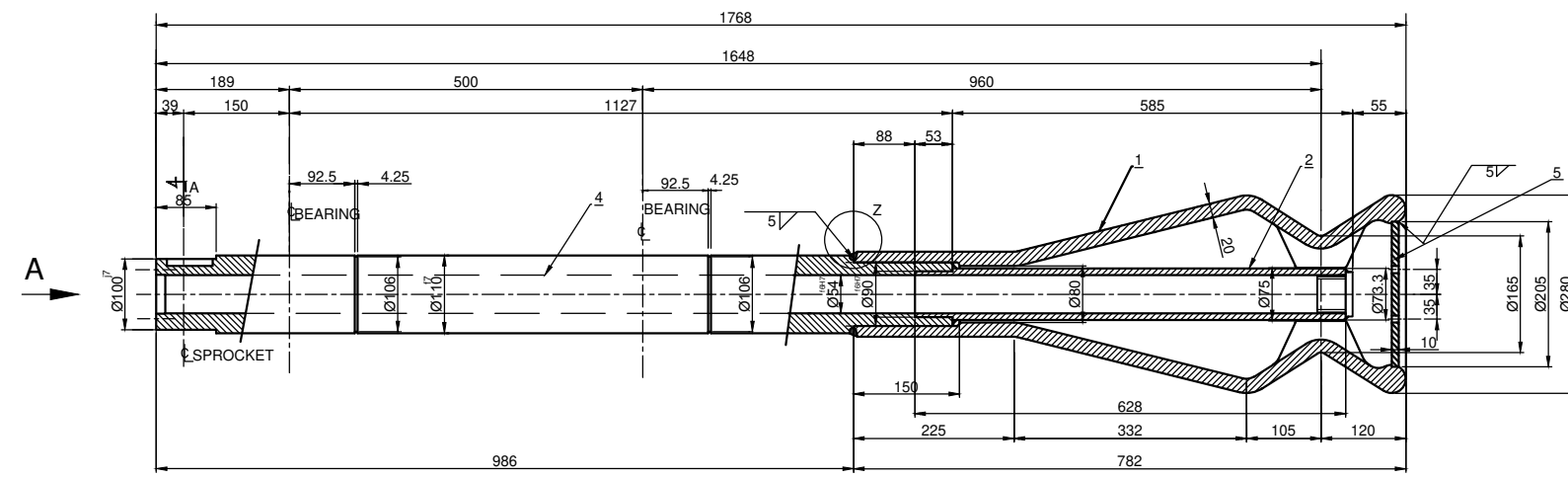
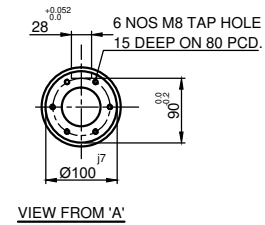
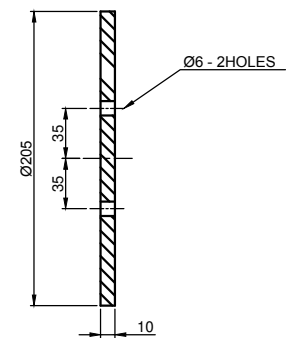
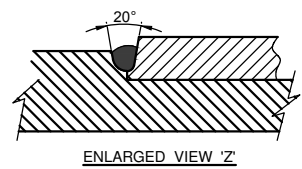


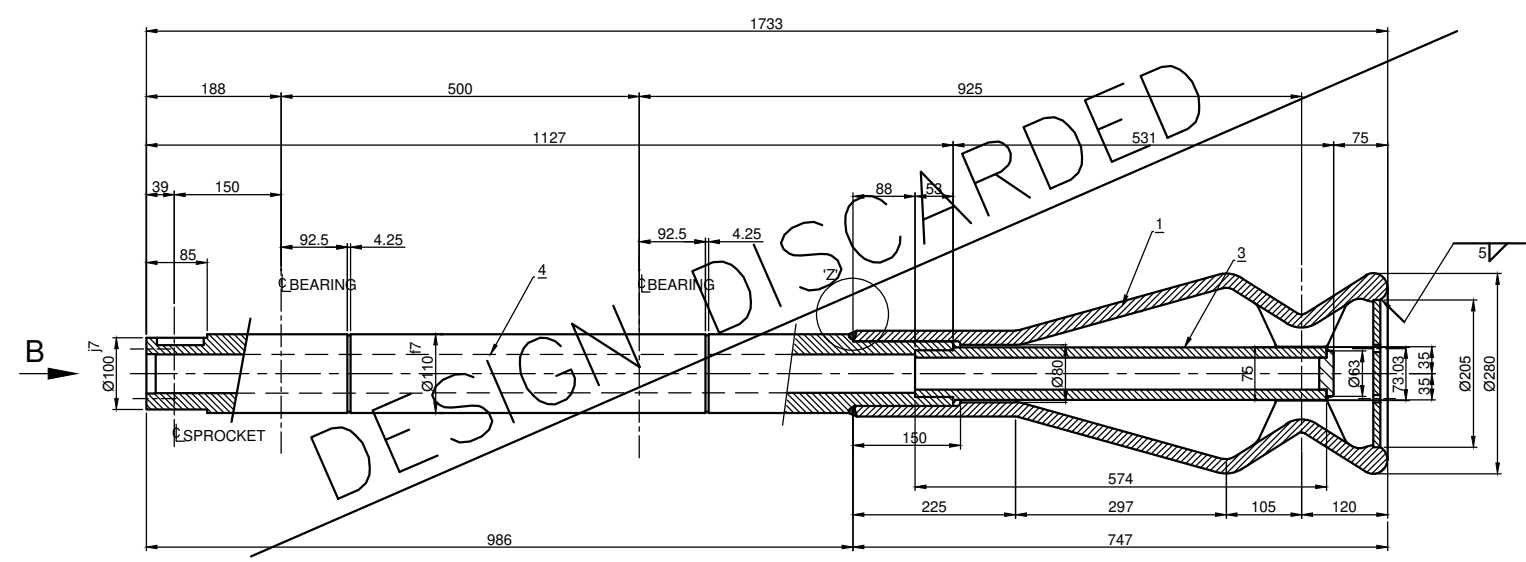
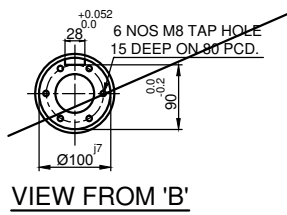
	$\sqrt{Ra\ 3.2}$	$\sqrt{Ra\ 1.6}$
Ø110 f7	-0.036	-0.071
Ø100 j7	+0.020	-0.015
Ø90 H7	+0.035	0
Ø90 f6	+0.036	+0.058
Ø65 H7	+0.030	0
Ø65 f6	-0.030	-0.049



CHARGE & DISCHARGE ROLLER ASSEMBLY



DETAIL OF ITEM No.5



DIS-CHARGE ROLLER ASSEMBLY

DESIGN DISCARDED

NOTE:
HYDRO TEST TO BE DONE AT 1.5 ATA
MATERIAL AS PER
INDENT AND TDC

ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT	QTY
5	PLATE 10 x Ø205		SS 310	2.6	1
4	SHAFT	1-7-1150-10-10002	SS-304 SS 310	84	1
9	PIPE ASSY(TYPE 1)		SS-304	12.75	1
2	PIPE	1-7-1150-00-10002	SS-304 SS 310	13	1
1	CHARGE / DISCHARGE ROLLER CASTING	1-7-1150-00-10001	HP 45Nd HK ALLOY (25%Cr, 20%Ni)	65	1

DEPT	SS/STP	GRADE OF UNTOOL DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM
456		Ø110/f Ø106/f Ø110/f Ø90/f Ø73.3/f Ø205/f Ø280/f	1:5	323.87	REF TO OLD DWG NO FA-0428-G23A	

REV	DATE	ALTERED / CHECKED / APPROVED	REV	DATE	ALTERED / CHECKED / APPROVED
02	23.02.17	S.S. Kumar / M. Manoharan	01	14.12.13	S.S. Kumar / M. Manoharan

REV	DATE	DESCRIPTION
02	23.02.17	2'BSP - PLUG ADDED IN CRT - DRT ROLLERS
01	14.12.13	CRT & DRT ROLLER LENGTH STANDARDIZED FOR 1768 AS PER HM MTCE. REQUEST. ITEM No. 5 ADDED.

DEPT	SS/STP	GRADE OF UNTOOL DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM
456		Ø110/f Ø106/f Ø110/f Ø90/f Ø73.3/f Ø205/f Ø280/f	1:5	323.87	REF TO OLD DWG NO FA-0428-G23A	

TITLE	CARD CODE	DRAWING NO :	REV
WBF - CHARGE & DISCHARGE ROLLER ASSY	U 01	1-7-1150-10-10003	02

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WALKING BEAM FURNACE

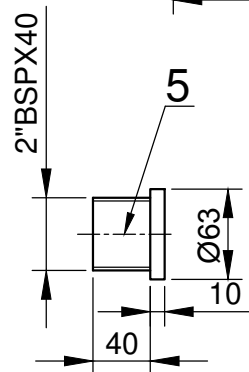
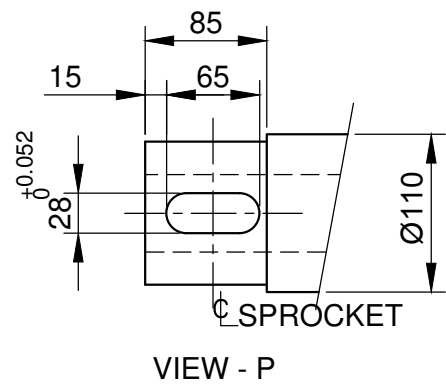
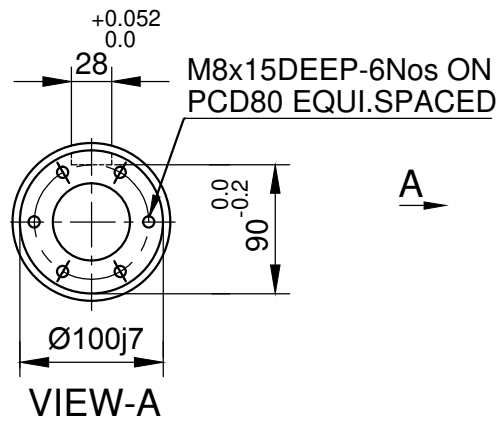
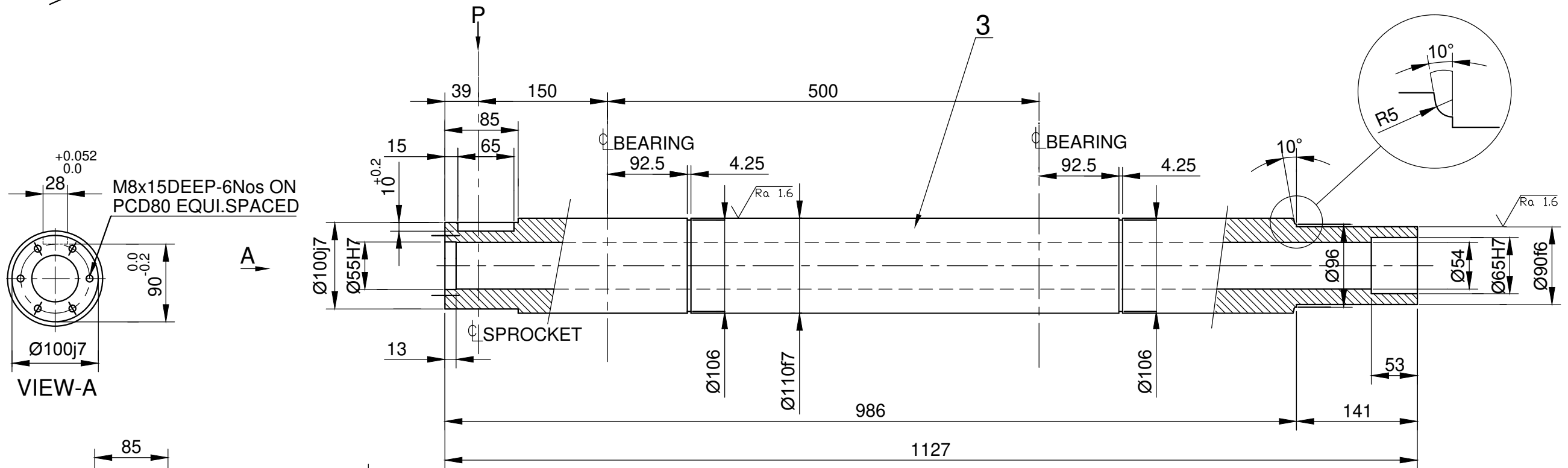
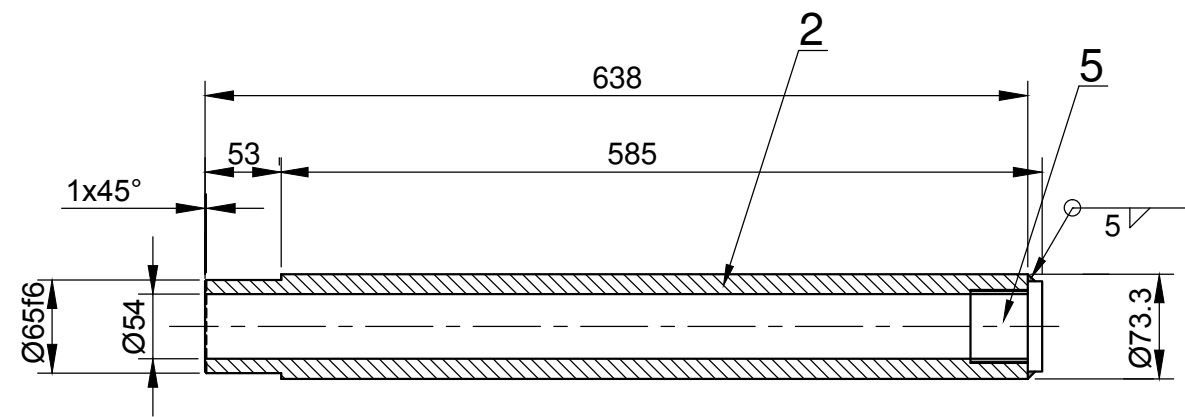
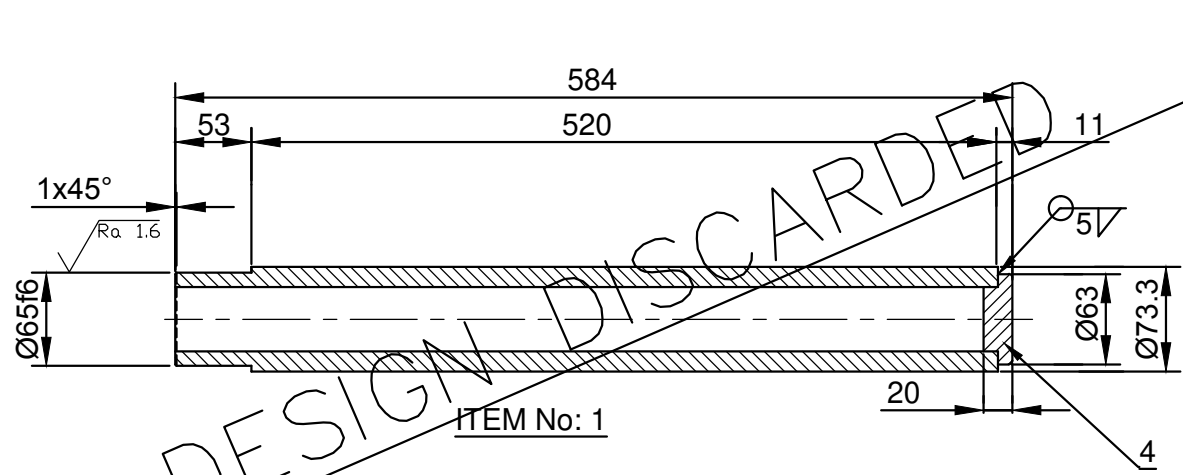
Bharat Heavy Electricals Ltd
SEAMLESS STEEL TUBE PLANT
TIRUCHIRAPALLI - 620014

NAME: S.KIRUBAHARAN
SIGNATURE: S.Kirubakaran
DATE: 03.02.12

CHD: SSN.KUMAR
SIGNATURE: SSN.Kumar
DATE: 03.02.12

APPD: R.RAGHUVIEER
SIGNATURE: R.Raghuveer
DATE: 03.02.12

√ Ra 3.2 (√ Ra 1.6)	
Ø100 j7	+0.020 -0.015
Ø65 H7	+0.030 0
Ø65 f6	-0.030 -0.049
Ø55 H7	+0.030 0



NOTES:

- ITEM NO. 2 & 3 TO BE ASSEMBLED AND WELDED (6mm FILLET) STRAIGHTNESS TO BE MAINTAINED WITH THE AXIS.
- HYDRO TEST SHOULD BE DONE AT 1.5 ATA AFTER ASSY.
- FOR CHARGE/DISCHARGE ROLLER ASSEMBLY, REFER DRG NO1-7-1150-10-10003

5	Ø63X50 L		SS 310	1.2
4	PL 20 x Ø65			1
				0.5
3	SHAFT		SS 310	2
				84
2	PIPE ASSY		SS 310	1
				13
1	PIPE ASSY (TYPE I)		SS 304	1
				-12.76
				±

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DEPT	SSTP	GRADE OF UNTEL. DSN	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM
408			1:5	111.95	REF TO OLD DWG NO	
TITLE				CARD CODE	DRAWING NO :	REV
WBFB - MACHINERY ITEM OF CHARGE & DISCHARGE ROLLER				U 01	1-7-1150-10-10002	02

REV	DATE	ALTERED	BY	REV	DATE	ALTERED	BY
02	23.02.17	CHECKED	S.S. Kumar	01	21.11.13	CHECKED	S.S. Kumar
IDEM NO: 05 ADDED AS PER USER'S REQUEST				CRT & DRT SHAFT LENGTH STANDRIZED FOR 619 AS PER HM MTCE. REQUEST.			

