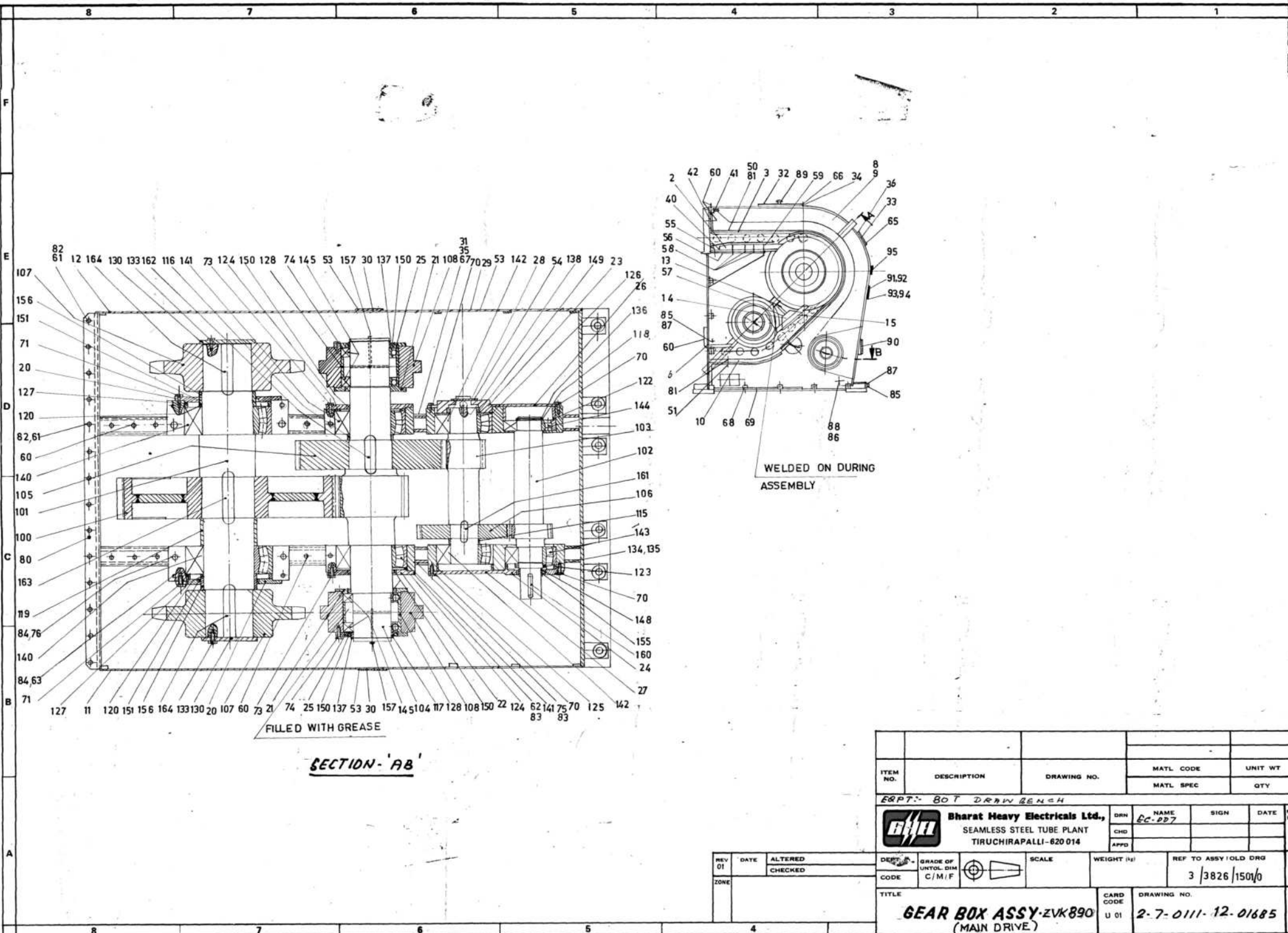


LIST OF BHEL DRAWINGS FOR REFERENCE		
PART NO	DETAILS	REF BHEL DRG NO
PART NO 100	OUTPUT BULL GEAR - 72 T	M&S-PD-22-007
PART NO 101	OUTPUT SHAFT - DIA 350	M&S-PD-22-009
PART NO 103	I ST INTERMEDIATE PINION SHAFT - 16T	M&S-PD-22-006
PART NO 105	II ND INTERMEDIATE BULL GEAR - 63T	M&S-PD-22-008
PART NO 106	I ST INTERMEDIATE BULL GEAR - 45T	M&S-PD-22-005
	ASSEMBLY DRAWING	2-7-0111-12-01685



ITEM NO.	DESCRIPTION	DRAWING NO.	MATL CODE	UNIT WT
			MATL SPEC	QTY

ERR: 80 T DRAW BENCH

	Bharat Heavy Electricals Ltd.,		DRN	NAME	SIGN	DATE
	SEAMLESS STEEL TUBE PLANT		CHD	EC-007		
	TIRUCHIRAPALLI-620 014		APPD			

REV	DATE	ALTERED	DEPT.	GRADE OF	SCALE	WEIGHT (KG)	REF TO ASSY / OLD DRG
01		CHECKED		UNTOOL DIM			
ZONE				C/M/F			

TITLE	CARD CODE	DRAWING NO.
GEAR BOX ASSY-ZVK890 (MAIN DRIVE)	U 01	3 / 3826 / 150/0

PART NO	ORL DRAWING NO	REV	MAKERS DRAWING	SPARE CODE	DESCRIPTION	MATL SPEC	QTY	UNIT	WT	REMARKS
001 023					SP717101399X CIRCLIP 60X2		8		0.000	
005	<u>2-7-0111-12-01685</u>	00	3/3826/1501/0		SP9011165000 GEAR BOX ZW890	MAIN DRIVE CHAIN	1		0.000	G. BOX
005 001	0-7-0111-12-00609	00	0/0108/7017/3		GEAR BOX CASING		1		0.000	
005 002	✓ 1-7-0111-12-01195	00	1/0019/7001/3		SP9011115122 SLIDING PART	HYLAM	2		0.000	
005 002	1-7-0111-12-01195	00	1/0019/7001/3		SP9011165102 SLIDING PART	HYLAM	2		0.000	
005 003	✓ 2-7-0111-12-01695	00	2/0019/7003/0		SP9011115120 VALCOLLUM LINING	POLYURATHANE	2		9.000	
005 003	2-7-0111-12-01695	00	2/0019/7003/0		SP9011165103 VALCOLLUM LINING	POLYURATHANE	2		9.000	
005 006	4-7-0111-12-03451	00	4/0023/7112/0		CHAIN GUIDE		1		0.000	
005 008	✓ 1-7-0111-12-02268	00	1/0023/7104/0		CHAIN GUIDE LH		1		0.000	
005 008 001	✓ 1-7-0111-12-02289	00			BOTTOM GUIDE		1		157.400	
005 008 002	✓ 2-7-0111-12-00713	00			TOP GUIDE		1		76.800	
005 009	✓ 1-7-0111-12-01107	00	1/0023/7105/0		CHAIN GUIDE RH		1		0.000	
005 009 001	✓ 1-7-0111-12-01106	00			BOTTOM GUIDE		1		157.400	
005 009 002	✓ 2-7-0111-12-01696	00			TOP GUIDE		1		76.800	
005 010	✓ 3-7-0111-12-02368	00	3/0023/7117/0		SP9011115121 GUIDE PLATE		2		0.000	
005 011	2-7-0111-12-00938	00	2/0023/7115/0		COVER		1		0.000	
005 012	2-7-0111-12-00937	00	2/0023/7114/0		COVER		1		0.000	

PART NO	DEEL DRAWING NO	REV	INKERS DRAWING	SPARE CODE	DESCRIPTION	NATL SPECN	QTY	UNIT WT	REMARKS
005 013			4/0023/7109/0		PLATE		2	0.000	
005 014	4-7-0111-12-02097	00	4/0023/7111/0		PLATE		2	0.000	
005 015	✓ 3-7-0111-12-02749	00	3/0023/7110/0		WEAR PLATE		2	0.000	
005 020			3/0421/7088/0		SEAL COVER		2	0.000	
005 021			2/0421/7085/0		SEAL COVER		2	0.000	
005 022			2/0421/7087/0		SEAL COVER		2	0.000	
005 023			2/0421/7083/0		SEAL COVER		1	0.000	
005 024			3/0421/7090/0		SEAL COVER		1	0.000	
005 025			3/0421/7084/0		SEAL COVER		2	0.000	
005 026			3/0439/7057/0		COVER		1	0.000	
005 027			3/0439/7060/0		COVER		1	0.000	
005 028			3/0448/7003/0		COVER		1	0.000	
005 029			4/0451/7002/0		COVER		1	0.000	
005 030			4/0451/7003/0		COVER		2	0.000	
005 031			4/0454/7005/0		COVER		2	0.000	
005 032			3/0454/7017/0		SIGHT COVER		1	0.000	
005 033			4/0454/7036/0		END COVER		4	0.000	

PART NO	BNEL DRAWING NO	REV INKERS DRAWING	SPARE CODE	DESCRIPTION	MATL SPECN	QTY	UNIT	WT	REMARKS
005 034		3/0985/0019/0		GASKET		1		0.000	
005 035		4/0985/7015/0		GASKET		2		0.000	
005 036		4/0985/7016/0		GASKET		4		0.000	
005 040		4/0980/7006/0		FITTING PLATE		2		0.000	
005 041		4/0980/7008/0		FITTING PLATE		2		0.000	
005 042		4/0980/7007/0		FITTING PLATE		2		0.000	
005 050				CSK SCREW M10X50	DIN 87	36		0.000	
005 051				CSK SCREW M10X70	DIN 87	16		0.000	
005 053				HEX SKT HD CAP SCREW M5X16	P8.8	IS:2269	14	0.000	
005 054			SP7123123085	HEX SKT HD CAP SCREW M8X20	P8.8	IS:2269	6	0.000	
005 055			SP7123123247	HEX SKT HD CAP SCREW M12X40	P8.8	IS:2269	2	0.000	
005 056			SP7123123565	HEX SKT HD CAP SCREW M12X70	P8.8	IS:2269	4	0.000	
005 057				HEX SKT HD CAP SCREW M16X55	P8.8	IS:2269	8	0.000	
005 058				HEX SKT HD CAP SCREW M12X80	P8.8	IS:2269	16	0.000	
005 059			SP7123123557	HEX SKT HD CAP SCREW M12X60	P8.8	IS:2269	4	0.000	
005 060			SP7111123034	HEX BOLT M20X65	P8.8	IS:1364	48	0.000	
005 061				HEX BOLT M20X110	P8.8	IS:1364	14	0.000	

PART NO	BHEL DRAWING NO	REV MAKERS DRAWING	SPARE CODE	DESCRIPTION	MATL SPECN	QTY	UNIT	WT	REMARKS
005 062				HEX BOLT M24X380	P8.8	IS:1364	4	0.000	
005 063				HEX BOLT M30X400	P8.8	IS:1364	4	0.000	
005 065			SP7121123215	HEX SCREW M10X20	P8.8	IS:1364	24	0.000	
005 066			SP7121123495	HEX SCREW M16X30	P8.8	IS:1364	14	0.000	
005 067			SP7121123509	HEX SCREW M16X35	P8.8	IS:1364	8	0.000	
005 068				HEX SCREW M20X25	P8.8	IS:1364	33	0.000	
005 069			SP7121124025	HEX SCREW M20X35	P8.8	IS:1364	10	0.000	
005 070			SP7121124041	HEX SCREW M20X45	P8.8	IS:1364	26	0.000	
005 072				HEX SCREW M20X55	P8.8	IS:1364	6	0.000	
005 073			SP7121124033	HEX SCREW M20X40	P8.8	IS:1364	16	0.000	
005 074			SP7121124076	HEX SCREW M20X50	P8.8	IS:1364	32	0.000	
005 075				STUD B M24X220	P8.8	IS:1862	4	0.000	
005 076				STUD B M30X220	P8.8	IS:1862	4	0.000	
005 080				TAPERED PIN 12X90		DIN 1	2	0.000	
005 081			SP7151115032	HEX NUT M10	P8.8	IS:1364	24	0.000	
005 082			SP7151115202	HEX NUT M20	P8.8	IS:1364	14	0.000	
005 083			SP7151115245	HEX NUT M24	P8.8	IS:1364	8	0.000	

PART NO	BHEL DRAWING NO	REV MAKERS DRAWING	SPARE CODE	DESCRIPTION	MATL SPECN	QTY	UNIT WT	REMARKS
005 084			SP7151115300	HEX NUT M30	P8.8	IS:1364	8	0.000
005 085				SCREEN PLUG 2" BSP			3	0.000
005 086				SCREEN PLUG 1/2" BSP			2	0.000
005 087				SEALING RING A60X68	DIN 7603		3	0.000
005 088				SEALING RING A48X55	DIN 7603		2	0.000
005 089				AIR VENT 1" A48X55			1	0.000
005 090				OIL GUNGE			1	0.000
005 091				RETAINING PLATE			1	0.000
005 092				NAME PLATE			1	0.000
005 093				NOTCHED TAPER PIN 3X8	DIN 1476		4	0.000
005 094				CSK OVAL HD SCREW A48X10	DIN 91		4	0.000
005 095				SAFETY STOPPER 3/4" BSP			1	0.000
005 100		1/0311/7009/0		SPUR GEAR			1	0.000
005 101		2/0230/7093/0		OUTPUT SHAFT			1	0.000
005 102		2/0253/7121/0		INPUT SHAFT			1	0.000
005 103		2/0253/7120/0		PINION SHAFT			1	0.000
005 104		2/0253/7122/0		PINION SHAFT			1	0.000

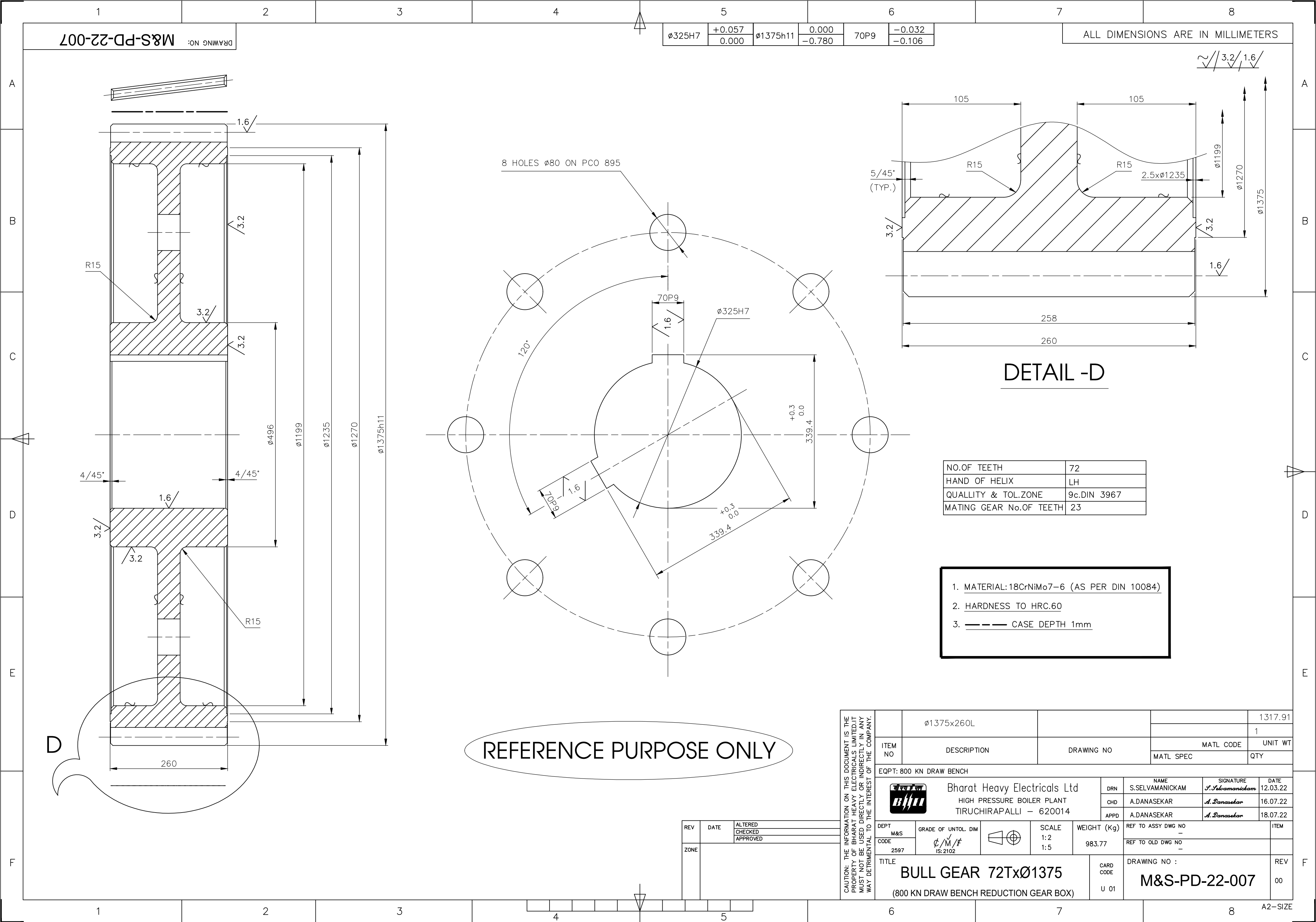
PART NO	BHEL DRAWING NO	REV MAKERS DRAWING	SPARE CODE	DESCRIPTION	MATL SPECN	QTY	UNIT WT	REMARKS
005 105		2/0302/7164/0		SPUR GEAR		1	0.000	
005 106		2/0302/7163/0		SPUR GEAR		1	0.000	
005 107		2/0315/7000/0	SP90111151/0	SPROCKET		2	0.000	
005 108		3/0967/7000/0		WHEEL		2	0.000	
005 115		4/0400/7242/0		SPACER RING		1	0.000	
005 116		4/0400/7245/0		SPACER RING		1	0.000	
005 117		4/0400/7244/0		SPACER RING		2	0.000	
005 118		4/0400/7243/0		SPACER RING		1	0.000	
005 119		4/0400/7249/0		SPACER RING		1	0.000	
005 120		4/0400/7246/0		SPACER RING		1	0.000	
005 122		4/0401/7151/0		SPACER RING		1	0.000	
005 123		4/0401/7152/0		SPACER RING		1	0.000	
005 124		4/0401/7154/0		SPACER RING		2	0.000	
005 125		4/0401/7155/0		SPACER RING		1	0.000	
005 126		4/0401/7153/0		SPACER RING		1	0.000	
005 127		4/0401/7156/0		SPACER RING		2	0.000	
005 128		4/0401/7157/0		SPACER RING		2	0.000	

DRAW BENCH 80TONS -BILL OF MATERIAL

PAGE 36

PART NO	BHEL DRAWING NO	REV MAKERS DRAWING	SPARE CODE	DESCRIPTION	MATL SPECN	QTY	UNIT	WT	REMARKS
005 130		3/0406/7080/0		DISC		2		0.000	
005 133				HEX SCREW M24X50		12		0.000	
005 134			SP7219301317	LOCK NUT M30		1		0.000	
005 135			SP7219401310	LOCK WASHER M30		1		0.000	
005 136				CIRCLIP 150X4		1		0.000	
005 137				CIRCLIP 240X5		2		0.000	
005 138				CYL PIN 8x 6X50	DIN 7	1		0.000	
005 140			SP721231561X	SPHERICAL ROLLER BRG 23164		2		0.000	
005 141			SP721231549X	SPHERICAL ROLLER BRG 23152		2		0.000	
005 142			SP721235332X	SPHERICAL ROLLER BRG 22334		2		0.000	
005 143			SP721235328X	SPHERICAL ROLLER BRG 22330		1		0.000	
005 144			SP7211532270	CYL ROLLER BRG M330		1		0.000	
005 145			SP721010840X	DEEP GROOVE BALL BRG 6048		4		0.000	
005 148			SP856260777X	SHAFT SEAL RING 150X180X13 B2		2		0.000	
005 149			SP856260791X	SHAFT SEAL RING 170X200X15 B2		2		0.000	
005 150			SP856260849X	SHAFT SEAL RING 260X300X20 B2		6		0.000	
005 151			SP856260886X	SHAFT SEAL RING 350X390X18 B2		2		0.000	

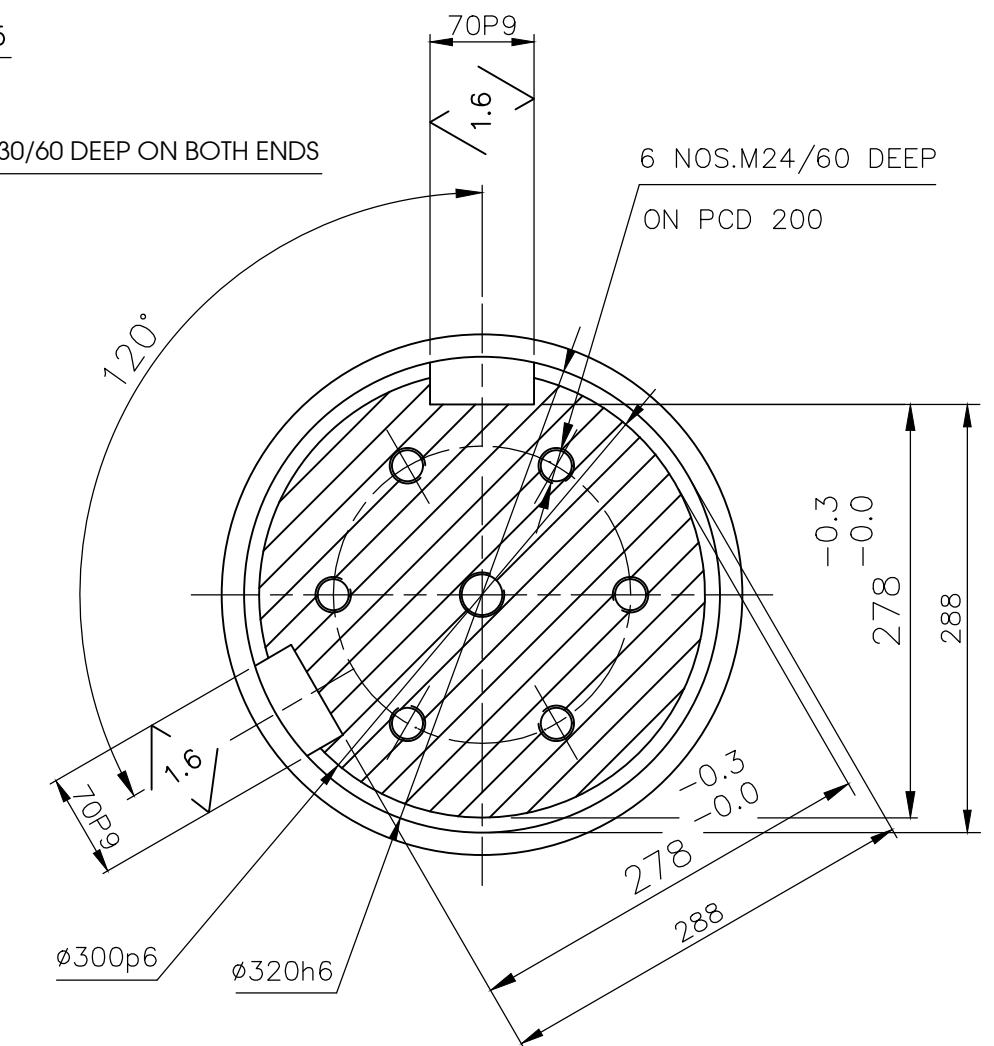
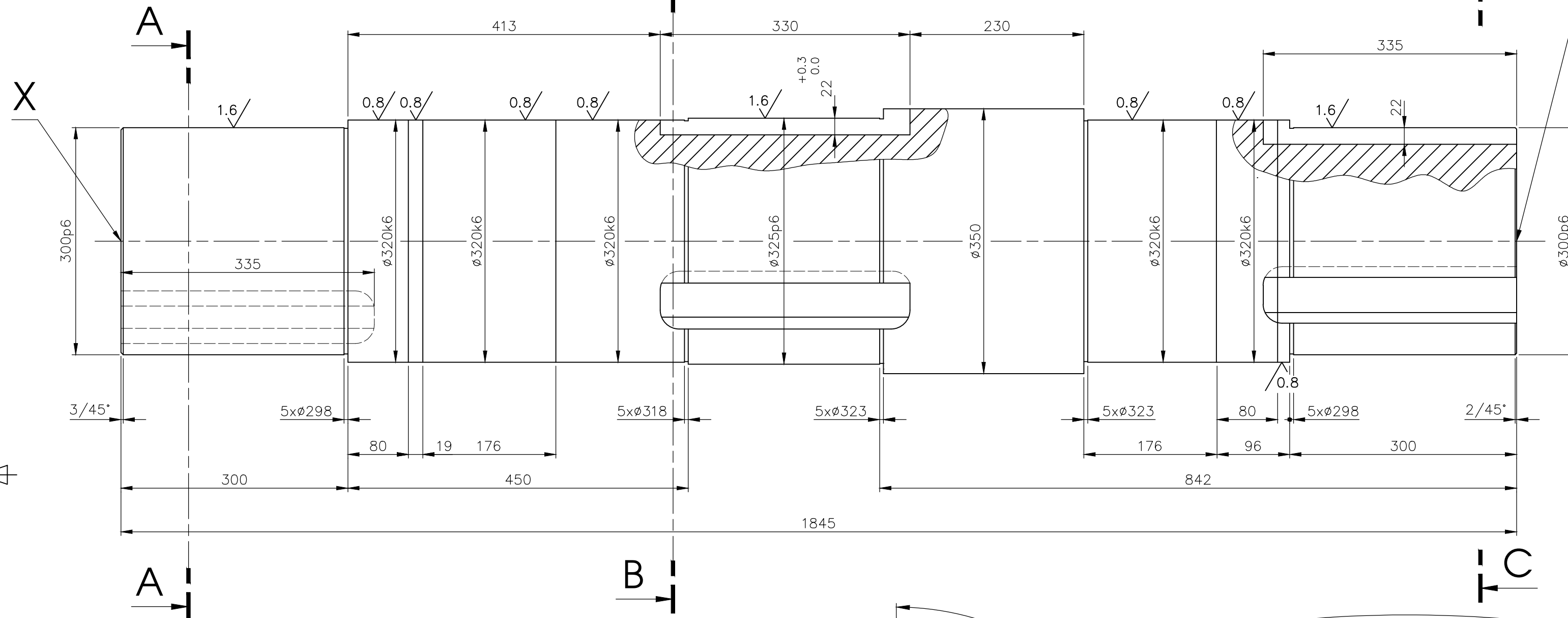
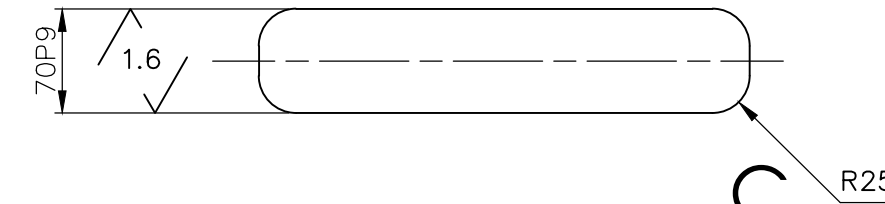
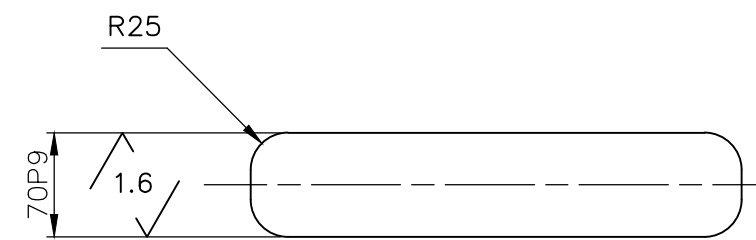
PART NO	BHEL DRAWING NO	REV MAKERS DRAWING	SPARE CODE	DESCRIPTION	MATL SPECN	QTY	UNIT	WT	REMARKS
005 155				SY7212937022 INNER RING IR 130X150X50 (INA)		1		0.000	
005 156				SY7212940066 INNER RING IR 320X350X80 (INA)		2		0.000	
005 157				LUBRICATION NIPPLE AM 10X1	DIN 3404	2		0.000	
005 160				PARALLEL KEY S 32X18X120	DIN 6885	2		0.000	
005 161				PARALLEL KEY S 45X25X90	DIN 6885	2		0.000	
005 162				PARALLEL KEY S 63X32X180	DIN 6885	2		0.000	
005 163				PARALLEL KEY S 70X36X260	DIN 6885	2		0.000	
005 164				PARALLEL KEY S 70X36X298	DIN 6885	4		0.000	
→ 006	2-7-0111-12-01684 00	3/3827/1501/0	SP9011113106	REVERSING GEAR BOX	ASSY Dwg. TECH	1		0.000	DATA IVL 480
006 056	LOHMANN'S STOLTER FORT 9.3.1977	3/0304/7003/0	SY9011167156	SPUR GEAR	4/3827/4505/0 sheet 1,2,3	1		0.000	2x63kW, 2x315kW
006 057		3/0304/7004/0	SY9011167157	SPUR GEAR	N. Forward 2.48 section 0.787	1		0.000	6/1106 1000 rpm
006 098		1/0609/7009/0	SY9011167198	CLUTCH LX70/14	TYE FKK 70/14	1		0.000	Return clutch.
006 098 001	1982 GERMANY		SY9011167201	SEALING SET FOR CLUTCH (294.3759.0)	nicked as per 210102 Rdn	1		0.000	
006 098 002			SY9011167202	SPRING SET (047.010.019.0078010.029.002)		1		0.000	
006 099		1/0609/7010/0	SY9011167199	CLUTCH KX70/14		1		0.000	Draw clutch
006 099 001			SY9011167211	SEALING SET FOR CLUTCH (294.3759.1)		1		0.000	
006 099 002			SY9011167212	SPRING SET (CONSISTS OF 24 NOS.)		1		0.000	



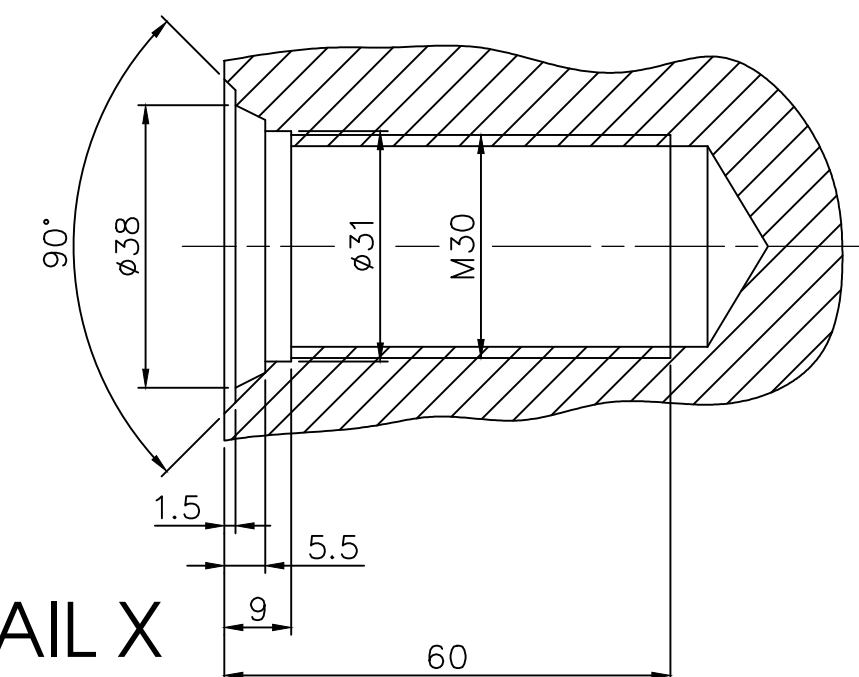
ALL DIMENSIONS ARE IN MILLIMETERS

3.2 1.6 0.8

ø300p6	+0.088	ø325p6	+0.098	ø320k6	+0.040	
	+0.056		+0.062		+0.004	
					70P9	-0.032
						-0.106



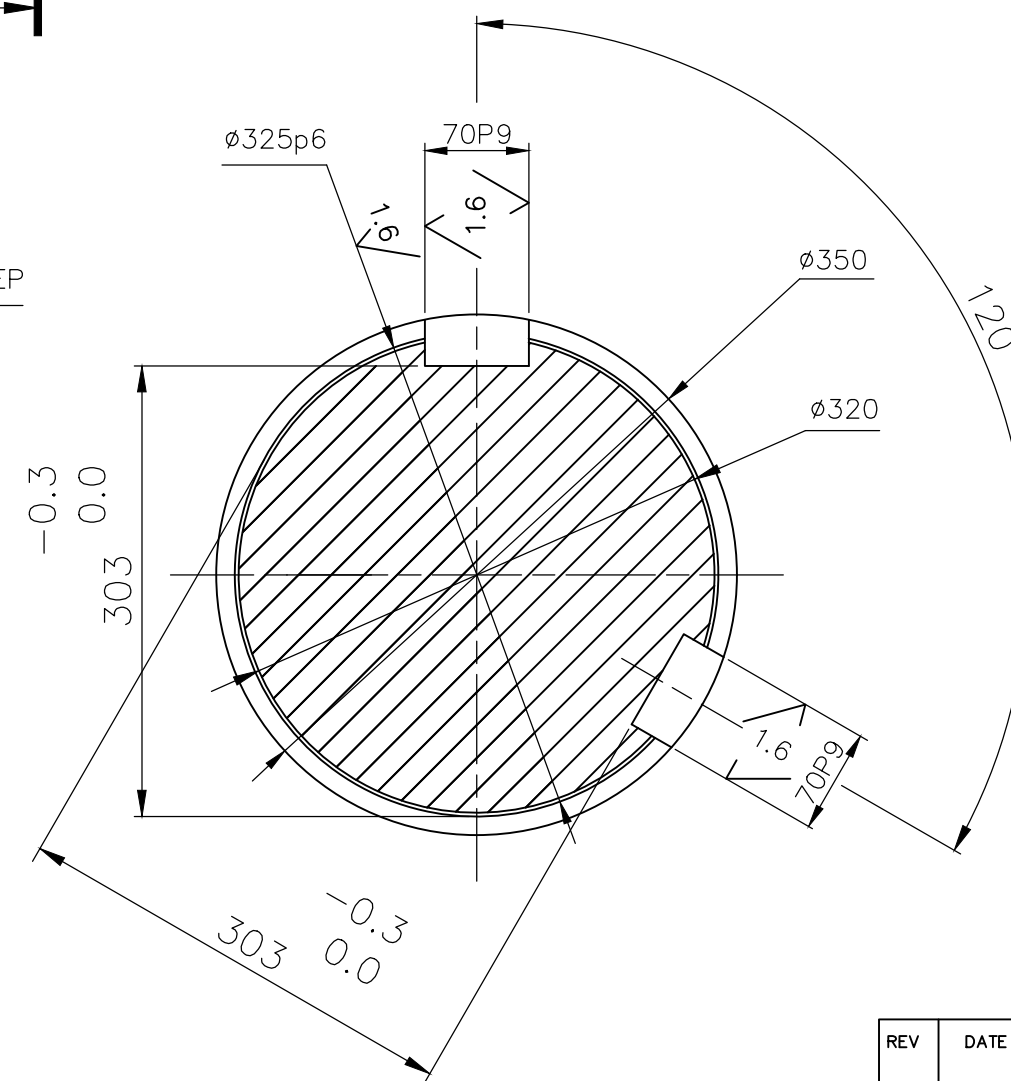
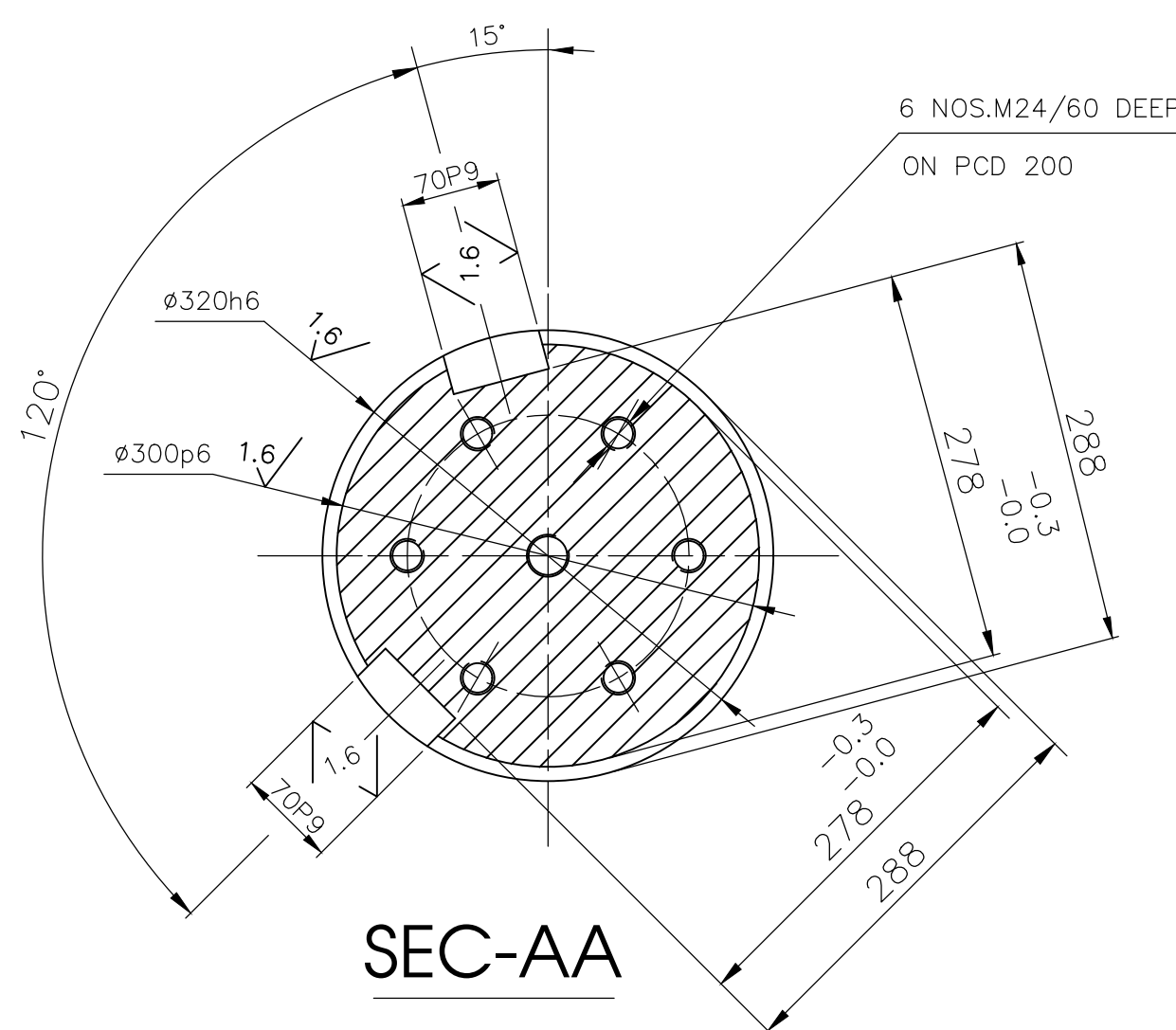
SEC-CC



REFERENCE PURPOSE ONLY

1. MATERIAL: EN24
2. HARDENED TO HRC.30
3. SHARP CORNERS TO BE REMOVED

DETAIL X

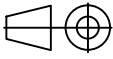


SEC-AA

SEC-BB

REV	DATE	ALTERED
		CHECKED
		APPROVED
ZONE		

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	Ø350x1845L				—	1141.80
					—	1
ITEM NO	DESCRIPTION		DRAWING NO		MATL CODE	UNIT WT
					MATL SPEC	QTY
EQPT: 800 KN DRAW BENCH						
 Bharat Heavy Electricals Ltd HIGH PRESSURE BOILER PLANT TIRUCHIRAPALLI — 620014			DRN	NAME S.SELVAMANICKAM	SIGNATURE <i>S. Selvamanickam</i>	DATE 12.03.22
			CHD	A.DANASEKAR	<i>A. Danasekar</i>	16.07.22
			APPD	A.DANASEKAR	<i>A. Danasekar</i>	18.07.22
DEPT M&S	GRADE OF UNTOL DIM		SCALE 1:2 1:5	WEIGHT (Kg) 1141.80	REF TO ASSY DWG NO — REF TO OLD DWG NO —	ITEM
CODE 2597	 IS: 2102					
TITLE OUTPUT SHAFT Ø350x1845L (800 KN DRAW BENCH REDUCTION GEAR BOX ASSY.)				CARD CODE U 01	DRAWING NO : M&S-PD-22-009	REV 00

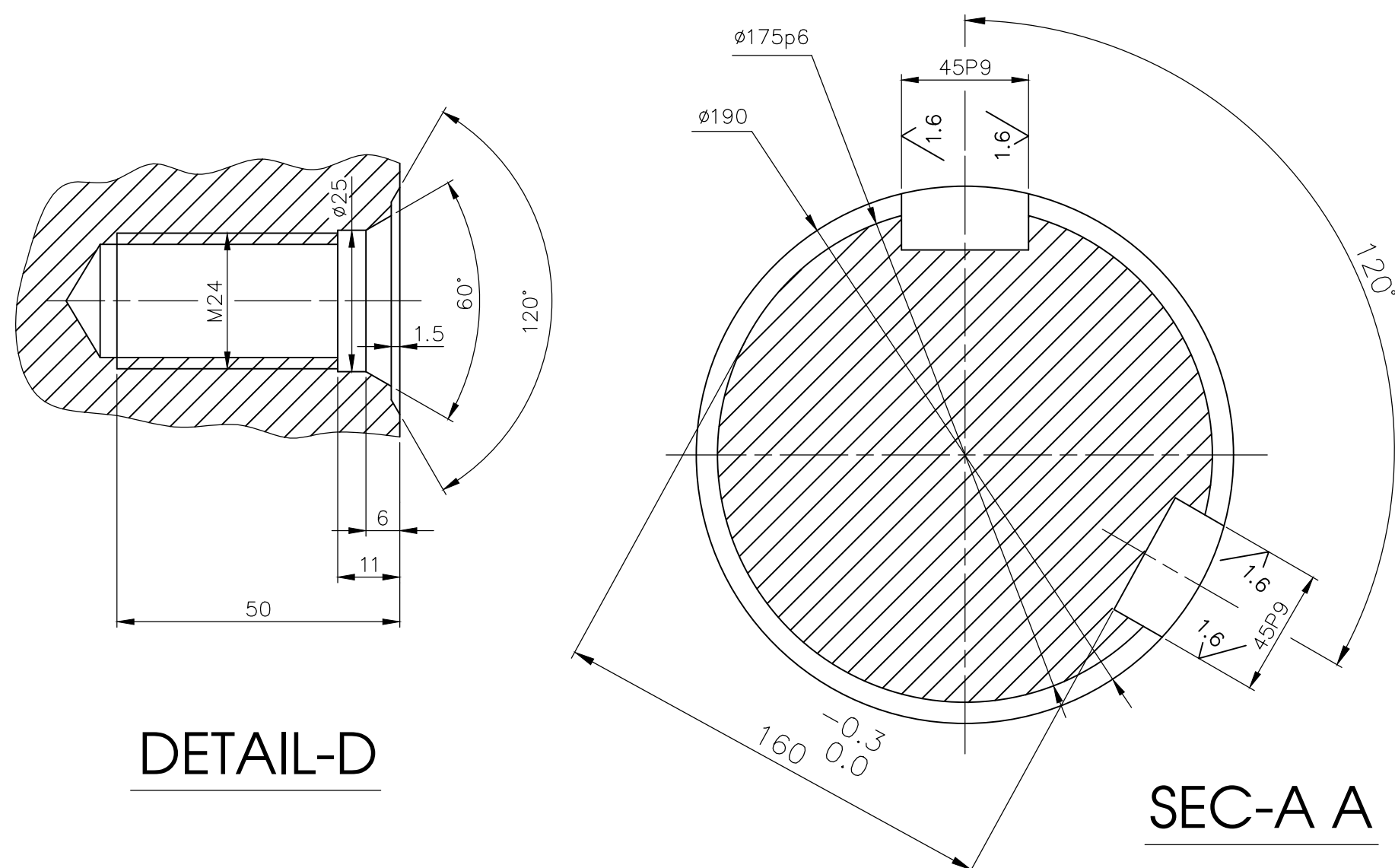
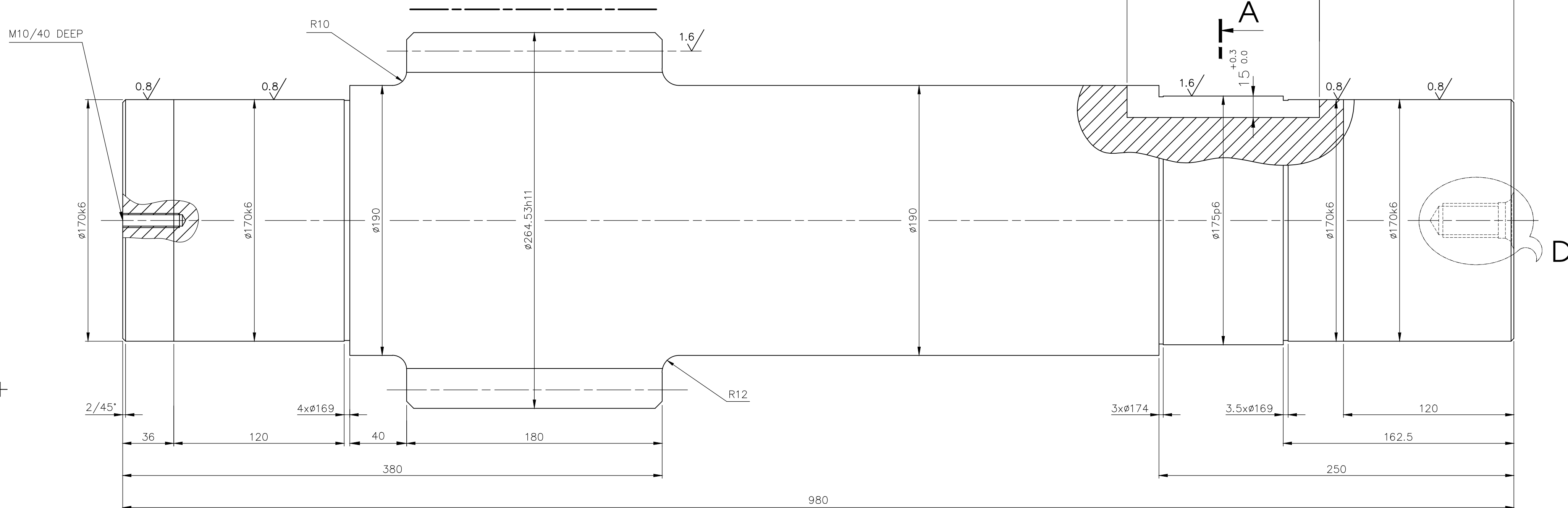
2-SIZE

ALL DIMENSIONS ARE IN MILLIMETERS

ø175p6	+0.068	ø170k6	+0.028	45P9	-0.026
	+0.043		+0.003		-0.088
ø264.53h11	-0.000				
	-0.032				

3.2 // 1.6 // 0.8

REFERENCE PURPOSE ONLY

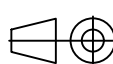
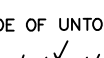


NO.OF TEETH	16
QUALITY & TOL.ZONE	9c.DIN 3967
HAND OF HELIX	LH
MATING GEAR No.OF TEETH	63
MATING GEAR REF.DRG.NO.	M&S-PD-22-008

NOTE: —

1. MATERIAL: 18CrNiMo7-6 (AS PER DIN 10084)
2. HARDNESS TO HRC.60
3. ———— CASE DEPTH 1mm
4. SHARP CORNERS TO BE REMOVED

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		ø266x980L				—	246.67	
						—	1	
ITEM NO	DESCRIPTION		DRAWING NO		MATL CODE		UNIT W	
					MATL SPEC		QTY	
EQPT: 800 KN DRAW BENCH								
		Bharat Heavy Electricals Ltd HIGH PRESSURE BOILER PLANT TIRUCHIRAPALLI — 620014			DRN	NAME S.SELVAMANICKAM	SIGNATURE <i>S. Selvamanickam</i>	DATE 04.06.22
					CHD	A.DANASEKAR	<i>A. Danasekar</i>	16.07.22
					APPD	A.DANASEKAR	<i>A. Danasekar</i>	18.07.22
DEPT M&S	GRADE OF UNTOL DIM		SCALE 1:1 1:2	WEIGHT (Kg) 246.67	REF TO ASSY DWG NO —			ITEM
CODE 2597	 IS: 2102				REF TO OLD DWG NO —			
TITLE FIRST INTERMEDIATE SHAFT 16Txø264.53 (REDUCTION GEAR BOX ASSY.)					CARD CODE U 01	DRAWING NO : M&S-PD-22-006		REV 00

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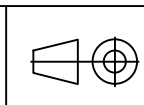


Bharat Heavy Electricals Ltd
HIGH PRESSURE BOILER PLANT
TIRUCHIRAPALLI - 620014

DRN	NAME S.SELVAMANICKAM	SIGNATURE <i>S.Selvamanickam</i>	DATE 04.06.2018
CHD	A.DANASEKAR	<i>A. Danasekar</i>	16.07.2018
APPD	A.DANASEKAR	<i>A. Danasekar</i>	18.07.2018

DEPT	M
CODE	2

&S	GRADE OF UNTOL. DI
597	C/M/F IS-2102



SCALE	WEIGHT (Kg)
1:1	
1:2	246.67

HT (Kg)	REF TO ASSY DWG NO —	ITEM
16.67	REF TO OLD DWG NO —	

TITLE	FIRST INTERMEDIATE SHAFT 16Txø264.53
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CARD CODE	DRAWING NO : M&S-PD-22-006	RE 00
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(REDUCTION GEAR BOX ASSY.)

U 01

M&S-PD-22-006

RE
00

A2-SIZE

DRAWING NO: M&S-PD-22-008

ALL DIMENSIONS ARE IN MILLIMETRES

ø946.63h11	0.000	63P9	-0.032
	-0.560		-0.106
ø265H7	+0.052		
	0.000		

3.2/1.6/

DETAIL-D

NO.OF TEETH	63
HAND OF HELIX	RH
MATING GEAR No.OF TEETH	16
QUALITY & TOL.ZONE	9c.DIN 3967

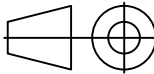
NOTE: -

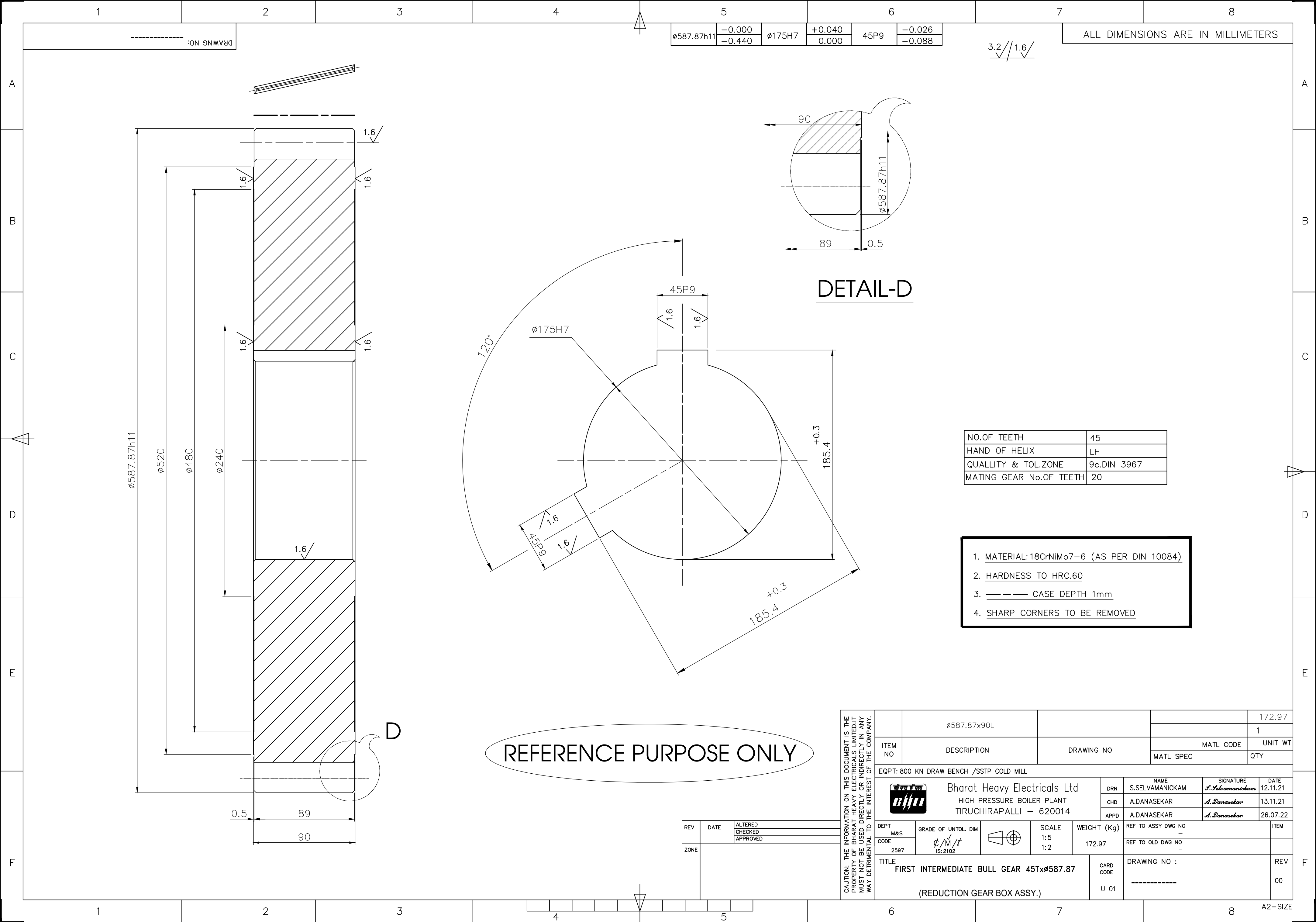
- MATERIAL:18CrNiMo7-6 (AS PER DIN 10084)
- HARDNESS TO HRC.60
- CASE DEPTH 1mm
- SHARP CORNERS TO BE REMOVED

D

REFERENCE PURPOSE ONLY

REV	DATE	ALTERED
		CHECKED
ZONE		APPROVED

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					—	1		
	ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE		UNIT WT		
				MATL SPEC		QTY		
	EQPT: 800 KN DRAW BENCH/SSTP COLD MILL							
	 Bharat Heavy Electricals Ltd HIGH PRESSURE BOILER PLANT TIRUCHIRAPALLI – 620014			DRN	NAME S.SELVAMANICKAM	SIGNATURE <i>S.Selvamanickam</i>	DATE 28.01.22	
				CHD	A.DANASEKAR	<i>A. Danasekar</i>	16.07.22	
				APPD	A.DANASEKAR	<i>A. Danasekar</i>	18.07.22	
	DEPT M&S	GRADE OF UNTOL. DIM ϕ / M / F IS: 2102		SCALE 1:5 1:2	WEIGHT (Kg) 926.07	REF TO ASSY DWG NO		ITEM
	CODE 2597					REF TO OLD DWG NO		
TITLE SECOND INTERMEDIATE BULL GEAR 63Txø946.634(RH) (REDUCTION GEAR BOX ASSY.)				CARD CODE U 01	DRAWING NO : M&S-PD-22-008		REV	



ø587.87h11

ø520

ø480

ø240

0.5

89

90

D

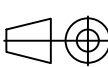
REFERENCE PURPOSE ONLY

DETAIL-D

NO.OF TEETH	45
HAND OF HELIX	LH
QUALLITY & TOL.ZONE	9c.DIN 3967
MATING GEAR No.OF TEETH	20

- MATERIAL:18CrNiMo7-6 (AS PER DIN 10084)
- HARDNESS TO HRC.60
- CASE DEPTH 1mm
- SHARP CORNERS TO BE REMOVED

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		ø587.87x90L					172.97
							1
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE		UNIT WT		
			MATL SPEC	QTY			
EQPT: 800 KN DRAW BENCH /SSTP COLD MILL							
 Bharat Heavy Electricals Ltd HIGH PRESSURE BOILER PLANT TIRUCHIRAPALLI – 620014			DRN	NAME S.SELVAMANICKAM	SIGNATURE <i>S.Selvamanickam</i>	DATE 12.11.21	
			CHD	A.DANASEKAR	<i>A. Danasekar</i>	13.11.21	
			APPD	A.DANASEKAR	<i>A. Danasekar</i>	26.07.22	
DEPT M&S	GRADE OF UNTOL. DIM		SCALE 1:5 1:2	WEIGHT (Kg) 172.97	REF TO ASSY DWG NO —	ITEM	
CODE 2597	φ/M/F IS:2102				REF TO OLD DWG NO —		
TITLE FIRST INTERMEDIATE BULL GEAR 45Txø587.87 (REDUCTION GEAR BOX ASSY.)			CARD CODE U 01	DRAWING NO : —————		REV 00	

A2-SIZE