

3D VIEW (FOR REF. ONLY)



SECTION-CC



SECTION-AA

CASTING:-

1. CASTING FOR SUSPENSION TUBE SHALL BE FROM LATEST RSO APPROVED CLASS 'A' FOUNDRY
2. TOLERANCES ON CAST UNMACHINED DIMENSION TO BE TO IS 4897 CLASS-2.
3. SUPPLEMENTAL ALLOWANCES TO BE MAINTAINED 5-7MM PER TOOL POINT IN CASE CASTING IS SUPPLIED & 3-5MM PER TOOL POINT IN CASE ROUGH MACHINED CASTING IS SUPPLIED AS PER BHEL PO.
4. CASTING TO BE SAND/SHOT BLASTED.
5. SURFACE FINISH ON UN-MACHINED CASTED SURFACE TO BE AS PER IS:3073.
6. CASTING TO BE STRESS RELIEVED.
7. IDENTIFICATION MARKING OF SUSPENSION TUBE CASTING TO BE DONE AS PER TM12548 AT THE LOCATION SHOWN.
- 1 HOLE DRILL THROUGH Ø6 DRILL
& TAP 1/4" BSPx25 DEEP FULL THREAD
AND SPOTFACE Ø25 SUFFICIENT TO CLEANUP

8. LIMITS ON MACHINED DIMENSIONS ± 0.25 UNLESS OTHERWISE STATED.

8. LIMITS ON MAXIMUM DIMENSIONS 4.0-25 UNLESS OTHERWISE STATED.
9. LIMITS ON TOLERANCED ANGLES 50°-30°
10. REMOVE ALL SHARP CORNERS
11. SUSPENSION TUBE TO BE LIGHT GREY PAINTED WITH POLYURETHANE FINISHING PAINT TO A661 42 AS PER PROCESS SPECIFICATION TM4217 INSIDE BREL.
12. ALL 28 NOS. OF ∇ MARKED DIMENSIONS ARE CRITICAL TO QUALITY(CIQ) & S.L.N.O. OF CTO DIMENSIONS ARE INSCRIBED IN ∇ e.g. 28.
13. IDENTIFICATION MARKING OF SUSPENSION TUBE MACHINING TO BE DONE AS PER TM12546 AT THE LOCATION SHOWN.
14. TEMPORARY RUST PREVENTIVE (TRP) TO BE APPLIED ON MACHINED SURFACES AS PER A655152.
15. EXCESSIVE MATERIAL IN THE INSIDE DIAMETER OF SUSPENSION TUBE (LESS THAN DIMENSIONS R110*3). IF OBTAINED IN THE CASTING IS TO BE REMOVED BY MACHINING THE INSIDE DIAMETER TO BE DRAWING DIMENSIONS R110*3.
16. SUSPENSION TUBE TO BE PRIMER PAINTED ON UNMACHINED SURFACES WITH INORGANIC ETHYLENE GLYCOL BASED PRIMER AS SUPPLIER.
17. SUSPENSION TUBE TO BE PRIMER PAINTED ON UNMACHINED SURFACES WITH INORGANIC ETHYLENE GLYCOL BASED PRIMER AS SUPPLIER.

INSPECTION:-

17. NDT TESTING REQUIREMENT OF SUSPENSION TUBE IS AS PER THE FOLLOWING TABLE:

S.L.NO.	TEST	SPECIFICATION	ACCEPTANCE CRITERIA
1.	ULTRASONIC TESTING ON ALL POSSIBLE AREA	AAS050104	AAS050104 LEVEL-II
2.	MPI TESTING ON COMPLETE AREA	AAS050133	AAS050134 LEVEL-II
3.	RADIOGRAPHY ON COMPLETE AREA	ASTM-E-446	a. LEVEL-2 AT PORTION "D" b. LEVEL-3 AT PORTION "E" c. RADIOGS. NOT TAKEN UNLESS INDICATED BY VISUAL INSPECTION ARE NOT ACCEPTABLE

18. QUALITY CHECKING OF SUSPENSION TUBE TO BE DONE AS PER TM12545 & QUALITY CHECKING OF SUSPENSION TUBE CASTING TO BE DONE AS PER QTM/QAP/VENDOR/13-14/001 (LATEST REVISION)



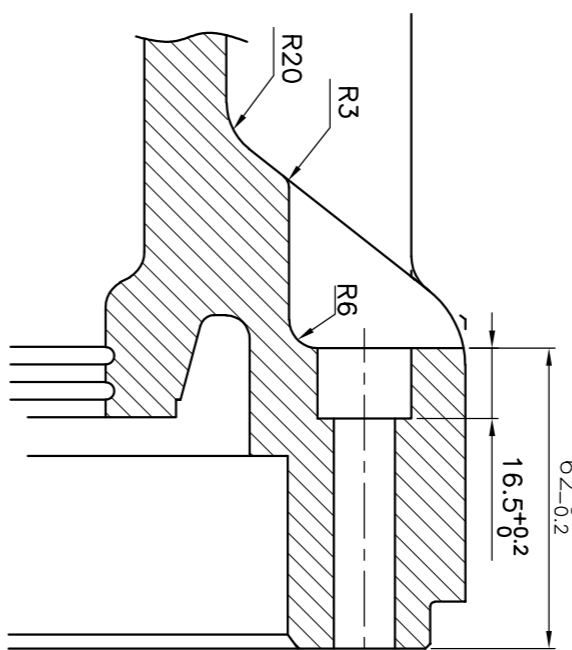
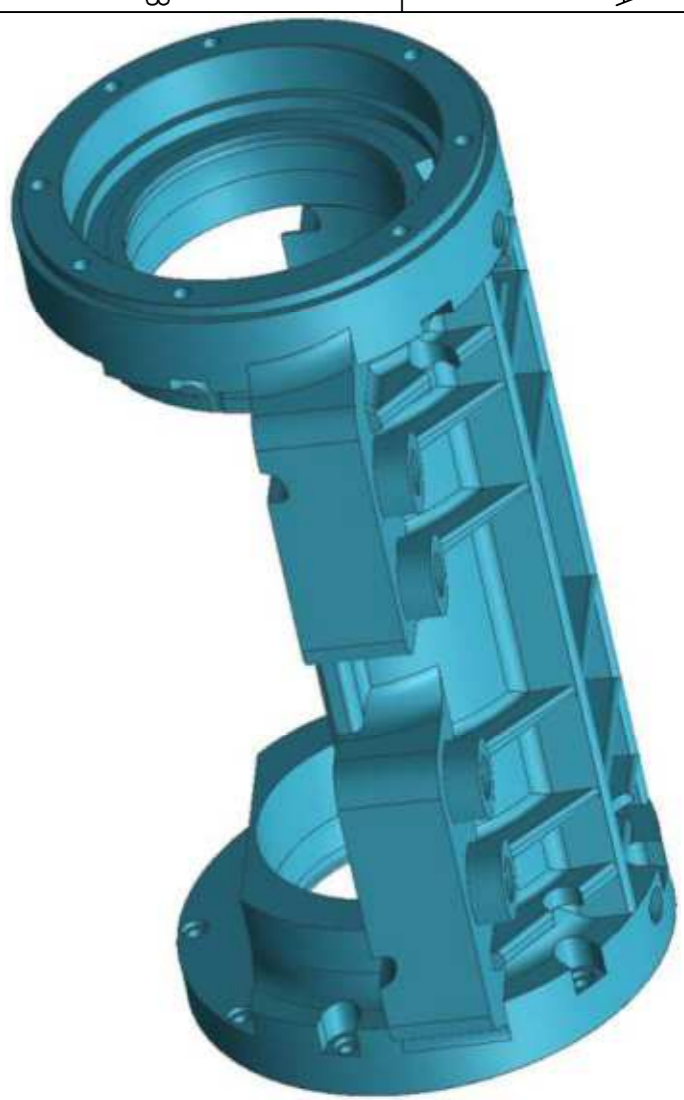
SECTION-BB



VIEW-Z

C

920 16 51 547 1 ON GRD



3D VIEW (FOR REF. ONLY)

SECTION-FF

THE DATUM(Z) FEATURE (FACE) SHALL BE WITHIN THE TOLERANCE OF 0.1 FROM DATUM U.

1 HOLE DRILL THROUGH .06 DRILL & TAP 1/4" BSPX25 DEEP FULL THREAD AND SPIGOT .028 SUFFICIENT TO CLEANUP

2 HOLES DRILL THROUGH

TAP M12

1 HOLE DRILL THROUGH .06 DRILL & TAP 1/4" BSPX25 DEEP FULL THREAD AND SPIGOT .028 SUFFICIENT TO CLEANUP

4 HOLES DRILL THROUGH & TAP M30

SEE NOTE-13

8 HOLES Ø33 THROUGH

1 HOLE DRILL THROUGH .06 DRILL & TAP 1/4" BSPX25 DEEP FULL THREAD AND SPIGOT .028 SUFFICIENT TO CLEANUP

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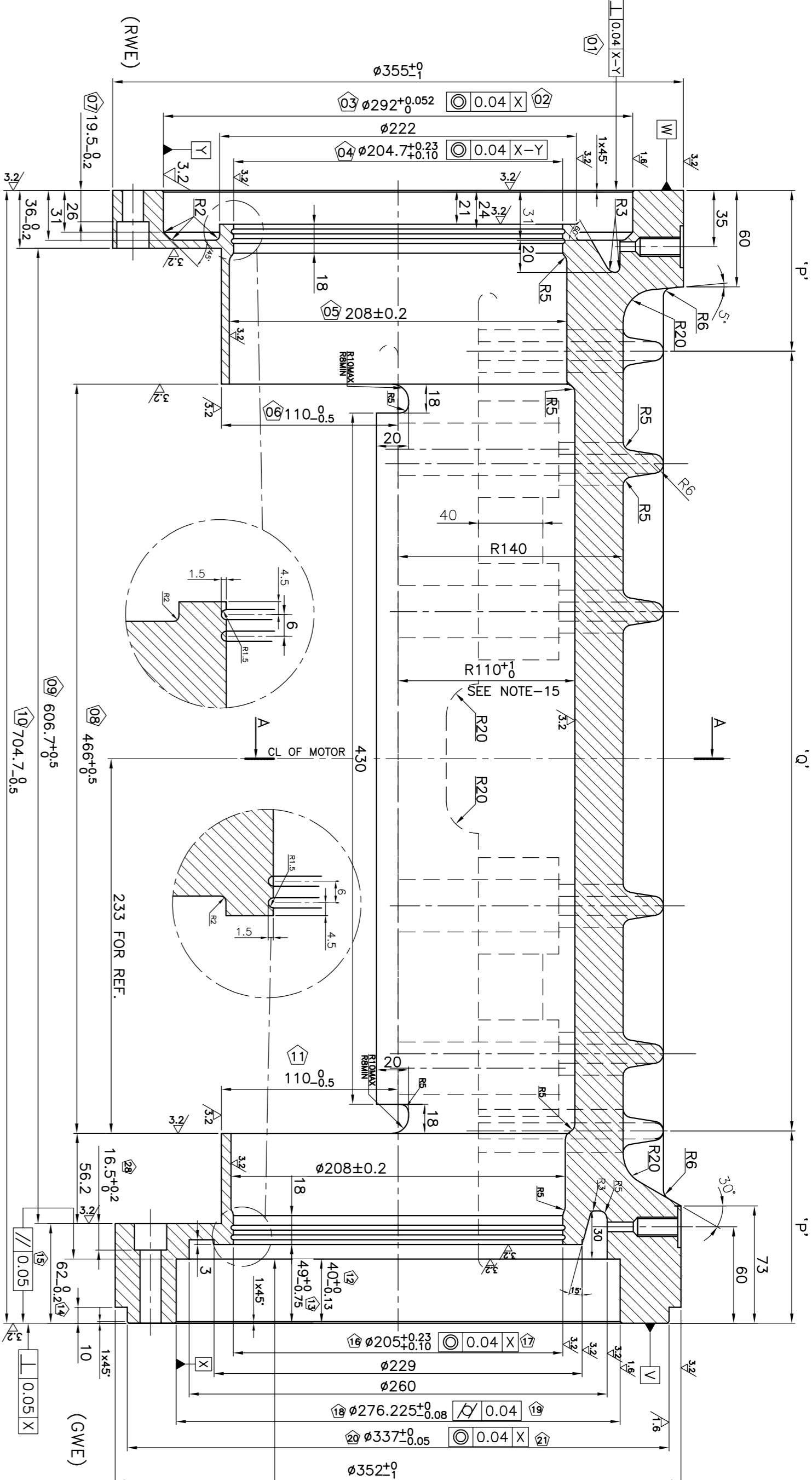
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SECTION-CC

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ITEM	TOOL NO.	DESCRIPTION
1514722	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514724	SP. SANDING CUTTER FOR BORE D. GRINDING	
1514725	U. DRILL FOR Ø13 AT C&E & F&E	
1514726	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514727	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514728	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514729	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514730	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514731	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514732	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514733	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514734	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514735	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514736	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514737	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514738	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514739	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514740	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514741	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514742	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514743	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514744	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514745	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514746	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514747	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514748	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514749	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514750	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514751	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514752	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514753	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514754	FOR BORE GRINDING TOOL, HOLDING WITH BT	
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1514756	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514757	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514758	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514759	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514760	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514761	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514762	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514763	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514764	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514765	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514766	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514767	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514768	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514769	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514770	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514771	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514772	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514773	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514774	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514775	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514776	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514777	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514778	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514779	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514780	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514781	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514782	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514783	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514784	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514785	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514786	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514787	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514788	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514789	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514790	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514791	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514792	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514793	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514794	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514795	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514796	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514797	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514798	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514799	FOR BORE GRINDING TOOL, HOLDING WITH BT	
1514800	FOR BORE GRINDING TOOL, HOLDING WITH BT	

NOTES:-

- CASTING:-
1. CASTING FOR SUSPENSION TUBE SHALL BE FROM LATEST ROSO APPROVED CLASS 'A' FOUNDRY.
 2. TOLERANCES ON CAST UNMACHINED DIMENSION TO BE TO IS 4897 CLASS-2.
 3. MACHINING ALLOWANCES TO BE MAINTAINED 5-7MM PER TOOL POINT IN CASE CASTING IS SUPPLIED & 3-5MM PER TOOL POINT IN CASE ROUGH MACHINED CASTING IS SUPPLIED AS PER BHEL PO.
 4. CASTING TO BE SAND/SHOT BLASTED.
 5. CASTING TO BE STRESS RELIEVED.
 6. IDENTIFICATION MARKING OF SUSPENSION TUBE CASTING TO BE DONE AS PER TM12548 AT THE LOCATION SHOWN.

MACHINING:-

8. LIMITS ON MACHINED DIMENSIONS ±0.25 UNLESS OTHERWISE STATED.
9. LIMITS ON UNTOLERANCED ANGLES ±0°-30°.
10. REMOVE ALL SHARP CORNERS.
11. SUSPENSION TUBE TO BE LIGHT GREY PAINTED WITH POLYURETHANE FINISHING PAINT TO AA6142 AS PER PROCESS SPECIFICATION TM4217 INSIDE BHEL.
12. ALL 28 NOS. "C" MARKED DIMENSIONS ARE CRITICAL TO QUALITY(CIT) & S.L.NO. OF C/D DIMENSIONS ARE INSERBED IN C/D. 28.
13. IDENTIFICATION MARKING OF SUSPENSION TUBE MACHINING TO BE DONE AS PER TM12548 PER BHEL PO.
14. TEMPORARY RUST PREVENTIVE (TRP) TO BE APPLIED ON MACHINED SURFACES AS PER AA61512.
15. EXCESSIVE MATERIAL IN THE INSIDE DIAMETER OF SUSPENSION TUBE LESS THAN DIMENSIONS R110±1 IF OBTAINED IN THE CASTING IS TO BE REMOVED BY MACHINING THE INSIDE DIAMETER TO DRAWING DIMENSIONS R110±1.
16. SUSPENSION TUBE TO BE PRIMER PAINTED ON UNMACHINED SURFACES WITH INORGANIC ETHYL ZINC SPRAY PRIMER (AA61113) AS PER SPEC. NO. 8 OF TABLE -II (G) OF SPEC. INSPECTION:-
17. NOT TESTING REQUIREMENT OF SUSPENSION TUBE IS AS PER THE FOLLOWING TABLE:

S.L.NO.	TEST	SPECIFICATION	ACCEPTANCE CRITERIA
1.	ULTRASONIC TESTING ON ALL POSSIBLE AREA	AA0850104	AA0850104 LEVEL-II
2.	MPI TESTING ON COMPLETE AREA	AA0850133	AA0850134 LEVEL-II
3.	RADIOGRAPHY ON COMPLETE AREA	ASTM-E 446	A LEVEL-2 AT PORTION "P" B LEVEL-3 AT PORTION "Q" CHARPERS, CHILLS AND INSERTS ARE NOT ACCEPTABLE.

18. QUALITY CHECKING OF SUSPENSION TUBE TO BE DONE AS PER TM12545 & QUALITY CHECKING OF SUSPENSION TUBE CASTING TO BE DONE AS PER QTM/QAP/VENDOR/13-14/001 (LATEST REVISION).

001	RAW WT.185 KG	001	TUBE	AA19511	165.0
59	QTY	64	VAR. 00	REMARKS	
75	76	77	78	79	80
81	82	83	84	85	86
87	88	89	90	91	92
93	94	95	96	97	98
99	100	101	102	103	104
105	106	107	108	109	110
111	112	113	114	115	116
117	118	119	120	121	122
123	124	125	126	127	128
129	130	131	132	133	134
135	136	137	138	139	140
141	142	143	144	145	146
147	148	149	150	151	152
153	154	155	156	157	158
159	160	161	162	163	164
165	166	167	168	169	170
171	172	173	174	175	176
177	178	179	180	181	182
183	184	185	186	187	188
189	190	191	192	193	194
195	196	197	198	199	200

ADDITIONAL INFORMATION

STATUS OF DRAWING
DISTRIBUTION OF PRINTS
TWE-1, TWX-3, TWX-11.

NAME OF PRODUCT
OR
NAME OF CUSTOMER/PROJECT

IM45044Z



9 60 16 51 544 2 ON GRD

2

3

4

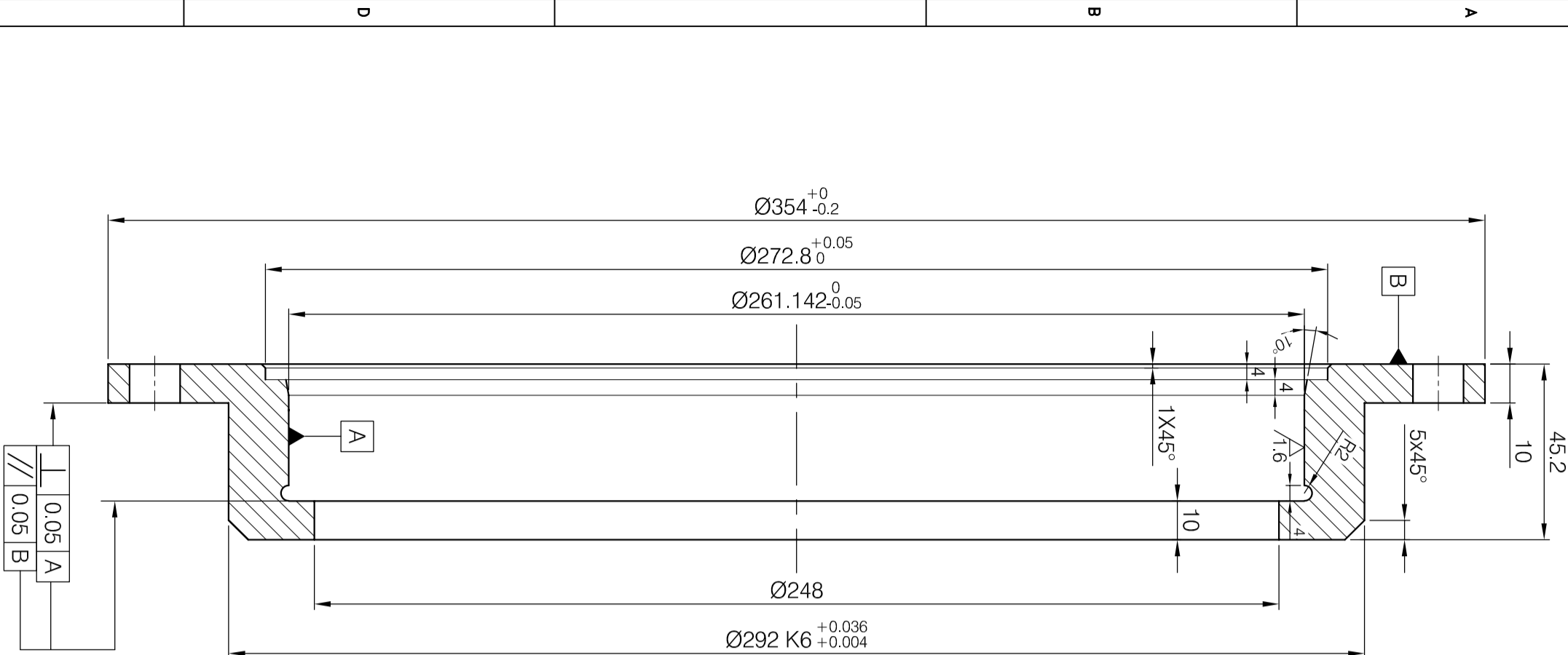
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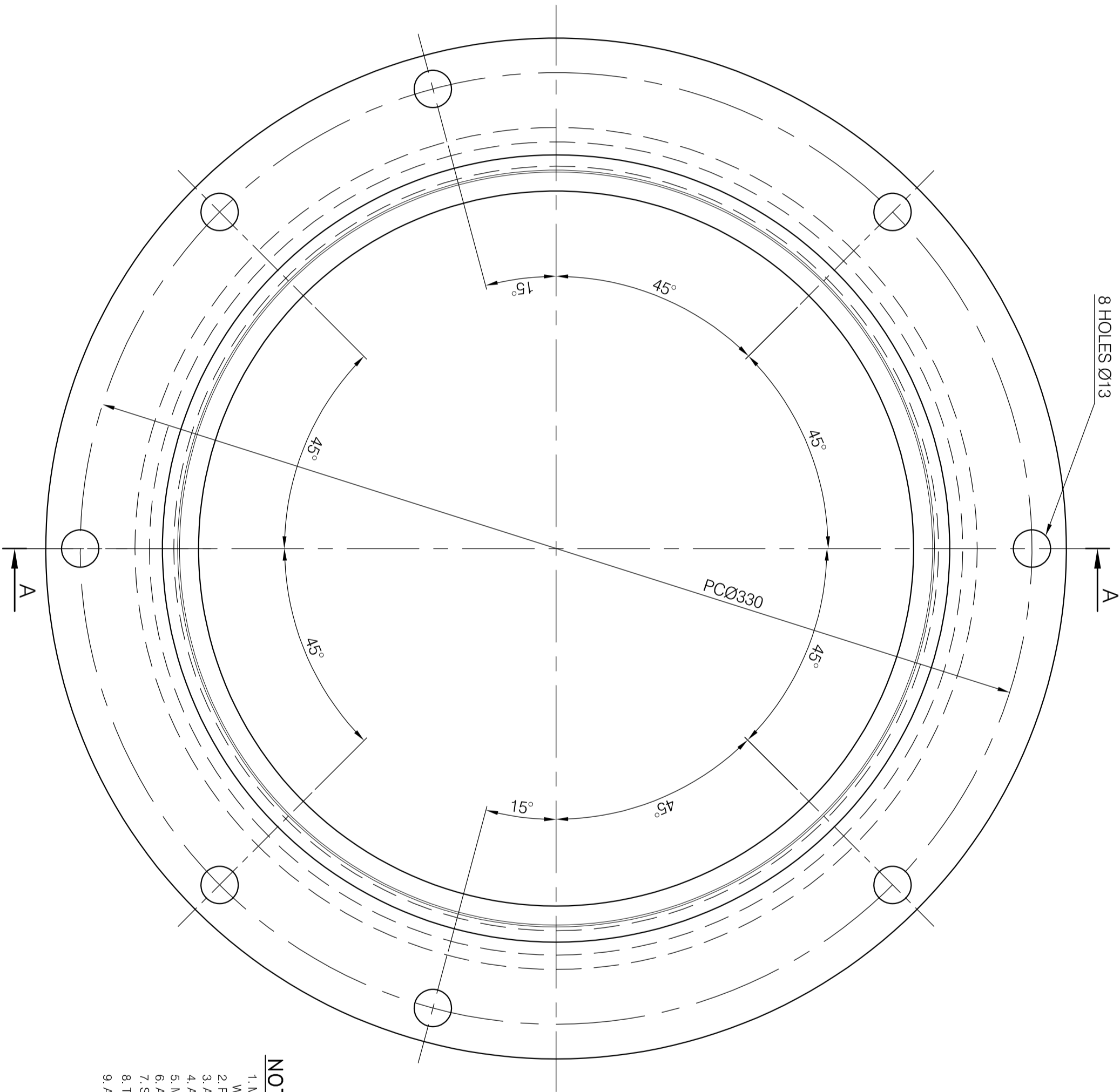
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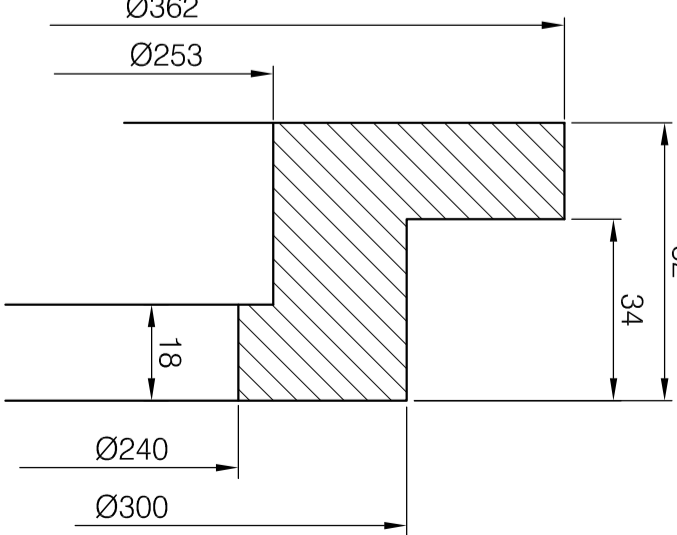
TOOL LIST		
IT.NO.	TOOL NO.	DESCRIPTION
001	1607650	DRILL JIG FOR 8 X Ø13 @ PCD 330
001	1607630	ID GROOVING TOOL, FULL ROUND R2, AP = 4MM AR=2MM INDEXABLE
001	1408585	PIN GAUGE 261, 142-0.05/0
001	1408586	SNAP GAUGE 292 +0.004/+0.036
001	1408587	OFFSET PIN GAUGE 273, 1+0.05/0
001	1408588	PIN GAUGE 280, 7/260.8



SECTION-AA



VIEW FOR ROUGH MACHINED FORGING



NOTES:-

1. MATERIAL OF ITEM-001 TO BE AA19333 EXCEPT FOR THE MECHANICAL PROPERTIES WITH SHALL CONFORM TO IS-2004 CLASS 4 TABLE-2
2. REMOVE ALL SHARP CORNERS.
3. ALL UNTOLERATED DIMENSIONS TO BE ±0.25
4. ALL UNTOLERATED ANGLES TO BE ±0°-30°
5. MACHINE ALL OVER \sqrt{v} EXCEPT WHEREVER SHOWN.
6. ALL CORNERS RADIUS SHALL BE 0.5 ϕ TO AVOID SHARNESS EXCEPT WHEREVER STATED.
7. SAMPLE Ø25X600 LONG AS PER 11.2 OF AA19333 TO BE SUPPLIED FOR TESTING OF ITEM 001.
8. TEMPORARY RUST PREVENTIVE (TRP) TO BE APPLIED ALL OVER AS PER AA55152.
9. ALTERNATIVE MATERIAL TO BE USED FOR IT, 001 IS AA10108 (SIZE 561TK, X Ø362).

001	001	BEARING HOUSING	58	59	60	77	29	31	34	45	55	58	65	72
QTY	REMARKS	VAR.	ITEM	NO.	DESCRIPTION	IT NO.	VAR.	MATL. CODE	A	57	58	UNIT	WT.	65
VAR 00														

ADDITIONAL INFORMATION REF. DRG. NO:-14391553006		TYPE OF PRODUCT OR		NAME OF CUSTOMER/PROJECT	
STATUS OF DRAWING		IM4504AZ			

DISTRIBUTION OF PRINTS
TIME-1, TMM-3,
TNX-1



BHARAT HEAVY ELECTRICALS LTD
BHOPAL

NAME	SIGN	DATE	NO. OF VAR.
DRN. A.JHARIA		12.12.19	
CHD. MOHIT P.		12.12.19	
APPD. MOHIT P.		12.12.19	01

REV.	DATE	ALTERED	REV.	DATE	ALTERED
03	16.12.20	CHECKED BY: [Signature] APPROVED BY: [Signature]	02	26.11.20	CHECKED BY: [Signature] APPROVED BY: [Signature]
ZONE	DIM. Ø272.8 $0^{+0.05}_{-0}$ WAS Ø273.1 $0^{+0.05}_{-0}$.	ZONE	IN TOOL LIST, TOOL NOS. 1408585 TO 1408588 ADDED. (TCM-356)		

REV.	DATE	ALTERED	ZONE
01	29.05.20	CHECKED BY: [Signature] APPROVED BY: [Signature]	TOOL LIST ADDED. (TCM356)

DEPT.	TIME	UNTO.	DIMS.	GR.
405	AA0230208	1M		
SCALE	WEIGHT (K.G.)			
N.T.S.	7.40			

DRAWING NO.	REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEM	REV.
2 445 15 91 076 03	1 445 15 91 076	002	001	03
SHT. NO.	01	NO. OF SHT.	01	

620 16 51 544 2 0N 3RD

2

3

4

5

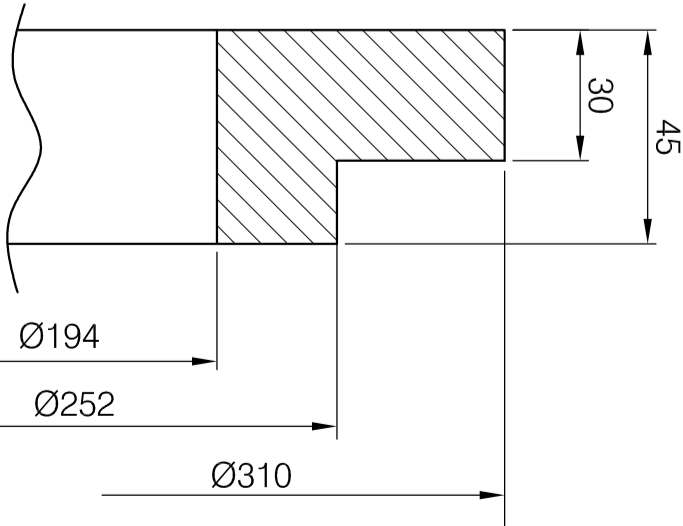
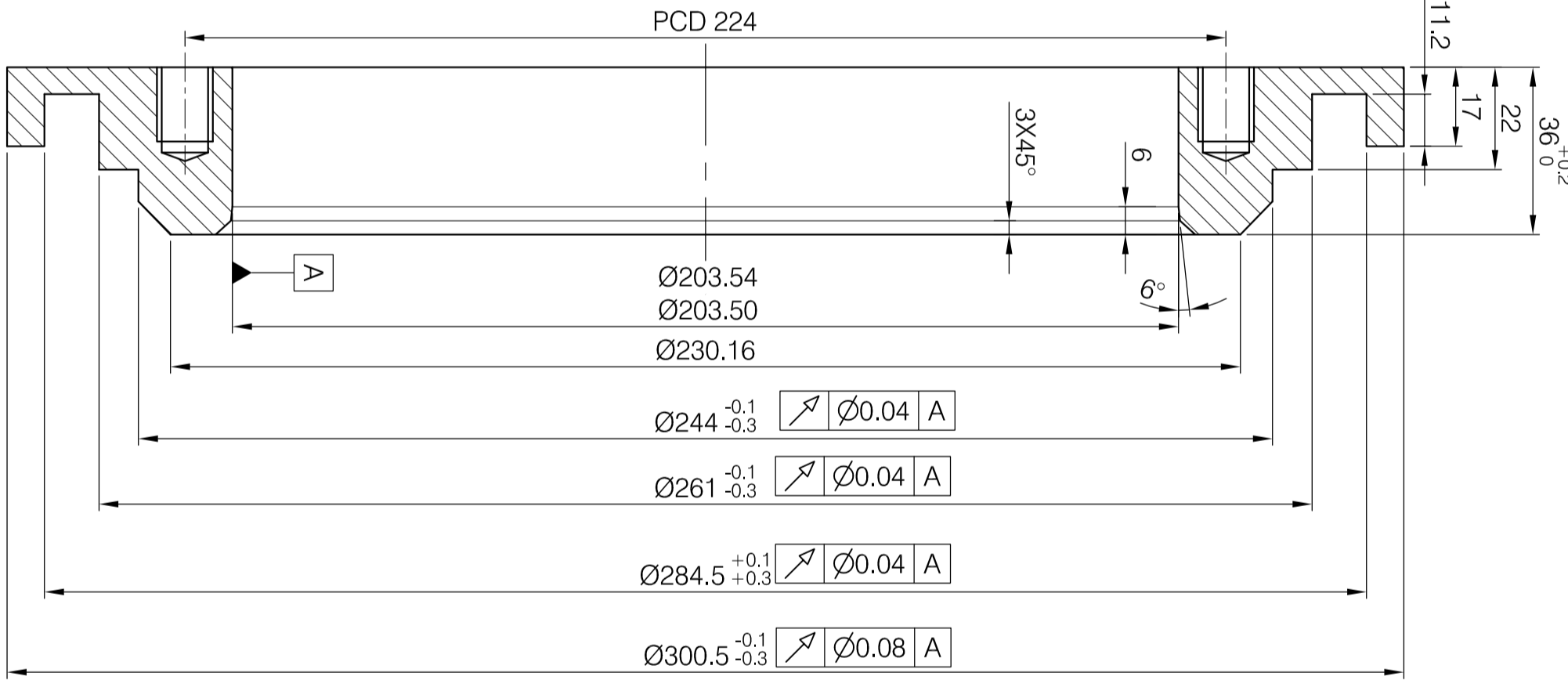
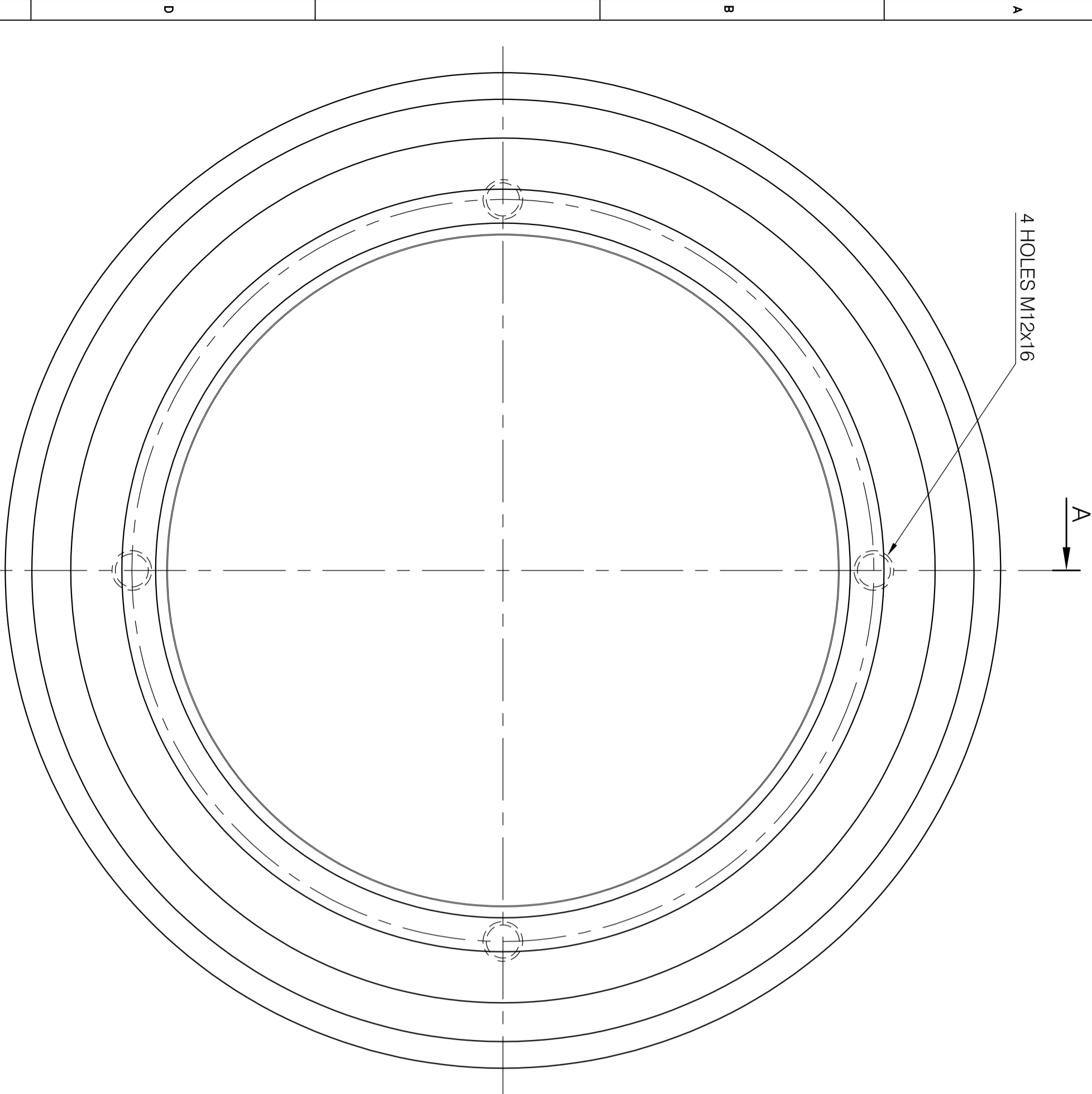
6

7

8

TOOL LIST

IT.NO.	TOOL NO.	DESCRIPTION
001	1607654	DRILL JIG FOR 4 X M12 @ PCD 224
001	1607636	PIN GAUGE 284.6284.8
001	1607637	FACE GROOVING TOOL INDEXABLE FIG- 1 & 2 OF SK-745 AP = 8-10 AR ≥ 12
001	1607638	GROOVE GAUGE 11.5 X 16.2
001	1607639	PIN GAUGE 203.50/203.54
001	1607640	CALPER GAUGE 261.1/261.3
001	1408570	SNAP GAUGE 305 -0.1/-0.3
001	1408573	SNAP GAUGE 244 -0.1/-0.3



NOTES:-

1. MATERIAL OF ITEM-001 TO BE AA19333 EXCEPT FOR THE MECHANICAL PROPERTIES WITH SHALL CONFORM TO IS:2004 CLASS 4 TABLE-2
2. REMOVE ALL SHARP CORNERS.
3. ALL UNTOLERATED DIMENSIONS TO BE ±0.25
4. ALL UNTOLERATED ANGLES TO BE ±0°-30°
5. MACHINE ALL OVER $\frac{3}{32}$ EXCEPT WHEREVER SHOWN.
6. ALL CORNERS RADII SHALL BE 0.5 $\frac{16}{3}$ TO AVOID SHARPNESS EXCEPT WHEREVER STATED.
7. SAMPLE 025X600 LONG AS PER 11.2 OF AA19333 TO BE SUPPLIED FOR TESTING OF ITEM 001.
8. TEMPORARY RUST PREVENTIVE (TRP) TO BE APPLIED ALL OVER AS PER AA56152.

001	001	ABUTMENT PIECE	58	59	60	77	29	31	34	45	55	58	65	72
QTY	REMARKS	VAR.	ITEM	NO.	DESCRIPTION	IT.NO.	MATL. CODE	A	57	58	68	71	75	72
VAR 00														

ADDITIONAL INFORMATION		TYPE OF PRODUCT		NAME OF CUSTOMER/PROJECT		IM4504AZ	
REF. DRG. NO.-14391553010		OR					
STATUS OF DRAWING							

DISTRIBUTION OF PRINTS		NAME OF CUSTOMER/PROJECT		BHARAT HEAVY ELECTRICALS LTD		BHO PAL	
TIME-1, TMM-3		TIME-1					
TMX-1							



DRN	AJHARIA	SGN	DATE	NO. OF VAR.
CHD.	MOHIT P.	MOHIT P.	12.12.19	
APPD.	MOHIT P.	MOHIT P.	12.12.19	01

REV.	DATE	ALTERED	ASAP	REV.	DATE	ALTERED	ASAP
04	15.12.21	CHECKED	ASAP	03	22.11.21	CHECKED	ASAP
ZONE	IN TOOL LIST, DESCRIPTION OF TOOL NO. 1607639 MODIFIED. (TCM-359)	APPROVED	ASAP	ZONE	DIM. 0203.50/ 0203.54 WAS 0203.54/ 0203.58. NOTE-9 DELETED.	APPROVED	ASAP

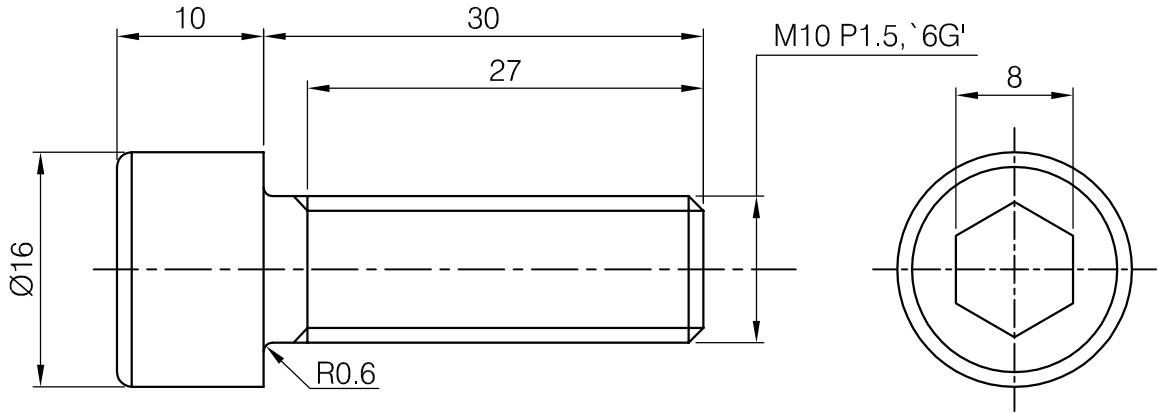
SECTION-AA

FOR ROUGH M/C FORGING

BHARAT HEAVY ELECTRICALS LIMITED.


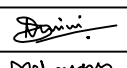
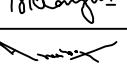
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REV.	DATE	ALTERED	REV.	DATE	ALTERED A.J.	ADDITIONAL INFORMATION
		CHECKED	01	31.10.19	CHECKED A.S.	
		APPROVED			APPROVED A.S.	
			1 HOLE DIA. 2.5 DELETED. IN REMARKS COLUMN OF BOM IT.001, 'UNBREAKO BOUGHTOUT' DELETED.			STATUS OF DRAWING
						DISTRIBUTION OF PRINTS
						TME-1 TNX-1 TXM -4



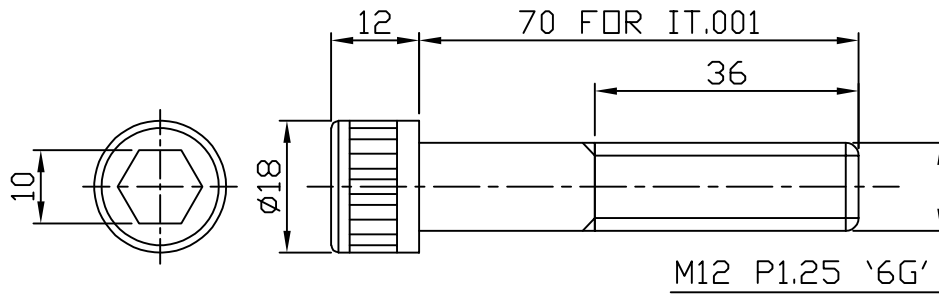
NOTES:-

1. IT. 002 TO BE APPLIED ON THREAD BEFORE TIGHTENING TO SCRU.
2. SCRU TO BE 100% M.C.D. TESTED OF BP0850178 .

REF. DRG. NO.	AS REQD,	002	LOCKTITE-270			KG	0.004
	SEE NOTE-1	001	SOCKET HEAD CAP SCRU M10x30, P12.9			KG	0.03
	REMARKS	ITEM NO.	DESCRIPTION	STD	MATL. CODE	A/C	UNIT WT.
					MATL. SPECN.		QTY.
SIGN. & DATE	CARD TYPE 3 → 28		28 → CARD TYPE 1		28 → CARD TYPE 2		
				DRN.	NAME	SIGN	DATE
				CKD.	A.JHARIA		04.05.11
				APPD.	D.K.		05.05.11
INVENTORY NO.	DEPT.	GRADE OF UN.TOL.	SCALE	WEIGHT(KG)	REF.TO ASSY.DRG.	ITEM NO.	NO.OF ITEM
	TME		N.T.S.	0.034	04451503001	010	002
	CODE						
	405						
TITLE					DRAWING NO.		REV
SOCKET HEAD CAP SCRU (IM3601AZ)					44451503005		01
					SHT.NO	NO.OF.SHT.	
					01	01	


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REV.	DATE	ALTERED	REV.	DATE	ALTERED	ADDITIONAL INFORMATION
		CHECKED			CHECKED	
		APPROVED			APPROVED	
						STATUS OF DRAWING
						DISTRIBUTION TME-1 TNX-1 OF PRINTS TXM-4



NOTES:-

1. IT. 002 TO BE APPLIED ON THREAD BEFORE TIGHTENING SCRU.
2. SCRU TO BE 100% M.C.D. TESTED TO BP0850178.

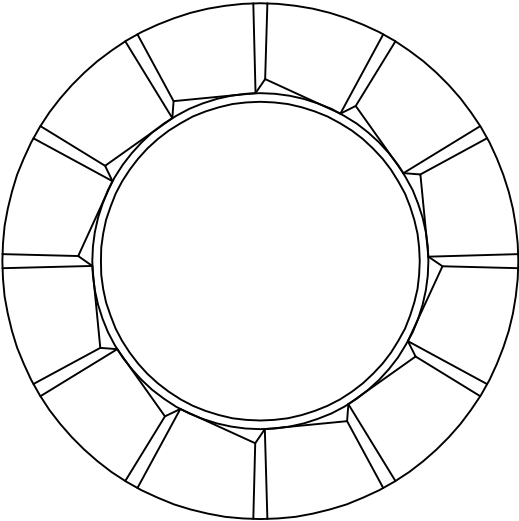
REF. DRG. NO.	AS REQD,	002	LOCKTITE-270		KG	0.004			
	SEE NOTE-1 UNBREAKD BOUGHTOUT	001	SOCKET HEAD CAP SCRU M12x70, P12.9		KG	0.08			
	REMARKS	ITEM NO.	DESCRIPTION	STD	MATL. CODE A/C MATL. SPECN.	UNIT QTY.			
SIGN. & DATE	CARD TYPE 3 → 28		28 → CARD TYPE 1	28	CARD TYPE 2				
	 BHARAT HEAVY ELECTRICALS LTD. BHOPAL			DRN.	SDB	SIGN	@Bharat	DATE	26.03.18
INVENTORY NO.	DEPT. TME CODE 405	GRADE OF UN.TOL.	SCALE N.T.S.	WEIGHT(KG) 0.084	REF.TO ASSY.DRG. 04451509051	ITEM NO. 011	NO.OF ITEM 02		
	TITLE SOCKET HEAD CAP SCRU (IM3302AZ)					DRAWING NO. 44451509051		REV 00	
					SHT.NO 01	NO.OF.SHT. 01			

FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm.

10009516242 – ON DRG

CAM ON MATING
SURFACE



SEIZING RIDGES ON
OUTER SURFACE

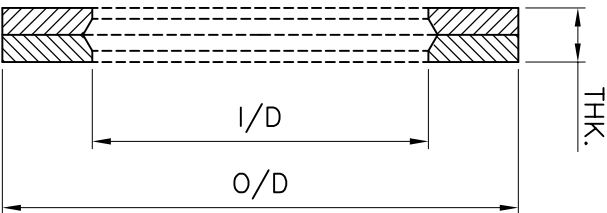
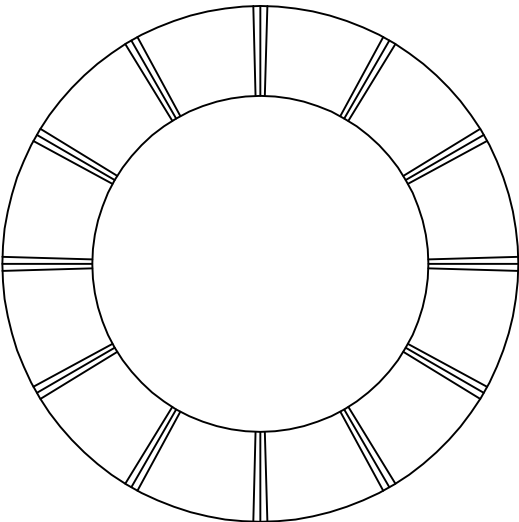


TABLE-1 (ALL DIMENSIONS ARE IN MM)

SL. NO.	SIZE	I/D	O/D	THK.	REF. ASSY. DRG. NO.	ITEM NO.
1	M12	A. 13.00±0.2	A. 19.60±0.2	A. 2.50±0.25	04391531106	014
		B. 12.95±0.2	B. 19.60±0.2	B. 4.22±0.25	04391413001 04391527001 04304581001	014 015
2	M12	A. 13.00±0.2	A. 19.60±0.2	A. 2.50±0.25	04391580002	014 & 037
		B. 12.95±0.2	B. 19.60±0.2	B. 2.50±0.25	04451509051	016
3	M30	A. 31.50±0.2	A. 47.00±0.3	A. 6.60-0.5	04393180001	011
		B. 32.39±0.2	B. 47.63±0.3	B. 6.73-0.5	04393131106 44453109001	017 002
4	M36	A. 37.30±0.2	A. 55.10±0.3	A. 6.60-0.5	04393113002	016
		B. 36.32±0.2	B. 55.78±0.3	B. 5.84-0.5	04393127007	016
5	M16	A. 17.00±0.2	A. 30.70±0.2	A. 3.30±0.25	04394001001	010
		B. 16.53±0.2	B. 31.67±0.2	B. 4.79±0.25		
6	M24	A. 25.40±0.2	A. 39.10±0.2	A. 3.30±0.25	04394001001	010
		B. 25.78±0.2	B. 41.30±0.2	B. 6.50±0.25		
7	M10	A. 10.55±0.2	A. 16.5±0.2	A. 2.5±0.25	04451509051	015

NOTES:

- SUPPLIER CAN OFFER THE WASHER AS PER EITHER 'A' OR 'B' AGAINST EACH SERIAL NO. AS MENTIONED IN TABLE 1
- MATERIAL OF SERRATED LOCK WASHER SHALL BE CONFORMING TO EITHER OF THE FOLLOWING:
 - AISI 1010: CARBON STEELS
 - EN 1.7182
 - 50Cr V4 TO DIN17222
- SURFACE COATING-DELTA PROTEKT ® BASE COAT (KL100) AND TOP COAT (VH302GZ)
- ONE SERRATED LOCK WASHER COMPRISE OF TWO PARTS ONE UPPER HALF AND ONE LOWER HALF. BOTH HALVES OF WASHER SHALL BE GLUED TOGETHER.
- PROCUREMENT OF M12 DISC LOCK WASHER FOR TM4303, IM3302 SHALL BE AS PER SL NO. 02 OF TABLE-1.

59	64	65	75	78	79	25	27	29	58	59	60	77	29	31	34	45	55	56	57	58	65	72
VAR 00	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	DRAWING NO.	IT.NO.	MATL. CODE	MATL. SPCN.	VAR.	MATL.	SPCN.	QTY.	UNIT	WT.	NO.	OF	ITEM	NO.	OF	ITEM	NO.	OF
59	64	65	75	78	79	25	27	29	58	59	60	77	29	31	34	45	55	56	57	58	65	72
VAR 00	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	DRAWING NO.	IT.NO.	MATL. CODE	MATL. SPCN.	VAR.	MATL.	SPCN.	QTY.	UNIT	WT.	NO.	OF	ITEM	NO.	OF	ITEM	NO.	OF

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INVENTORY NO.	SIGN. & DATE	REF. DRG. NO.
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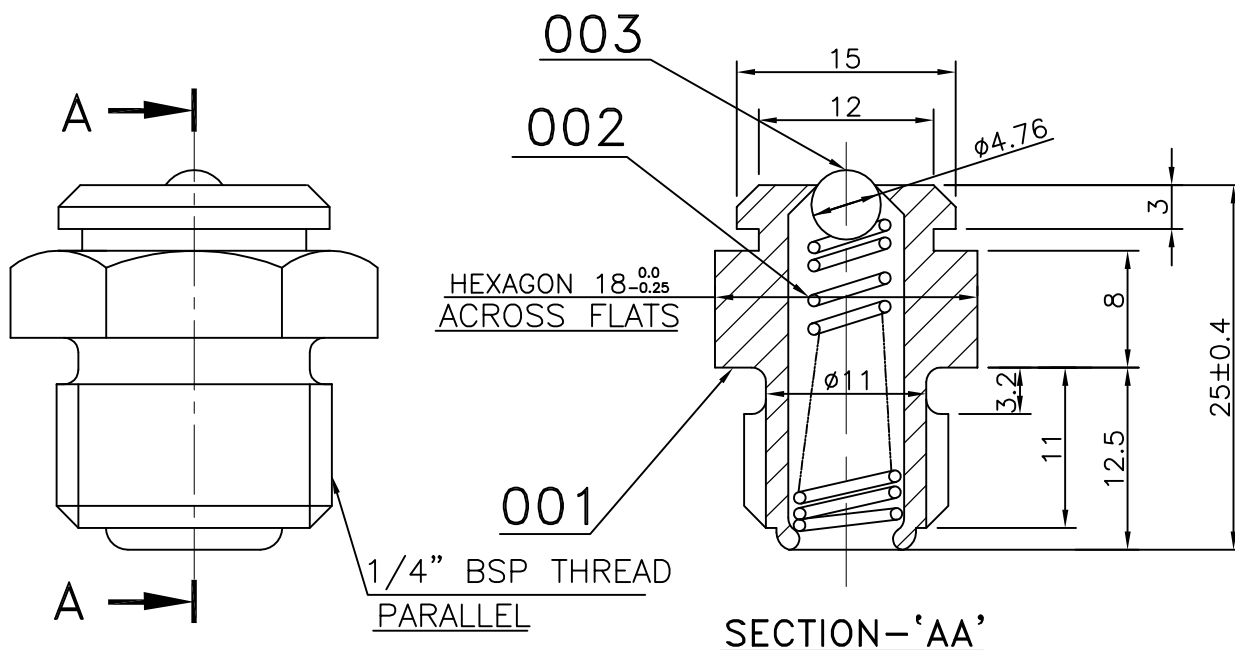
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04 17.10.19										IN TABLE-1, SL. NO. 2 & 3, REF. ASSY. DRG. NO. 04451509051 & 44453109001 ADDED. NOTE-5 MODIFIED. IN TABLE-1, SL. NO. 7 ADDED.										STATUS OF DRAWING										DISTRIBUTION OF PRINTS										TME-1, TXM-3, TNX-1																																							
ZONE										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										ZONE										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										ZONE										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										ZONE										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.									
REV. DATE										ALTERED A.JHARIA										CHECKED A.JAIN										APPROVED A.JAIN										REV. DATE										ALTERED A.JHARIA										CHECKED A.JAIN										APPROVED A.JAIN									
03 23.01.15										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										02 12.07.14										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										01 13.07.13										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										00 18.03.13										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.									
ZONE										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										ZONE										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										ZONE										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										ZONE										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.									
REV. DATE										ALTERED A.JHARIA										CHECKED A.JAIN										APPROVED A.JAIN										REV. DATE										ALTERED A.JHARIA										CHECKED A.JAIN										APPROVED A.JAIN									
03 23.01.15										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										02 12.07.14										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										01 13.07.13										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										00 18.03.13										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.									
ZONE										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										ZONE										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										ZONE										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										ZONE										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.									
REV. DATE										ALTERED A.JHARIA										CHECKED A.JAIN										APPROVED A.JAIN										REV. DATE										ALTERED A.JHARIA										CHECKED A.JAIN										APPROVED A.JAIN									
03 23.01.15										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										02 12.07.14										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										01 13.07.13										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										00 18.03.13										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.									
ZONE										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										ZONE										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										ZONE										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										ZONE										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.									
REV. DATE										ALTERED A.JHARIA										CHECKED A.JAIN										APPROVED A.JAIN										REV. DATE										ALTERED A.JHARIA										CHECKED A.JAIN										APPROVED A.JAIN									
03 23.01.15										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										02 12.07.14										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										01 13.07.13										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										00 18.03.13										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.									
ZONE										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										ZONE										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										ZONE										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										ZONE										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.									
REV. DATE										ALTERED A.JHARIA										CHECKED A.JAIN										APPROVED A.JAIN										REV. DATE										ALTERED A.JHARIA										CHECKED A.JAIN										APPROVED A.JAIN									
03 23.01.15										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										02 12.07.14										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										01 13.07.13										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.										00 18.03.13										IN TABLE-1, SL. NO. 1, REF. ASSY. DRG. NO. 04304581001 ADDED. NOTE-5 ADDED.									
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(ALL DIMENSIONS ARE IN mm)

THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED.
IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY
WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

REV.	DATE	ALTERED	REV.	DATE	ALTERED	ADDITIONAL INFORMATION
		CHECKED			CHECKED	
		APPROVED			APPROVED	
ZONE			ZONE			STATUS OF DRAWING
						DISTRIBUTION TME-1, TXM-3, TNX-1 OF PRINTS

**NOTE:-**

- GREASE NIPPLE TO BE ZINC PLATED TO AA0673603 AND AA0673604.

001		003	BALL					KG.	0.01
001		002	VALVE SPRING					KG.	0.01
001		001	GREASE NIPPLE BODY					KG.	0.02
VAR00	REMARKS	ITEM NO.	DESCRIPTION	DRAWING NO.	IT.NO.	MATL. CODE	A/C	UNIT	UNIT WT.
					VAR.	MATL. SPCN.			QTY.
28 → CARD TYPE-3			28 → CARD TYPE-1			28 → CARD TYPE-2			



BHARAT HEAVY ELECTRICALS LTD.
BHOPAL

	NAME	SIGN	DATE	NO. OF VAR.
DRN.	A.JHARIA	<i>A.Jharia</i>	22.07.11	
CHD.	D.K.	<i>D.K.</i>	22.07.11	
APPD.	A.S.	<i>A.S.</i>	22.07.11	01

INVENTORY NO.	DEPT. TME CODE	UNTOL. DIMS. GR.	SCALE	WEIGHT (K.G.)	REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEM
	405		N.T.S.	—	04451503001 24454303001	013 016	003
TITLE					DRAWING NO.		REV.
GREASE NIPPLE IM3601AZ					4 445 15 03 007		00
					SHT. NO.	01	NO. OF SHT. 01