

DEVIATIONS OF UNTOLERANCED DIMENSIONS TO BE AS PER IS:2102-1989 MEDIUM.

1.6 / 0.8 /

10 H7	+0.015
0	0
111 H7	+0.035
0	0

MATERIAL:45C8 IS:1570(Part II)-1979

MARK MATERIAL CODE No.:6908210106



Bharat Heavy Electricals Ltd
SEAMLESS STEEL TUBE PLANT
TIRUCHIRAPPALLI - 620014

DRN NAME
R.KUMAR
CHD SIGNATURE
APPD S.KARUPPASAMY

DATE
08.11.08

DEPT	GRADE OF UNTOLE DM C/M/F	SCALE	WEIGHT(Kg)
CODE		1:1	3.8

REF TO ASSY DWG NO	REF TO OLD DWG NO	ITEM NO
10.ST.192.01.030	RW28085-4	7

TITLE	CARD CODE	DRAWING NO :	REV
THREADED RING (FOR P B FIXED)	U 01	30.ST.192.01.242	02

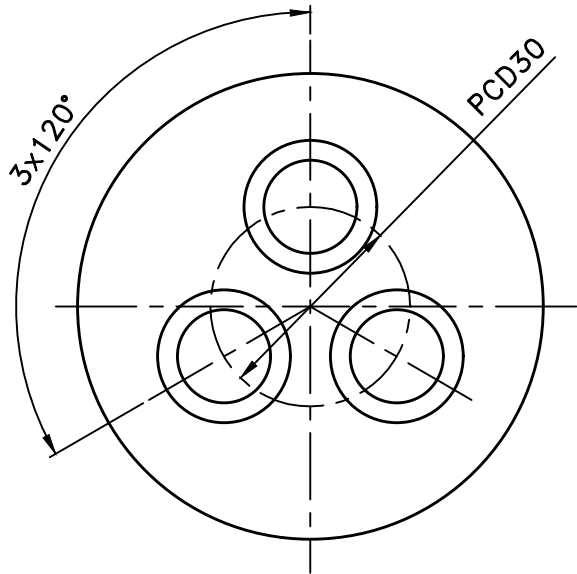
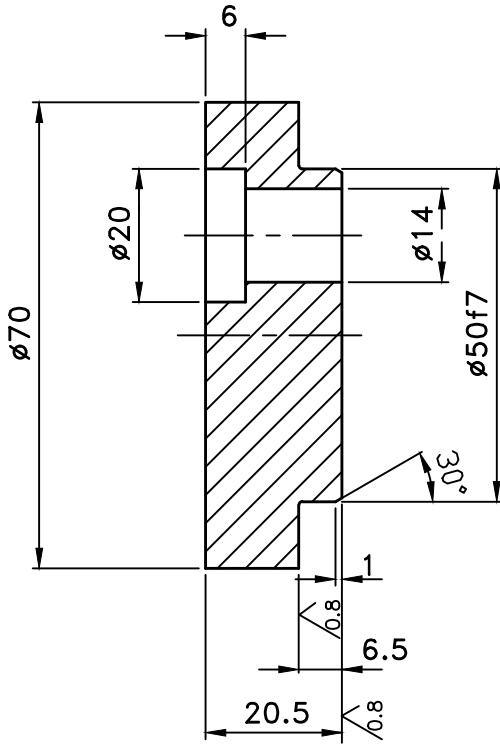
REV	DATE	ALTERED :
		APPROVED

ALL DIMENSIONS ARE IN MM

REV 01	DATE	ALTERED
		CHECKED
		APPROVED

1.6/0.8/

50	f7	-0.025
		-0.050



MATERIAL CODE No.:69 06 21 011 4

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ITEM NO	DESCRIPTION	DRAWING NO	IS:1570(PartII)1979	UNIT WT
	ø70X20.5		45C8	
			MATL CODE	QTY
			MATL SPEC	

EQPT:

	Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014	DRN	NAME R.KUMAR	SIGNATURE <i>R.Kumar</i>	DATE 27.09.11
		CHD	N ARUMUGANAINAR	<i>N. Arumuganainar</i>	29.09.11
		APPD	S KARUPPASAMY	<i>S Karuppasamy</i>	01.10.11

DEPT SSTP TE	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM
456	ø/M/F IS: 2102	1:1	0.53	10-ST-192-01-30	11
				REF TO OLD DWG NO	
				RW 39379-3	

TITLE	CARD CODE	DRAWING NO :	REV
COVER-BRG LOCK PLATE (BALL BEARING 3310)	U 01	40-ST-192-01-009	00

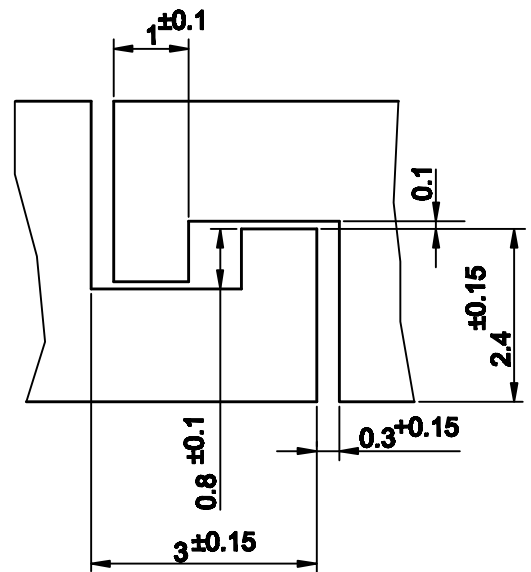
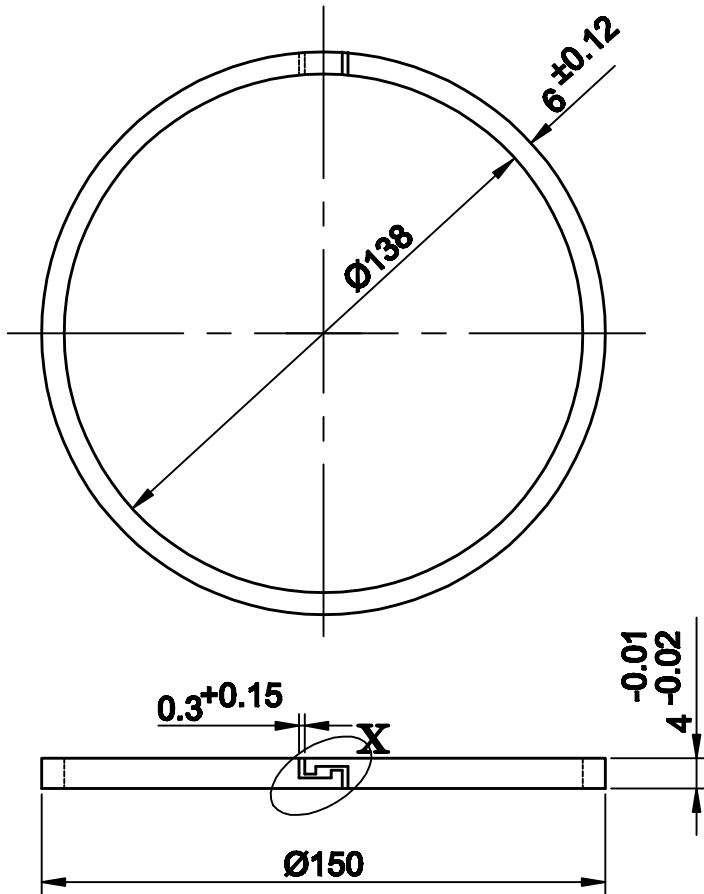
A4-SIZE

REV	DATE	ALTERED
01	24.06.09	APPROVED

DEVIATIONS OF UNTOLERANCED DIMENSIONS TO BE AS PER IS:2102-1969 MEDIUM. **1.6**

NOTE ADDED

DETAIL-X



OPENING OF THE RING : 20mm ±15%
 OUTER & INNER EDGES : SHARP, BUT FREE FROM BURRS

MATERIAL : 125 Cr1(DIN 1.2002)

CHEMICAL COMPOSITION


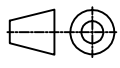
C	Si	Mn	P	S	Cr
1.20	0.15	0.25	MAX.0.030	MAX.0.030	0.30
1.30	0.30	0.40			0.40

NOTE

MATERIAL CHEMISTRY - NABL ACCREDITED LAB TEST CERTIFICATE IS TO BE PROVIDED.

EQUIVALENT MATERIAL: IS:1570-61 105_Cr1 OR BS 970 En31

MATERIAL CODE No.:69 06 21 017 3

		Bharat Heavy Electricals Ltd		DRN	NAME R.KUMAR	SIGNATURE	DATE 24.06.09
		SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		APPD	S.KARUPPASAMY		
DEPT	GRADE OF UNTOL. DIM		SCALE	WEIGHT (Kg)	REF TO ASSY DRG	ITEM NO	
CODE	C/M/F		NTS	0.08	REF TO OLD DRG	10.....030	13
TITLE				CARD CODE	DRAWING NO :		REV
PISTON RING (P B FIXED STAND)				U 01	40.ST.192.01.011		01

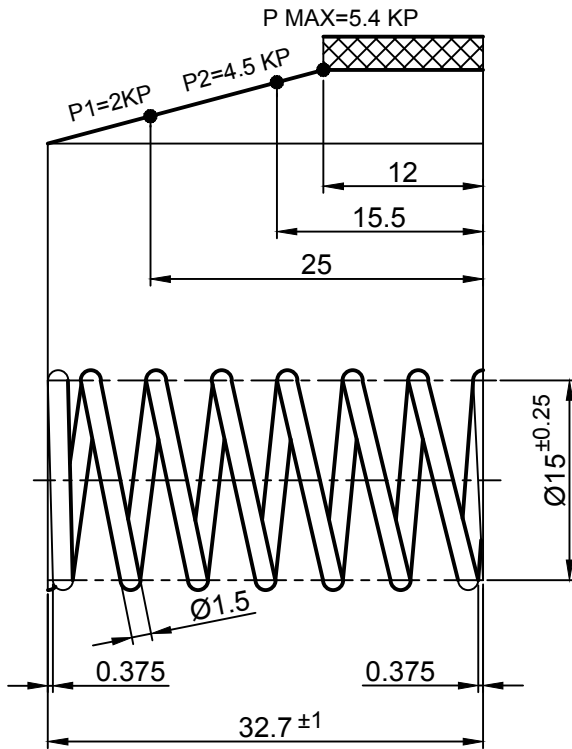
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ALL DIMENSIONS ARE IN MM

REV. 02	DATE 30.03.10	ALTD: M.Bhawa APPD: S.Karuppasamy
MATERIAL CHANGED AS SPRING STEEL IS:4454 (PART 1) :2001 Gr. SM. INSTEAD OF 80 C6 (OR) 970 EN42.		

~ / 0.8 /


DEVIATIONS OF UNTOLERANCED DIMENSIONS TO BE ASPER IS:2102-1969 MEDIUM.



CHECK ON MANDREL : Ø13
DEVELOPED LENGTH : 377mm
NO. OF RESILIENT COILS : 6
NO. OF DEAD COILS : 1+1

HARDEN TO 40 - 45 HRC.
MATERIAL CODE NO: 69 06 21 023 8

SL NO:	MATERIAL	CHEMICAL COMPOSITION					
		C	Si	Mn	S	P	Cu
01.	SPRING STEEL (WIRE) IS:4454 (PART 1) :2001 Gr.SM.	0.35	0.10	0.30	(0.03 Max)	(0.03 Max)	(0.20 MAX)
		1.00	0.30	1.20			

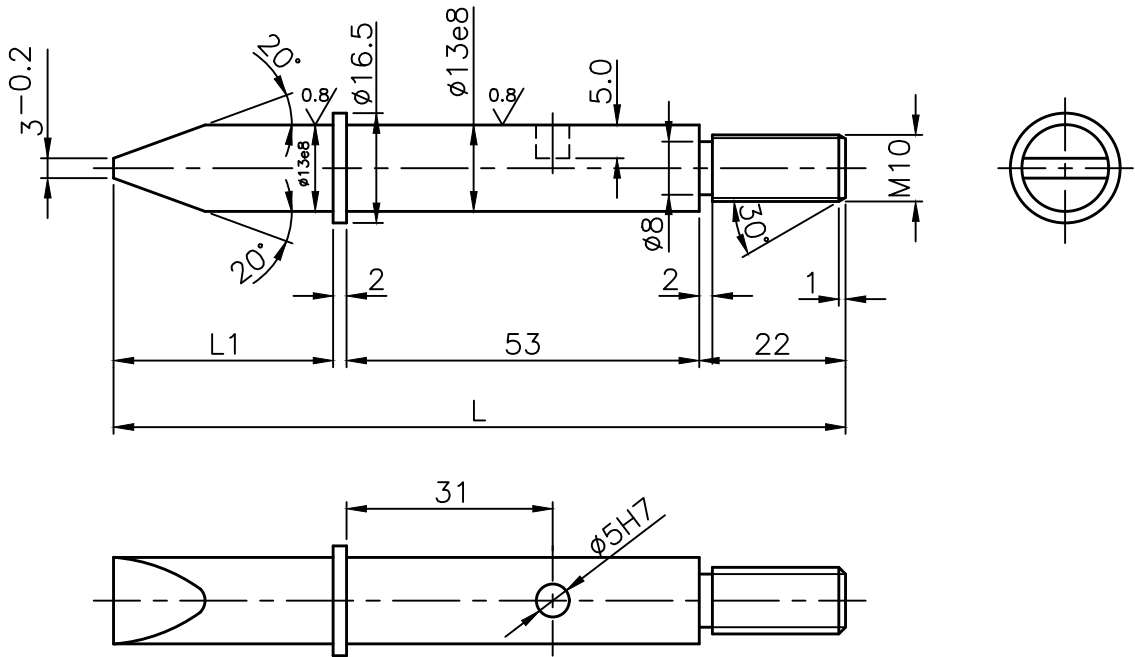
		Bharat Heavy Electricals Ltd		DRN	NAME	SIGNATURE	DATE
		SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		APPD	M.Bhawa		15.12.09
DEPT	TE	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DRG	ITEM NO	
CODE		C/M/F	2:1	0.005	00.ST.192.01.002 00.ST.192.02.003	48 56	
TITLE				CARD CODE	REF TO OLD DRG:		
SPRING				U 01	RW28240-8		
					DRAWING NO:		REV
					40-ST-192-01-014		02

ALL DIMENSIONS ARE IN MM

REV 01	DATE	ALTERED
		CHECKED
		APPROVED

1.6/0.8/

6 H7	+0.012
	0
13 e8	-0.032
	-0.059



SL No.	L	L1	WT.KG	MATERIAL CODE No.
01	110	33 ^{+0.2}	0.11	69 06 21 024 6
02	125	48 ^{+0.2}	0.13	69 06 31 034 8

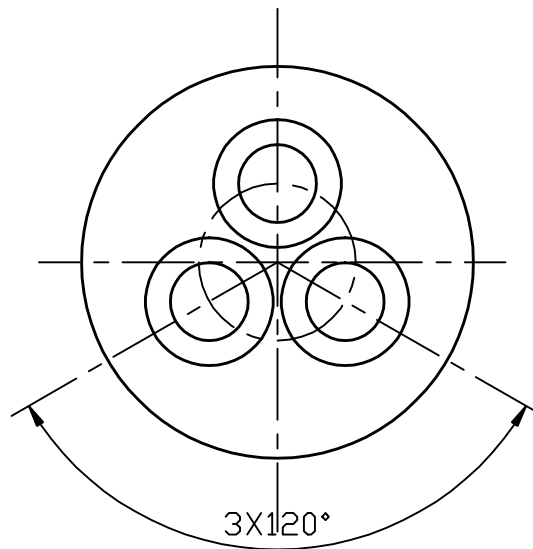
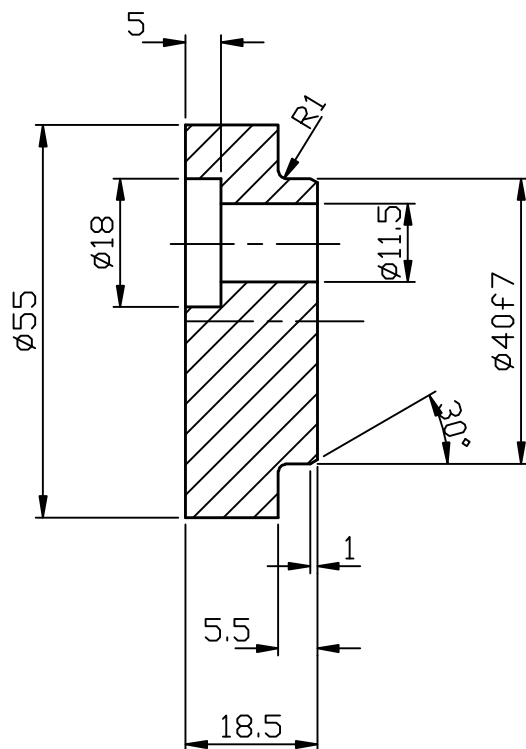
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	Ø16.5XL		IS:1570(PartII)1979		
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT	
			MATL SPEC	QTY	
EQPT:					
	Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014	DRN	R.KUMAR	SIGNATURE <i>R.Kumar</i>	DATE 27.09.11
		CHD	N ARUMUGANAINAR	<i>N. Arumuganainar</i>	29.09.11
		APPD	S KARUPPASAMY	<i>S. Karuppasamy</i>	01.10.11
DEPT SSSTP TE	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM
456	Ø/M/F IS: 2102	1:1		00-ST-192-01-002	49
				00-ST-192-02-003	61
TITLE				REF TO OLD DWG NO	
LOCATING PIN (P B FIXED&ADJ.ASSY)				RW 28240-6&10	
CARD CODE		DRAWING NO :		REV	
U 01		40-ST-192-01-114		02	


1.6/

DEVIATIONS OF UNTOLERANCED DIMENSIONS TO BE AS PER IS:2102-1969 MEDIUM

50	f7	-0.025
		-0.050



MATERIAL CODE No.:69 06 31 009 7

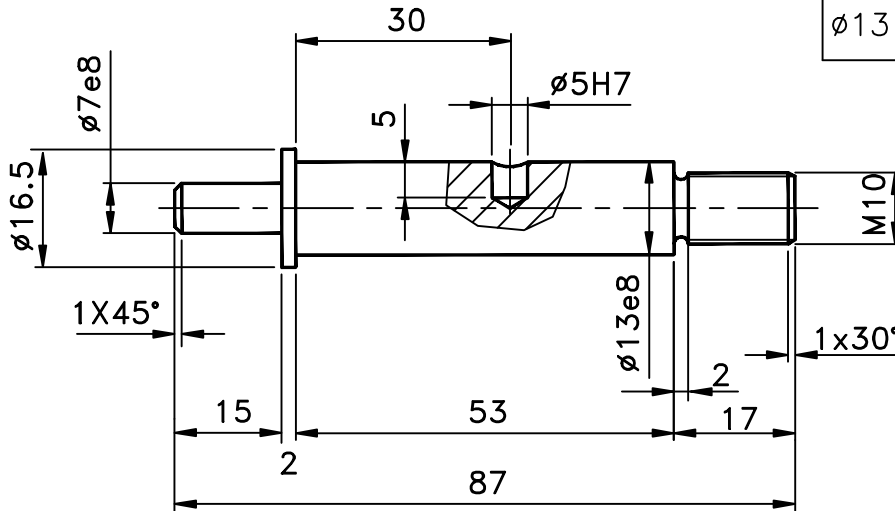
Ø55X18.5		IS:1570(PartII)1979	
		45C8	
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE
			MATL SPEC
			UNIT WT
			QTY
EQPT:			
		Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014	
		DRN	NAME
		CHD	SIGNATURE
		APPD	DATE
		R.KUMAR	
		S.KARUPPAAMY	
DEPT	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)
T E	C/M/F	1:1	0.29
CODE			
TITLE		CARD CODE	DRAWING NO :
COVER		U 01	40.ST.192.02.016
(BALL BEARING 3308)			REV
			00

REV 01	DATE	ALTERED
		CHECKED
		APPROVED

1.6/

DEVIATIONS OF UNTOLERANCED DIMENSIONS TO BE AS PER IS:2102-1969 MEDIUM

ø5	H7	+0.012
		0
ø7	e8	-0.025
		-0.047
ø13	e8	-0.032
		-0.059



MATERIAL CODE :69 06 31 029 1

			IS:5517	
			45C8	
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT
			MATL SPEC	QTY

EQPT:



Bharat Heavy Electricals Ltd
SEAMLESS STEEL TUBE PLANT
TIRUCHIRAPALLI - 620014

DRN	NAME R.KUMAR	SIGNATURE	DATE 11.9.97
CHD			
APPD	P.GANESAN		

DEPT T E	GRADE OF UNTOL. DIM C/M/F		SCALE 1:1	WEIGHT (Kg) 0.08	REF TO ASSY DRG 00.....003	ITEM NO
CODE					REF TO OLD DRG RW 28240-5	

TITLE PIN (P B ADJ ASSY)	CARD CODE U 01	DRAWING NO : 40.ST.192.02.023	REV 00
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Pre-Qualifying Criteria

1. The vendor should be a manufacturer/trader and should have supplied similar machining tools to any of production, manufacturing, support services departments in any Central/State/Govt organisation/PSU Company/ Public Listed company after 31st March 2021.
2. Purchase Order copy of the same is to be furnished.
3. Supply completion proof (Delivery Challan/Tax Invoice/Payment Proof /Performance certificate) for the above Purchase order.

Abhighna
a D

Digitally signed
by Abhighna D
Date: 2024.03.13
12:53:48 +05'30'