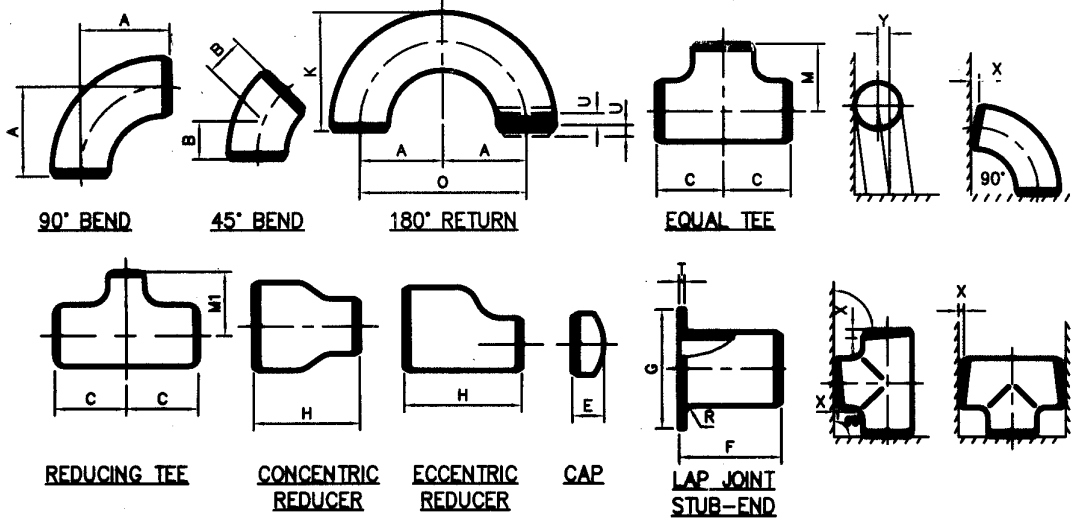


CAUTION: The information on this document is the property of BHARAT HEAVY ELECTRICALS LTD. It must not be used directly or indirectly in any way detrimental to the interest of the company.

REV	DATE	ALTERED
01	05.02.05	APPROVED <i>[Signature]</i> APMK
TITLE BLOCK AND DRAWING ALTERED		

(REFERENCE : IBR ,REG.NO 361(A) INCLUDED
IN AMENDMENT)



ALL FITTINGS				90°&45° ELBOWS AND TEES	REDUCER	180° RETURNS			CAPS	LAP-JOINT		STUB END	
DN.	O.D AT BEVEL	I.D AT END	WALL THICK NESS	CENTER TO END A,B,C,M,M1	OVERALL LENGTH H	CENTER TO CENTER O	BACK TO FACE K	ALIGN- MENT OF END U	OVER ALL LENGTH E	END TO END F	RADIUS R	DIA OF LAP G	THICKNESS OF LAP
15 TO 65	+1.6 -0.8	±0.8	NOT LESS THAN 87 1/2% OF NOMINAL THICKNESS	±1.6	±1.6	±6.4	±6.4	±0.8	±3.2	±1.6	+ 0 -0.8	+ 0 -0.8	+1.6 - 0
80 TO 90	±1.6	±1.6		±1.6	±1.6	±6.4	±6.4	±0.8	±3.2	±1.6	+ 0 -0.8	+ 0 -0.8	+1.6 - 0
100	±1.6	±1.6		±1.6	±1.6	±6.4	±6.4	±0.8	±3.2	±1.6	+ 0 -0.8	+ 0 -0.8	+1.6 - 0
125 TO 200	+2.4 -1.6	±1.6		±1.6	±1.6	±6.4	±6.4	±0.8	±6.4	±1.6	+ 0 -0.8	+ 0 -0.8	+1.6 - 0
250 TO 400	+4.0 -3.2	±3.2		±2.4	±2.4	±9.5	±6.4	±1.6	±6.4	±2.4	+ 0 -1.6	+ 0 -1.6	+1.6 - 0
500 & ABOVE	+6.4 -4.8	±4.8		±2.4	±2.4	±9.5	±6.4	±1.6	±6.4	±2.4	+ 0 -1.6	+ 0 -1.6	+1.6 - 0

OFF-SQUARE TOLERANCES		
NOMINAL SIZE OF FITTING	OFF SQUARE TOLERANCE, X	OFF SQUARE TOLERANCE, Y
UP TO AND INCLUDING 100	0.8	1.6
125 TO 150	1.2	2.4
200 TO 550	1.6	3.2
600 & ABOVE	3.2	6.4

NOTES : 1. ALL DIMENSIONS ARE IN MILLIMETRES

STANDARD

		BHARAT HEAVY ELECTRICALS LIMITED PIPING CENTRE CHENNAI 600 017		DRN	NAME ENGG.ENTERPRISES	SIGN Sd	DATE 15.10.1986	NO.OF VAR
				CHD	R.ANANTH	Sd	15.10.1986	
				APPD	J.JUDE	Sd	15.10.1986	
DEPT	GRADE OF UNTOLD DIM		SCALE	WEIGHT (KG).	REF. TO ASSY./OLD DRG.		ITEM NO.	NO. OF ITEMS
CODE	C / M / F		N.T.S	-	-		-	
TITLE TOLERANCES ON FITTINGS				CARD CODE U 01	DRAWING NO. 4-80-301-26192			REV 01