

## **SCHEDULE 1**

### **RIFLE PLUG 32.20 MM ( 30.442/06 )**

RIFLE PLUG DIA. 32.20 mm

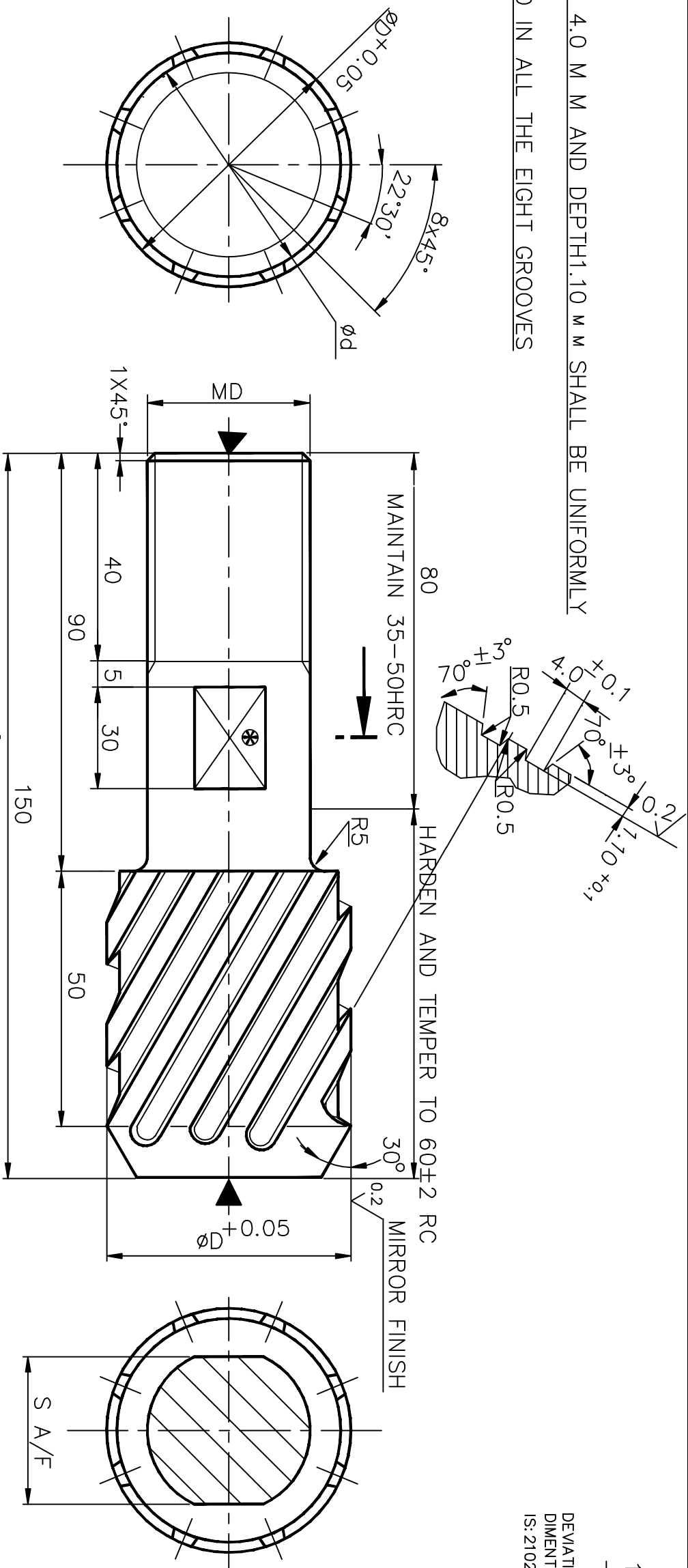
DRAWING No. : 30.ST.221.23.442/06 Sl. No. : 05

NOTE

THE WIDTH 4.0 M M AND DEPTH 1.10 M M SHALL BE UNIFORMLY MAINTAINED IN ALL THE EIGHT GROOVES

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

1.6 / 0.2 /



NOTE TO SUPPLIER

- 01) MATERIAL CHEMISTRY-NABL ACCREDITED LAB TEST CERTIFICATE IS TO BE PROVIDED
- 02) HARDNESS & HEAT TREATMENT CERTIFICATE OBTAINED FROM THE HEAT TREATERS IS TO BE PROVIDED
- 03) THREADED AREA TO BE PROPERLY PROTECTED, COATED WITH RUST PREVENTIVE OIL AND PACKED TO AVOID DAMAGES DURING TRANSIT
- 04) MARK MATERIAL CODE No., FIRMS NAME, P O No.

DATA  
 No OF RIBS : 8  
 HELIX ANGLE : 30°  
 LEAD : SEE IN TABLE  
 HELIX : RIGHTHAND HELIX

SL No.	MD	D	d	LEAD	TUBE SIZE	MATERIAL CODE No.	S
01		38.70	36.50	209.80	51X5.6	69 23 99 501 9	
02		37.80	35.60	205.68	51X6.0	69 23 99 505 2	
03	M30	35.4	33.2	191.8	51X7.1	69 23 99 506 0	24
04		37.0	34.8	200.5	63.5X12	69 23 99 508 6	
05	M24	32.2	30.0	175.21	44.5X5.6	69 23 99 511 0	22

MATERIAL: HIGH CARBON HIGH CHROMIUM COLDWORKING DIE STEEL

ANYONE OF THE FOLLOWING MATERIAL SHALL BE USED

SL. No.	MATERIAL	C	Si	Mn	Cr	Mo	Max.	P	S
01	XT215Cr12 IS: 3748-1990	2.0	0.10	0.25	11.0	Max. 0.80	Max. 0.035	Max. 0.035	
02	XT210Cr12 DIN-1.2080	1.9	0.2	0.2	11.0	-	Max. 0.035	Max. 0.035	

		Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	R. KUMAR	SIGNATURE	DATE	19.11.10
DEPT	TE	GRADE OF UNTOL. DIM C/M/F	SCALE	N T S	WEIGHT(kg)	CARD CODE	U 01	
TITLE		RIFLE PLUGS		DRAWING NO :		30.221.23.442		
				REF TO ASSY DWG NO		00.ST.221.99.025		
				REF TO OLD DWG NO				
				ITEM NO		10		
				REV		06		