

REF. TO ASSY. :-


VAR 00 - 35211001556 IT. 008
VAR 01 - 35211001556 IT. 107
VAR 02 - 35211001556 IT. 126

TYPED ITEM NO. :-

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FOR VAR 00 - BP 9099431953
FOR VAR 01 - BP 9099432437
FOR VAR 02 - BP 9099432445
```

[illegible]

FOR ARRGT. REF. :- DRG. 25211001534

ADDITIONAL INFORMATION			mRikn dk i—dkj ;k xk—gd@fj;kstuk dk uke TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT			V.C.B.									
STATUS OF DRAWING			HAKjr gsoh bysfDV&dYl fyfeVsm Haksiky BHARAT HEAVY ELECTRICALS LTD. BHOPAL			uke@NAME B.D.V. Sd/— 24.09.82									
DISTRIBUTION OF PRINTS						gLrk@SIGN Sd/— 03.10.82									
□/C		SWM	TCX		fnaukd@DATE 14.10.82			osfj— dh la; k No. OF VAR							
1		3	1		tWpk CKD M.Z.G. Sd/— 03.10.82			02							
REV.	DATE	ALTERED	foHAK DEPT			vuklkr SCALE		HAKj_dk_x— WEIGHT (K.G.)		vis— M&kbZax dk lanHAZ REF. TO ASSY. DRG.		en d— ITEM NO. 008 107 126		en— la; k NIL OF ITEM	
04	29.08.02	CHECKED APPROVED	409 AA0230208			N.T.S.		2.710		35211001556		005		005	
DRG. REDRAWN.			'kh"AZ@OLE			B.O.M. FOR CLOSING SPRING ASSY.			vkjs[A d—DRAWING NO. 35211001557			tqu—@EV 04			
(DCA. NO. 11638)									i="B d—@S. No. 01			i="Bksa dh la; k NO. OF SHT. 01			

INVENTORY NO. _____ SIGN AND DATE _____ REF. DRG. NO. _____
52110.25211001512-402-501
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FIRST ANGLE PROJECTION

DRG. NO. 25211001512

2

3

4

5

6

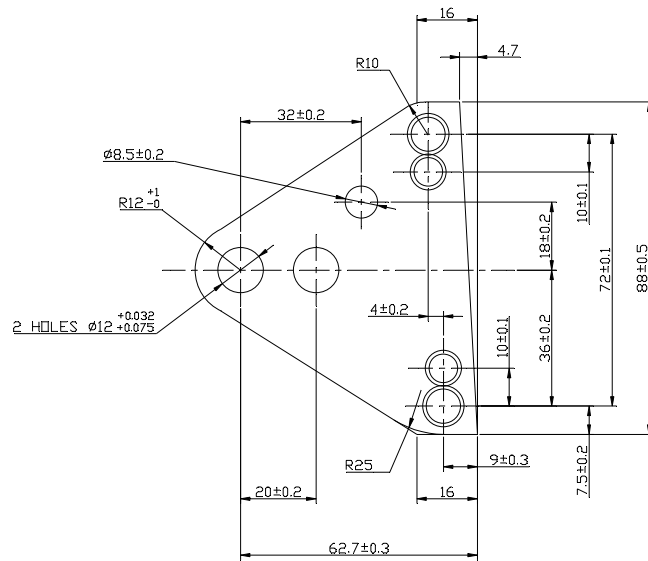
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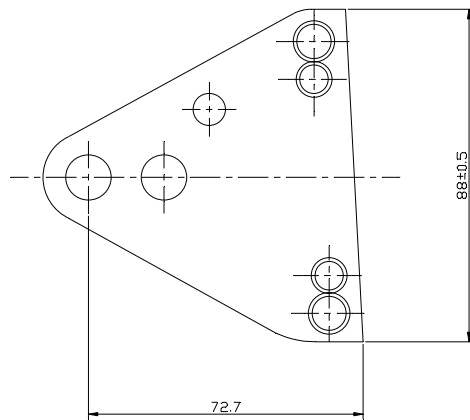
ALL DIMENSIONS ARE IN mm

11/35

185

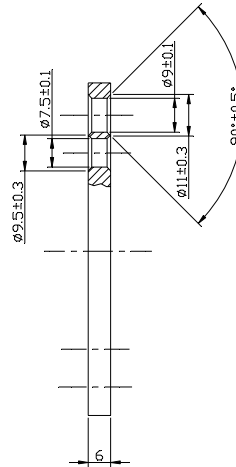


ITEM 001



ITEM 002

SEE ITEM 001 FOR
UNSPECIFIED DIMENSIONS



TOOL LIST :-

- 1492703 - FLAME CUTTING PLATE FOR ITEM 001
- 1492704 - DRILL JIG
- 1492611 - 12 Eg REAMER
- 1492612 - 12 Eg PLUG GAUGE
- 1492761 - FLAME CUTTING TAMPLETE FOR ITEM 002

FINISH :- PARKERISE TO PR. S. 7609

NOTE :- SURFACE AT THE EDGES SHALL BE DRESSED SMOOTH
AFTER FLAME CUTTING.

BP9099430396	002	6 TK. x 84.7 x 88 STRUCTURAL STEEL PLATE	AA1011808030 AA10108	KG.	0.351 001	
BP9099430380	001	6 TK. x 74.7 x 88 STRUCTURAL STEEL PLATE	AA1011808030 AA10108	KG.	0.309 001	
VAR 00	REMARKS	VAR NO. ITEM NO.	DESCRIPTION	STD.	DRAWING NO.	IT NO. MATL. CODE UNIT QTY. ZONE

ADDITIONAL INFORMATION

STATUS OF DRAWING

DISTRIBUTION OF PRINTS
QC - 1 TCX - 1
SWM - 1

mRikn dk i-dkj ;k
xk-gd@f;kstuk dk uke
TYPE OF PRODUCT OR
NAME OF CUSTOMER/PROJECT

V.C.B.



HAKjr gsoh bysfDV&dYl fyfeVsM
HAKsiky
BHARAT HEAVY ELECTRICALS LTD.
BHOPAL

uoke@NAME	lgLrk_IGN	muokd@DATE	osfj_ dh
B.D.V.	Sd/-	22.08.82	id;k
M.Z.G.	Sd/-	25.08.82	VAR.
B.P.N./R.K.G.	Sd/-	05.09.82	-

REV.	DATE	ALTERED
02	29.08.08	CHECKED
		APPROVED
ZONE		DRG. REDRAWN.

REV.	DATE	ALTERED
02	29.08.08	CHECKED
		APPROVED
ZONE		DRG. REDRAWN.

foHAKx DEPTS.WE CODE	lu_Vky_uki dh dskh UNTOL. DIMS. GR.	vuqkr SCALE 1:1	HAKj fd_@ WEIGHT (KG.)	vs_M&kbZax dk lanHAZ REF. TO ASSY. DRG.	en d_@ ITEM NO.	on id;k NO. OF ITEM
				25211001534	001	002

kh"AZ@BLE	M&kbZax DRAWING NO.	iqu_@ REV.
	25211001512	02

(DCA NO. 27232)

SPRING HOLDER

im"B d_@HT. NO.01 im"Bso dh id;@ OF SHT.01

A2

8

1855609/2023/HEP-SWM20961

VAR. 00 & 01 = 351±0.5
VAR. 02 = 361±0.5VAR. 00 & 01 = 229±0.5
VAR. 02 = 239±0.5

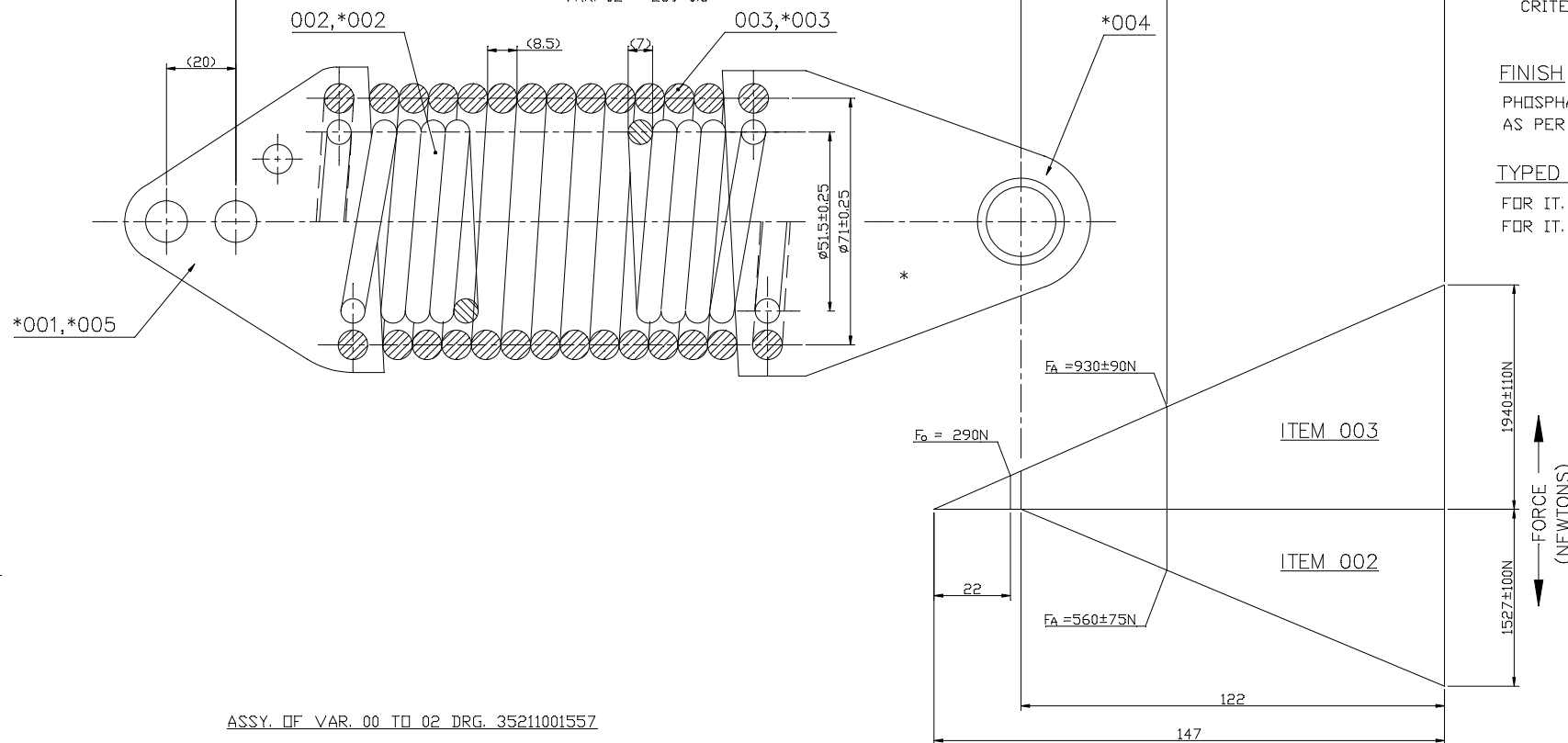
NOTE :-

1. MANUFACTURER SHALL PUT IDENTIFICATION AT LOCATION MARKED * DOCKET NO/BATCH NO.
2. REFER SG 12703 FOR TESTING AND ACCEPTANCE CRITERIA.

FINISH :-

PHOSPHATE COATED AND OILING
AS PER AA 0673616.

TYPED IT. NO. :-

FOR IT. 002 - BP9099431821
FOR IT. 003 - BP9099431830

ASSY. OF VAR. 00 TO 02 DRG. 35211001557

(FOR B.D.M. REF. DRG. 35211001557)

(ITEM NOS. MARKED THUS * BELONGS TO DRG. 35211001557)

FIG.-A

IT.NO.	WIRE DIA d	NO. OF ACTIVE TURNS f	TOTAL NO. OF TURNS lg	PERMISSIBLE SHEAR STRESS Tkn N/mm ²	MODULUS OF RIGIDITY G N/SQ. mm	DIRECTION OF WINDING	BALANCE OF MANUFACTURING EFFORT	MATERIAL SPECIFICATION FOR WIRE
002	7±0.06	14.5	17	695	83000	L.H.S.	F _o & D _m	COLD DRAWN SPRING ST. WIRE AS PER IS 4454 (1975) SEC II GR 3
003	8.5±0.06	11.5	14.4	663	83000	R.H.S.	F _o & D _m	COLD DRAWN SPRING ST. WIRE AS PER IS 4454 (1975) SEC II GR 3

SCALE FOR ITEM 002 = 12.5 NEWTON/mm.

SCALE FOR ITEM 003 = 13.2 NEWTON/mm.

		003	Ø8.5x2760 LG. PATENTED & COLD DRAWN SPG. S. WIRE						1.237		
		002	Ø7x3140 LG. PATENTED & COLD DRAWN SPG. S. WIRE						0.955		
VAR 00	REMARKS	VAR NO.	ITEM NO	DESCRIPTION	STD.	DRAWING NO.	IT.NO VAR	MATL. CODE	VAR	MATL. SPECN.	UNIT

ADDITIONAL INFORMATION

mRikn dk i-dkj ;k
xk-gd@fjkstuk dk uke
TYPE OF PRODUCT OR
NAME OF CUSTOMER/PROJECT

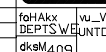
V.C.B.

STATUS OF DRAWING

DISTRIBUTION OF PRINTS

QC - 1 TCX - 1
SWM - 3HAKjr gsoh bysFDV&dYl fyfeVsM
HAKsiky
BHARAT HEAVY ELECTRICALS LTD.
BHOPAL

NAME	SIGN.	DATE	DATE
B.D.V.	Sd/-	24.09.82	
M.Z.G.	Sd/-	05.10.82	
B.P.N./R.K.G.	Sd/-	10.10.82	

foHAKr lw_Vky_uki dh jskh
DEPT'S W/UNTDL. DIMS. GR.
dksM409
CODEvuqikr SCALE 1:1
HAKg fd_x
REF. TO ASSY. DRG.
35211001557en d-
ITEM NO.
002
ITEM NO.
003ZONE NOTE-3 ADDED.
DCA-MCD/5285

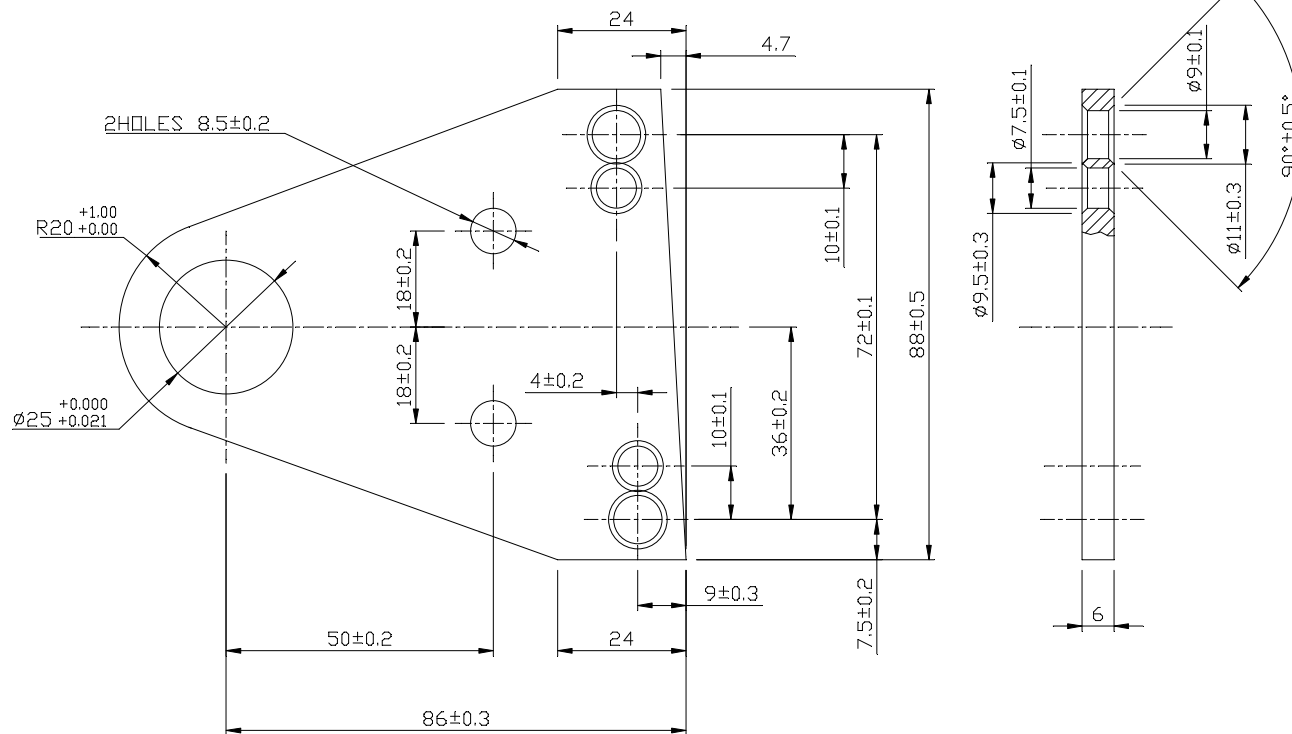
"kh"AZ00E

CLOSING SPRING

M&kbZax DRAWING NO.
25211001534im"B d-
SHT. NO.01

REV.	DATE	ALTERED	CHECKED	APPROVED	REV.	DATE	ALTERED	CHECKED	APPROVED	REV.	DATE	ALTERED	CHECKED	APPROVED	REV.	DATE	ALTERED	CHECKED	APPROVED	REV.	DATE	ALTERED	CHECKED	APPROVED
07	15.03.04				06	29.08.02				05	06.04.01				04	17.03.98				03	21.09.95			
		TOTAL NO. OF TURNS FOR IT.003 WAS 14					DRG. REDRAWN.					F _a 930&560 WAS 886&576 RESPECTIVELY. NOTE-3 REINSTATED					NOTE-1,2&3 DELETED AND NOTE-4 ADDED.				IT. 002 & 003 WERE ITEM 002 & 003 OF DRG. NO. 35211001557 FINISH WAS TO PR.S.7609			
		<DCA NO.13003 >					<DCA NO. 11640>					<DCA NO. 08880>					<DCA NO. 07108>							

1855609/2023/HEP-SWM20961



TOOL LIST :-

- 1492702 - FLAME CUTTING TEMPLATE
- 1492697 - DRILL JIG
- 1498710 - 25 H7 REAMER
- 1498711 - 25 H7 PLUG GAUGE

FINISH :- NATURAL

NOTE :-

SURFACE AT THE EDGES SHALL BE DRESSED
SMOOTH AFTER FLAME CUTTING.

			001	6TK. x 88 x 106 STRUCTURAL STEEL PLATE				AA1011808030		KG.		-	-
								AA10108			001		
VAR 00	REMARKS	VAR. NO.	ITEM NO	DESCRIPTION	STD.	DRAWING NO.	IT.NO	MATL. CODE	C/A	UNIT	UNIT WT.	G.S.	ZONE
							VAR	MATL. SPECN.			QTY.		

ADDITIONAL INFORMATION

mRikn dk i-dkj ;k
xk-gd@fj;kstuk dk uke
TYPE OF PRODUCT OR
NAME OF CUSTOMER/PROJECT

V.C.B.

STATUS OF DRAWING

DISTRIBUTION OF PRINTS

□/C	SWM	TCX
1	3	1



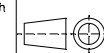
HAKjr gsoh bysfDV&dYl fyfeVsm
HAKsiky
BHARAT HEAVY ELECTRICALS LTD.
BHOPAL

uke@NAME	gLrk@SIGN	fnaukd@DATE	osfj_ dh
B.D.V.	Sd/-	18.08.82	la; k NO. OF VAR
M.Z.G.	Sd/-	05.09.82	
B.P.N.	Sd/-		

REV.	DATE	ALTERED
01	29.08.02	CHECKED
		APPROVED

foHAKs
DEPT SWE
dksM
CODE 409

vu_ Vky_ uki dh Js.kh
UNTIL.DIMS. GR.
M
AA0230208



vuqjkr
SCALE
1:1

HAKj fd_xk_
WEIGHT (K.G.)

vis_ M&kbZax dk lanHAZ
REF. TO ASSY. DRG.

en d_ _
ITEM NO.

DRG. REDRAWN.

'kh"AZ@OLE

SPRING HOLDER

vksj[A d-dRAWING NO.

35211001524

i="B d-@S. No. 01

i="Bksa dh la; NO. OF SHT. 01

A3

35211001525

DRG. NO.

+0.000
Ø20 +0.021

4.5±0.3

002

2.5√

001

6

TOOL LIST :-

1492694 - WELDING FIXTURE

1498708 - 20 H7 REAMER

1498709 - 20 H7 PLUG GAUGE

FINISH :- PARKERISE TO PR. S. 7609

NOTE :- WELDING METHOD MAGC AS PER SN 31010
WELDING CHECKING AS PER BK DIN 8563

BP 9089469460-00

001			002	BOSS	45211001519	001			KG.	0.0578		
										001		
001			001	SPRING HOLDER	35211001524	001			KG.	0.439	-	-
										001		
VAR 00	REMARKS	VAR. NO.	ITEM NO	DESCRIPTION	STD.	DRAWING NO.	IT.N	MATL. CODE	A	UNIT	UNIT WT.	G.S.
							VAR	MATL. SPECN.	C	UNIT	QTY.	ZONE

ADDITIONAL INFORMATION

mRikn dk i-dkj ;k
xk-gd@fj;kstuk dk uke
TYPE OF PRODUCT OR
NAME OF CUSTOMER/PROJECT

V.C.B.

STATUS OF DRAWING

DISTRIBUTION OF PRINTS

D/C	SWM	TCX
1	4	1

HAKjr gsoh bysfDV&dYl fyfeVsM
HAKsiky
BHARAT HEAVY ELECTRICALS LTD.
BHOPAL

uke@NAME	gLrk@SGN	fnaukd@ATE	osfj_- dh la[-k NO. OF VAR
B.D.V.	Sd/-	05.09.82	
M.Z.G.	Sd/-	29.08.82	
R.K.G.	Sd/-	05.09.82	00

REV.	DATE	ALTERED	CHECKED	APPROVED
01	28.08.02			

DRG. REDRAWN.

(DCA. NO. 11635)

faHAKs DEPT	vu_- Vky_- uki dh Js.kh UNTAL.DIMS. GR.	vuqjkr SCALE	HAKj fd_xk_- WEIGHT (K.G.)	vis_- M&kbZax dk lanHAZ REF. TO ASSY. DRG.	en d_- ITEM NO.	en_- la[-k NO. OF ITEM
SWE	M	1:1		25211001534	004	002
dkSM CODE	AA0230208					
'kh"AZA						

SPRING HOLDER ASSY.

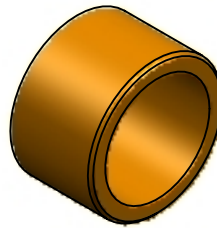
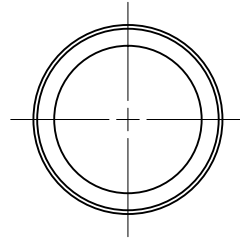
DRAWING NO. 35211001525



ITEM NO. 01

NO. OF SHT. 01

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Technical drawing of a shaft with a keyway. The shaft has a diameter of $\varnothing 25$ mm and a length of $\varnothing 19.5$ mm. The keyway has a width of 15 ± 0.3 mm and a depth of $0.5 \times 45^\circ$. The drawing shows the shaft with a keyway and a key.

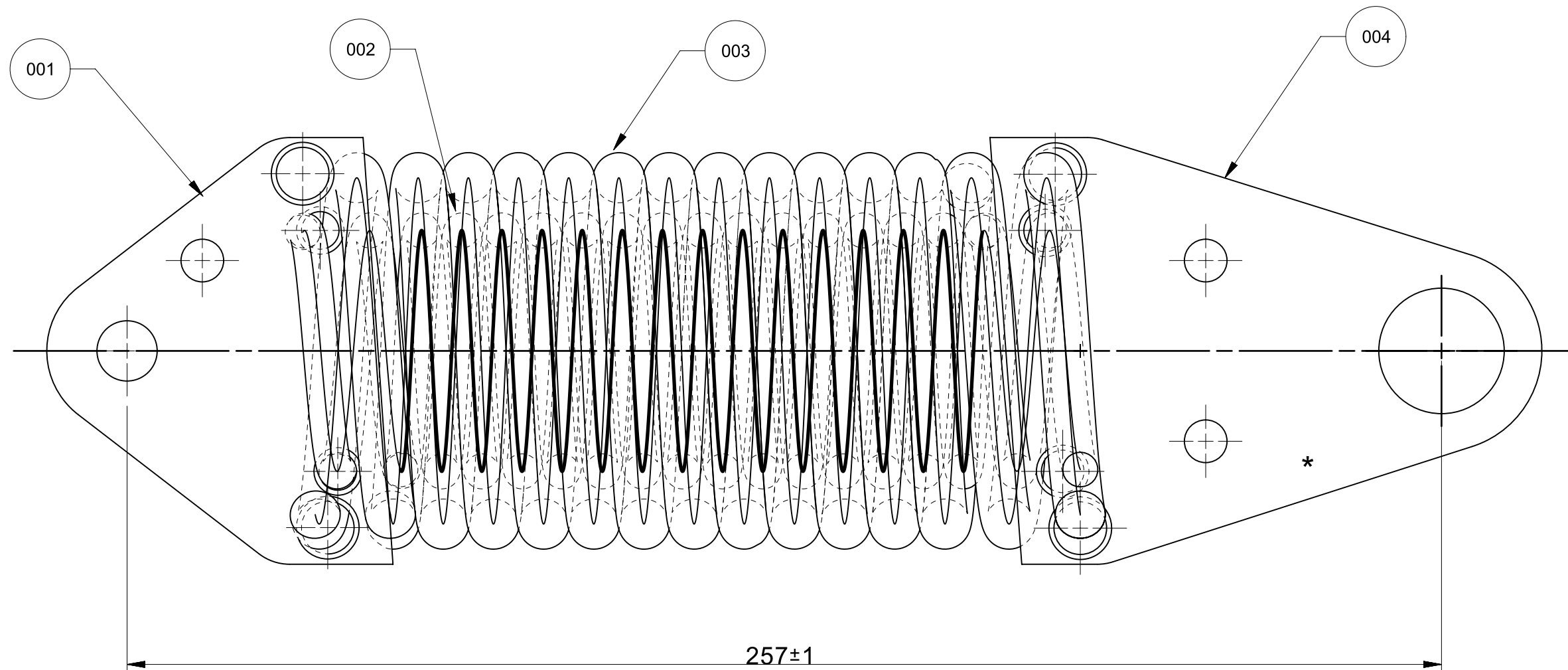


REF.DRG.NO.	FINISH ; - NATURAL									
		001	Ø 25 X 15 Lg.STRL S. (STD. QLTY) ROUND			AA 1010208128 AA 10108			Kg.	0.02 001
REMARKS	ITEM NO.	DESCRIPTION		STD.	MATL. CODE MATL. SPECN.		A C	UNIT	UNIT WT. QTY.	
	mRikn dk izdkj ;k xzkgd@ifj;kstuk dk uke TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		PVN 36							
SIGN AND DATE	 Hkkjr gsOH bysfDV`dYl fyfeVsM Hkksiky BHARAT HEAVY ELECTRICALS LTD. BHOPAL		cuk;k DRN.	uke/NAME	gLrk-/SIGN.	fnuakd/DATE	osfj- dh la[k NO.OF VAR			
			tkWpk CKD.	TSE	Sd/-	-				
			Lohd'r APPD.	MZG	Sd/-	27.08.82				
INVENTORY NO.	foHkKx DEPT.SWE	vu-Vky-uki dh Js.kh UNTOL.DMS. GR.		vuqikr SCALE	Hkkj (fd-zxk-) WEIGHT(K.G.)	vls-MkbZax dk lanHkZ REF.TO ASSY.DRG.		en dz- ITEM NO.	en- dh la[k NO.OF ITEMS	
	dkSM CODE 409	M AA0230208		1 : 1	0.57	35211001501 & 1525		002	001	
	'kh"kZd/TITLE					vkjs[k dz-/DRAWING NO.			iqu-/REV.	
	BOSS					45211001519			03	
						i"B dz-/SHT NO.1		i"Bksa dh la[k/NO.OF SHT.1		

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1855609/2023/HEP-SWM20961

DRG.NO. 35211001921



NOTE :-

1. SPRING SHALL CONFIRM TO PRODUCT STANDARD SG. 12703
2.*IDENTIFICATION MARKING AS PER PRO. STD. SG. 12703

FOR VAR.00 -BP9089186617

<u>LOAD - TABLE</u>				
SPRING LENGTH (mm.)	DEFLECTIO N (mm.)	TEST - LOAD (N)	PRETENS ON (N)	SCALE (N/mm)
257	00	00	560	-
271	14	1134±120	-	-
351	94	4410±270	-	41

	001	004	WA OF SPRING HOLDER		35211001501		01		KG		0.29 001		
	001	003	SPRING (OUTER)		35213030705		001		KG		1.86 001		
	001	002	SPRING (INNER)		35213030704		001		KG		0.80 001		
	001	001	SPRING HOLDER		25211001516		001		KG		0.17 001		
REMARKS	VAR. 00	ITEM NO.	DESCRIPTION	STD.	DRAWING NO.	IT. NO. VAR	MATL. CODE MATL. SPECN.	A C	UNIT	UNIT WT. QTY.	G.S.	ZONE	
ADDITIONAL INFORMATION				<div>mRikn dk izdkj ;k xzkgd@ifj;kstuk dk uke TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT</div>									
STATUS OF DRAWINGS				PVN 36									
DISTRIBUTION OF DRAWINGS				<div><div><div><div>बी एच ई एल</div><div>BHEL</div></div><div>Hkkjr gsoh bysfDV` dYl fyfeVsM Hkksiky BHARAT HEAVY ELECTRICALS LTD. BHPAL</div></div><div><div>cuk;k DRN. tkWpk CKD. Lohd`r APPD.</div><div><div>uke/NAME</div><div>A.P.</div><div>S.M.</div><div>I.L.B.</div></div><div><div>gLrk-/SIGN.</div><div>Sd/-</div><div>Sd/-</div><div>Sd/-</div></div><div><div>inuakd/DATE</div><div>04.04.93</div><div>24.06.93</div><div>28.06.93</div></div><div><div>osfj- dh la[k NO.OF VAR</div><div>00</div><div>004</div><div>005</div></div></div></div>									
SWE	SWM	TCX		foHkxx DEPT.SWE	vu-Vky-uki dh Js.kh UNTOL.DMS. GR.		vugikr SCALE	Hkki (fd-zxk- WEIGHT(K.G.)	vls-MkbZax dk lanHkZ REF.TO ASSY.DRG.	en dz- ITEM NO.	en- dh la[k NO.OF ITEMS		
				dksM CODE 409	M AAO230208	1 : 1	3.12	15211030501	008	004			
ZONE	-DRG. REDRAWN IN NX S/W.			'kh"kZd/TITLE				vksj[k dz-/DRAWING NO.		iqu-/REV.			
				CLOSING SPRING				35213030702		05			
	(DCA NO. 34739)							i"B dz-/SHT NO.1		i"Bksa dh la[k;/NO.OF SHT.1			

1855609/2023/HEP-SWM20961

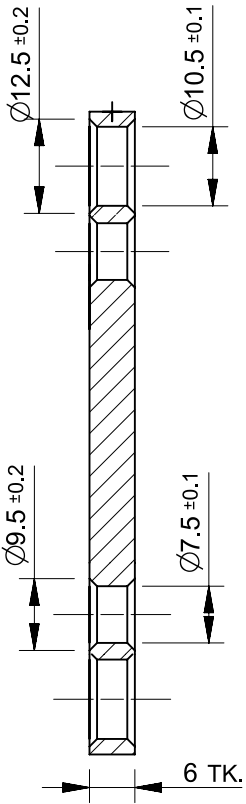
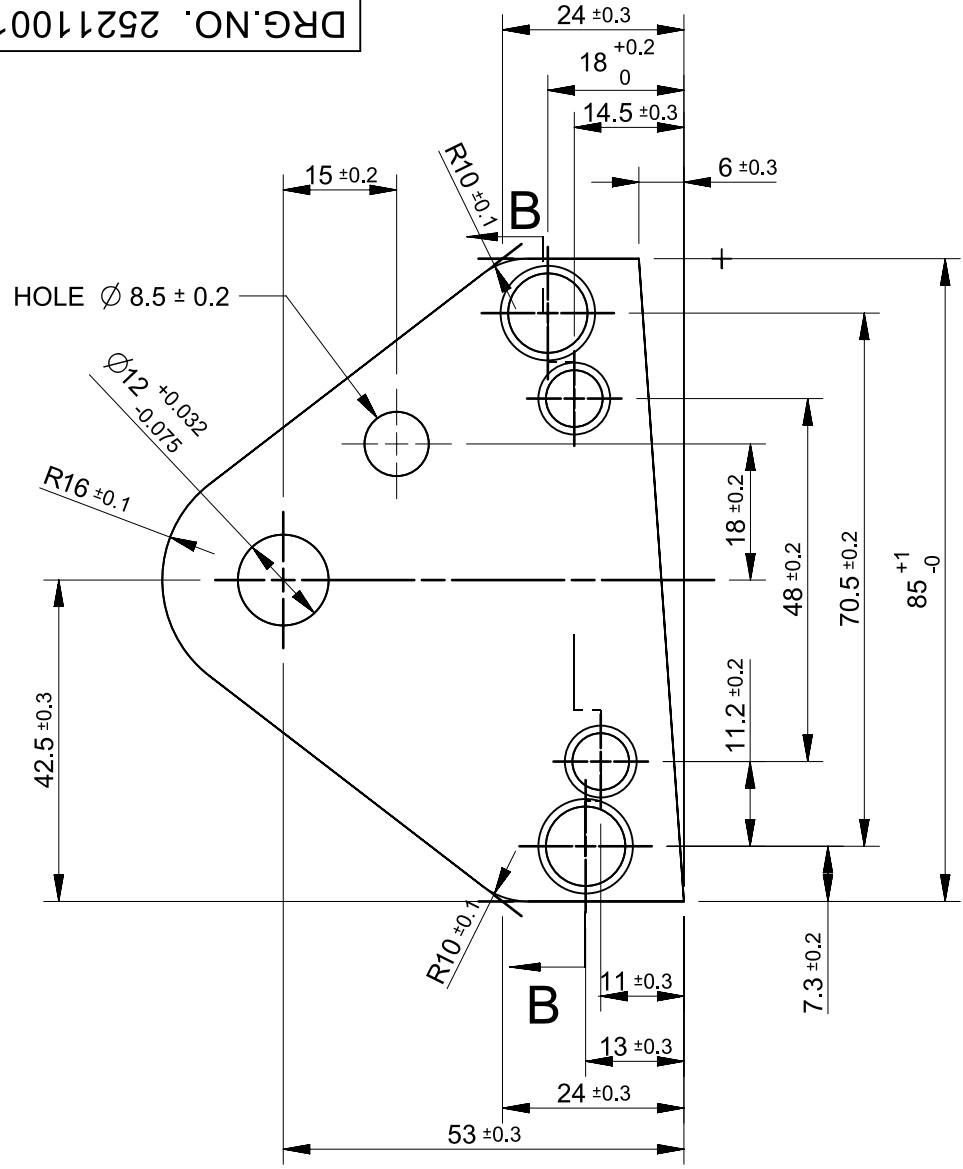
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REF.DRG.NO.

SIGN AND DATE

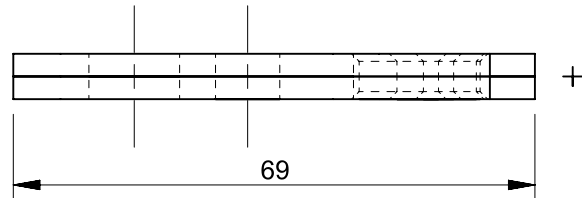
INVENTORY NO.



SECTION B-B

NOTE
SURFACE AT THE EDGES SHALL BE DRESSED SMOOTH AFTER FLAME CUTTING.

FINISH
PARKERISE TO PR.S. 7609



ST 943043				001		6 THK. X 69 X 85 Lg. STR. STEEL PLATE						AA 1011808030				0.28						
												AA 10108				001						
REMARKS		VAR. NO.	ITEM NO.	DESCRIPTION				STD.	DRAWING NO.				IT. NO. VAR		MATL. CODE MATL. SPECN.		A C	UNIT	UNIT WT. QTY.		G.S.	ZONE
ADDITIONAL INFORMATION						mRikn dk izdkj ;k xzkgd@ifj;kstuk dk uke TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT																
STATUS OF DRAWINGS						PVN 36																
DISTRIBUTION OF DRAWINGS						Bharat Heavy Electricals Ltd. Bhopal																
SWE		SWM		TCX				Bharat Heavy Electricals Ltd. Bhopal				cuk;k DRN.	uke/NAME		gLrk-/SIGN.		fnuakd/DATE		osfj- dh la[k; NO.OF VAR			
												tkWpk CKD.	B.D.V.		Sd/-		22.08.82					
												Lohd'r APPD.	M.Z.G.		Sd/-		28.08.82					
													B.P.N/R.K.J.		Sd/-		28.08.82		-			
REV. 01	DATE. 24.04.17	ALTERED - AKN CHECKED - JAG APPD - SKP				foHkKx DEPT.SWE	vu-Vky-uki dh Js.kh UNTOL.DMS. GR.					vuqikr SCALE	Hkkj (fd-xzk-) WEIGHT(K.G.)	vls-MkbZax dk lanHkZ REF.TO ASSY.DRG.			en dz- ITEM NO.		en- dh la[k; NO.OF ITEMS			
	-DRG REDRAWN IN NX S/W.					dksM CODE 409	M AA0230208					1 : 1	0.17	25211001538			001		001			
ZONE	(DCA NO. 34733)					'kh"kZd/TITLE										vksj[k dz-/DRAWING NO.				iqu-/REV.		
						SPRING HOLDER										25211001516				01		
						i"B dz-/SHT NO.1				i"Bksa dh la[k; NO.OF SHT.1												

1855609/2023/HEP-SWM20961

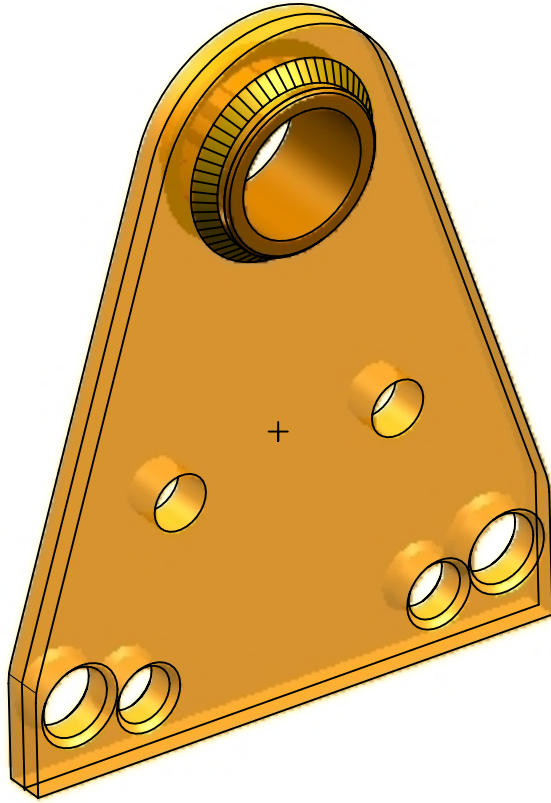
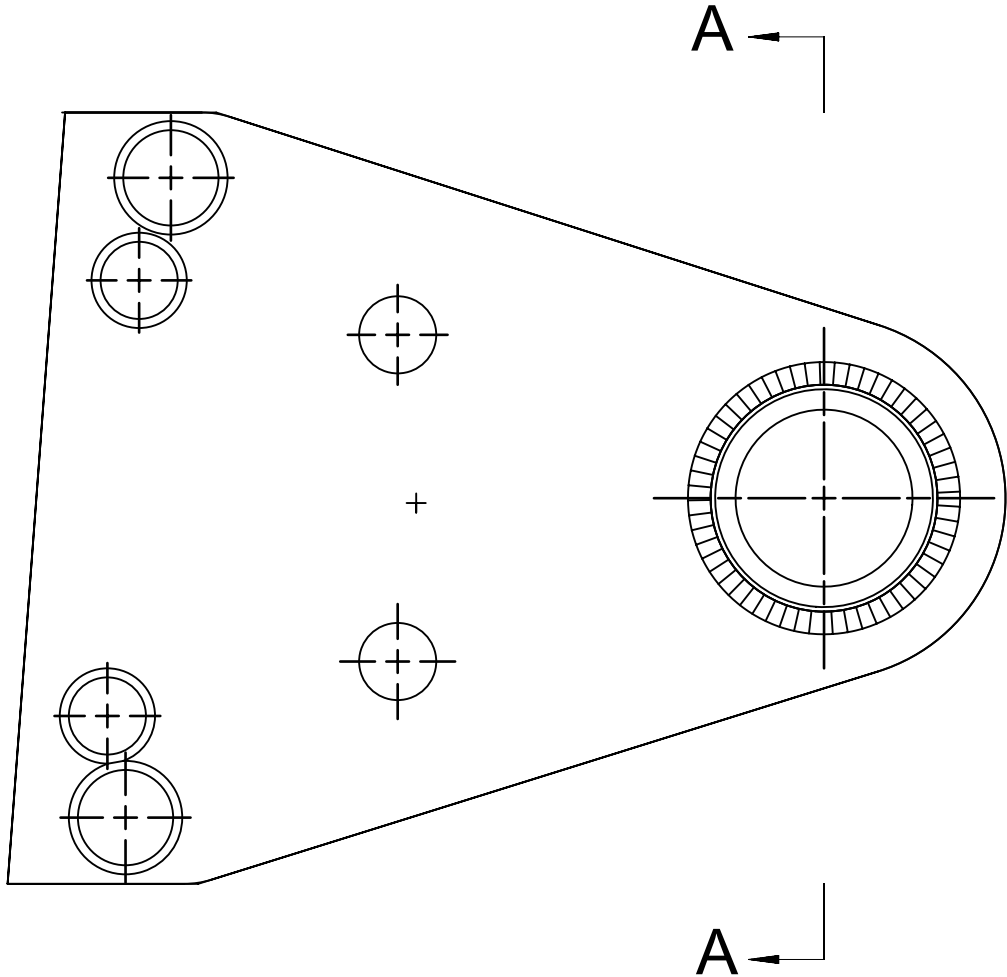
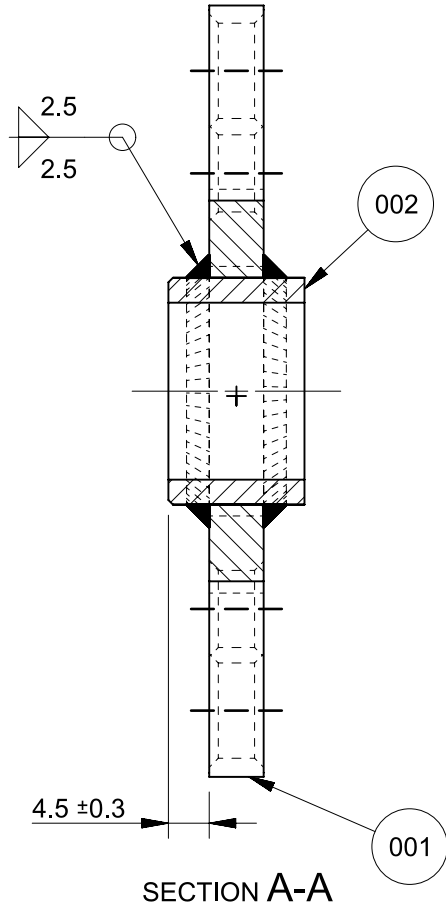
DRG.NO. 35211001501

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REF.DRG.NO.



SIGN AND DATE

INVENTORY NO.



- TOOL LIST
- 1492694 - WELDING FIXTURE
 - 1498708 - 20 H7 REMER
 - 1498709 - 25 H7 PLUGH GAUGE

NOTE :-
SURFACE AT THE EDGES SHOULD BE DERSSSED
SMOOTH AFTER FLAME CUTTING..
FINISH :-
PARKERISE TO PROCESS SPEC. 7609.

		001	002	BOSS		45211001519		001			Kg.	0.02		001		
		001	001	SPRING HOLDER PLATE		35211001506		001			Kg.	0.26		001		
REMARKS		VAR. 01	ITEM NO.	DESCRIPTION		STD.	DRAWING NO.		IT. NO. VAR	MATL. CODE MATL. SPECN.		A/C	UNIT	UNIT WT. QTY.		G.S. ZONE
ADDITIONAL INFORMATION				mRikn dk izdkj ;k xzkgd@ifj;kstuk dk uke TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT				PVN 36								
STATUS OF DRAWINGS																
DISTRIBUTION OF DRAWINGS				<div></div> <div>Hkkjr gsoh bysfDV`dYI fyfeVsM Hkksiky BHARAT HEAVY ELECTRICALS LTD. BHOPAL</div>				cuk;k DRN. tkWpk CKD. Lohd`r APPD.	uke/NAME	gLrk-/SIGN.	fnuakd/DATE	osfj- dh la[k NO.OF VAR 00				
SWE	SWM	TCX									TSE				Sd/-	----
											MZG				Sd/-	29.08.82
											RKJ				Sd/-	05.09.82
REV. 01	DATE. 11.10.03	ALTERED - CHECKED - APPD -		foHkkx DEPT.SWE	vu-Vky-uki dh Js.kh UNTOL.DMS. GR.		vugikr SCALE	Hkkj (fd-xzk-) WEIGHT(K.G.)	vls-MkbZax dk lanHkZ REF.TO ASSY.DRG.		en dz- ITEM NO.		en- dh la[k NO.OF ITEMS			
				dksM CODE 409	M AA0230208		1 : 1	0.29	35213030702		004		002			
ZONE	-DRAWING REDRAWN			'kh"kZd/TITLE WA OF SPRING HOLDER					vkjs[k dz-/DRAWING NO. 35211001501				iqu-/REV. 02			
									i`B dz-/SHT NO.1		i`Bksa dh la[k; NO.OF SHT.1					

1855609/2023/HEP-SWM20961

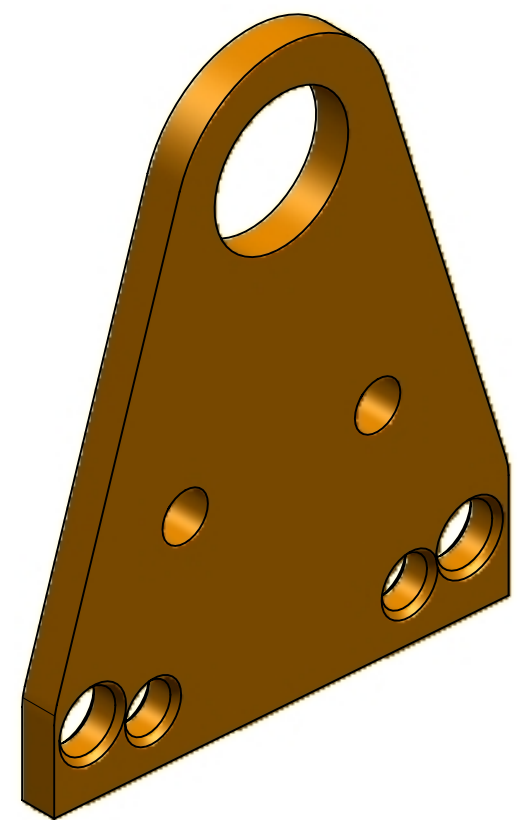
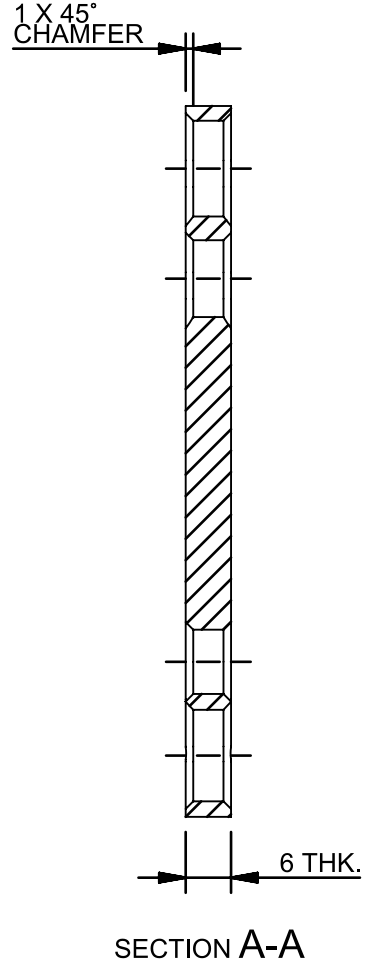
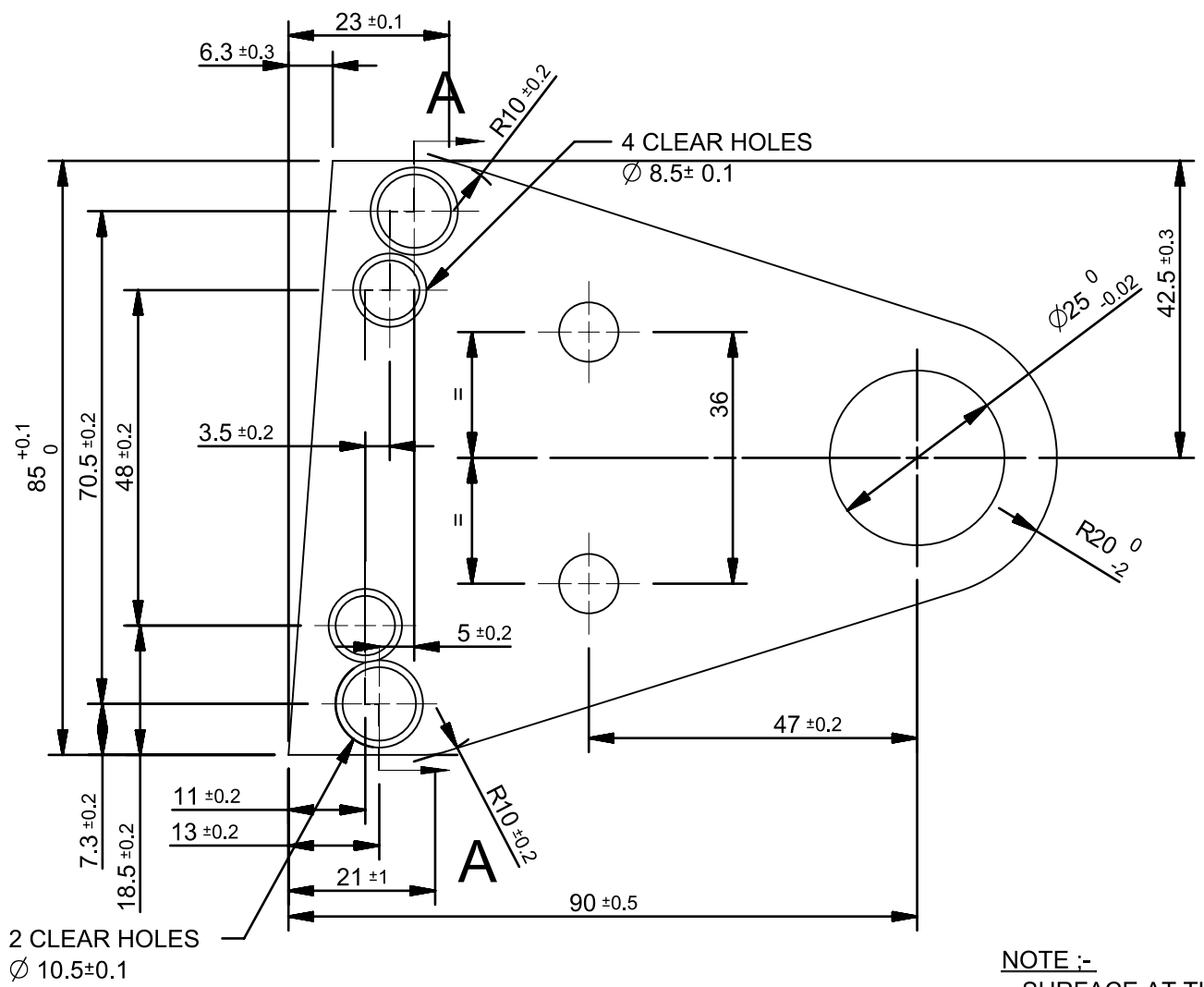
DRG.NO. 35211001506

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REF.DRG.NO.

SIGN AND DATE

INVENTORY NO.



NOTE :-
SURFACE AT THE EDGES SHOULD BE DRESSED
SMOOTH AFTER CUTTING.

FINISH :- NATURAL.

TOOL LIST
1492695 - DRILL JIG
1492701 - FLAME CUTTING TEMPLATE
1498710 - 25 H7 REAMER
1498711 - 25 H7 PLUG GAUGE

		001	6 THK. X 85 X 110 Lg. STR. STEEL PLATE				AA 1011808030			0.26		
							AA 10108			001		
REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	STD.	DRAWING NO.	IT. NO. VAR	MATL. CODE MATL. SPECN.	A C	UNIT	UNIT WT. QTY.	G.S.	ZONE
ADDITIONAL INFORMATION				mRikn dk izdkj ;k xzkgd@ifj;kstuk dk uke TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT								
STATUS OF DRAWINGS				PVN 36								
DISTRIBUTION OF DRAWINGS				<div><div><div>बी एच ई एल</div><div>BHEL</div></div><div>Hkkjr gsoh bysfDV`dYl fyfeVsM Hkksiky BHARAT HEAVY ELECTRICALS LTD. BHOPAL</div></div>								
SWE	SWM	TCX					uke/NAME	gLrk-/SIGN.	fnuakd/DATE	osfj- dh la[k NO.OF VAR		
							BDV	Sd/-	-			
							MZG	Sd/-	18.08.82			
							BPN	Sd/-	05.09.82	-		
REV. 01	DATE. 11.10.03	ALTERED - CHECKED - APPD -	foHkKx DEPT.SWE	vu-Vky-uki dh Js.kh UNTOL.DMS. GR.		vuqikr SCALE	Hkkj (fd-xzk-) WEIGHT(K.G.)	vls-MkbZax dk lanHkZ REF.TO ASSY.DRG.	en dz- ITEM NO.	en- dh la[k NO.OF ITEMS		
			dkSM CODE 409	M AA0230208		1 : 1	0.40	35211001501	001	001		
ZONE	-DRG. REDRAWN.			'kh"kZd/TITLE				vkjs[k dz-/DRAWING NO.		iqu-/REV.		
				SPRING HOLDER PLATE				35211001506		02		
							i`B dz-/SHT NO.1		i`Bksa dh la[k;k/NO.OF SHT.1			

1855609/2023/HEP-SWM20961

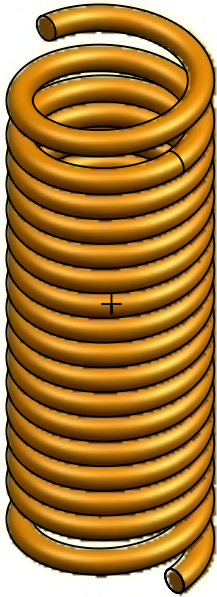
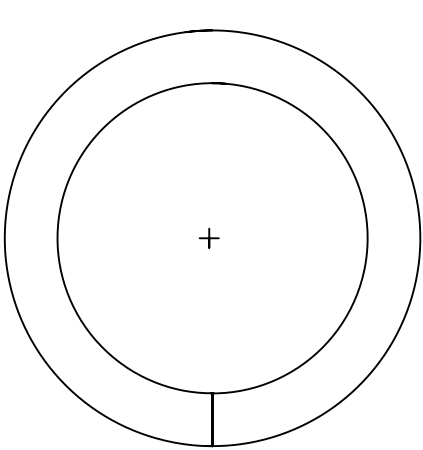
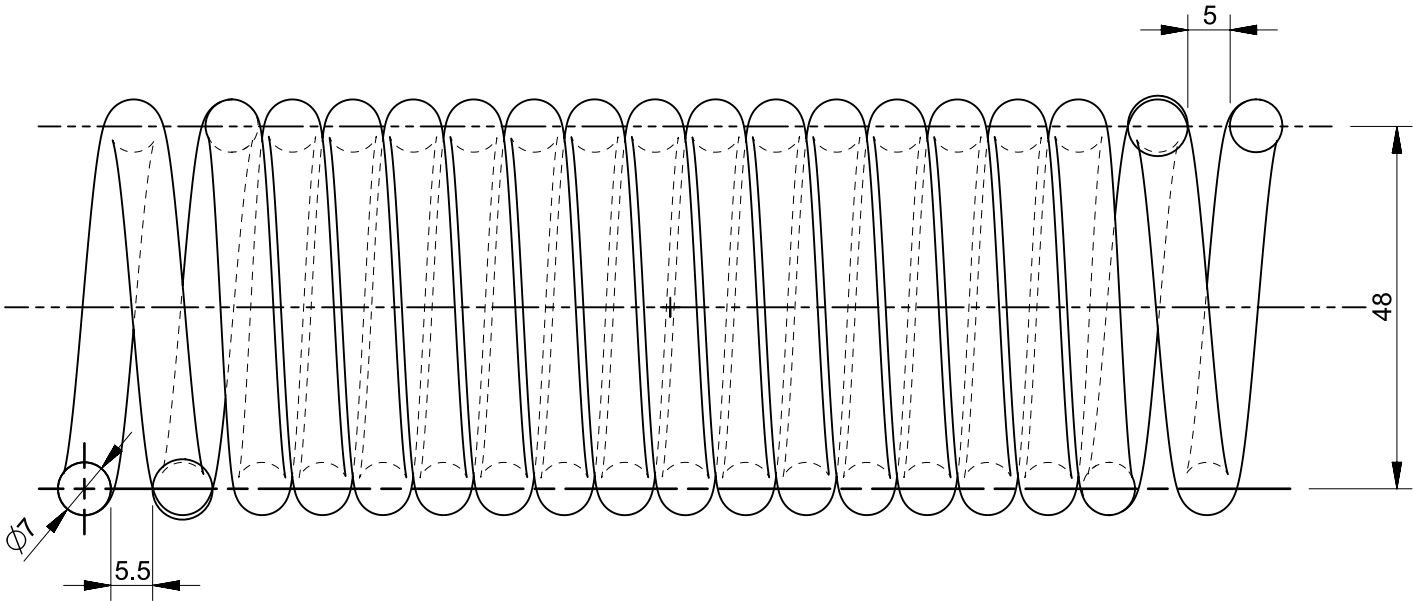
DRG.NO. 35213030704

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REF.DRG.NO.

SIGN AND
DATE

INVENTORY NO.




S.NO.	SPRING PARAMETERS	
01	WIRE DIAMETER	7 mm.
02	OUTSIDE DIAMETER	55 mm.
03	INSIDE DIAMETER	41 mm.
04	No. OF ACTIVE TURNS	16.5
05	TOTAL No. OF TURNS	19.4
06	DIRECTION OF WINDING	L.H.S.
07	SCALE	13.6 N / mm
08	PERMISSIBLE SHERE STRESS	668 N / mm ²
09	MODULUS OF RIGIDITY	83000 N / mm ²

TESTING PROCEDURE
5% OF SPRINGS MANUFACTURED SHOULD BE TESTED TO VERIFY THE SCALE.
END PLATES TO SUIT TEST SET - UP SHOULD BE ASSEMBLED AS SHOWN AND
LOAD AT VARIOUS DEFLECTIONS AS PER TABLE ON LEFT HAND CORNER VERIFIED.

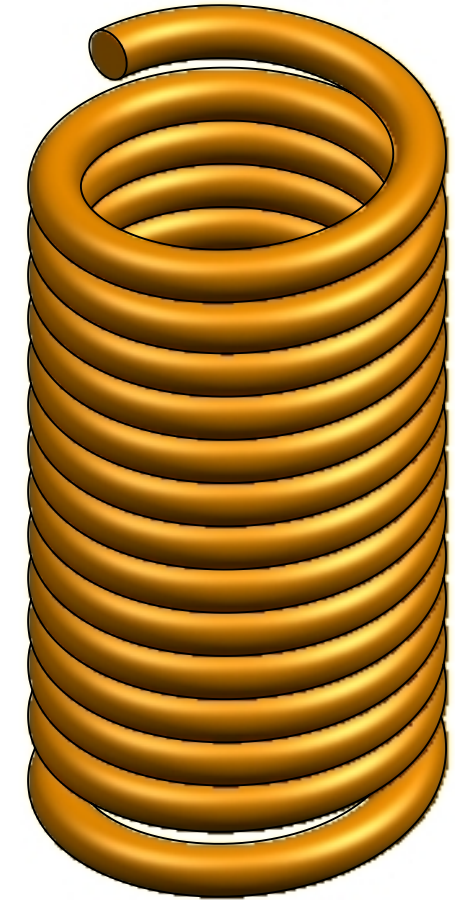
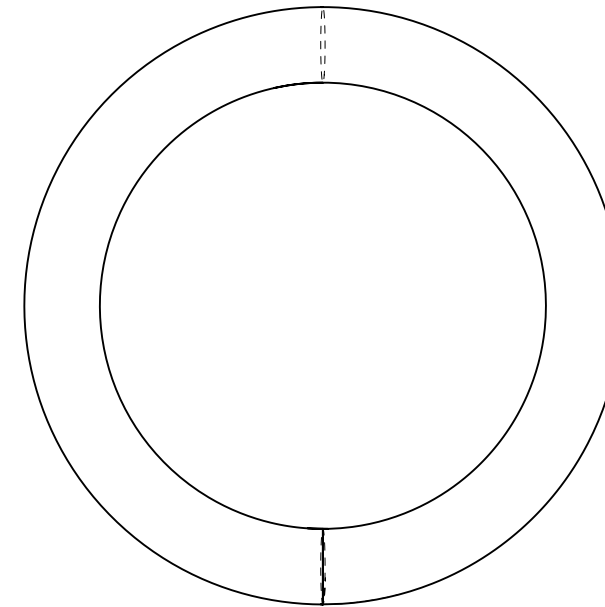
NOTE :- BOTH END TURNS TO BE OPENED OUT BYOUT BY 5 mm.

FINISH :-MANGANESE PHOSPHATING AS PER AA0673616.

DEFLECTION (mm)	LOAD Kg.
00	00
14	476±50
47	923±70
94	1563±100

			001	Ø 7 X 3050 Lg. COLD DRAWN SPG. ST. WIRE				BP 10398 IS : 4454 PART - 1			Kg.	0.80 001									
REMARKS		VAR. NO.	ITEM NO.	DESCRIPTION		STD.	DRAWING NO.		IT. NO. VAR	MATL. CODE MATL. SPECN.		A C	UNIT	UNIT WT. QTY.		G.S. ZONE					
ADDITIONAL INFORMATION				mRikn dk izdkj ;k xzkgd@ifj;kstuk dk uke TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT				PVN 36													
STATUS OF DRAWINGS																					
DISTRIBUTION OF DRAWINGS				<div><div><div>बी एच ई एल</div><div>BHEL</div></div><div>Hkkjr gsoh bysfDV' dYl fyfeVsM Hkksiky BHARAT HEAVY ELECTRICALS LTD. BHOPAL</div></div>				cuk;k DRN.		uke/NAME		gLrk-/SIGN.		fnuakd/DATE		osfj- dh laf;k NO.OF VAR					
SWE		SWM						TCX				AMRIT PAL		Sd/-				10.04.93			
												tkWpk CKD.		S. MATHUR				Sd/-		26.06.93	
												Lohd'r APPD.		I L BHATIA				Sd/-		28.06.93	
REV. 01	DATE. 24.04.17	ALTERED - AKN CHECKED - JAG APPD - SKP		foHkx DEPT.SWE		vu-Vky-uki dh Js.kh UNTOL.DMS. GR.				vugjkr SCALE		Hkkj (fd-xzk-) WEIGHT(K.G.)		vls-MkbZax dk lanHkZ REF.TO ASSY.DRG.		en dz- ITEM NO.		en- dh laf;k NO.OF ITEMS			
				dksM CODE 409		M AA0230208		1 : 1		0.93		35213030702		002		001					
ZONE		-DRG. REDRAWN IN NX S/W. (DCA NO. 34738)		'kh"kZd/TITLE								vksjs[k dz-/DRAWING NO.				iqu-/REV.					
				SPRING (INNER)								35213030704				01					
												i"B dz-/SHT NO.1		i"Bksa dh laf;k/NO.OF SHT.1							

INVENTORY NO.



DEFLECTION (mm)	LOAD (N)
00	00
14	657±70
47	1559±110
94	2847±170

5% OF SPRINGS MANUFACTURED SHOULD BE TESTED TO VERIFY THE SCALE.
END PLATES TO SUIT TEST SET - UP SHOULD BE ASSEMBLED AS SHOWN AND
LOAD AT VARIOUS DEFLECTIONS AS PER TABLE ON LEFT HAND CORNER VERIFIED.

FINISH :-MANGANESE PHOSPHATING AS PER AA0673616.

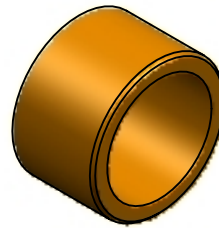
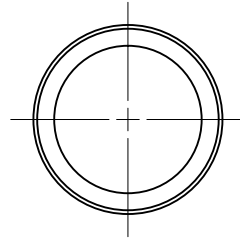
S.NO.	SPRING PARAMETERS	
01	WIRE DIAMETER	10 mm.
02	OUTSIDE DIAMETER	79 mm.
03	INSIDE DIAMETER	59 mm.
04	No. OF ACTIVE TURNS	11.5
05	TOTAL No. OF TURNS	14.4
06	DIRECTION OF WINDING	R.H.S.
07	SCALE	27.4 N / mm
08	PERMISSIBLE SHERE STRESS	600 N / mm ²
09	MODULUS OF RIGIDITY	83000 N / mm ²



REV.	DATE.	ALTERED -	REV.	DATE.	ALTERED -
		CHECKED -			CHECKED -
		APPD -			APPD -
ZONE			ZONE		

		001	Ø 10 X 2880 Lg. COLD DRAWN SPG. ST. WIRE				BP 10398 IS: 4454 PART - 1		Kg.	1.86 001			
REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	STD.	DRAWING NO.	IT. NO. VAR	MATL. CODE MATL. SPECN.	A C	UNIT	UNIT WT. QTY.	G.S.	ZONE	
ADDITIONAL INFORMATION				mRikn dk izdkj ;k xzkgd@ifj;kstuk dk uke TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT <div>PVN 36</div>									
STATUS OF DRAWINGS													
DISTRIBUTION OF DRAWINGS													
SWE		SWM	TCX		<div><div>बी एच ई एल</div><div><div>Hkkjr gsos bysfDV`dYl fyfeVsM Hkksiky BHARAT HEAVY ELECTRICALS LTD. BHOPAL</div></div></div>		cuk;k DRN.	uke/NAME	gLrk-/SIGN.	fnuakd/DATE	osfj- dh la[k NO.OF VAR		
				tkWpk CKD.			AMRIT PAL	Sd/-	09.04.93				
				Lohd`r APPD.			S MATHUR	Sd/-	24.06.93				
							I L BHATIA	Sd/-	28.06.93	-			
REV. 01	DATE 24.04.17	ALTERED - AKN CHECKED - JAG APPD - SKP			foHkx DEPT.SWE	vu-Vky-uki dh Js.kh UNTOL.DMS. GR.		vugikr SCALE	Hkjk (fd-xzk-) WEIGHT(K.G.)	vls-MkbZax dk lanHkZ REF.TO ASSY.DRG.		en dz- ITEM NO.	en- dh la[k NO.OF ITEMS
				dksM CODE 409	M AA0230208	1 : 1		1.97	35213030702		003	001	
ZONE	-DRG. REDRAWN IN NX S/W. <div>(DCA NO. 34737)</div>				'kh"kZd/TITLE <div>SPRING (OUTER)</div>					vksj[k dz-/DRAWING NO. 35213030705		iqu-/REV. 05	
										i`"B dz-/SHT NO.1		i`"Bksa dh la[k;k/NO.OF SHT.1	

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Technical drawing of a cylindrical part. The drawing shows a front view and a side view. The front view is a rectangle with a width of 15 ± 0.3 and a height of $\varnothing 25$. The side view is a rectangle with a width of $\varnothing 19.5$ and a height of 25 . A chamfer of $0.5 \times 45^\circ$ is indicated on the top edge of the front view.



REF.DRG.NO.	FINISH ; - NATURAL												
		001	Ø 25 X 15 Lg.STRL S. (STD. QLTY) ROUND			AA 1010208128 AA 10108			Kg.	0.02 001			
SIGN AND DATE	REMARKS	ITEM NO.	DESCRIPTION		STD.	MATL. CODE MATL. SPECN.		A C	UNIT	UNIT WT. QTY.			
	mRikn dk izdkj ;k xzkgd@ifj;kstuk dk uke TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		PVN 36										
INVENTORY NO.	 Hkkjr gsOH bysfDV`dYl fyfeVsM Hkksiky BHARAT HEAVY ELECTRICALS LTD. BHOPAL		cuk;k DRN. tkWpk CKD. Lohd'r APPD.		uke/NAME		gLrk-/SIGN.	fnuakd/DATE	osfj- dh la;k NO.OF VAR				
					TSE		Sd/-	-	27.08.82	-			
					MZG		Sd/-	29.08.82			-		
	foHkKx DEPT.SWE		vu-Vky-uki dh Js.kh UNTOL.DMS. GR.			vuqikr SCALE		Hkkj (fd-xzk-) WEIGHT(K.G.)		vls-MkbZax dk lanHkZ REF.TO ASSY.DRG.		en dz- ITEM NO.	en- dh la;k NO.OF ITEMS
	dksM CODE 409		M AA0230208			1 : 1		0.57		35211001501 & 1525		002	001
'kh"kZd/TITLE					vkjs[k dz-/DRAWING NO.					iqu-/REV.			
BOSS					45211001519					03			
					i`"B dz-/SHT NO.1					i`"Bksa dh la;k/NO.OF SHT.1			