

SCHEDULE 3

RIFLE PLUG DIA 47.90 mm (30.443/02)

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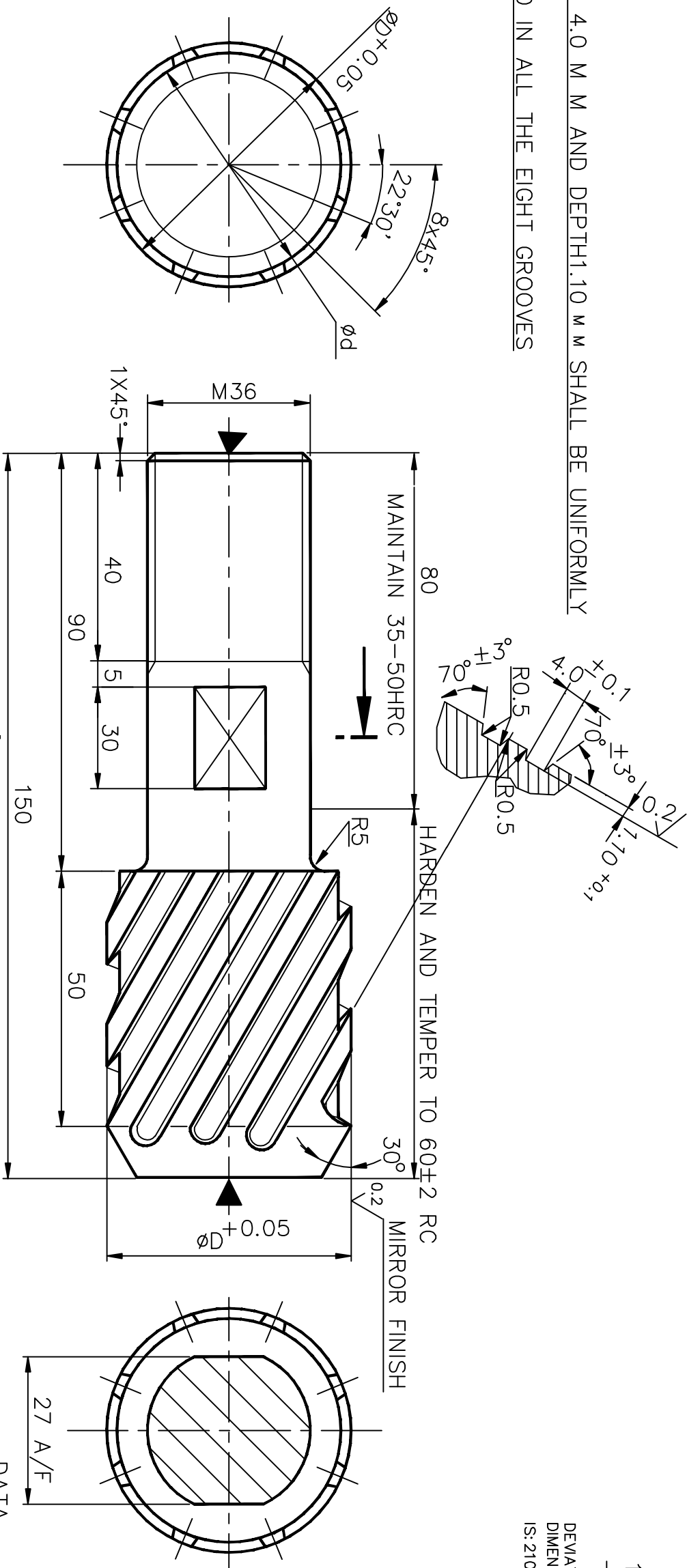
DRAWING NO.: 30. ST.221.23.443/02 SL. NO. : 01

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 / 10.2 /



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) \otimes MARK MATERIAL CODE No., FIRMS NAME, P O No.

MATERIAL: HIGH CARBON HIGH CHROMIUM COLD WORKING DIE STEEL

ANYONE OF THE FOLLOWING MATERIAL SHALL BE USED

SL No.	MATERIAL	C	Si	Mn	Cr	Mo	V	P	S
01	X215Cr12.8 IS: 3748-1990	2.0	0.10	0.25	11.0	Max.0.8	Max.0.8	Max.0.035	Max.0.035
02	X210Cr12 DIN: 1.2080	1.9	0.2	0.2	11.0	-	-	Max.0.035	Max.0.035

SL.No	D	d	LEAD	TUBE SIZE	MATERIAL CODE No.
01	47.9	45.7	259.70	63.5X7.1	69 23 99 502 7
02	39.25	37.05	212.6	63.5X11	69 23 99 507 8
03	46.78	44.58	254.41	63.5X7.6	69 23 99 510 2

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

		Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME	SIGNATURE	DATE
DEPT	TE	GRADE OF UNTO. DIM C/M/F	SCALE	WEIGHT(kg)	APPD	SKARUPPASAMY	REF TO ASSY DWG NO
001			N T S	2.35-3.60			00.ST.221.99.025
TITLE				CARD CODE	DRAWING NO :		
RIFLE PLUGS				U 01	30.ST.221.23.443		
				REV	02		