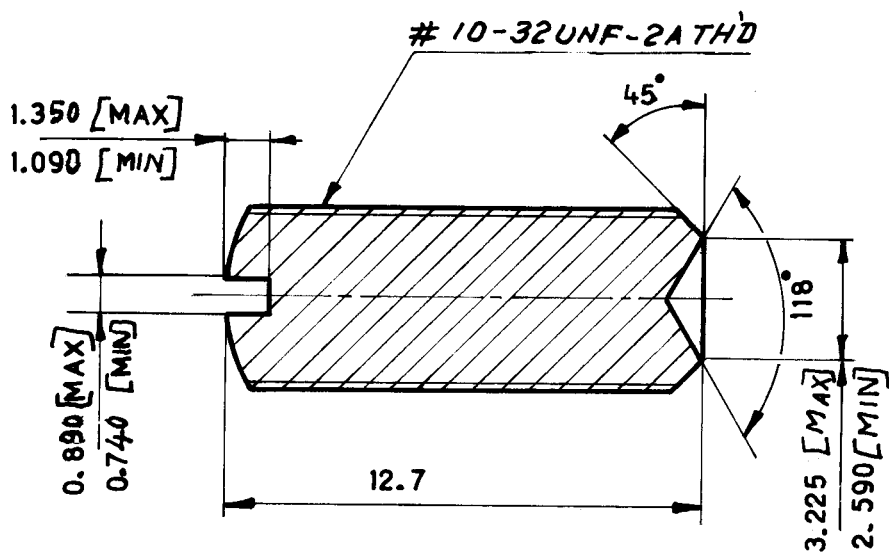
DEPT.	GRADE OF UNTOL. DIM	SCALE
VL	F/M/F	N.T.S
CODE		
346		

WEIGHT (kg) 1.41/1000
PIECES
DRESSER DRG. NO. 222/EF020
PART NO. 222017
SL. NO. 2842

TITLE	CARD CODE	DRAWING NO.	REV
COTTER PIN	U 0	4-V-7504-10330-01	

QTY	DATE	BY
01	28-6-97	CHD/APPD: W.
MATL. IS 2062 Fe 410 WA WAS IS 226 OR BMC-20		
NOTES UPDATED DCN. NO. SY: 0438		

FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP/QP.



- NOTE:-**
1. SHARP CORNERS TO BE REMOVED.
 2. UNSPECIFIED MACHINING TOLERANCES ± 0.25 mm.

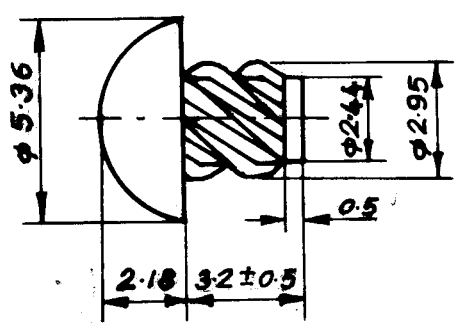
		96415202	IS 2062 Fe 410 WA CERTIFY	-		0.01	-	522	
NO. OF PIECES	NAME - DIMENSIONS	MATL CODE	FINAL MATERIAL	HEAT TREATMENT	SCRAP SORT	NET Wt (kg)	GROSS Wt (kg)	DRAWING NO.	ITEM NO.
REMARKS				TOTAL NET Wt (kg)					
SCALE	DRAWN	A. VELSAMY		ALTERATIONS	DATE	SIGNATURE	ALTERATION INDEX		
NTS	CHECKED	V. Prasad Pillai							
	APPROVED	W.		DRESSER DR. NO. 207/EV 591					
	STDS. OFFICER			PART NO.: 2070126, SL. NO. 8915, 8916					
	DATE	20.3.89							
TYPE		GROUP		OLD DRG.	NEW DRG.				
TITLE		SET SCREW		DRAWING NO.		4-V-7520-10388-01			



TP-DG-4-V-7520-10388
CORP/INT/001

REV 01	DATE	ALTERED
CHECKED	02	CHECKED

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NOTE :-

THIS COMPONENT IS IDENTICAL TO BPS 416-01-31101 EXCEPT LENGTH.

MICROFILMED ON
ROLL 00523 FRAME 019

MATERIAL :-

LOW CARBON STEEL UP TO 0.18% C
NICKEL PLATED.

CODE :- 96162131

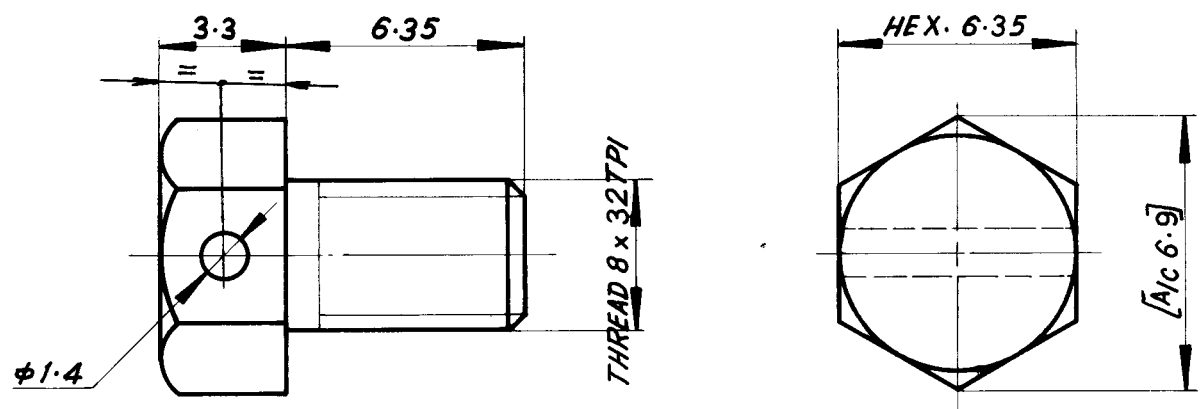
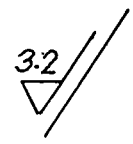


BHARAT HEAVY ELECTRICALS LIMITED
BOILER PLANT UNIT, TIRUCHIRAPALLI-620014

DEPT VL	CODE 340		SCALE 5:1	WEIGHT (kg.) .0003	REF. TO ASSY. DRG.	IT.No. 235	
TITLE DRIVE SCREW					DRAWN R.S.RATU	SIGN <i>[Signature]</i>	DATE 17.5.79
					CHECKED K.B	SIGN <i>[Signature]</i>	DATE 17.5.79
					APPROVED D.K	SIGN <i>[Signature]</i>	DATE 15.5.79
DIMENSIONS TO BE CONTROLLED WITHIN LIMITS AS SHOWN. MACHINING TOLERANCE ± 0.25 mm. UNLESS OTHERWISE SHOWN NON-MACHINING TOLERANCE \pm				CARD CODE	4 DRAWING NO. 4-V-9000-13082		



REV	DATE	ALTERED
02		CHECKED



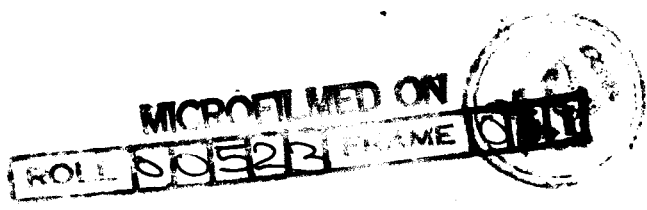
NOTES:-

1. 45° CHAMFER FIRST THREAD.
2. TO BE ZINC PLATED.
3. COMMERCIAL DESIGNATION:- STEEL HEX. HEAD SELF TAPPING SCREW TYPE 'F'

MATERIAL:-

CARBON STEEL : CARBON 0.3 TO 0.4
HARDNESS -175 BHN. [MIN.]

CODE : 96162145



BHARAT HEAVY ELECTRICALS LIMITED
BOILER PLANT UNIT, TIRUCHIRAPALLI-620014

05-249/A

[REV. CM 986]

DEPT VL	CODE 340		SCALE 5:1	WEIGHT (kg) 0.001	DRESSER DRG. No. 207577. (2705) PART No. 0757702.	IT. No. 242
TITLE SELF TAP SCREW					DRAWN E. ATRI ANNAVI. <i>Athiyan</i>	SIGN DATE 9.7.79
					CHECKED K. B.	9.7.79
					APPROVED D. K.	9.7.79

DIMENSIONS TO BE CONTROLLED WITHIN LIMITS AS SHOWN. MACHINING TOLERANCE ± 0.25 mm UNLESS OTHERWISE SHOWN NON-MACHINING TOLERANCE ±

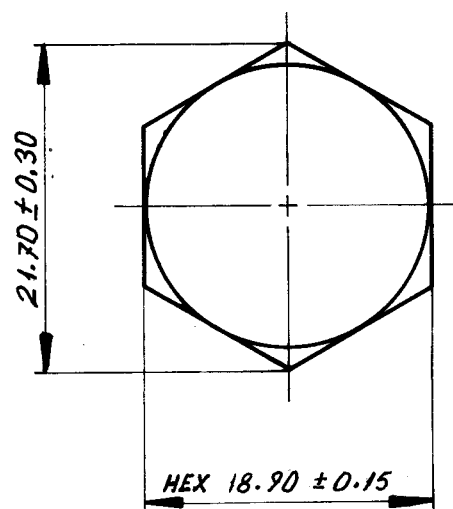
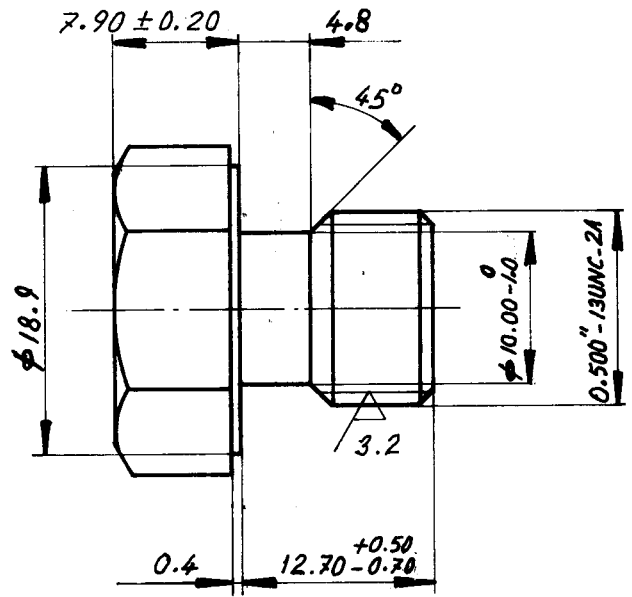
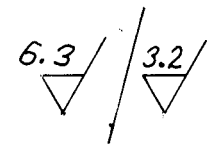
CARD CODE	4 DRAWING NO. 4-V-9000-13091	15	16 REV 17
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REV	DATE	ALTERED	K.N. Ramani
01	4.8.81	CHECKED	<i>[Signature]</i>
1.	RAW MATL. BMCQ-45 WAS IS:1367 CLASS 6-6		
2.	NOTES:- 2&3 ADDED.		
REV	DATE	ALT:	M.N.
03	10.3.97	CHD. & APPD.	<i>[Signature]</i>
NOTES UPDATED.			
DCN:SR: 0184			

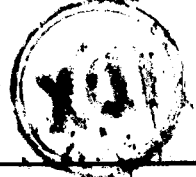
REV	DATE	ALTERED	K.N. Ramani
02	5.10.81	CHECKED	<i>[Signature]</i>
1. RAW MATL. ASTM A 194 Gr.4 WAS BMCQ-45 AND ITS DETAILS CHANGED			
2. HARDNESS:- 24-38 HRC WAS 190-240 BHN.			



NOTE:-

1. 45° CHAMFER FIRST THREAD.
2. HARDNESS:- 24-38 HRC
3. PHOSPHATE COAT AS PER APPLICABLE QUALITY PROCEDURE.

MICROFILMED ON CO5214



01	BAR φ32x26	15039222	Q&T	ASTM-A194-Gr.4	10	0-01	0-16	93075594.	158
NO OFF	DESCRIPTION	MATL. CODE	HEAT TREATMENT	MATL. SPECN (CERTIFY)	SCRAP SORT	NET WEIGHT	GRDS (ECKD)	COMP. CODE	ITEM NO



BHARAT HEAVY ELECTRICALS LIMITED
BOILER PLANT UNIT, TIRUCHIRAPALLI-620014

05-249/A

DEPT	CODE	SCALE	WEIGHT (kg)	REF. TO ASSY. DRG.	IT.No.
VL	340	2:1	0.01		

TITLE	DRAWN	NAME	SIGN	DATE
	CHECKED	K.B	K. K. K.	23/01/80
	APPROVED	D.K	D.K	16/5/80

SEALING PLUG

DIMENSIONS TO BE CONTROLLED WITHIN LIMITS AS SHOWN. MACHINING TOLERANCE ± 0.25 mm UNLESS OTHERWISE SHOWN. NON-MACHINING TOLERANCE ±

CARD CODE	4 DRAWING NO.	15	16 REV 17
	4.V.9096.13194		03

