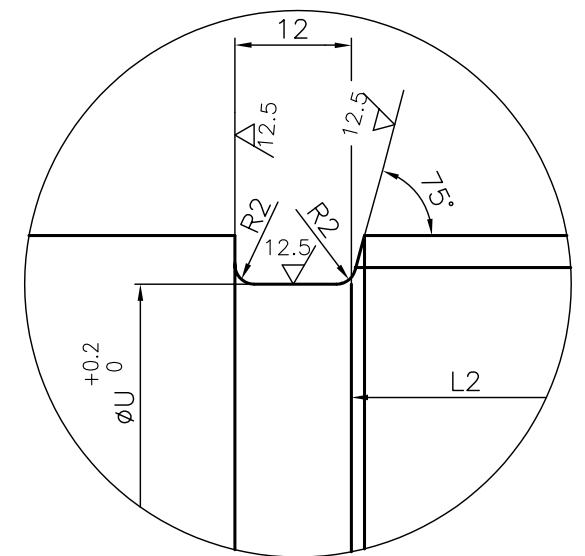
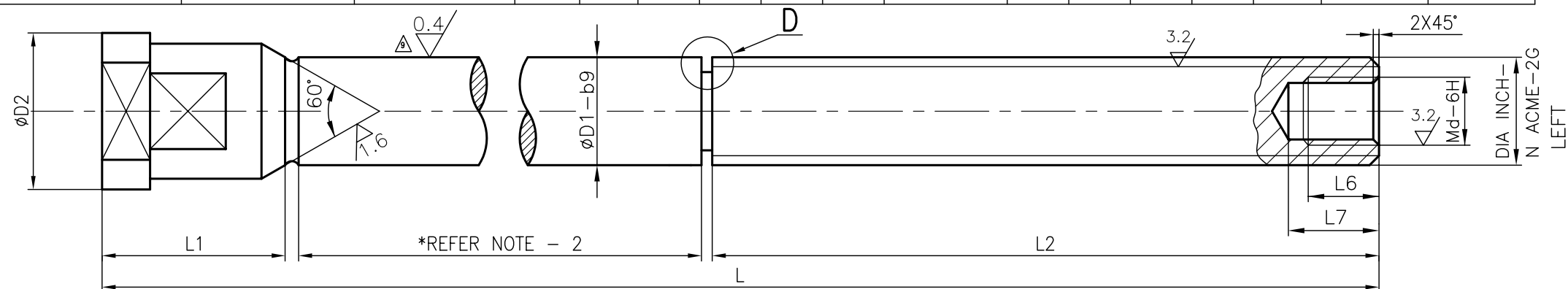


DRAWING NO. 3-A-0000-17825																	
SL. NO.	DRAWING NO.	COMP. CODE	MATL. SPECN.	ØD1 b9	ØD2	L	L1	L2	ØU	DIA INCH-N ACME 2G-LEFT	L6	L7	Md-6H	SCRAP SORT	NET WT(Kg.)	* ØD1	
																DIM.PRIOR TO PLATING	DIM.AFTER PLATING
01	3-V-N622-17825/02	931076490000	OHTARON,QT*	—	66	1110	62	490	36.2	1 3/4"-4ACME	20	27	M20	40	13.20	-0.210 -0.272 44.45	-0.180 -0.242 44.45
02	3-V-N721-17825/01	931086140000	ASTM A182 F316, SH, CERTIFY	44.45	70	1192	68.15	500	36.2	1 3/4"-4ACME	20	27	M20	46	15.25	—	—
03	3-V-N722-17825/01	931086150000	ASTM A182 F316, SH, CERTIFY	47.625	73	1345	75	585	39.4	1 7/8"-4ACME	20	27	M20	46	19.4	—	—
04	3-V-N738-17825/01	931088260000	ASTM A182 F6a- CL.3, NT, CERTIFY	57.15	90	1800	94	820	46.6	2 1/4"-3ACME	20	27	M20	40	39.4	—	—
05	3-V-N591-17825/01	931091570000	ASTM A276-410, HT, CERTIFY	57.15	90	1700	94	720	46.6	2 1/4"-3ACME	20	27	M20	40	37.0	—	—
06	3-V-N750-17825/01	931091580000		57.15	90	1800	94	820	46.6	2 1/4"-3ACME	20	27	M20	40	39.4	—	—
07	3-V-K966-17825/01	931091960000	ASTM A182 F316 SH, CERTIFY	57.15	90	1800	94	820	46.6	2 1/4"-3ACME	20	27	M20	46	39.4	—	—
08	3-V-E463-17825/01	931092580000	ASTM A182 F6a CL.3 NT, CERTIFY	47.625	73	2315	75	600	39.4	1 7/8"-4ACME	20	27	M20	40	32.6	—	—
09	3-V-N829-17825/02	931095660000	OHTARON, QT*	—	90	1700	94	720	46.6	2 1/4"-3ACME	20	27	M20	40	37.0	-0.220 -0.294 57.15	-0.190 -0.264 57.15
10	3-V-NA58-17825	931301530000	ASTM A182 F316, SH, CERTIFY	44.45	66	1070	62	450	36.2	1 3/4"-4ACME	20	27	M20	46	13.2	—	—
11	3-V-NA70-17825	931302850000	ASTM A182 F6a CL.3 NT, CERTIFY	47.625	73	1390	75	630	39.4	1 7/8"-4ACME	20	27	M20	40	20.1	—	—
12	3-V-NE60-17825	932010520000	OHTARON, QT*	—	90	1800	94	820	46.6	2 1/4"-3ACME	20	27	M20	40	39.4	-0.220 -0.294 57.15	-0.190 -0.264 57.15



DETAIL-D

ø40-ø50 b9	-0.180
	-0.242
ø50-ø80 b9	-0.190
	-0.264

NOTES:—

1. HARDNESS 250 TO 300BHN FOR A182-F6a cl.3
HARDNESS 240 TO 320BHN FOR OHTARON.

* 2. CHROME PLATING TO 0.03mm FOR OHTARON MATERIAL ONLY.

REV	DATE	ALTERED M.SRINIVASAN
12	14.03.07	CHD & APPD P.BOOMINATHAN

SL. No.12 INCLUDED.

REV	DATE	ALTERED VB	REV	DATE	ALTERED VB	REV	DATE	ALTERED VB
11	07.07.04	CHD & APPD MRK	10	20.02.04	CHD & APPD MRK	09	01.08.03	CHD & APPD MRK



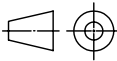
SL. No.11 INCLUDED.

SL. No.10 INCLUDED.

SURFACE FINISH $\frac{0.4}{\nabla}$ WAS $\frac{0.8}{\nabla}$

DCP. No.800219

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NO OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT									
<div></div> <div>BHARAT HEAVY ELECTRICALS LTD, UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI _620014.</div> <div>365-121</div>					DRN	NAME V.BAIRAVAN	SIGN	DATE 01.08.03	NO.OF VAR.
					CHD	R.L.NARAYANAN		01.08.03	—
					APPD	M.RAJAKUMAR		01.08.03	
DEPT VL			SCALE	WEIGHT (KG).	REFERENCE INFORMATIONS 3V017825				NO. OF ITEMS
CODE 320			NTS.	REF. TABLE					—
TITLE				CARD CODE	DRAWING NO.				REV
STEM				U 01	3-V-0000-17825				12