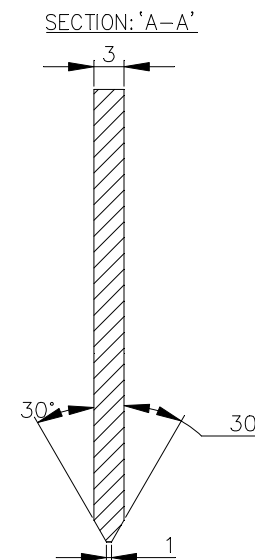


FORM DG38(B)

3.2/ THE REST



 MARK
 DRAWING NUMBER
 TYPE OF PRODUCT
 COMP. DRG. NO.

1- SHARP EDGES TO BE ROUNDED OFF.
2- TO BE CONSERVED AS PER TL-30007

					T90Mn6Cr2				
					HW10892				
ITEM No.	DESCRIPTION	STD	DRAWING No.		MATERIAL CODE	A	UNIT		UNIT WEIGHT
				VAR.	MATERIAL SPECN.	C			QTY.

GMS No./GR.SP.No.			STATUS OF DRG.	TYPE OF PRODUCT CHINTALPUDI HYDRO-MOTOR (17.8MW)	COMP. DRG. No. 02540137601-00	M/C TOOL TRANS No.	REF. DRG. No. BHOPAL DRG. NO. SK-1270/1553151
AGREED DEPT.	NAME	SIGN.	DATE		DESIGN ORDER No. HGM/17.8/0018	M/C MODEL No.	
E.M.T	AEMTUK	Sd/-	25.02.17				

GRADE OF UNTOL. DIM.: -
M/CG- C /M/F AA0230208
WELDING-A/ B / C / D AA0621104
GAS CUTTING-'T3' AA0621101

सी. रमच. ई. रल.
BH'EL

BHARAT HEAVY ELECTRICALS LTD
HARDWAR

	NAME	SIGN.	DATE	No. OF VAR
DRN	DEEPAK	Sd/—	23.12.16	
CHD	SJTEAR	Sd/—	09.02.17	
APD	AJTFGK	Sd/—	27.02.17	

REV	DATE	ALTERED	REV	DATE	ALTERED	REV	DATE	ALTERED	DEPT. JTE		SCALE	WEIGHT(Kg)	REF.TO ASSY. DRG.	ITEM No.
		CHECKED			CHECKED			CHECKED	CODE 209		N.T.S	0.22		No.

TITLE FULL FORM PROFILE GAUGE		DRAWING No. R8138-0883		RE
		SHEET No. 01	No. OF SHEETS 01	

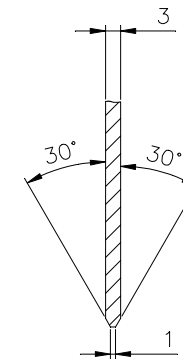
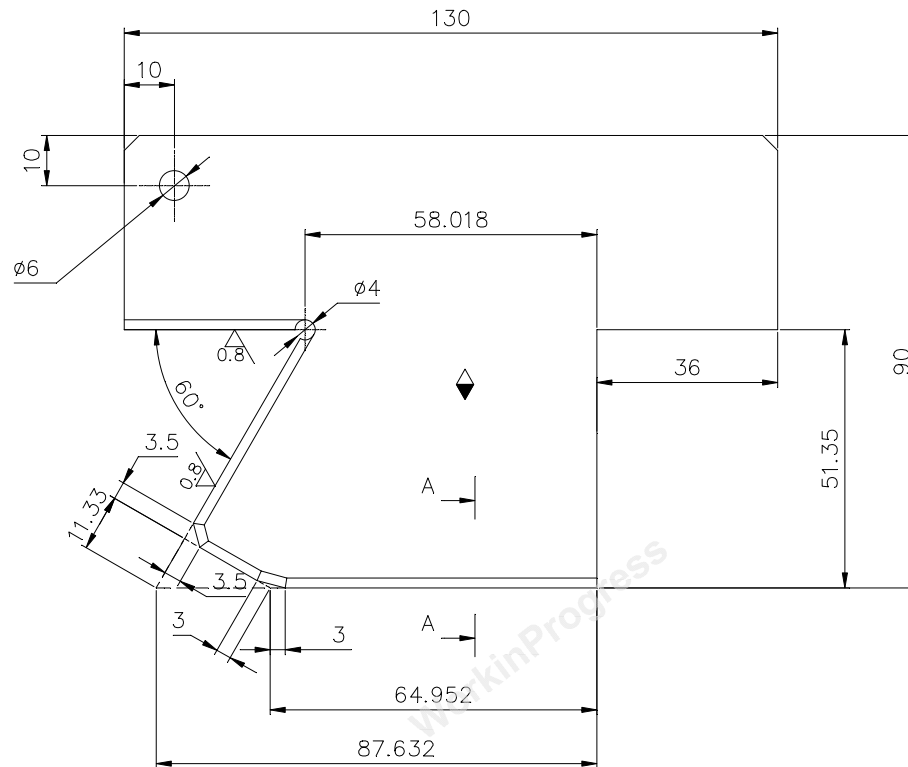
SIZE A 3

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

FORM DG38(B)

DRAWING No. R8138-0884

3.2/
THE REST

MARK

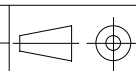
DRAWING NUMBER
TYPE OF PRODUCT
COMP. DRG. NO.

NOTES: -

- 1-SHARP EDGES TO BE ROUNDED OFF..
2-CONSERVATION TO BE DONE AS PER TL-30007.

					T90Mn6WCr2				
					HW10892				
ITEM No.	DESCRIPTION	STD	DRAWING No.		MATERIAL CODE	A	UNIT	UNIT WEIGHT	QTY.
				VAR.	MATERIAL SPECN.	C			

GMS No./GR.SP.No.				STATUS OF DRG.	TYPE OF PRODUCT CHINTALPUDI HYDRO-MOTOR (17.8MW)		COMP. DRG. No. 02540137601-00 DESIGN ORDER No. HGM/17.8/0016		M/C TOOL TRANS No.		REF. DRG. No. BHOPAL DRG. No. SK-1270/1553281		
AGREED DEPT.	NAME	SIGN.	DATE										
E.M.T	AEMTUK	Sd/-	23.01.17										

DEPT. JTE
CODE 209SCALE
N.T.SWEIGHT(Kg)
0.20

REF.TO ASSY. DRG.

ITEM No. OF
No. ITEMSTITLE
HALF FORM DOVETAIL GAUGE (R.H.)DRAWING No.
R8138-0884

REV.

SHEET No. 01 | No. OF SHEETS 01

SIZE A 3

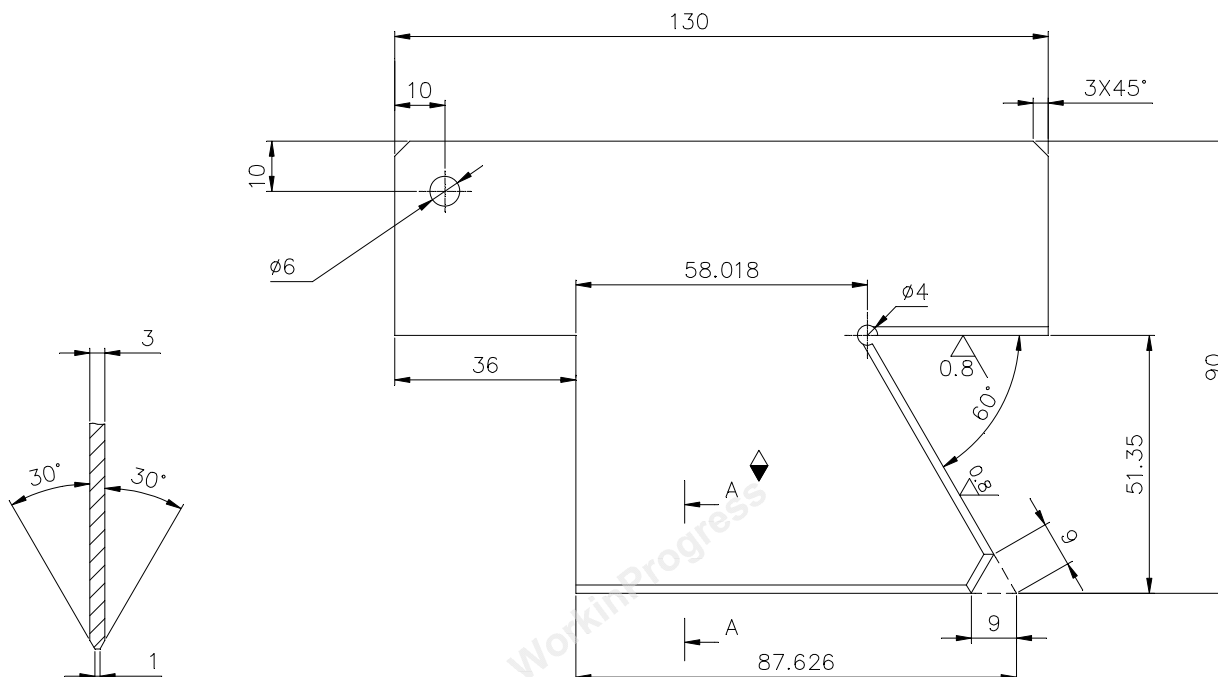
FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

FORM DG38(B)

DRAWING No. R8138-0885

3.2/ THE REST



	MARK _____
	DRAWING NUMBER _____
	TYPE OF PRODUCT _____
COMP. DRG. NO. _____	

NOTES: —

- 1-SHARP EDGES TO BE ROUNDED OFF..
2-CONSERVATION TO BE DONE AS PER TL-30007.

				T90Mn6WCr2			
				HW10892			
ITEM No.	DESCRIPTION	STD	DRAWING No.	MATERIAL CODE	A	UNIT	UNIT WEIGHT
			VAR.	MATERIAL SPECN.	C		QTY.

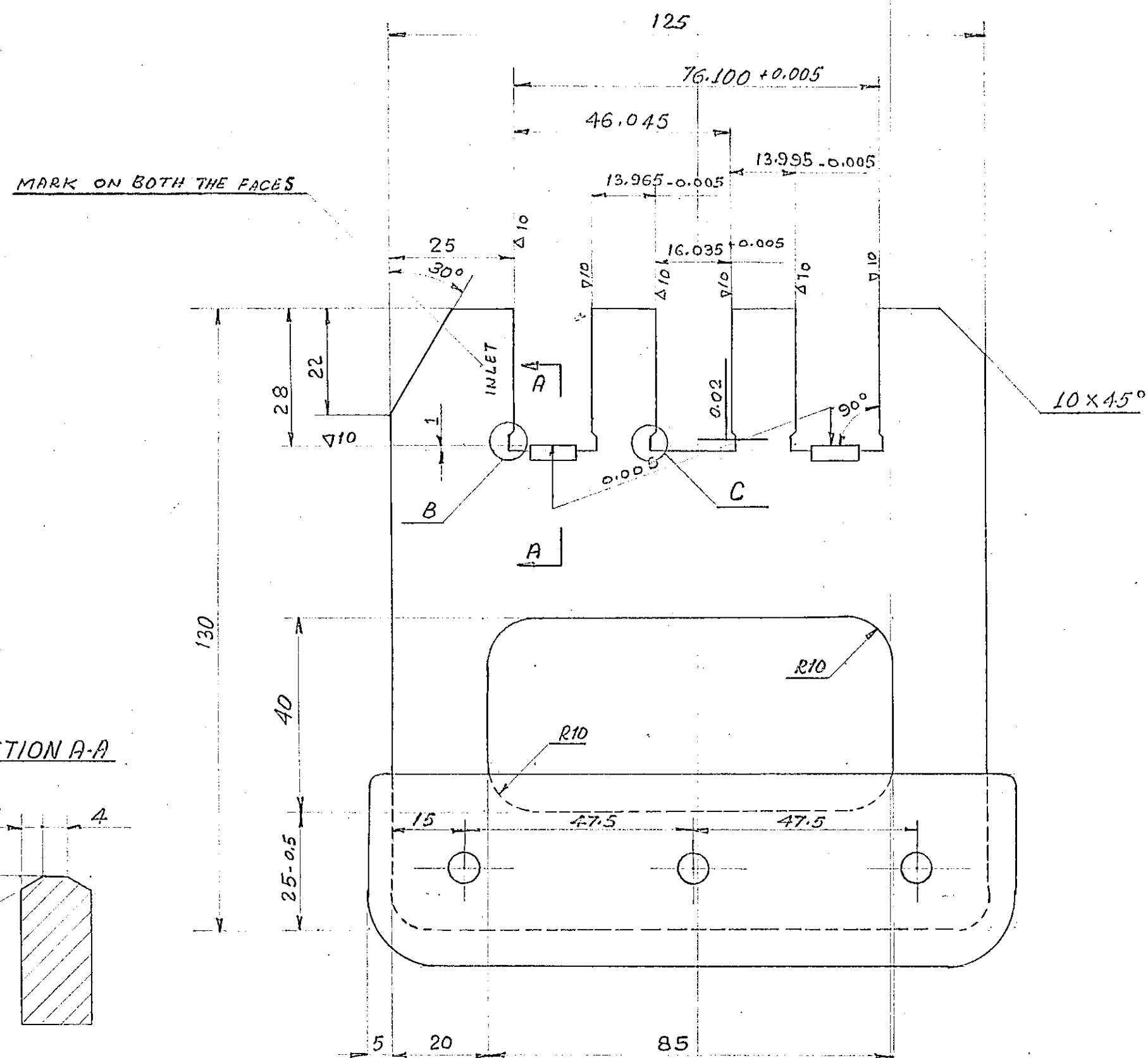
INVENTORY No.	REV	DATE	ALTERED CHECKED	REV	DATE	ALTERED CHECKED	REV	DATE	ALTERED CHECKED	GMS No./GR.SP.No.				STATUS OF DRG.		TYPE OF PRODUCT CHINTALPUDI HYDRO-MOTOR (17.8MW)		COMP. DRG. No. 02540137601-00		M/C TOOL TRANS No.		REF. DRG. No. BHOPAL DRG. No. SK-1270/1553282	
										AGREED DEPT.	NAME	SIGN.	DATE	DESIGN ORDER No. HGM/17.8/0017		M/C MODEL No.							
										E.M.T	AEMTUK	Sd/-	23.01.17										
										GRADE OF UNTOL. DIM.: -													
										M/CG-Ø/M/F AA0230208													
WELDING-A/B/C/D AA0621104																							
GAS CUTTING-'T3' AA0621101																							

SIZE A 3

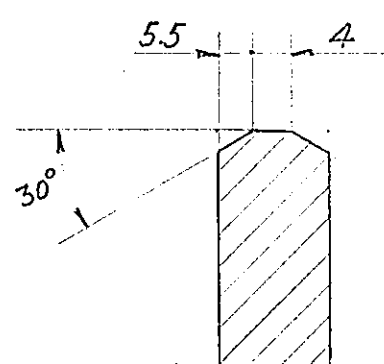
1106-69382

FIRST ANGLE PROJECTION

V6 THE REST

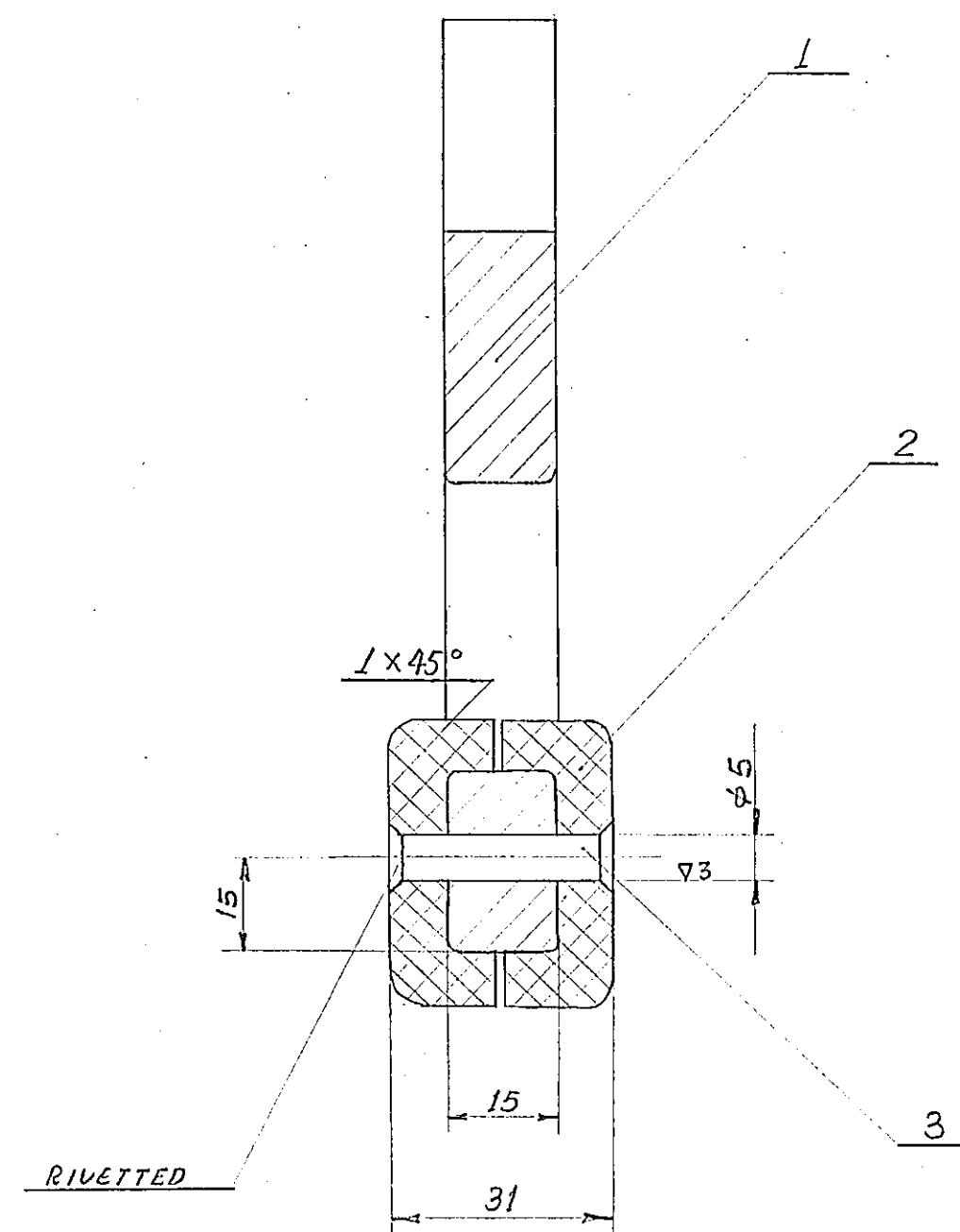
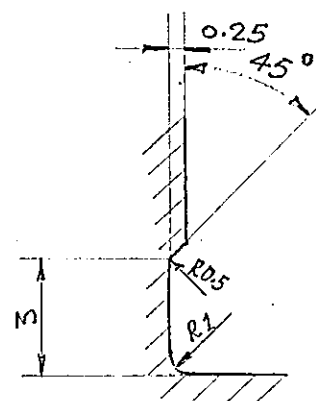


SECTION A-A



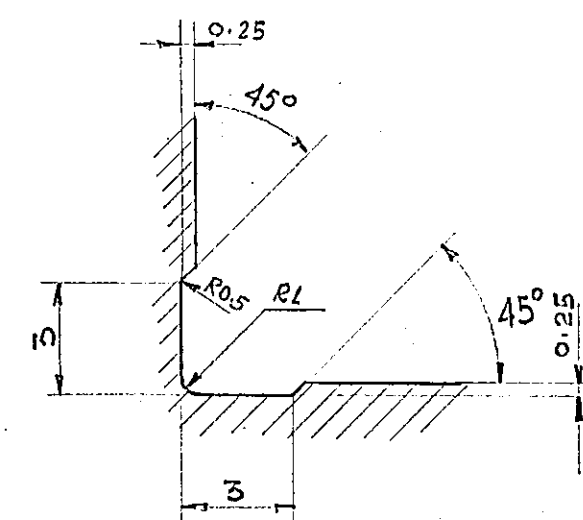
DETAIL 'C'

SCALE 5:1



DETAIL 'B'

SCALE 5:1



MARK
R8369-9011
PROFILE NO 551
24TH & 28TH STAGE

ALLOWED WORN OUT SIZE ON FOLLOWING DIMENSIONS ARE

1. DIMENSION 16.035 ± 0.005 TO 16.045 AND DIMENSION 13.965 ± 0.005 TO 13.955 AND DIMENSION 13.995 ± 0.005 TO 13.985 AND DIMENSION 46.045 ± 0.005 TO 46.055 AND DIMENSION 76.100 ± 0.005 TO 76.110

2. HARDEN TO HRC=58±62

3. WORKING SURFACE EDGES ARE TO BE LAPPED WITH OIL STONE

4. NON WORKING EDGES ARE TO BE ROUNDED OFF R0.5

3	21.8962-090	RIVET 5x35	3			M.S.	
2	R8369-9011	HANDLE	2			EBONITE	
1	-	GAUGE	1			XBT	
S.NO	ORG NO	DESCRIPTION	QTY	PERC	TOTAL	MATERIAL	REMARKS
				WEIGHT			
C-200-130							
ROOT PROFILE TEMPLATE							R8369-9011
CHG NOS	DOCU. NO	SIGN	DATE	LETTER	WEIGHT	SCALE	
WORKED	Y.D. DARGAM					1:1	
CHECKED	S.K. GUPTA						
SUPERVISED	S.K. GUPTA						
TECH. CONT	KAMRA						
S.D.E							
APPROVED	V.K. ARORA						
		32305000	32305001	SHEET 1 TOTAL SHEETS 1			
		STB/2382	776	HEEP JIG & TOOL			

U.S.S.R. DRG. NO
AM 8369-9801

SIGN AND DATE
2-4/2/13

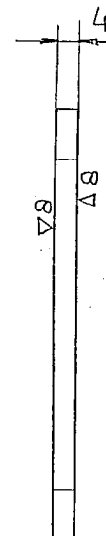
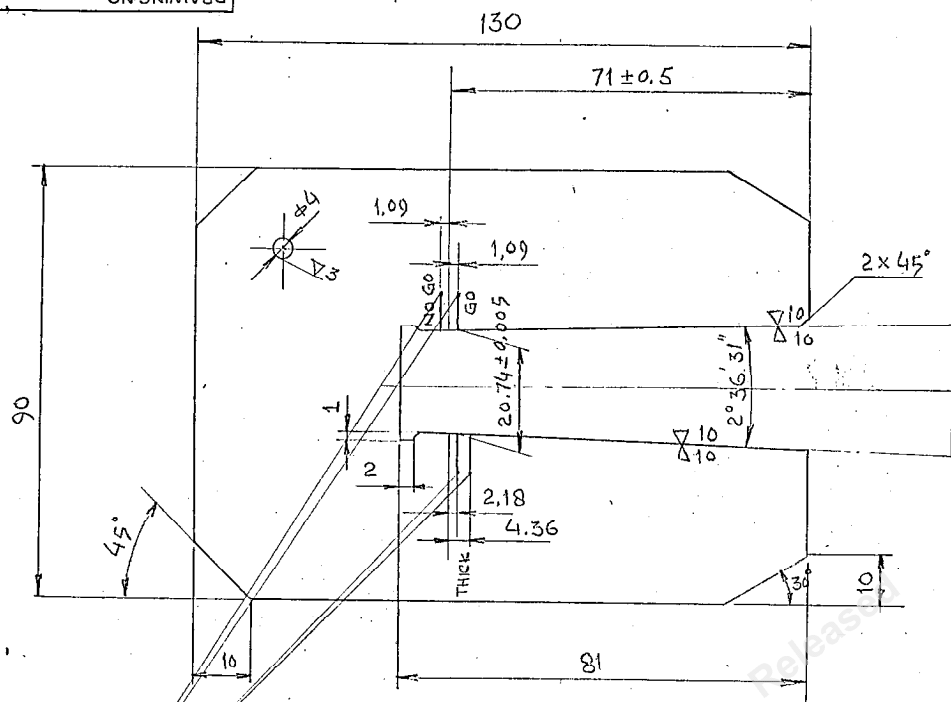
INVENTORY NO
2-4/2/13

FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

Form/DG-38

DRAWING NO.
R8371-0173

V6 THE REST



MARK
R8371-0173

ENGRAVED 4 LINES 0.1 THICK
ON EACH SIDES, MAINTAINING
ACCURACY OF ± 0.08 MARK 'GO'
& 'NO GO' & THICK
HARDENED TO HRC 56-64

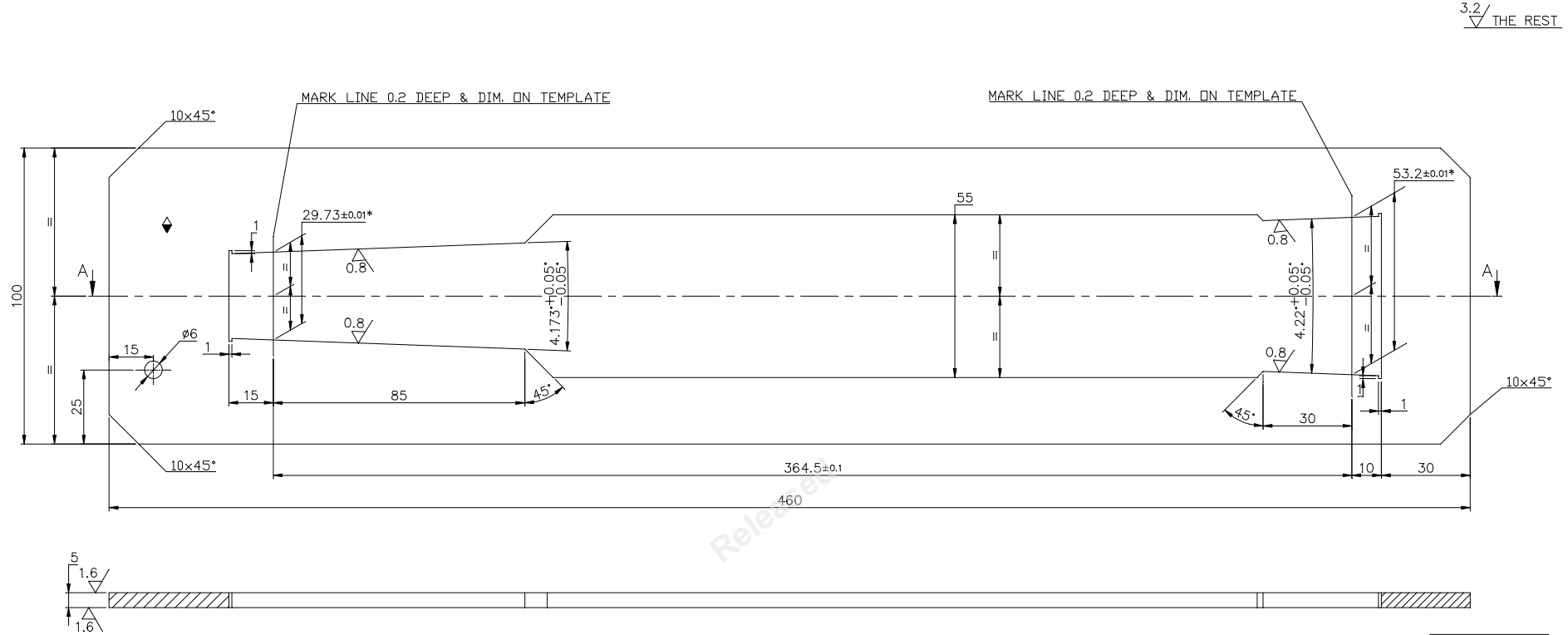
VAR. 00		REMARKS		ITEM NO.	DESCRIPTION	DRAWING NO.	MATERIAL CODE		UNIT WT. (Kg.)	
CARD TYPE-3		CARD TYPE-1		CARD TYPE-2		MATERIAL SPECN		MATERIAL SPECN		UNIT WT. (Kg.)
GMS/GR. SP. NO.		STATUS OF DRG.		TYPE OF PRODUCT		COMP DRG. NO.		MIC TOOL TRANS NO.		REF. DRG. NO.
AGREED DEPT.		NAME		SIGN.		DATE		MIC TOOL MODEL NO.		INVENTORY NO.
NAME		SIGN.		DATE		NAME OF CUSTOMER		NAME		NO. OF VAR.
DATE		ALTERED		CHECKED		DEPT.		GRADE OF UNFOLDING		SCALE
REV		DATE		ALTERED		CODE		C/M/F		WEIGHT (Kg)
TITLE		DRAWING NO.		CARD CODE		REF. TO ASSY. DRG.		ITEM NO.		NO. OF ITEMS
TEMPLATE FOR		R8371-0173		SHEET NO.		NO. OF SHEETS:-		REV.		NO. OF REV.
L 2°36'31" & 20.74 ± 0.05		R8371-0173		SHEET NO.		NO. OF SHEETS:-		REV.		NO. OF REV.

RETRACED SIZE A3

FIRST ANGLE PROJECTION (ALL DIMENSIONS IN m.m.)

FORM DG 44(B)

DRAWING No. R8371-0728



SECTION-AA

MARK

R8371-0728

NOTES: —

- 1-NON WORKING SHARP EDGES TO BE ROUNDED OFF.
- 2-HARDEN TO HRc 55±60 AS PER PS 0912-008.
- *3-MARK EXACT DIMENSION ON TEMPLATE.
- 4-CONSERVATION TO BE DONE AS PER TL 30007.

VAR.00	REMARKS	ITEM No.	DESCRIPTION	STD.	DRAWING No.	T90Mn6WCr2 HW10892	MATERIAL CODE	UNIT WEIGHT	QTY.	ZONE

GMS No./GR.SP.No.	STATUS OF DRG.	TYPE OF PRODUCT	COMP. DRG. No.	M/C TOOL TRANS No.	REF. DRG. No.
		ST 660MW	01020256017		R8371-0175

AGREED	NAME	SIGN.	DATE
TBM	ANIL	-sd-	26.12.13

GRADE OF UNTOL.DIM. : —
M/CG-~~E~~/M/E/AA0230208
WELDING-A/B/C/D-AA0621104

GAS CUTTING-'T3'AA0621101

REV.	DATE	ALTERED	CHECKED

REV.	DATE	ALTERED	CHECKED

DRN.	NAME	SIGN.	DATE	No. OF VAR.
CHD	ASHOK	-Sd-	26.12.13	
APD	RAVI	-Sd-	30.12.13	
	ANKUR	-Sd-	30.12.13	

DEPT.	SCALE	WEIGHT(Kg.)	REF. TO ASSY. DRG.	ITEM No.	No. OF ITEM
JTE	1:1	~1.18			

TITLE	DRAWING No.	REV.
RADIAL PLANE CHECKING TEMPLATE	R8371-0728	

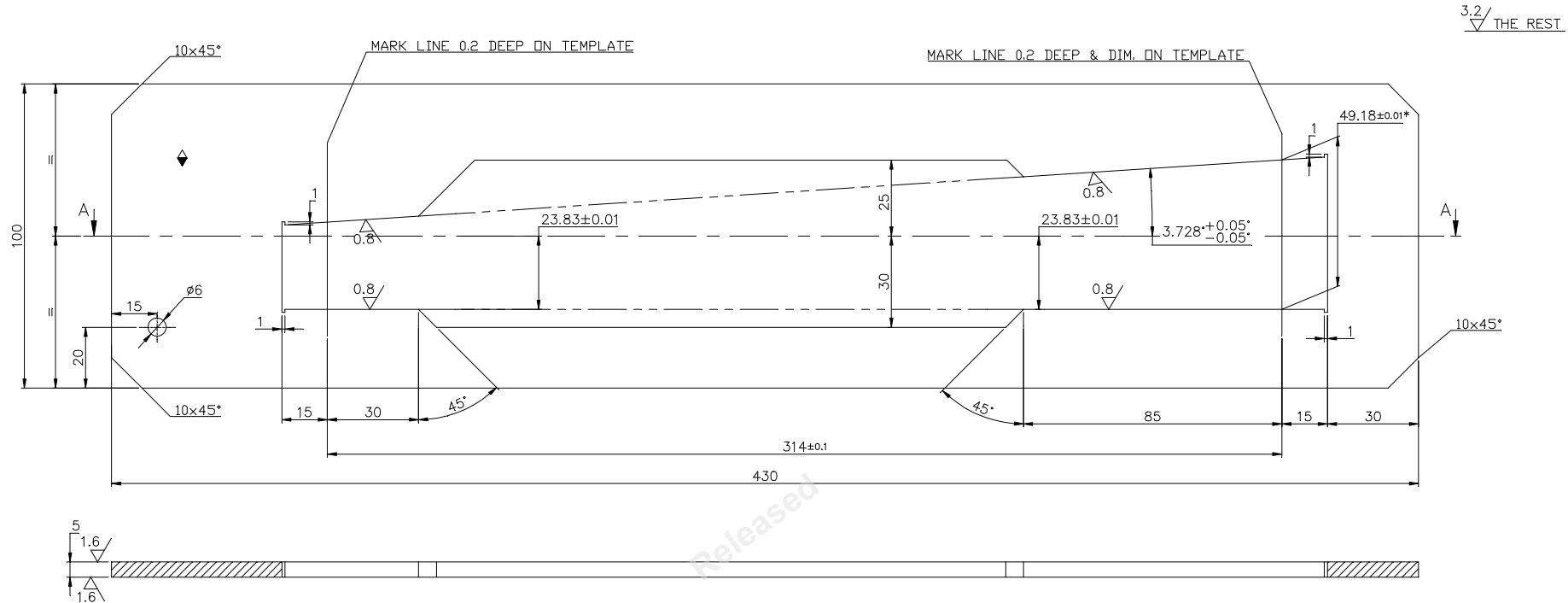
SHEET No. 01 No. OF SHEET 01

SIZE A 2

FIRST ANGLE PROJECTION (ALL DIMENSIONS IN m.m.)

FORM DG 44(B)

DRAWING No. R8371-0730



SECTION-AA

MARK

R8371-0730

NOTES:—

- 1-NON WORKING SHARP EDGES TO BE ROUNDED OFF.
- 2-HARDEN TO HRC 55±60 AS PER PS 0912-008.
- *3-MARK EXACT DIMENSION ON TEMPLATE.
- 4-CONSERVATION TO BE DONE AS PER TL 30007.

VAR.00	REMARKS	ITEM No.	DESCRIPTION	STD.	DRAWING No.	T90Mn6WCr2 HW10892	MATERIAL CODE	UNIT WEIGHT	QTY.	ZONE

GMS No./GR.SP.No.	STATUS OF DRG.	TYPE OF PRODUCT	COMP. DRG. No.	M/C TOOL TRANS No.	REF. DRG. No.
AGREED DEPT. TBM	NAME ANIL	SIGN. -sd-	DATE 28.12.13	ST 660MW	01061656016
				DESIGN ORDER No. B/RCT/660/003	MODEL No. R8371-0175

GRADE OF UNTOL.DIM. :-
M/CG-~~E~~/M/E/AA0230208
WELDING-A/B/C/D-AA0621104

GAS CUTTING-'T3'AA0621101

REV.	DATE	ALTERED	CHECKED

REV.	DATE	ALTERED	CHECKED

DEPT. JTE
CODE 209

SCALE 1:1

WEIGHT(Kg.) ~1.12

TITLE RADIAL PLANE CHECKING TEMPLATE

NAME	SIGN.	DATE	No. OF VAR.
DRN. CHD	ASHOK	-Sd-	28.12.13
APD	RAVI	-Sd-	03.01.14
	ANKUR	-Sd-	

REF. TO ASSY. DRG.	ITEM No.	No. OF ITEM

DRAWING No.	REV.
R8371-0730	

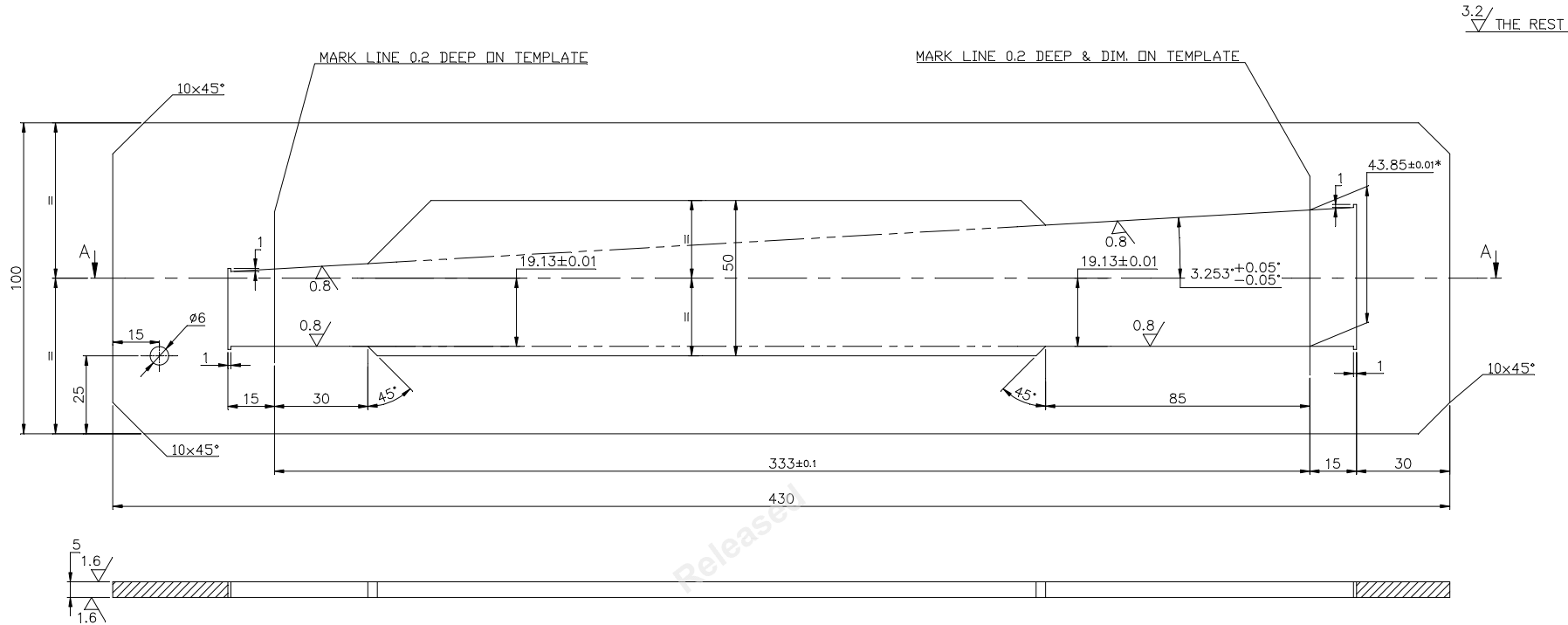
SHEET No.	No. OF SHEET	01

SIZE A 2

FIRST ANGLE PROJECTION (ALL DIMENSIONS IN m.m.)

FORM DG 44(B)

DRAWING No. R8371-0731



SECTION-AA

MARK

R8371-0731

NOTES: -

1-NON WORKING SHARP EDGES TO BE ROUNDED OFF.

2-HARDEN TO HRc 55±60 AS PER PS 0912-008.

*3-MARK EXACT DIMENSION ON TEMPLATE.

4-CONSERVATION TO BE DONE AS PER TL 30007.

VAR.00	REMARKS	ITEM No.	DESCRIPTION	STD.	DRAWING No.	T90Mn6WCr2 HW10892	MATERIAL CODE	UNIT WEIGHT	QTY.	ZONE

GMS No./GR.SP.No.	STATUS OF DRG.	TYPE OF PRODUCT	COMP. DRG. No.	M/C TOOL TRANS No.	REF. DRG. No.
AGREED DEPT. TBM	NAME ANIL	SIGN. -sd-	DATE 28.12.13	ST 660MW	01061656033
				DESIGN ORDER No. B/RCT/660/004	MODEL No. R8371-0175

GRADE OF UNTOL.DIM. :-
M/CG-~~E~~/M/E/AA0230208
WELDING-A/B/C/D-AA0621104
GAS CUTTING-'T3'AA0621101

REV. DATE ALTERED
CHECKED

REV. DATE ALTERED
CHECKED



BHARAT HEAVY ELECTRICALS LTD.
HARDWAR

NAME	SIGN.	DATE	No. OF VAR.
DRN. ASHOK	-Sd-		
CHD RAVI	-Sd-	28.12.13	
APD ANKUR	-Sd-	03.01.14	

DEPT. JTE

CODE 209



SCALE 1:1

WEIGHT(Kg.) ~1.09

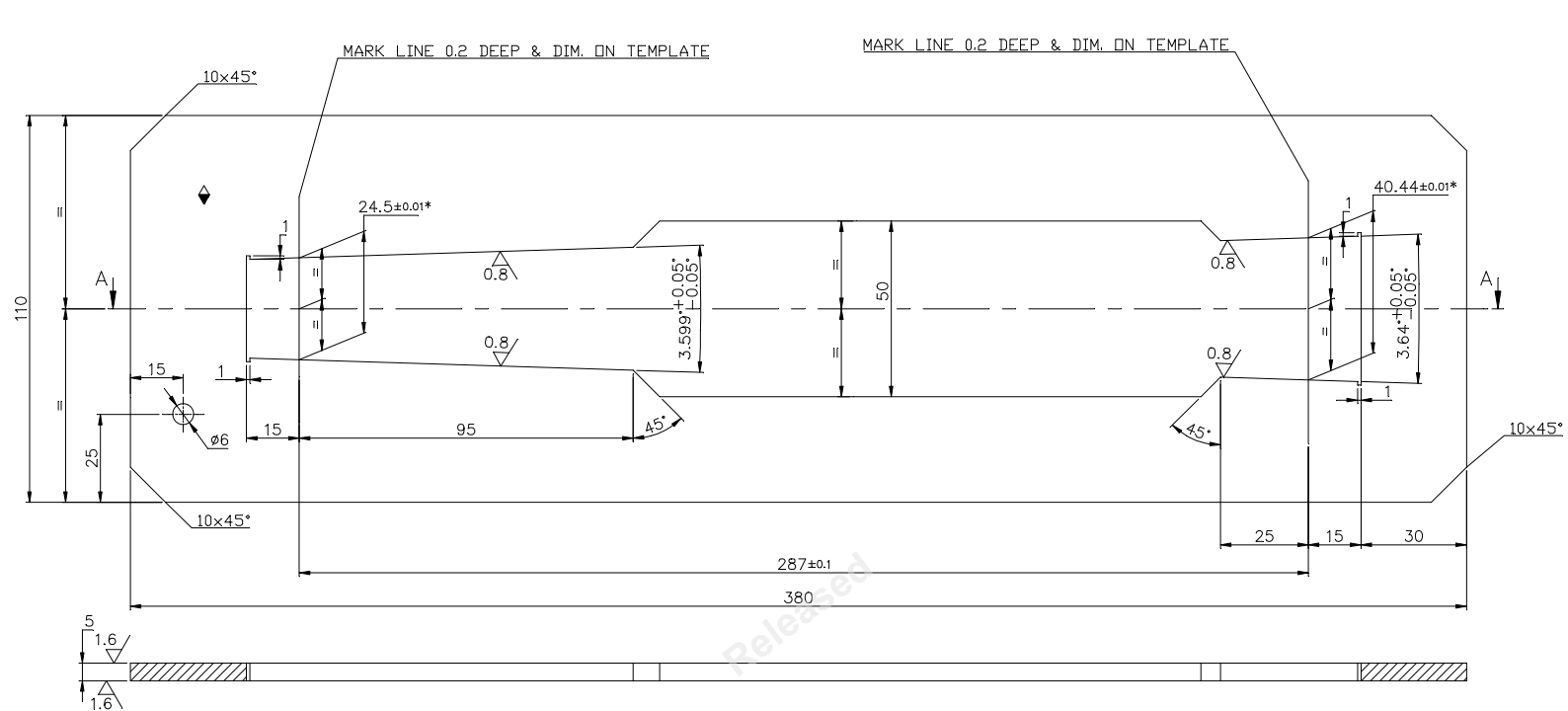
REF. TO ASSY. DRG. ITEM No.

TITLE RADIAL PLANE CHECKING
TEMPLATE

DRAWING No. R8371-0731
SHEET No. 01 No. OF SHEET 01

SIZE A 2

DRAWING No. R8371-0732



SECTION-AA

MARK

R8371-0732

NOTES: —

- 1-NON WORKING SHARP EDGES TO BE ROUNDED OFF.
2-HARDEN TO HRc 55±60 AS PER PS 0912-008.
*3-MARK EXACT DIMENSION ON TEMPLATE.
4-CONSERVATION TO BE DONE AS PER TL 30007.

[illegible]

GMS No./GR.SP.No.			STATUS OF DRG.	TYPE OF PRODUCT	COMP. DRG. No.	M/C TOOL TRANS No.	REF. DRG. No.
AGREED DEPT.	NAME	SIGN.	DATE	250MW	DESIGN ORDER No.	MODEL No.	R8371-0175
01/01/14	ANIL		01/01/14		B / RCT / 250 / 001		

GRADE OF UNTOL.DIM. :-
M/CG- C /M/F/AA0230208
WELDING-A/B/C/D-AA0621104

GAS CUTTING-'T3'AA0621101		
REV.	DATE	ALTERED
		CHECKED

		STATE

	BHARAT HEAVY ELECTRICALS LTD. HARDWAR	DRN.	NAME	SIGN.	DATE	No. OF VAP
		CHD	ASHOK	-Sd-		
		APD	RAVI	-Sd-	01.01.14	
		APD	ANKUR	-Sd-	06.01.14	

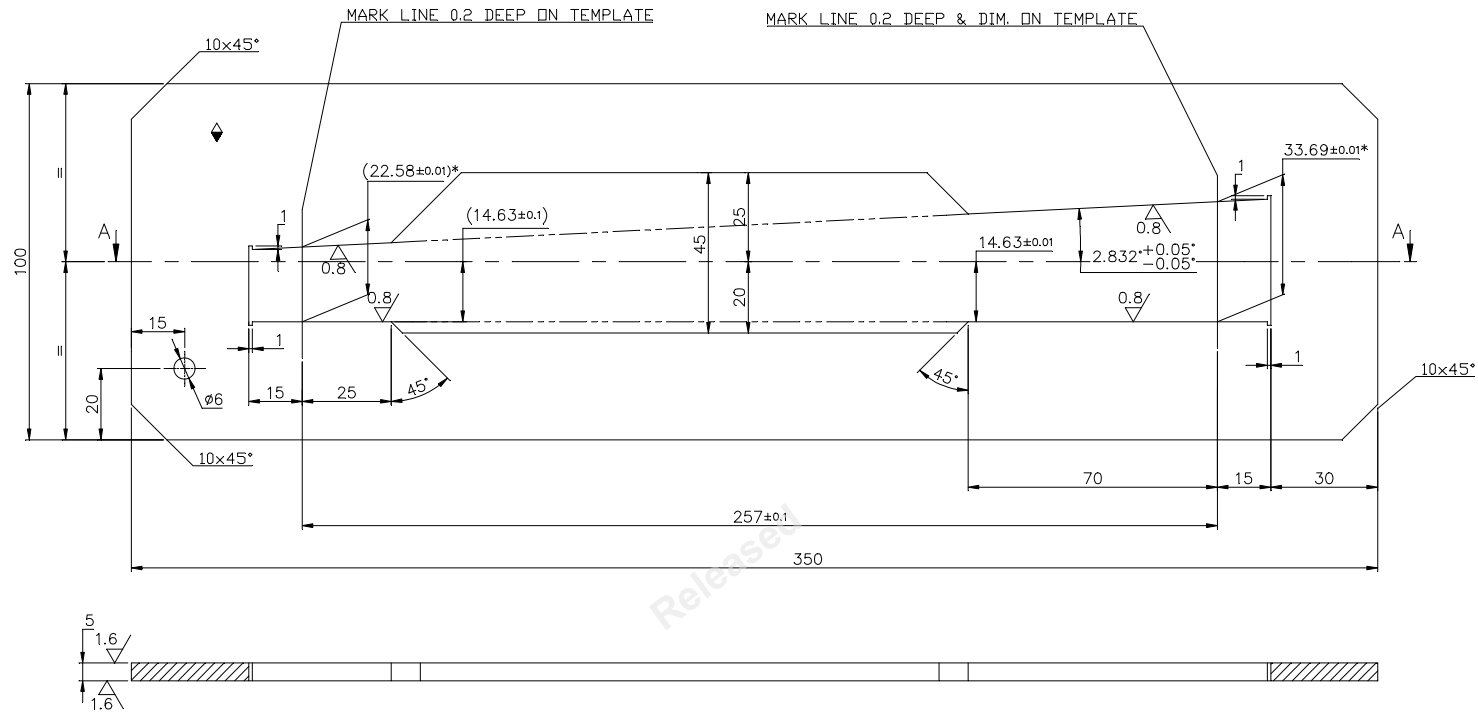
DEPT. JTE		SCALE	WEIGHT(Kg.)	REF. TO ASSY. DRG.	ITEM No.	No. OF ITEM
CODE 209		NTS	~1.09			

TITLE	RADIAL PLANE CHECKING TEMPLATE	DRAWING No.	REV
		R8371-0732	
		SHEET No. 01	No. OF SHEET 01

FIRST ANGLE PROJECTION (ALL DIMENSIONS IN m.m.)

FORM DG 44(B)

DRAWING No. R8371-0733

3.2/
THE REST

SECTION-AA

MARK

R8371-0733

NOTES: —

1-NON WORKING SHARP EDGES TO BE ROUNDED OFF.

2-HARDEN TO HRc 55±60 AS PER PS 0912-008.

*3-MARK EXACT DIMENSION ON TEMPLATE.

4-CONSERVATION TO BE DONE AS PER TL 30007.

VAR.00	REMARKS	ITEM No.	DESCRIPTION	STD.	DRAWING No.	T90Mn6WCr2 HW10892	MATERIAL CODE	UNIT WEIGHT	QTY.	ZONE

GMS No./GR.SP.No.	STATUS OF DRG.	TYPE OF PRODUCT	COMP. DRG. No.	M/C TOOL TRANS No.	REF. DRG. No.
250MW			01061646011		R8371-0175
DESIGN ORDER No.	MODEL No.				
B/RCT/250/002					

GRADE OF UNTOL.DIM. :-
M/CG- E /M/E/AA0230208
WELDING-A/B/C/D-AA0621104
GAS CUTTING-'T3'AA0621101

REV.	DATE	ALTERED	CHECKED

REV.	DATE	ALTERED	CHECKED

DEPT.	JTE

CODE	209

TITLE RADIAL PLANE CHECKING
TEMPLATE

NAME	SIGN.	DATE	No. OF VAR.
ASHOK	-Sd-		
RAVI	-Sd-	01.01.14	
ANKUR	-Sd-	06.01.14	

REF. TO ASSY. DRG.	ITEM No.	No. OF ITEM

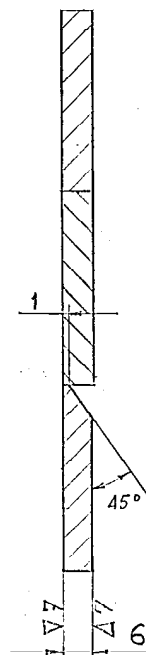
DRAWING No.	R8371-0733	REV.

SHEET No.	01	No. OF SHEET	01

SIZE A 2

Δ6 THE REST

MARK TWO LINES ON BOTH SIDES
OF THE TEMPLATE & MARK GO & NO GO



2 SHARP EDGES TO BE ROUNDED OFF

[illegible]

DRAWN/TRACED

SIZE 12

FIRST ANGLE PROJECTION

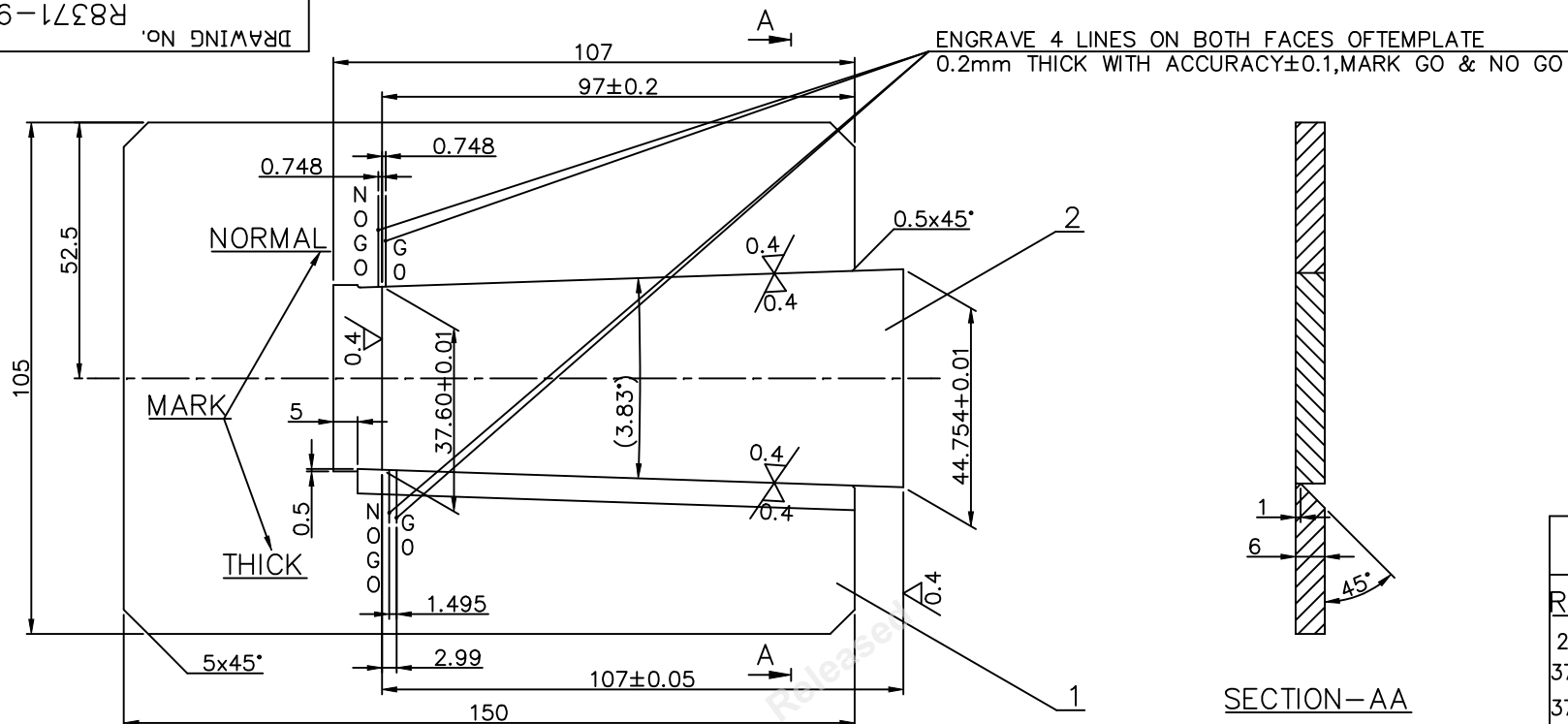
(ALL DIMENSIONS ARE IN mm)

FORM DG38(B)

R8371-9515

DRAWING NO.

1.6/△ THE REST



SECTION-AA

MARK

R8371-9515

27th&31th STAGE

37.60 $^{+0.05}_{-0.05}$ NORMAL

37.60 $\pm_{-0.2}^{+0.1}$ THICK

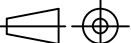
NOTES: -

1-SHARP EDGES TO BE ROUNDED OFF.

2-HARDEN TO HRc. 55-60 AS PER P.S. 0912.008.

3-CONSERVATION IS TO BE DONE AS PER TL 30007.

		2	COUNTER TEMPLATE		—		T90Mn6WCr2			0.21
							HW10892			1
		1	TEMPLATE		—		T90Mn6WCr2			0.52
							HW10892			1
VAR.00	REMARKS	ITEM No.	DESCRIPTION	STD	DRAWING No.		MATERIAL CODE	A	UNIT	UNIT WEIGHT
						VAR.	MATERIAL SPECN.	C		QTY.

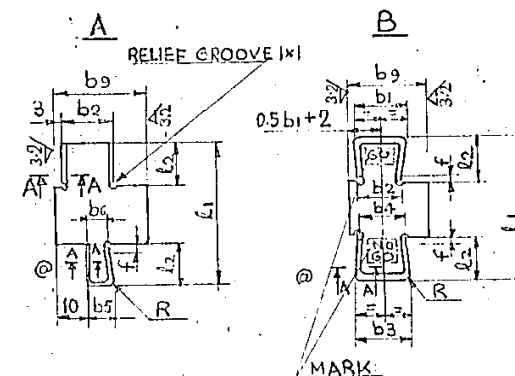
GMS No./GR.SP.No.				STATUS OF DRG.		TYPE OF PRODUCT		COMP. DRG. No. 32305004,32305008		M/C TOOL TRANS No.		REF. DRG. No.													
AGREED DEPT.		NAME		SIGN.		DATE		210MW		DESIGN ORDER No. STB-2171		M/C MODEL No.		R8371-9509											
GRADE OF UNTOL. DIM.: -						भारत भारती BHEL BHARAT HEAVY ELECTRICALS LTD. HARDWAR								NAME		SIGN.		DATE		No. OF					
M/CG- C /M/F AA0230208												DRN		G.SHYAM		-Sd-		25.07.14		VAR.					
WELDING- A/B/C/D AA0621104												CHD		RAVI		-Sd-		25.07.14							
GAS CUTTING-'T3' AA0621101												APD		ANKUR		-Sd-		25.07.14							
REV		DATE		ALTERED		REV		DATE		ALTERED		DEPT. JTE				SCALE		WEIGHT(Kg)		REF.TO ASSY. DRG.		ITEM No. OF			
				CHECKED						CHECKED		CODE 209				1:1		0.73				No. OF			
												TITLE						DRAWING No.		REV					
												RADIAL TEMPLATE						R8371-9515							
																		SHEET No. 01						No. OF SHEETS 01	

SIZE A 3

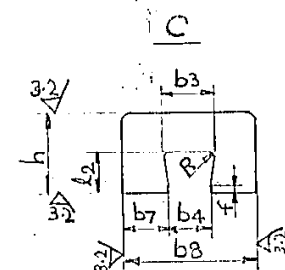
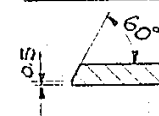
DRAWING NO. R8372.0038 ÷ 0050

^{0.4}✓ALLOVER EXCEPT OTHERWISE STATED

KUN 662-10 BL. WT. GROOVE NO	DRG. NO.	b1 H7	b2 H7	b3 H7	b4 H7	b5 H7	b6 H7	b7	b8	b9	F	h	l	l2 ±0.05	R
8	R8372-0038	8 +0.015	5.6 +0.012	8.05 +0.015	5.65 +0.012	4 +0.012	2.8 +0.010	22	50	18	1	35	35	7	1
10	-0039	10 +0.015	6.8 +0.015	10.05 +0.018	6.85 +0.015	5 +0.012	3.4 +0.012	21						9	
12	-0040	12 +0.018	8.4 +0.015	12.05 +0.018	8.45 +0.016	6 +0.012	4.2 +0.012	26	60	20		46	40	10	
15	-0041	15 +0.018	11 +0.018	15.05 +0.018	11.05 +0.018	7.5 +0.015	5.5 +0.012	25					45	11	
21	-0042	21 +0.021	16.2 +0.018	21.05 +0.021	16.25 +0.018	10.5 +0.018	8.1 0.015	26	70	30		50		14	
36	-0043	26 +0.021	21.2 +0.021	26.05 +0.021	21.25 +0.021	13 0.018	10.6 +0.018	28					50		
31	-0044	31 +0.025	25 +0.021	31.05 +0.025	25.06 +0.021	15.5 +0.018	12.5 +0.018	27		38			65	17	
36	-0045	36 +0.025	30 +0.021	36.05 +0.025	30.05 +0.025	18 +0.018	15 +0.018	25	80	43		65	70		2
41	-0046	41 +0.025	33.8 +0.025	41.05 +0.025	33.85 +0.025	20.5 +0.021	16.9 +0.018	24		50	2		85	20	
46	-0047	46 +0.025	35.6 +0.025	46.05 +0.025	35.65 +0.025	23 +0.021	17.8 +0.018	27		55		70		23	
51	-0048	51 +0.030	41.4 +0.025	51.05 +0.030	41.45 +0.025	25.5 +0.021	20.7 +0.021	24	90				90	26	
60	-0049	60 +0.030	49.2 +0.025	60.05 +0.030	49.25 +0.025	30 +0.021	24.6 +0.021	20		65				29	
70	-0050	70 +0.030	58 +0.030	70.05 +0.030	58.05 +0.030	35 +0.025	29 +0.021	21	100	75		80		32	



SECTION A-A



A - HALF PROFILE TEMPLATE FOR MACHINING OF GROOVE

B - GO/NO GO GAUGE FOR BALANCING WT. GROOVE

C - TOOL CHECKING TEMPLATE

NOTE:-

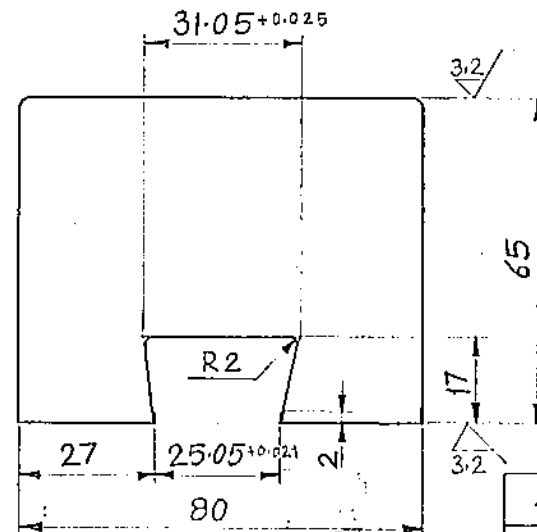
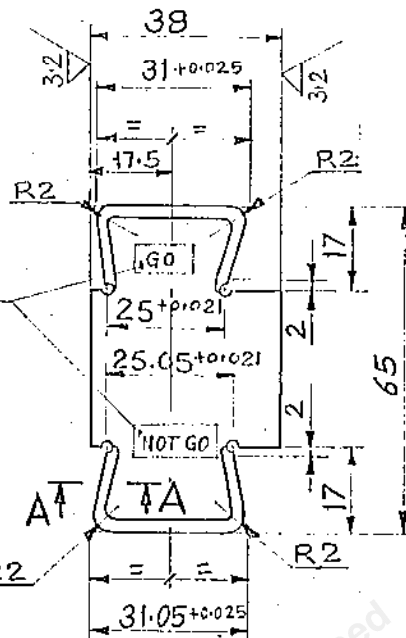
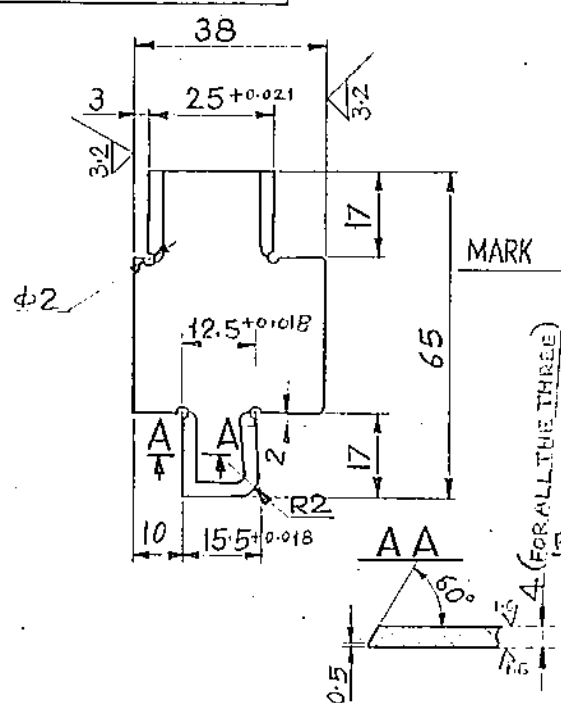
1. MAT. OF TEMPLATE TO BE 16Mn Cr. 58
2. TO BE HARDENED TO HRC. 50-55
3. THICKNESS OF TEMPLATE 4 mm.
4. MARK: DRG. NO., TYPE A OR B OR C
AND BL. WT. GROOVE NO.

[illegible]

SIZE A3

014/
✓ THE REST

DRAWING NO. R8372-0076



◆ MARK

R 8372-0076

THDF 115/59

1-143-09-01002

1. TO BE HARDENED TO HR'C 50 ÷ 55
2. SHARP EDGES TO BE ROUNDED OFF TO R0.5 EXCEPT WORKING EDGES.

VAR. 00		REMARKS		ITEM NO.		DESCRIPTION		DRAWING NO.		MATERIAL CODE		UNIT WT. (KG.)	
CARD TYPE-3		CARD TYPE-1		CARD TYPE-2		MATERIAL SPECN		MATERIAL SPECN		MATERIAL SPECN		UNIT WT. (KG.)	
GMS/GN. SP. NO.		STATUS OF DRG.		TYPE OF PRODUCT		COMP. DRG. No.		M/C TRANS. No.		REF. DRG. No.			
AGREED		NAME		SIGN.		DATE		ORTHDF 115/59		1-143-09-01002		2-74205-01000	
EMT		PRAKASH		Dg		2/10/11		NAME OF CUSTOMER/PROJECT		W/ORDER No.		M/C TOOL MODEL No.	
NCT		J.K.SHARMA		S/P				EX 500/190, NAGINI 628		INV. No.			
REV		DATE		ALTERED		CHECKED		DEPT.		GRADE OF		SCALE	
								C/M/F		1:1		WEIGHT (KG)	
								TITLE		DRAWING NO.		REV.	
								PROFILE TEMPLATE		R8372-0076			
								(FOR BALANCING WT. GROOVE)		SHEET NO.		NO. OF SHEETS:-	

SIZE A3

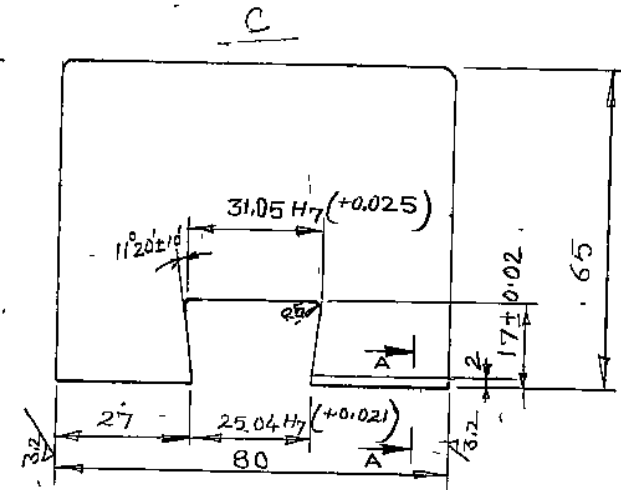
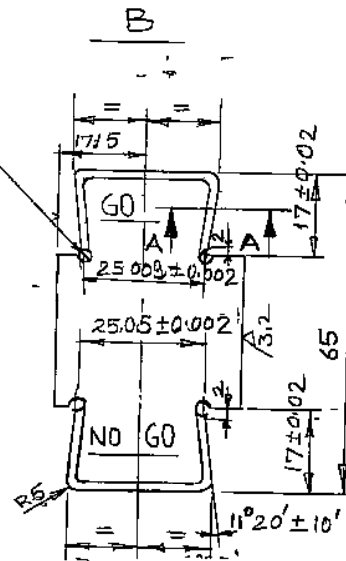
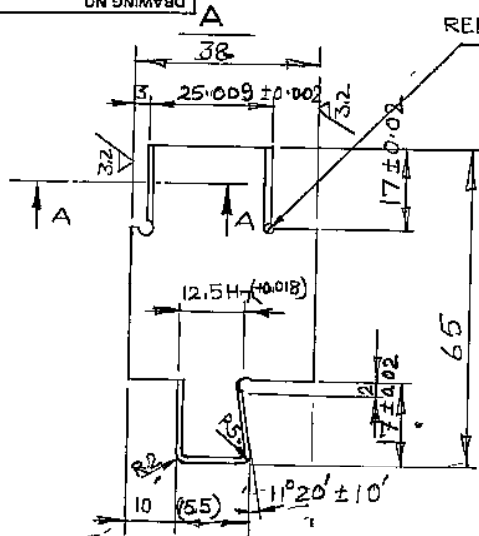
FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

FORM DG-38

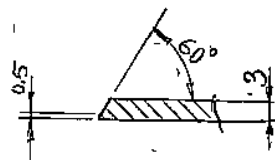
R8372-0114
DRAWING NO

D.4

ALLOVER EXCEPT OTHERWISE STATED



SECTION-AA



NOTE -

- A. HALF PROFILE TEMPLATE FOR MACHINING OF GROOVE.
- B. GO/NO GO GAUGE FOR BALANCING WT. GROOVE.
- C. TOOL CHECKING TEMPLATE.

MARK
R8372-0114

VAR 00	REMARKS	ITEM No	DESCRIPTION	DRAWING No	MATERIAL CODE	UNIT WEIGHT
59	64	65	75	25	27	29
58	59	60	77	32	33	48

GMS No /GR	SP No	STATUS OF DRG
AGREED	NAME	SIGN
DEPT	DATE	

TYPE OF PRODUCT
250 MV! ST
DESIGN ORDER NO.
K0250 ST 3ST M0099
COMP DRG. N
0-12h-01-18500

MIL TOOL NO
169
REF DRG NO
R8372-0044
MODEL NO

GRADE OF UNTOL DIM -
M/CG - C/M/F/ AA 023 0208
WELDING - T1' O 610 003
GAS CUTTING - T3' AA 0621101

BHARAT HEAVY ELECTRICALS LTD.
HARDWAR

NAME
SANJEEV
SIGN
B.K. ROY
DATE
3-4-93

REV	DATE	ALTERED
		CHECKED

DEPT
CODE
125

SCALE
1:1
WEIGHT (KG)

ZONE

TITLE
PROFILE TEMP FOR BALANCING
WT GROOVE WITH CORNER RADII
R 5

REF TO ASSY DRG
ITEM No
73, 74

REV	DATE	ALTERED
		CHECKED

CARD CODE
DRAWING No
R8372-0114
SHEET No 1
No OF SHEETS 1

REV
221 23 24

SIZE - A3

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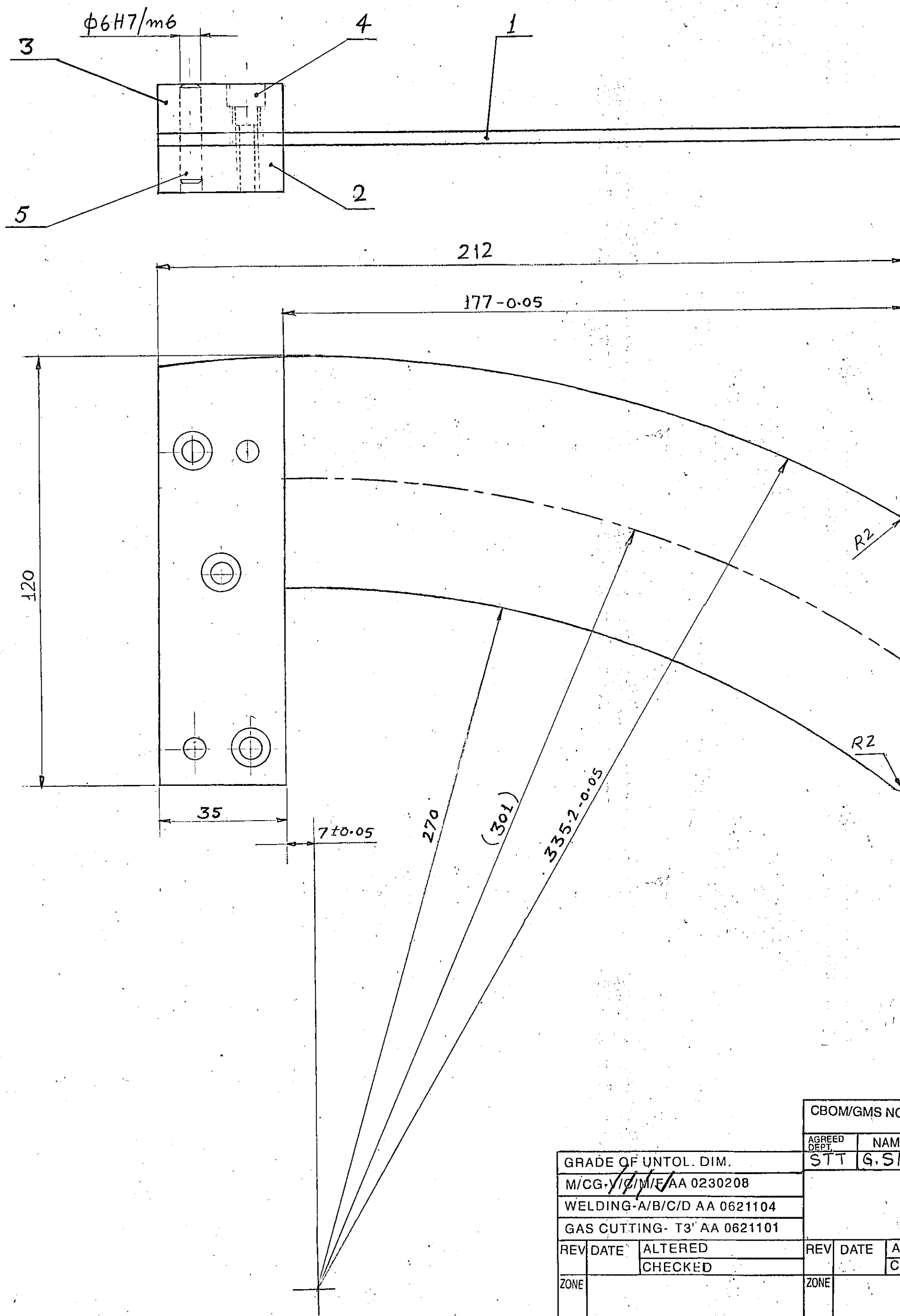
REF. DRG. NO.

INVENTORY NO. SIGN & DATE
2-15974 12.12.99

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

FORM DG 44B



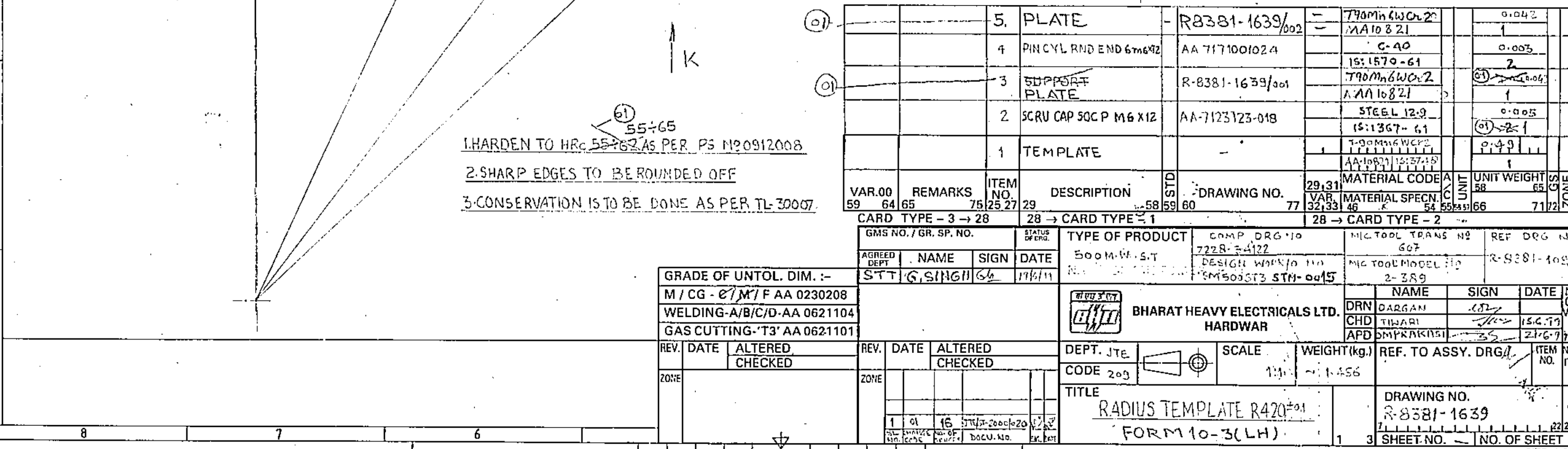
MARK
R 8381-1624
(FORM-17)

5	PIN CYL. RND Ø6mm X 30	AA 7171001-040	C 40 : 1515 70	0.006	
			AA 7171001	2	
4	SCAU CAP SOC PM6 X 25	AA 7123123-042	STEEL 12.9	0.007	
			AA 7123123	3	
3	PLATE UPPER	R 8381-1624/003	T 55 SL 2 mm 90	~0.40	
			AISI : 54/15:3748	1	
2	PLATE LOWER	R 8381-1624/002	T 55 SL 2 mm 90	~0.40	
			AISI : 54/15:3748	1	
1	PLATE	R 8381-1624/001	T 90 MM WCR2	~0.35	
			AA 16821/15:3748	1	
ITEM No.	DESCRIPTION	DRAWING NO	MATERIAL CODE	UNIT WT.	
			VAR. MATERIAL SPEC	QTY.	

CBOM/GMS NO.		STATUS OF DRG		TYPE OF PRODUCT		COMP. DRG. No 7228-34121 (1-1037-41032)		M/C TOOLS TRANS		REF. DRG. NO	
AGREED DEPT.		NAME		SIGN		DATE		M/C TOOL MODEL NO		R 8381-1093	
STT		G. SINGH		GL		21/1/99		DI/ORDER NO.		SM 500 ST3 ST M0003	
GRADE OF UNTOL. DIM.		M/CG-Y/C/M/E/AA 0230208		WELDING-A/B/C/D AA 0621104		GAS CUTTING- T3 AA 0621101		NAME		SIGN	
REV		DATE		ALTERED		REV		DATE		ALTERED	
ZONE				CHECKED		ZONE				CHECKED	
CODE 209		DEPT. J.T.E		SCALE 1:1		WEIGHT (kg.) ~1.20		REF. TO ASSY. DRG.		ITEM NO.	
TITLE		RADIUS TEMPLATE		R 335.2 (FORM-17)		CARD CODE		DRAWING No.		REV.	
								R 8381-1624		122 23124	
								SHEET NO.		NO. OF SHEETS	

SIZE A2

2-16071	6-25-6-99	REF. DRG. NO.
INVENTORY NO.	SIGN & DATE	

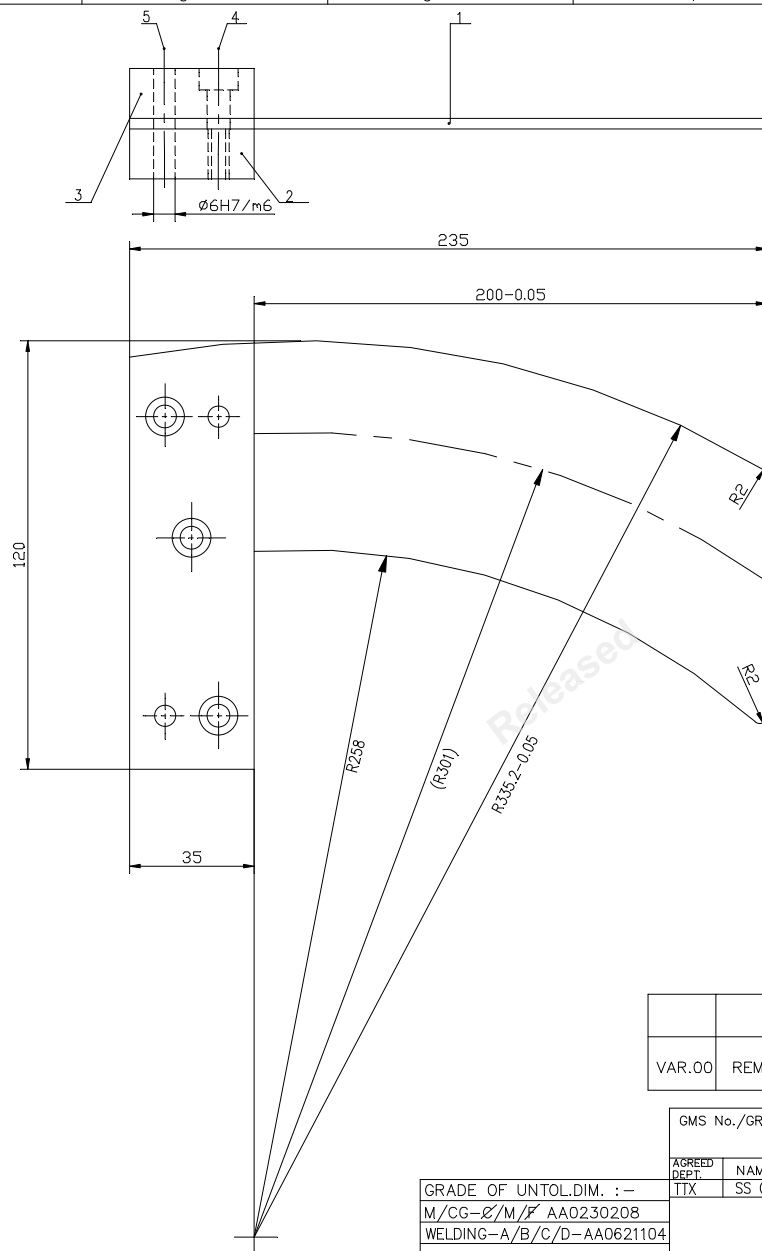
[illegible]

CARD TYPE - 3 → 28				28 → CARD TYPE - 1				28 → CARD TYPE - 2						
GMS NO./GR. SP. NO.				STATUS OF ENGR.	TYPE OF PRODUCT			COMP. DRG. NO.		MIC TOOL TRANS. NO.		REF. DRG. NO.		
AGREED DEPT.		NAME		SIGN	DATE	500MM. S.T			7228-3-4122		607		R-8381-109	
STT		G. SINGH		66	17/6/11	5M505ST3 STM-0415			MIC TOOL MODEL NO.		2-389			
भारत भारती BHARAT HEAVY ELECTRICALS LTD. HARDWAR							NAME		SIGN		DATE			
						DRN	DARGAN		10/11					
						CHD	TILARI		15.6.11					
						APD	DMPKAKINSI		21.6.11					
REV.		DATE		ALTERED CHECKED		DEPT. JTE			SCALE	WEIGHT (kg.)	REF. TO ASSY. DRG.		ITEM NO.	
ZONE						CODE 203		1:1	1.456					
1		01		16		ST/17-2000/20		TITLE		DRAWING NO.		R-8381-1639		
SHEET NO.		NO. OF SHEETS		DOCU. NO.		ENC. DATE		RADIUS TEMPLATE R420 ^{±0.1}		1		3	SHEET NO.	NO. OF SHEET
								FORM 10-3(LH)						

FIRST ANGLE PROJECTION (ALL DIMENSIONS IN m.m.)

FORM DG 44(B)

DRAWING No. R8381-1800



MARK
R8381-1800
FORM-17

5	PIN CYL.RNDØ6m6X30	AA7171001-040	C40:ISIS70	2	0.006				
			AA7171001	2					
4	SCRU CAP SOC PM6X25	AA7123123-042	STEEL12.9	3	0.007				
			AA7123123	3					
3	PLATE UPPER	R8381-1800/003	T55Si2Mn90	1	~0.40				
			AA10521	1					
2	PLATE LOWER	R8381-1800/002	T55Si2Mn90	1	~0.40				
			AA10521	1					
1	PLATE	R8381-1800/001	T90Mn6WCr2	1	~0.26				
			HW10892	1					
VAR.00	REMARKS	ITEM No.	DESCRIPTION	STD.	DRAWING No.	MATERIAL CODE	UNIT	UNIT WEIGHT	ZONE
						VAR. MATERIAL SPECN.C	QTY.		

GMS No./GR.SP.No.				STATUS OF DRG.		TYPE OF PRODUCT		COMP. DRG. No. 01030756032/34		M/C TOOL TRANS No.		REF. DRG. No. R8381-1720	
AGREED DEPT.		NAME		SIGN.		DATE		DESIGN ORDER No. BH660ST35TM0060		MODEL No.			
TTX		SS ORAON		-Sd-		18.2.12							
4													
1													
REV.		DATE		ALTERED CHECKED		DEPT. JTE		SCALE		WEIGHT(Kg.)		REF. TO ASSY. DRG.	
						CODE 209		1:1		~1.10		ITEM No.	

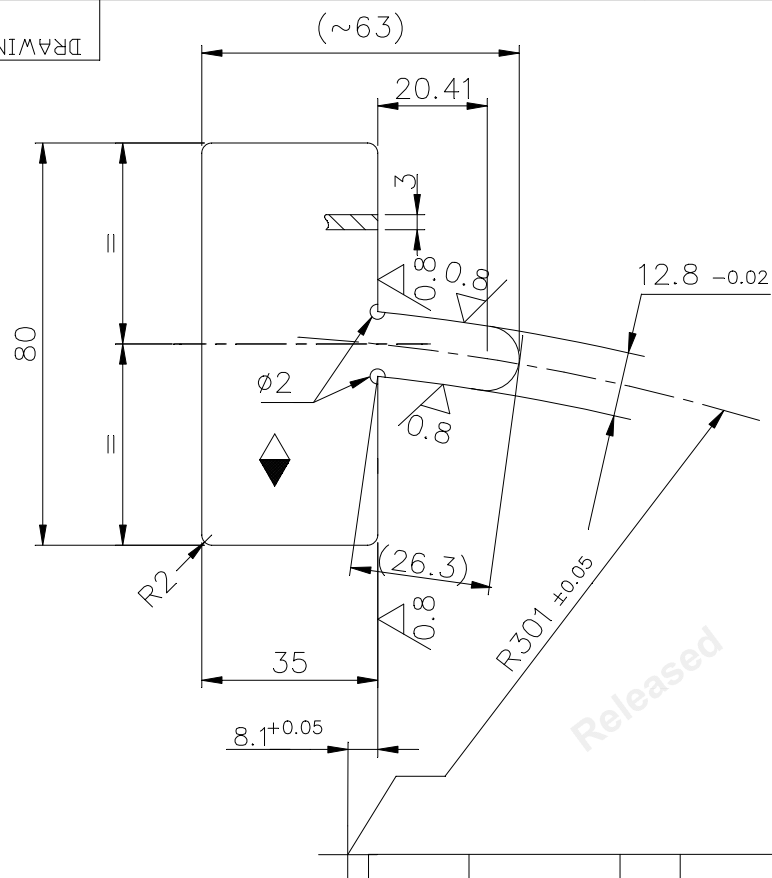
						TITLE		RADIUS TEMPLATE R301				DRAWING No. R8381-1800	
												SHEET No. 01	
												No. OF SHEET 01	
												SIZE A 2	

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

FORM DG38(B)

DRAWING No. R8381-1802



1.6 ~~THE~~ REST

NOTES: –

- 1- SHARP EDGES TO BE ROUNDED OFF.
- 2- HARDEN TO HRC 50-55 AS PER
P.S. No.0912-008.
- 3- CONSERVATION AS PER TL-30007.

MARK

R8381-1802

R301,12.8

L.H, FORM 17

[illegible]

SIZE A 3

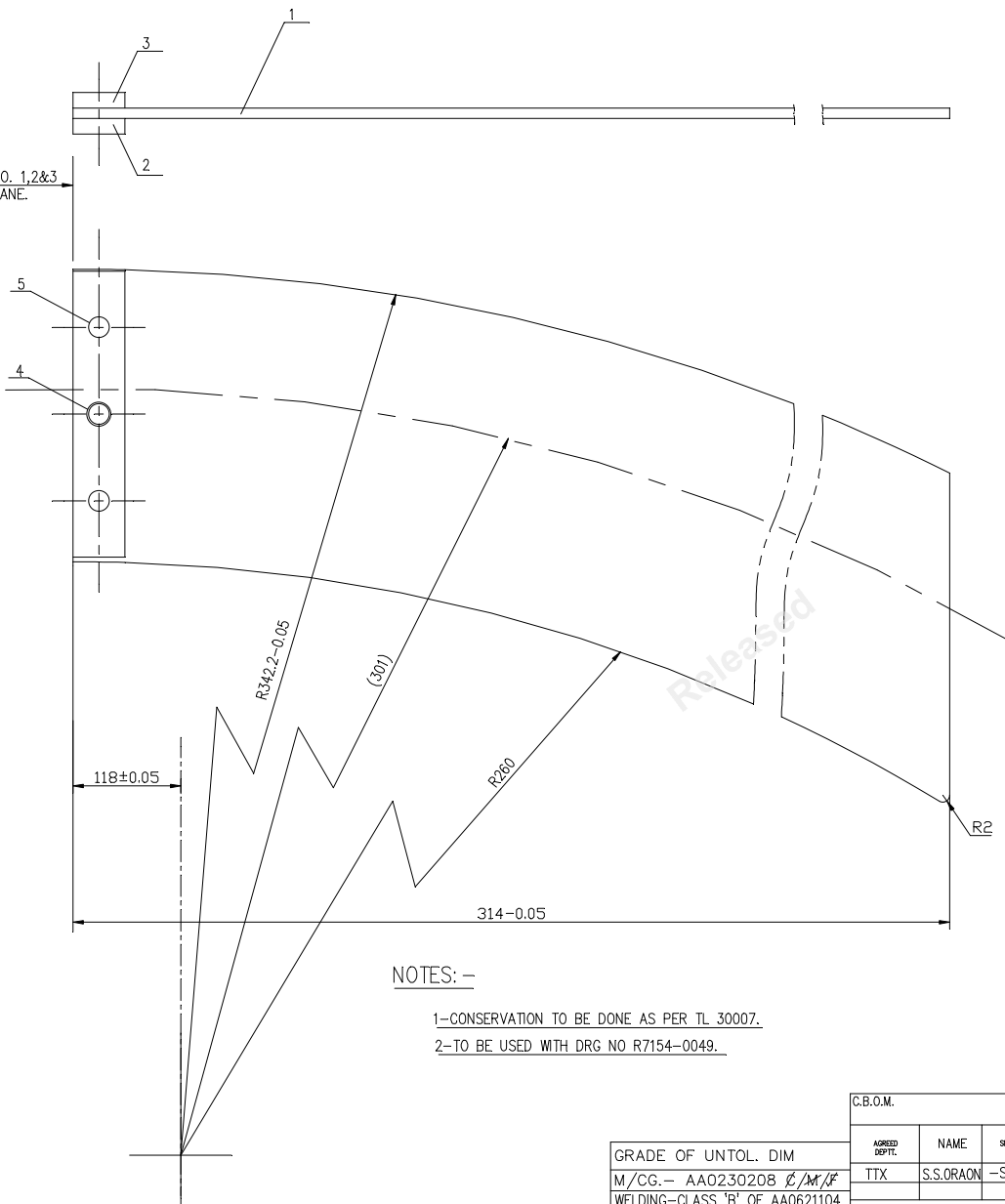
FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm.

FORM 44 (B)

R8381-1842

DRAWING NO.



DRG. SUPERSEDES THE OLD DRG.

MARK

R8381-1842

FORM 20S (800MW)

P.O. No.

NOTES:-

1-CONSERVATION TO BE DONE AS PER TL 30007.

2-TO BE USED WITH DRG NO R7154-0049.

05	PIN CYL. RND Ø6m 6x12	AA 7171001-040	C40:ISIS70		0.006
			AA7171001		2
04	SCRU CAP SOC PM 6x12	AA 7123123-042	STEEL 12.9		0.007
			AA7123123		1
03	PLATE UPPER	R8381-1842/003	T55Si2Mn90		0.05
			AISI: S4/IS: 3748		1
02	PLATE LOWER	R8381-1842/002	T55Si2Mn90		0.05
			AISI: S4/IS: 3748		1
01	PLATE	R8381-1842/001	T90Mn6WCr2		0.64
			HW10892		1
ITEM NO.	DESCRIPTION	DRAWING NO.	MAT CODE	A	UNIT WEIGHT
			VAR.	C	QTY.

C.B.O.M.		APPROVED BY STATUS OF DRG.		TYPE OF PRODUCT 800 MW		COMP.DRG.No. 0-10307-58032 0-10307-58034 W/O No. YR800ST3STM0018		M/c No. 607 M/c MODEL No. PAMA		REF.DRG.No. R8381-1720	
GRADE OF UNTOL. DIM		APPROVED DEPT.	NAME	SIGN.	DATE	BHARAT HEAVY ELECTRICALS LIMITED, RANIPUR, HARDWAR		NAME		SIGN.	DATE
M/CG.- AA0230208 C/M/f		TTX	S.S.O.RAON	-Sd-	25.10.12			G.SHAYAM		-Sd-	22.10.12
WELDING-CLASS 'B' OF AA0621104								RAVI		-Sd-	23.10.12
GAS CUTTING-TABLE 3 OF AA0621101								ANKUR		-Sd-	23.10.12
REV.	DATE	ALTERED BY	SJT/RS			DEPT.	JTE	SCALE	WEIGHT (KG)	REFER TO ASSLY. DRG.	
		CHD	AJTEAM			CODE	209	NTS	0.76	ITEM NO.	
02	JTE-15-F0110	Sd/-	26.11.15			TITLE RADIUS TEMPLATE (R301) FOR NECK FOR ROTOR GROOVE OF MOVING BLADE 3L/3R,F-20S.					
						CARD CODE		DRAWING NO. R8381-1842			
						7		22		23	
						Sheets No.		01		No. of Sheets	
										01	

A2 SIZE

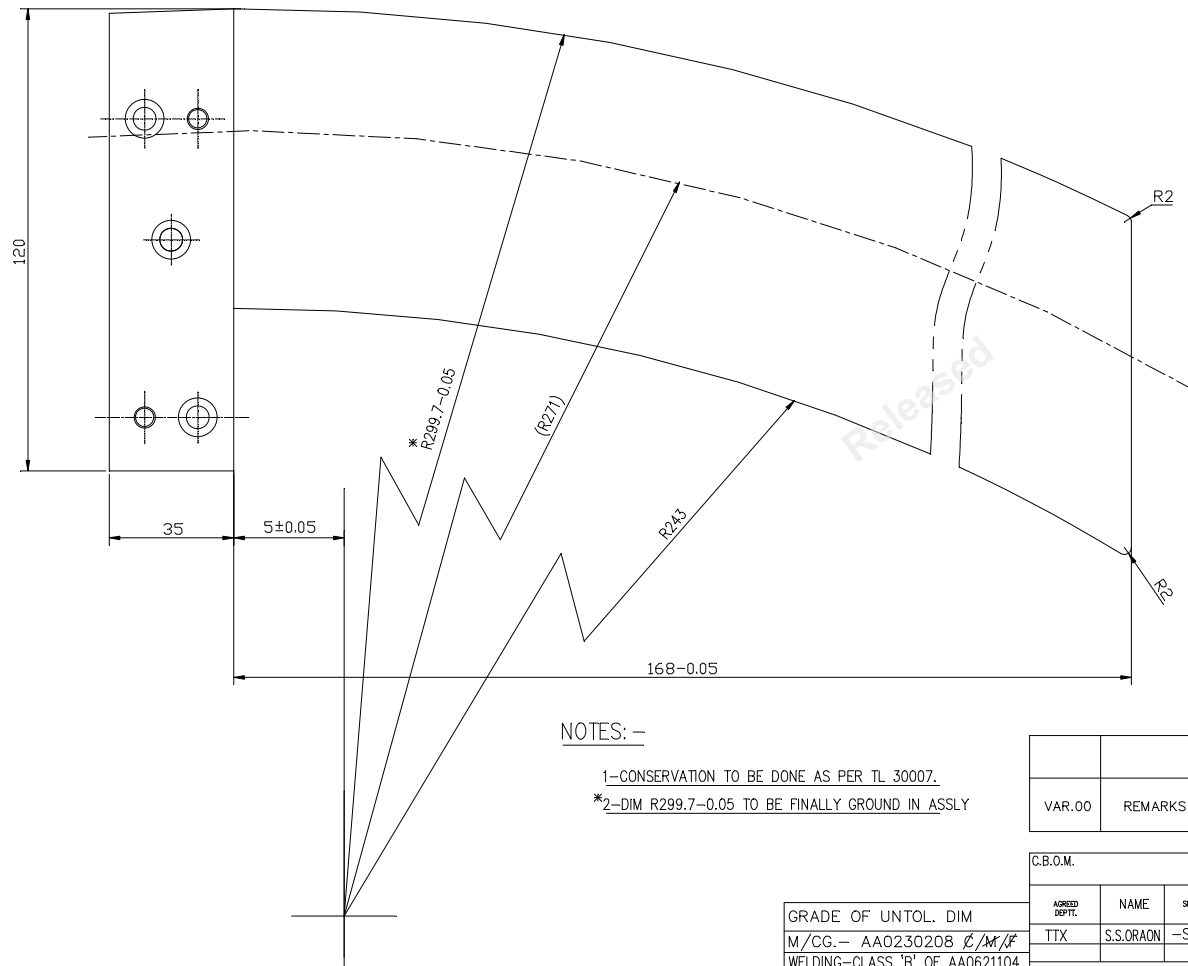
FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm.

FORM 44 (B)

R8381-1845

DRAWING NO.



NOTES: -

1-CONSERVATION TO BE DONE AS PER TL 30007.

*2-DIM R299.7-0.05 TO BE FINALLY GROUND IN ASSLY

MARK
R8381-1845
FORM 11 (800MW)

05	PIN CYL. RND Ø6m 6x12	AA 7171001-040	C40:ISIS70		0.006
			AA7171001	2	
04	SCRU CAP SOC P M 6x25	AA 7123123-042	STEEL 12.9		0.007
			AA7123123	3	
03	PLATE UPPER	R8381-1845/003	T55Si2Mn90		~0.40
			AISI: S4/IS: 3748	1	
02	PLATE LOWER	R8381-1845/002	T55Si2Mn90		~0.40
			AISI: S4/IS: 3748	1	
01	PLATE	R8381-1845/001	T90Mn6WCr2		0.42
			HW10892	1	
VAR.00	REMARKS	ITEM NO.	DESCRIPTION	DRAWING NO.	MAT. CODE
					MAT. SPECN.
					UNIT WEIGHT
					QTY.

C.B.O.M.		APPROVED TO BY STATUS OF DRG.		TYPE OF PRODUCT		COMP.DRG.No. 1-10307-58031 1-10307-58033 W/O No. YR800ST3STM0022		M/c No.		REF.DRG.No.	
APPROVED DEPTT.		NAME		SIGN.		DATE		M/c MODEL No.		R8381-1720	
TTX		S.S.O.RAON		-Sd-		06.12.12					
GRADE OF UNTOL. DIM											
M/CG.- AA0230208 C/M/F											
WELDING-CLASS 'B' OF AA0621104											
GAS CUTTING-TABLE 3 OF AA0621101											
REV.		DATE		ALTERED BY		DATE		DEPTT. JTE		SCALE	
REV.		C/A NO		SIGN.		DATE		CODE 209		WEIGHT (KG)	
										~1.253	
TITLE											
RADIUS TEMPLATE R271 FOR ROTOR											
GROOVE OF MOVING BLADE 2L/2R,F-11.											
CARD CODE											
DRAWING NO.											
R8381-1845											
Sheets No. 01 No. of Sheets 01											

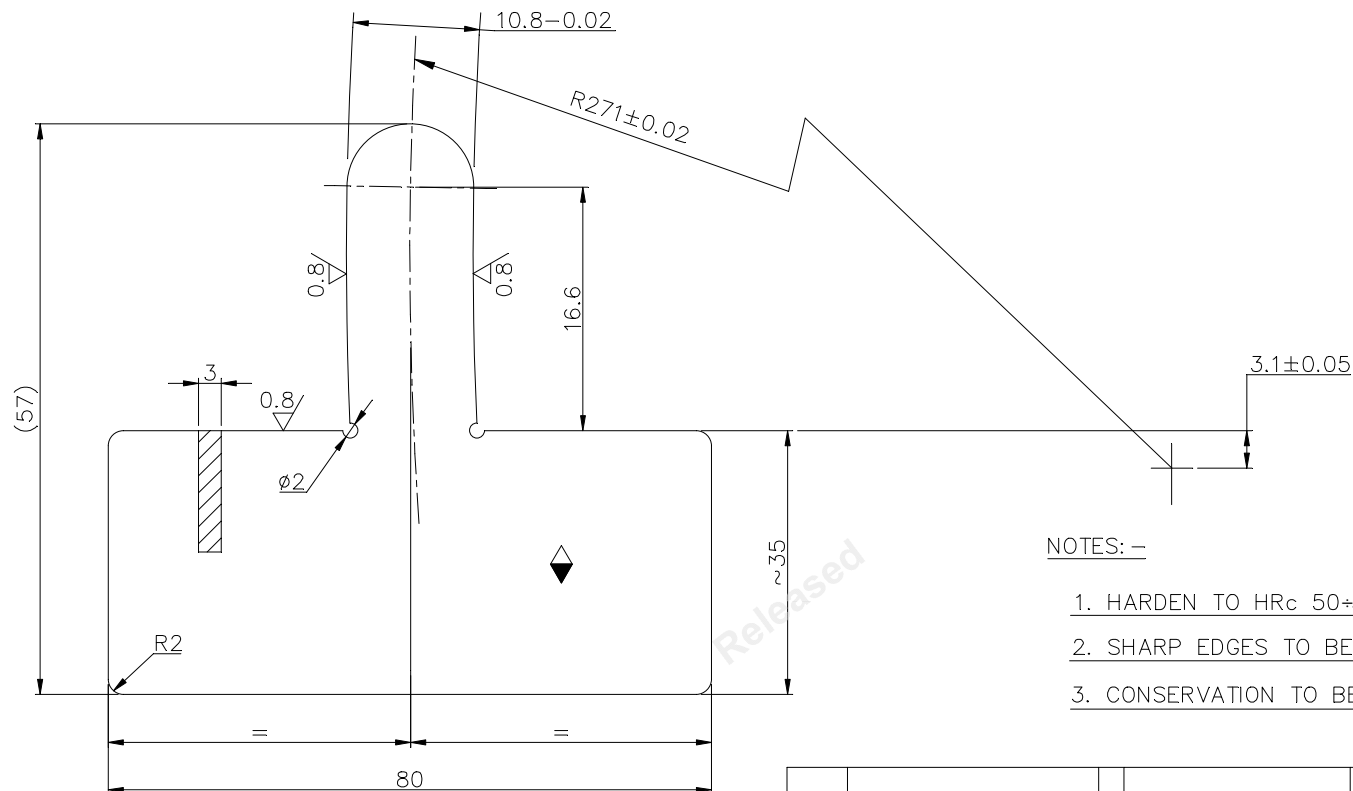
A2 SIZE

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

FORM DG38(B)

DRAWING No. R8381-1846

1.6/
THE REST

◆ MARK

R8183-1846

R271& 10.8

FORM 11

NOTES: -

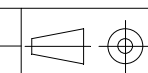
1. HARDEN TO HRc 50+55 AS PER PS 0912-008.
2. SHARP EDGES TO BE ROUNDED OFF.
3. CONSERVATION TO BE DONE AS PER TL 30007.

VAR.00	REMARKS	ITEM No.	DESCRIPTION	STD	DRAWING No.	T90Mn6WCr2	AA10821/IS: 3748	MATERIAL CODE	A	UNIT	UNIT WEIGHT	QTY.
--------	---------	----------	-------------	-----	-------------	------------	------------------	---------------	---	------	-------------	------

GMS No./GR.SP.No.	STATUS OF DRG.	TYPE OF PRODUCT	COMP. DRG. No. 110307-58031 110307-58033	M/C TOOL TRANS No.	REF. DRG. No.
AGREED DEPT.	NAME	SIGN.	DATE	DESIGN ORDER No. YR800ST3STM0024	M/C MODEL No. PAMA M/C
TTX	S.S.OAON	-Sd-	06.12.12		

GRADE OF UNTOL. DIM.: -
M/CG-Ø/M/F AA0230208
WELDING-A/B/C/D AA0621104
GAS CUTTING-'T3' AA0621101
REV DATE ALTERED CHECKED

REV DATE ALTERED CHECKED

DEPT. JTE
CODE 209SCALE
NTSWEIGHT(Kg)
0.08REF. TO ASSY. DRG.
ITEM No. OF
No. ITEMSTITLE
LOCKING GROOVE TEMPLATE LEFT FOR
ROTOR GROOVE OF MOVING BLADE 2L/2R,F-11DRAWING No.
R8381-1846
SHEET No. 01 No. OF SHEETS 01

SIZE A 3

FIRST ANGLE PROJECTION

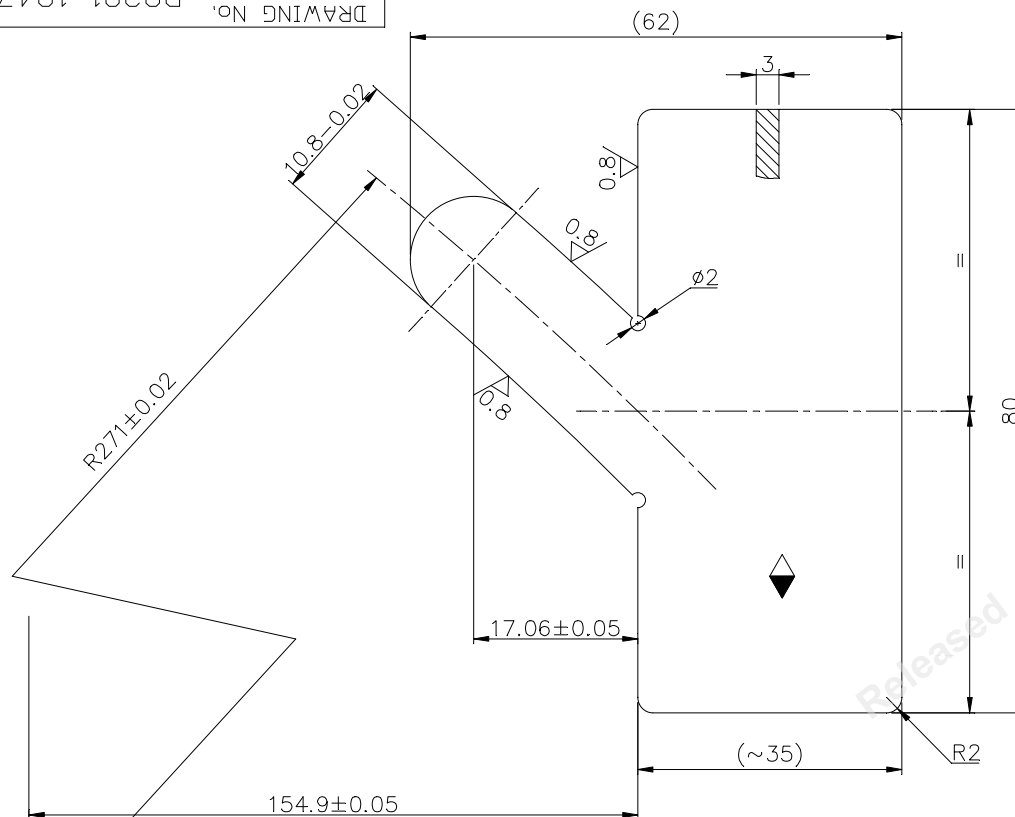
(ALL DIMENSIONS ARE IN mm)

FORM DG38(B)

1.6/ THE REST

R8381-1847

DRAWING No.



 MARK

R8183-1847

R271 & 10.8

FORM 11

NOTES: —

1. HARDEN TO HRc 50+55 AS PER PS 0912-008.
2. SHARP EDGES TO BE ROUNDED OFF.
3. CONSERVATION TO BE DONE AS PER TL 30007.

						T90Mn6WCr2			
						AA10821/IS: 3748			
VAR.00	REMARKS	ITEM No.	DESCRIPTION	STD	DRAWING No.	MATERIAL CODE	A	UNIT	UNIT WEIGHT
					VAR.	MATERIAL SPECN.	c		QTY.

GMS No./GR.SP.No.				STATUS OF DRG.		TYPE OF PRODUCT		COMP. DRG. No. 110307-58031 110307-58033		M/C TOOL TRANS No.		REF. DRG. No.									
AGREED DEPT.		NAME		SIGN.		DATE		800 MW		DESIGN ORDER No. YR800ST3STM0025		M/C MODEL No. PAMA M/C		R8381-1620							
GRADE OF UNTOL. DIM.: -						भारत भारती BHEL BHARAT HEAVY ELECTRICALS LTD. HARDWAR						DRN CHD APD		NAME		SIGN.		DATE		No. OF	
RAJESH		-Sd-		06.12.12										VAR.							
RAVI		-Sd-		06.12.12																	
WELDING-A/B/C/D AA0621104		REV				DATE		ALTERED		DEPT. JTE				SCALE		WEIGHT(Kg)		REF.TO ASSY. DRG.		ITEM No. OF	
GAS CUTTING-'T3' AA0621101						CHECKED		CHECKED		CODE 209		NTS		0.064						No. OF	
																				ITEMS	
						TITLE LOCKING GROOVE TEMPLATE RIGHT FOR ROTOR GROOVE OF MOVING BLADE 2L/2R,F-11.								DRAWING No. R8381-1847				REV			
														SHEET No. 01				No. OF SHEETS		01	

SIZE A 3

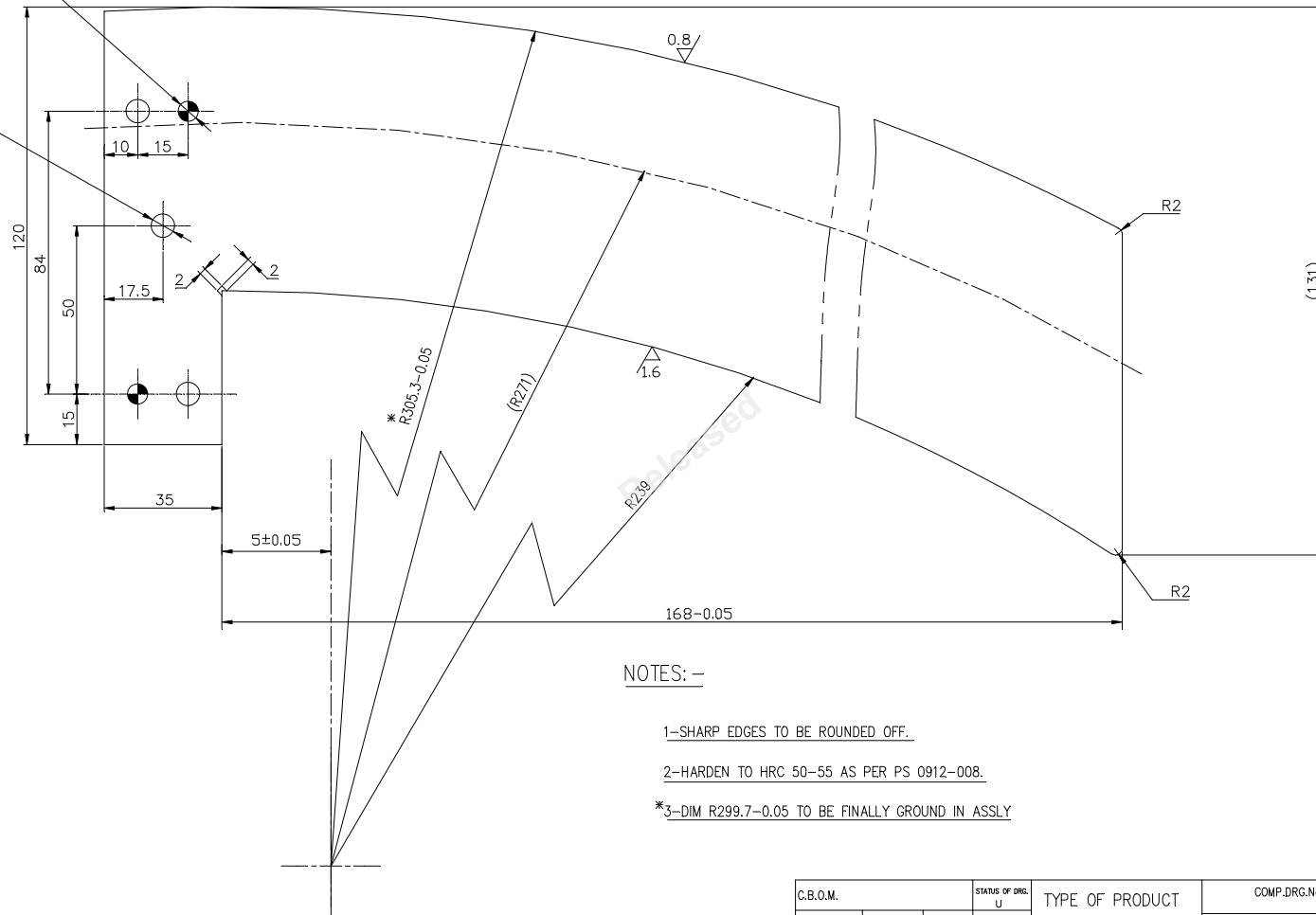
FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm.

FORM 44 (B)

100/0681-18384

DRAWING NO.

6.3
THE REST2HOLES, 6H7(+0.012)
TO BE DRILLED IN ASSY.3HOLES, $\phi 7$ 

NOTES: -

1-SHARP EDGES TO BE ROUNDED OFF.

2-HARDEN TO HRC 50-55 AS PER PS 0912-008.

*3-DIM R299.7-0.05 TO BE FINALLY GROUND IN ASSLY

	T90Mn6WCr2		
	HW10892		
	MAT.CODE	A	UNIT WEIGHT
VAR.	MAT. SPECN.	C	QTY.

GRADE OF UNTOL. DIM
M/CG.- AA0230208 C/M/X
WELDING-CLASS 'B' OF AA0621104
GAS CUTTING-TABLE 3 OF AA0621101

REV.	DATE	ALTERED BY	CHK

C.B.O.M.	STATUS OF DRG.
APPROVED	U
NAME	DATE

REV.	DATE	ALTERED BY	CHK

TYPE OF PRODUCT		COMP.DRG.No.		M/c No.		REF.DRG.No.	
		W/O No.		M/c MODEL No.			
BHARAT HEAVY ELECTRICALS LIMITED, RANIPUR, HARDWAR							
DEPTT.	JTE	SCALE	WEIGHT (KG)	REFER TO ASSLY. DRG.		ITEM NO.	NO. OF ITEMS
CODE	209	NTS	0.33	R8381-1890		01	05
TITLE				DRAWING NO.			
PLATE				R8381-1890/001			
CARD CODE				No. of Sheets		22 23 24	
				01		01	

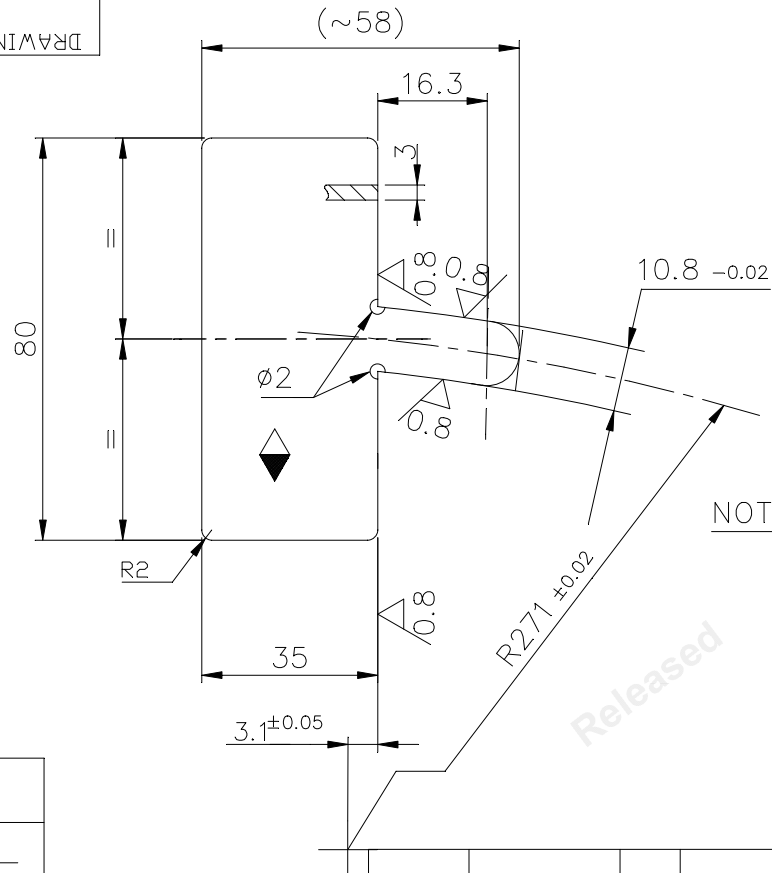
A2 SIZE

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

FORM DG38(B)

DRAWING No. R8381-1892

1.6/
THE REST

NOTES: -

1- SHARP EDGES TO BE ROUNDED OFF.

2- HARDEN TO HRc 50-55 AS PER
P.S. No.0912-008.

3- CONSERVATION TO BE DONE AS PER TL-30007.

◆ MARK

R8381-1892

R271,10.8

L.H,FORM 11

VAR.00		REMARKS		ITEM No.		DRAWING No.		DRAWING No.		T90Mn6WCr2		AA10821/IS: 3748		UNIT WT.(Kg.)		ZONE	
CARD TYPE-3		28		28		CARD TYPE-1		28		CARD TYPE-2		28		28		28	
GMS No./GR.SP.No.				STATUS OF DRG.		TYPE OF PRODUCT				COMP. DRG. No.		M/C TOOL TRANS No.		REF. DRG. No.			
AGREED DEPT.				NAME		SIGN.		DATE		ST 800MW		110307-58041 110307-58042		MODEL No.		R8381-1846	
NCT				MANISH		-Sd-		11.02.15		NC/ST-80/T/1470		PAMA FIRTREE,BL-3					
GRADE OF UNTOL. DIM.: -				M/CG-2/M/E/AA0230208		WELDING-A/B/C/D AA0621104		GAS CUTTING-'T3' AA0621101		REV		DATE		ALTERED		CHECKED	
REV				DATE		ALTERED		CHECKED		REV		DATE		ALTERED		CHECKED	
DEPT. JTE				CODE		209		SCALE		NTS		WEIGHT(Kg)		~0.08		REF.TO ASSY. DRG.	
TITLE				LOCKING GROOVE TEMPLATE LEFT FOR		LP ROTOR GROOVE OF MOVING BLADE 2L/R,F-11		DRAWING No.		R8381-1892		SHEET No. 01		No. OF SHEETS 01		REV.	

SIZE A 3

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USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY

INVENTORY NO. SIGN & DATE
2-16581

REF. DRG. NO.
R8381-9523 ÷ 9524

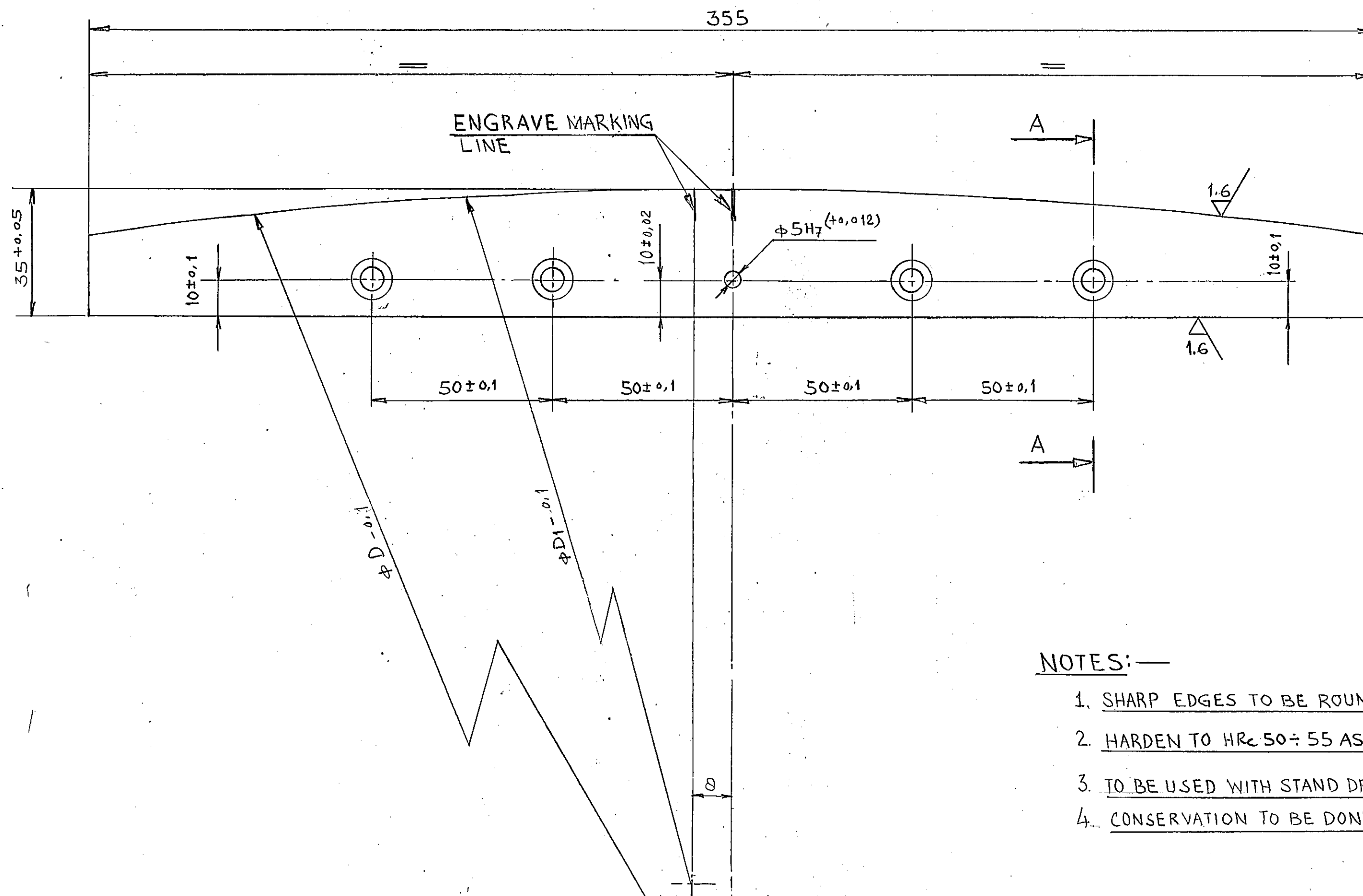
FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

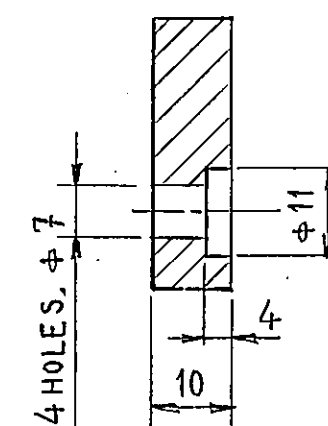
FORM DG 44B

DRAWING NO. R8381-9523 ÷ 9524

3.2
✓ THE REST



SECTION A-A



MARK

DRG. NO. R8381-9523 ÷ 9524

φ

NOTES:—

1. SHARP EDGES TO BE ROUNDED OFF.
2. HARDEN TO HRC 50 ÷ 55 AS PER P.S. NO. 0912008.
3. TO BE USED WITH STAND DRAWING NO. WE 0-13-3400
4. CONSERVATION TO BE DONE AS PER TL 30007.

S.No.	W/O NO.	DRAWING NO.	φD-0.1	φD1-0.1	TYPE OF BLADE
1.	KBM-7311	R8381-9523	2757.4	-	FORM-14
2.	KBM-7411	R8381-9524	-	2894	FORM-17

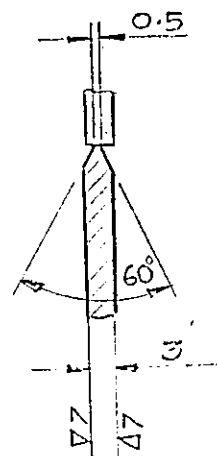
ITEM No.	DESCRIPTION	DRAWING NO.	VAR.	MAT. SPECN.	UNIT	QTY.	UNIT WT. (kg)	ZONE
—	—	—	—	—	—	—	—	—

CBOM/GMS NO.		STATUS OF DRG.		TYPE OF PRODUCT		COMP. DRG. NO.		M/C TOOL TRANS NO.		REF. DRG. NO.	
M/CG-VI/M/F AA 0230208		PEB YC G		250 M.W. S.T.		0103074600385		BIG V. STAND		R8381-9511 ÷ 9513	
WELDING-A/B/C/D AA 0621104		GAS CUTTING-T3' AA 0621101		NAME OF CUSTOMER		W/O NO.		MIC MODEL NO.		SIGN	
REV DATE		ALTERED		FANIPAT		SEE TABLE		BIG V. STAND		DATE	
ZONE		CHECKED		Bharat Heavy Electricals Ltd.		HARDWAR		DRN V.C. GUPTA		NO. OF VAR	
REV DATE		ALTERED		CODE 209		SCALE 1:1		WEIGHT (kg.)		REF. TO ASSY. DRG.	
ZONE		CHECKED		DEPT. JTE		TITLE		DRAWING No.		ITEM NO. OF	
				RADIUS CHECKING TEMPLATE		CARD CODE		R8381-9523 ÷ 9524		ITEM NO.	
								SHEET NO. -		NO. OF SHEETS -	

SIZE A2

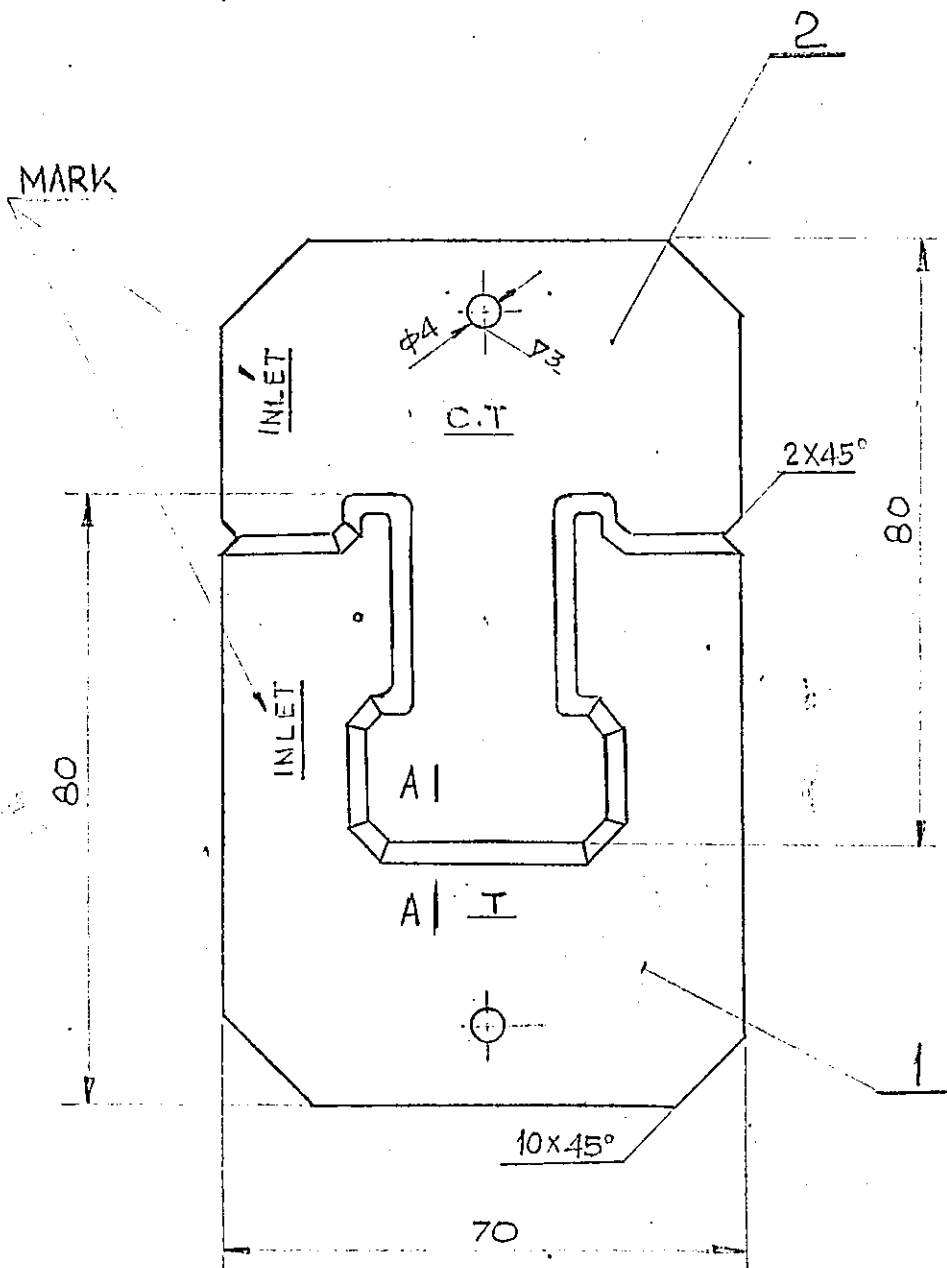
▽ 6 THE REST

MARK

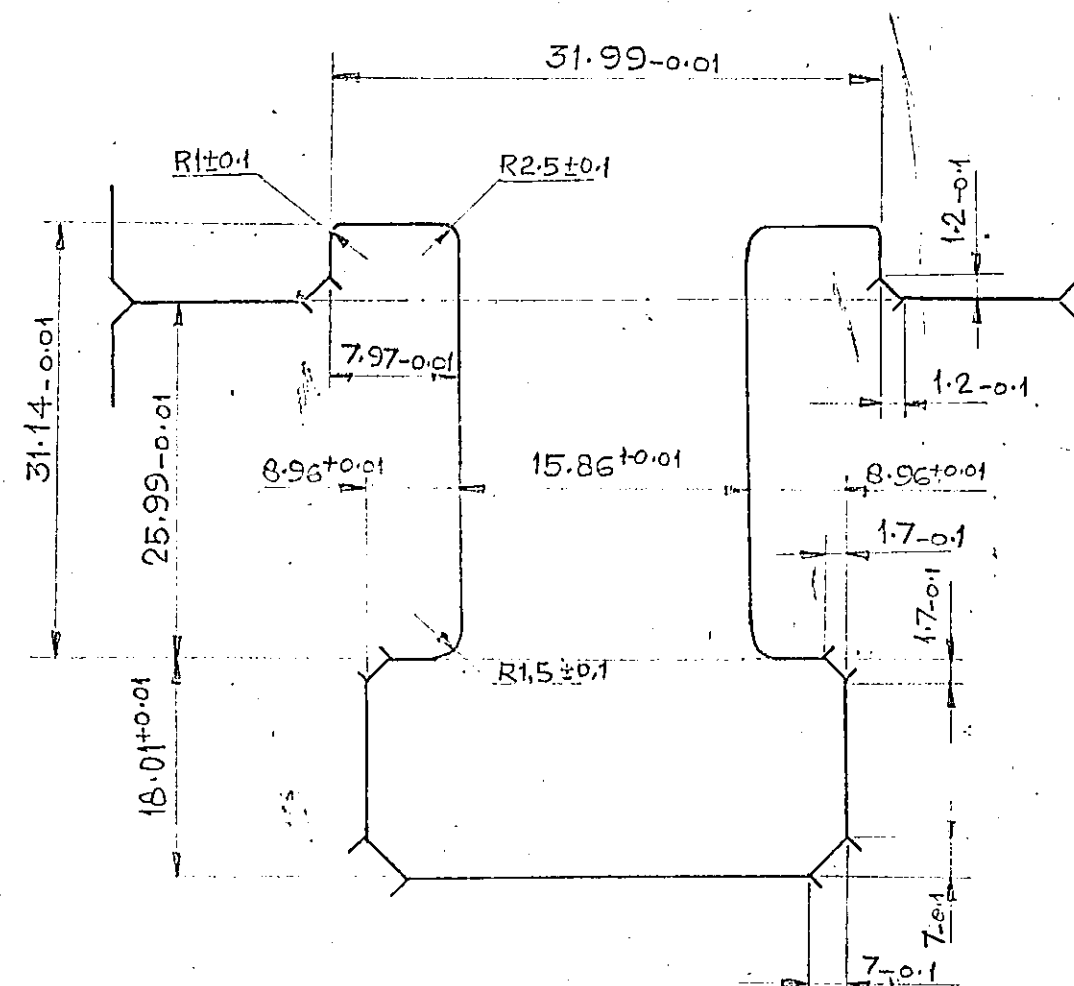


MARK

R8384-9007
PROFILE NO. 1157
STAGE 16 ÷ 18
T & CT



PROFILE
SCALE 2:1



PROFILE NO. 1157 DRG. NO. 32311027.

NOTES:-

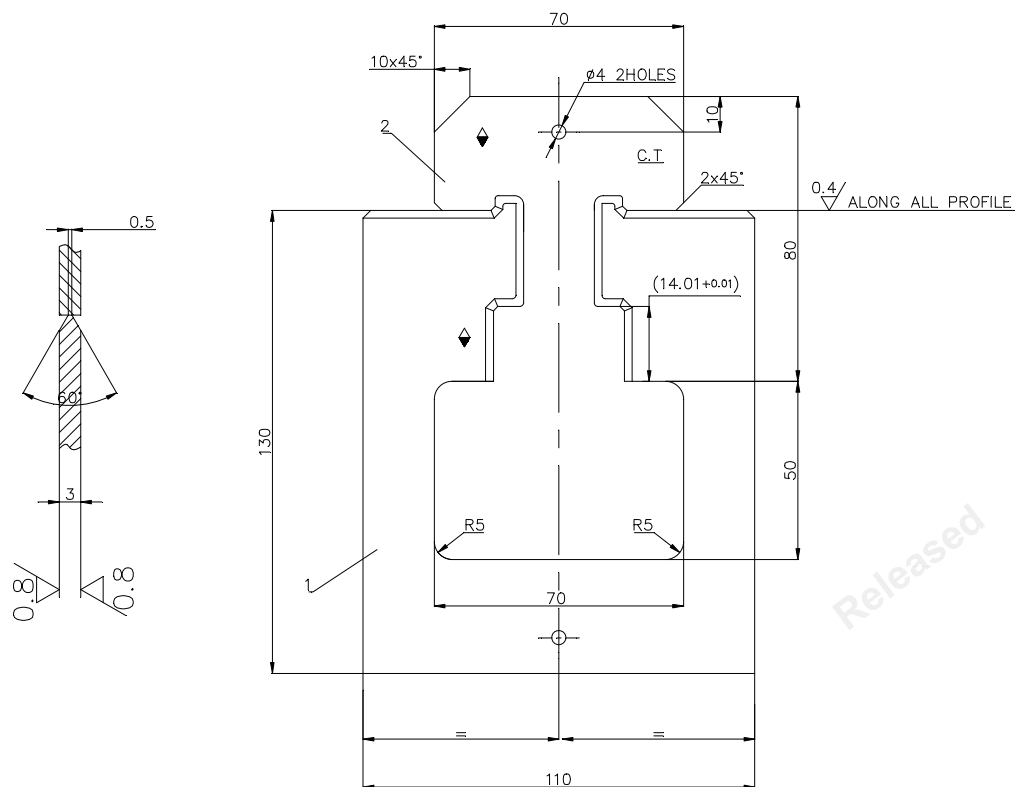
1. HARDEN TO HRC 56÷64.
2. SURFACE FINISH OF THE PROFILE $\nabla 10$.
3. FILE GROOVE UPTO WIDTH 0.25 ON THE INTERNAL ANGLES OF THE TEMPLATE.
4. PROFILE OF THE TEMPLATE AND COUNTER TEMPLATE ON FULL PROFILE SHOULD MATCH WITH MAXIMUM ALLOWABLE CLEARANCE 0.01.

[illegible]

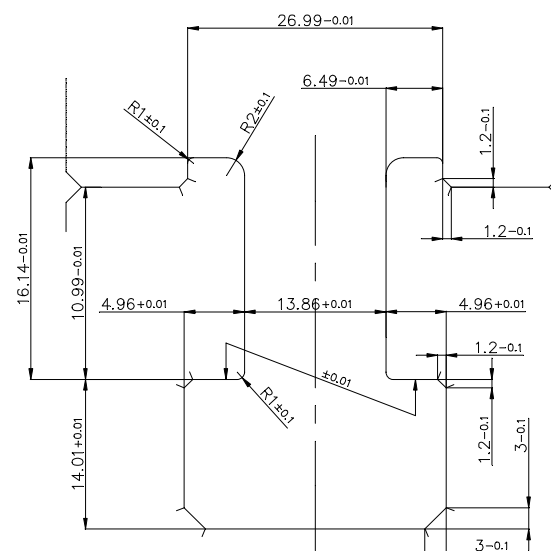
DRAWN / TRACED

SIZE 12

DRAWING No. R8384-9025



PROFILE OF THE TEMPLATE
SCALE 2:1



1.6/ THE REST

MARK

R8384-9025

NOTES: –

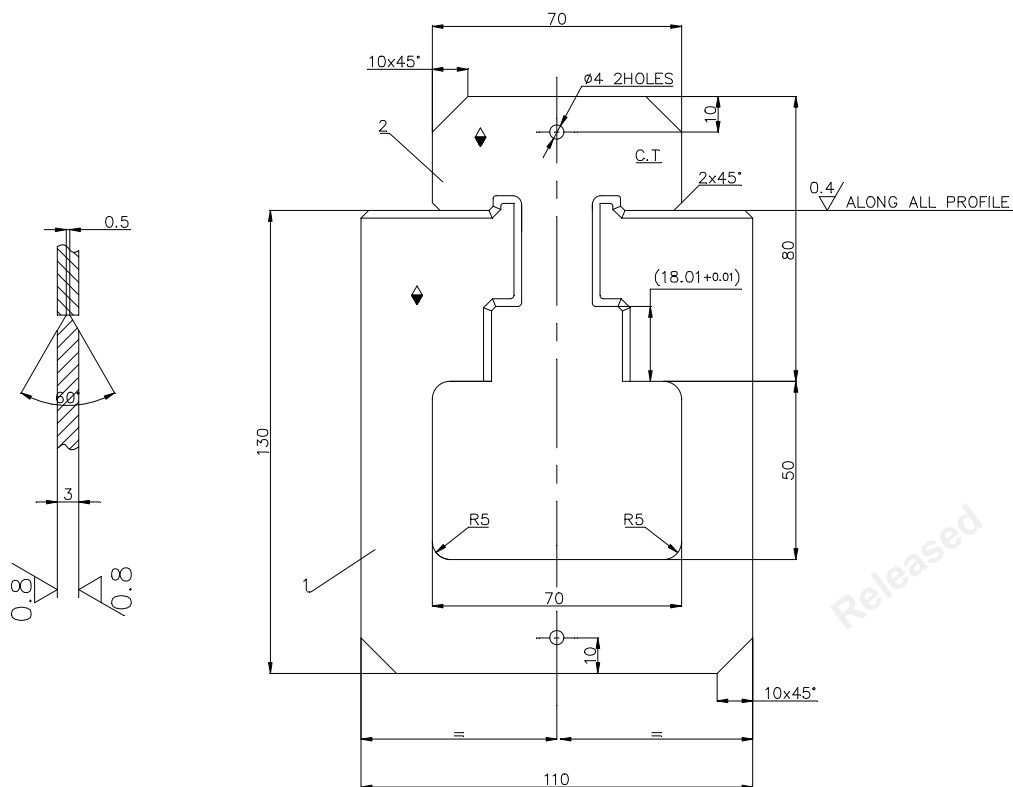
- 1-HARDEN TO HRC 55±60 AS PER PS NO. 0912-008.
- 2-ON THE INTERNAL CORNERS OF THE TEMPLATE.IT IS ALLOWED TO MAKE CUT WIDTH 0.25.
- 3-TEMPLATE AND C'TEMPLATE SHOULD MATCH WITH MAX. ALLOWABLE CLEARANCE 0.01 AGAINST LIGHT.
- 4-CONSERVATION TO BE DONE AS PER TL 30007.

[illegible]

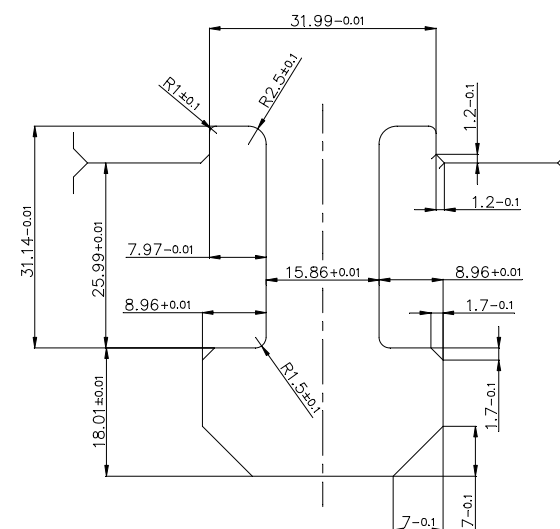
GMS No./GR.SP.No.					STATUS OF DRG.	TYPE OF PRODUCT		COMP. DRG. No. 00032302021-00		M/C TOOL TRANS No. 628		REF. DRG. No.				
AGREED DEPT.		NAME		SIGN.	DATE	195 MW		DESIGN ORDER No. NBF/1920		MODEL No. 5 AXIS MACHINE		R8384-9006				
TBM		ANIL KUMAR		-Sd-	09.09.15											
						BHARAT HEAVY ELECTRICALS LTD. HARDWAR		DRN. CHD APD		NAME MUKESH RAVI ANKUR		SIGN. -Sd- -Sd- -Sd-		DATE 09.09.15 09.09.15 09.09.15		No. OF VAR
REV		DATE	ALTERED CHECKED			DEPT. JTE		SCALE N.T.S	WEIGHT(Kg.) ~0.04	REF. TO ASSY. DRG.		ITEM No. --	No. OF ITEM			
						CODE 209										
TITLE CHECKING TEMPLATE OF ROOT PROFILE WITH TECHNICAL ALLOWANCES.										DRAWING No. R8384-9025		REV.				
										SHEET No. 01		No. OF SHEET 01		0		

SIZE A 2

DRAWING No. R8384-9028



PROFILE OF THE TEMPLATE
SCALE 2:1



1.6/ THE REST

MARK

R8384-9028

NOTES: –

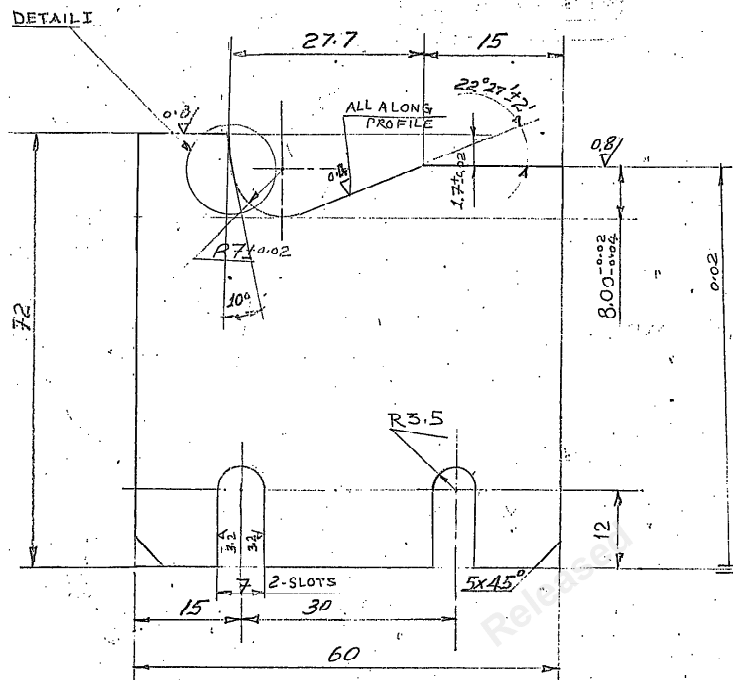
- 1-HARDEN TO HRC 55+60 AS PER PS NO. 0912-008.
2-ON THE INTERNAL CORNERS OF THE TEMPLATE,IT IS ALLOWED TO MAKE CUT WIDTH 0.25.
3-TEMPLATE AND C'TEMPLATE SHOULD MATCH WITH MAX. ALLOWABLE
4-CLEARANCE OF 0.01 AGAINST LIGHT
5-PERMITTANCE TO BE DONE AS PER TL 30007.

[illegible]

GMS No./GR.SP.No.				STATUS OF DRG.	TYPE OF PRODUCT 195 MW		COMP. DRG. No. 00032312007-00		M/C TOOL TRANS No. 628		REF. DRG. No.						
195 MW				DESIGN ORDER No. NBF/1923			MODEL No. 5 AXIS MACHINE		R8384-9007								
AGREED DEPT.		NAME		SIGN.		DATE											
NBF		ANIL KUMAR		-Sd-		12.10.15											
				बीएलएस BHEL		BHARAT HEAVY ELECTRICALS LTD.											
				HARDWAR				NAME MUKESH -Sd- 09.10.15		SIGN.							
								DRN. CHD RAVI -Sd- 10.10.15		DATE		No. of VAR					
								APD ANKUR -Sd- 13.10.15		DATE							
REV.		DATE		ALTERED CHECKED		DEPT. JTE				SCALE		WEIGHT(Kg.)		REF. TO ASSY. DRG.		ITEM No. of ITEM	
						CODE 209		N.T.S		~2.3						---	
TITLE										CHECKING TEMPLATE OF ROOT PROFILE WITH TECHNICAL ALLOWANCES.				DRAWING No. R8384-9028		REV.	
														SHEET No. 01		No. of SHEET 01	

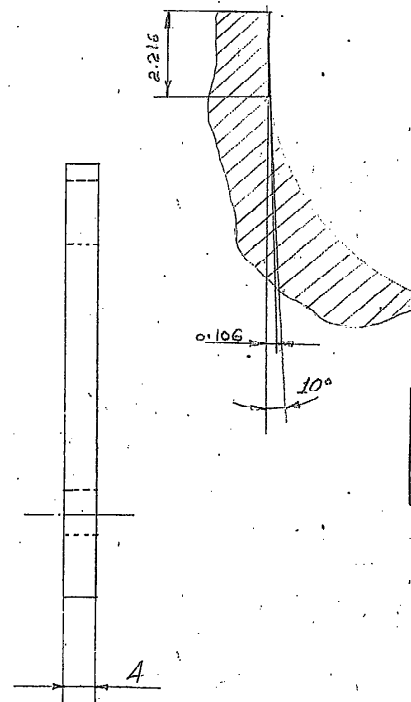
SIZE A 2

DRAWING NO.



DETAILS

1.6/ THE REST



MARK
R8388-7599
SE-II. M.B. ST. A

DRG. SUPERSEDES THE OLD DRG.

NOTES:-

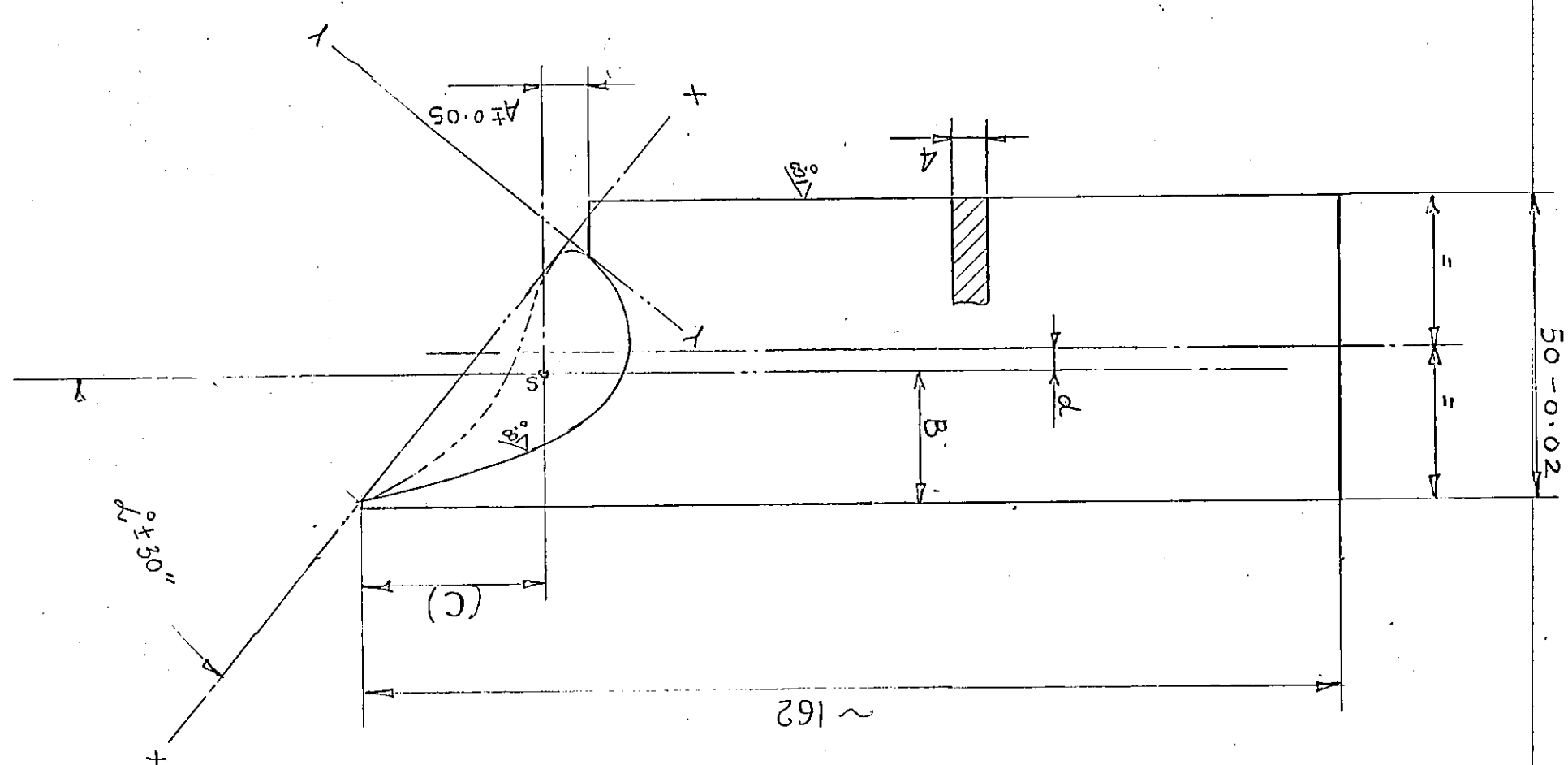
1. HARDEN TO HRC 50-60 AS PER P.S. NO. 0912-008.
2. ROUND OFF SHARP EDGES.
3. MANUFACTURING ACCURACY ON PROFILE ± 0.02 .
4. PROFILE SHOULD BE MATCHED WITH CORRESPONDING SHADOWGRAPH
5. DOVETAIL ROOT PROFILE DRG. NO. I-74127-01004 OF SF-11 WITH ± 0.02
6. TO BE USED FOR CUTTER DRG. NO. R2249-9766
7. CONSERVATION TO BE DONE AS PER TL 30007

--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--	--

SIZE A2

2-13950

1



1. PROFILE CARRESPONDS TO DRG Nº 1-14600-35228 (SIE MENUS)

2. SHARP EDGES TO BE ROUNDED OFF

3. HARDEN TO HRC 55÷65 AS PER P.S. № 0912008.

4. PROFILE TO BE MATCHED PERFECTLY WITH THE CORRESPONDING

SHADOW GRAPH WITH IN 0.02

5. CONSERVATION TO BE DONE AS PER TL-30007

SL. No	A ^{+0.05}	B	d	$\alpha \pm 30''$	C	W/O No	DRG No
1	8.33	19.9	5.1	47.5°	31.77	KBM-5201	R-8390-1067
2	8.00	20.5	4.5	48.5°	31.43	KBM-5202	R-8390-1008
3	7.67	21.0	4.0	49.5°	31.08	KBM-5203	R-8390-1009
4	7.31	24.6	3.4	50.5°	30.72	KBM-5204	R-8390-1010
5	7.00	22.1	2.9	51.5°	30.35	KBM-5205	R-8390-1011
6	6.66	22.6	2.4	52.5°	29.98	KBM-5206	R-8390-1012
7	6.33	23.1	1.9	53.5°	29.59	KBM-5207	R-8390-1013
8	5.98	23.6	1.4	54.5°	29.19	KBM-5208	R-8390-1014

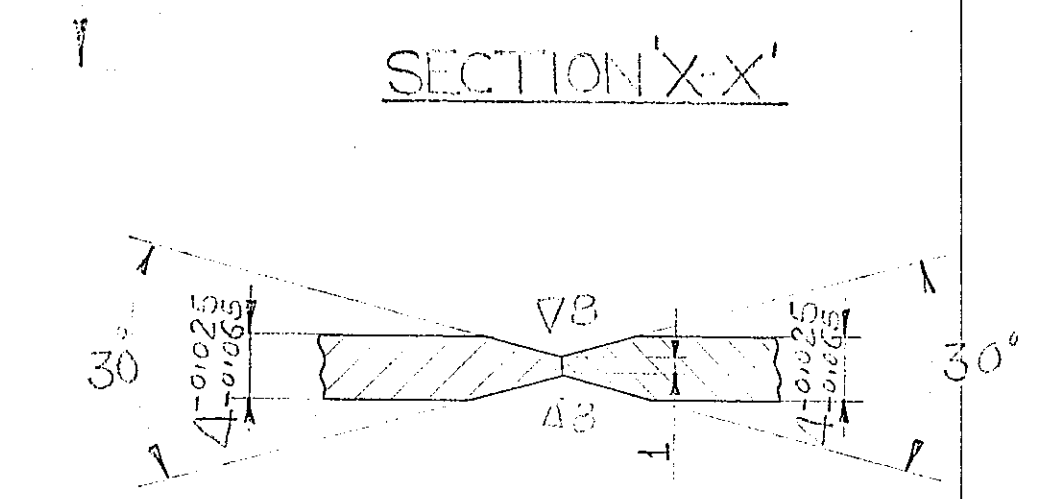
VAR. 00		REMARKS		ITEM NO.		DESCRIPTION		STD		DRAWING NO.		VAR		MATERIAL SPECN		UNIT		ZONE	
59		64		75		28		58		31		29		32		55		71	
27		25		23		21		19		17		15		13		11		9	
26		24		22		20		18		16		14		12		10		8	
25		23		21		19		17		15		13		11		9		7	
24		22		20		18		16		14		12		10		8		6	
23		21		19		17		15		13		11		9		7		5	
22		20		18		16		14		12		10		8		6		4	
21		19		17		15		13		11		9		7		5		3	
20		18		16		14		12		10		8		6		4		2	
19		17		15		13		11		9		7		5		3		1	
18		16		14		12		10		8		6		4		2		0	
17		15		13		11		9		7		5		3		1		-1	
16		14		12		10		8		6		4		2		0		-2	
15		13		11		9		7		5		3		1		-1		-3	
14		12		10		8		6		4		2		0		-2		-4	
13		11		9		7		5		3		1		-1		-3		-5	
12		10		8		6		4		2		0		-2		-4		-6	
11		9		7		5		3		1		-1		-3		-5		-7	
10		8		6		4		2		0		-2		-4		-6		-8	
9		7		5		3		1		-1		-3		-5		-7		-9	
8		6		4		2		0		-2		-4		-6		-8		-10	
7		5		3		1		-1		-3		-5		-7		-9		-11	
6		4		2		0		-2		-4		-6		-8		-10		-12	
5		3		1		-1		-3		-5		-7		-9		-11		-13	
4		2		0		-2		-4		-6		-8		-10		-12		-14	
3		1		-1		-3		-5		-7		-9		-11		-13		-15	
2		0		-2		-4		-6		-8		-10		-12		-14		-16	
1		-1		-3		-5		-7		-9		-11		-13		-15		-17	
0		-2		-4		-6		-8		-10		-12		-14		-16		-18	
-1		-3		-5		-7		-9		-11		-13		-15		-17		-19	
-2		-4		-6		-8		-10		-12		-14		-16		-18		-20	
-3		-5		-7		-9		-11		-13		-15		-17		-19		-21	
-4		-6		-8		-10		-12		-14		-16		-18		-20		-22	
-5		-7		-9		-11		-13		-15		-17		-19		-21		-23	
-6		-8		-10		-12		-14		-16		-18		-20		-22		-24	
-7		-9		-11		-13		-15		-17		-19		-21		-23		-25	
-8		-10		-12		-14		-16		-18		-20		-22		-24		-26	
-9		-11		-13		-15		-17		-19		-21		-23		-25		-27	
-10		-12		-14		-16		-18		-20		-22		-24		-26		-28	
-11		-13		-15		-17		-19		-21		-23		-25		-27		-29	
-12		-14		-16		-18		-20		-22		-24		-26		-28		-30	
-13		-15		-17		-19		-21		-23		-25		-27		-29		-31	
-14		-16		-18		-20		-22		-24		-26		-28		-30		-32	
-15		-17		-19		-21		-23		-25		-27		-29		-31		-33	
-16		-18		-20		-22		-24		-26		-28		-30		-32		-34	
-17		-19		-21		-23		-25		-27		-29		-31		-33		-35	
-18		-20		-22		-24		-26		-28		-30		-32		-34		-36	
-19		-21		-23		-25		-27		-29		-31		-33		-35		-37	
-20		-22		-24		-26		-28		-30		-32		-34		-36		-38	
-21		-23		-25		-27		-29		-31		-33		-35		-37		-39	
-22		-24		-26		-28		-30		-32		-34		-36		-38		-40	
-23		-25		-27		-29		-31		-33		-35		-37		-39		-41	
-24		-26		-28		-30		-32		-34		-36		-38		-40		-42	
-25		-27		-29		-31		-33		-35		-37		-39		-41		-43	
-26		-28		-30		-32		-34		-36		-38		-40		-42		-44	
-27		-29		-31		-33		-35		-37		-39		-41		-43		-45	
-28		-30		-32		-34		-36		-38		-40		-42		-44		-46	
-29		-31		-33		-35		-37		-39		-41		-43		-45		-47	
-30		-32		-34		-36		-38		-40		-42		-44		-46		-48	
-31		-33		-35		-37		-39		-41		-43		-45		-47		-49	
-32		-34		-36		-38		-40		-42		-44		-46		-48		-50	
-33		-35		-37		-39		-41		-43		-45		-47		-49		-51	
-34		-36		-38		-40		-42		-44		-46		-48		-50		-52	
-35		-37		-39		-41		-43		-45		-47		-49		-51		-53	
-36		-38		-40		-42		-44		-46		-48		-50		-52		-54	
-37		-39		-41		-43		-45		-47		-49		-51		-53		-55	
-38		-40		-42		-44		-46		-48		-50		-52		-54		-56	
-39		-41		-43		-45		-47		-49		-51		-53		-55		-57	
-40		-42		-44		-46		-48		-50		-52		-54		-56		-58	
-41		-43		-45		-47		-49		-51		-53		-55		-57		-59	
-42		-44		-46		-48		-50		-52		-54		-56		-58		-60	
-43		-45		-47		-49		-51		-53		-55		-57		-59		-61	
-44		-46		-48		-50		-52		-54		-56		-58		-60		-62	
-45		-47		-49		-51		-53		-55		-57		-59		-61		-63	
-46		-48		-50		-52		-54		-56		-58		-60		-62		-64	
-47		-49		-51		-53		-55		-57		-59		-61		-63		-65	
-48		-50		-52		-54		-56		-58		-60		-62		-64		-66	
-49		-51		-53		-55		-57		-59		-61		-63		-65		-67	
-50		-52		-54		-56		-58		-60		-62		-64		-66		-68	
-51		-53		-55		-57		-59		-61		-63		-65		-67		-69	
-52		-54		-56		-58		-60		-62		-64		-66		-68		-70	
-53		-55		-57		-59		-61		-63		-65		-67		-69		-71	
-54		-56		-58		-60		-62		-64		-66		-68		-70		-72	
-55		-57		-59		-61		-63		-65		-67		-69		-71		-73	
-56		-58		-60		-62		-64		-66		-68		-70		-72		-74	
-57		-59		-61		-63		-65		-67		-69		-71		-73		-75	
-58		-60		-62		-64		-66		-68		-70		-72		-74		-76	
-59		-61		-63		-65		-67		-69		-71		-73		-75		-77	
-60		-62		-64		-66		-68		-70		-72		-74		-76		-78	
-61		-63		-65		-67		-69		-71		-73		-75		-77		-79	
-62		-64		-66		-68		-70		-72		-74		-76		-78		-80	
-63		-65		-67		-69		-71		-73		-75		-77		-79		-81	
-64		-66		-68		-70		-72		-74		-76		-78		-80		-82	
-65		-67		-69		-71		-73		-75		-77		-79		-81		-83	
-66		-68		-70		-72		-74		-76		-78		-80		-82		-84	
-67		-69		-71		-73		-75		-77		-79		-81		-83		-85	
-68		-70		-72		-74		-76		-78		-80		-82		-84		-86	
-69		-71		-73		-75		-77		-79		-81		-83		-85		-87	
-70		-72		-74		-76		-78		-80		-82		-84		-86		-88	
-71		-73		-75		-77		-79		-81		-83		-85		-87		-89	
-72		-74		-76		-78		-80		-82		-84		-86		-88		-90	
-73		-75		-77		-79		-81		-83		-85		-87		-89		-91	
-74		-76		-78		-80		-82		-84		-86		-88		-90		-92	
-75		-77		-79		-81		-83		-85		-87		-89		-91		-93	
-76		-78		-80		-82		-84		-86		-88		-90		-92		-94	
-77		-79		-81		-83		-85		-87		-89		-91		-93		-95	
-78		-80		-82		-84		-86		-88		-90		-92		-94		-96	
-79		-81		-83		-85		-87		-89		-91		-93		-95		-97	
-80		-82		-84		-86		-88		-90		-92		-94		-96		-98	
-81		-83		-85		-87		-89		-91		-93		-95		-97		-99	
-82		-84		-86		-88		-90		-92		-94		-96		-98		-100	
-83</																			

1.6 / THE REST

DRAWING NO.
R-8390-1007 ÷ 1014

FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

FORM DG 44B



- | | | | | | | | |
|------------|------------|------------------------|------|----------------------|-------------------|------------|------------|
| 4 | — | TEMPLATE FOR PAD | 1 | | | 60 C 2A | |
| 3 | — | COUNTER TEMPLATE | 1 | | | 60 C 2A | |
| 2 | — | MASTER TEMPLATE | 1 | | | 60 C 2A | |
| 1 | — | STANDARD TEMPLATE | 1 | | | 60 C 2A | |
| ITEM NO. | DRG. NO. | DESCRIPTION | QTY | PER UNIT WEIGHT (KG) | TOTAL WEIGHT (KG) | MATERIAL | REMARKS |
| | | C-200-130 | | | | | |
| | | TEMPLATE | | | | R8392-0334 | |
| | | (Glass) | | | | | |
| | | C TEMPLATE | | | | | |
| | | FOR EXT. MOD. SEC. I-I | | | | | |
| | | STR-206 & 212 | | | | | |
| | | 6.9750-707 | | | | | |
| CHKD. NOS. | DOCU. NO. | SIGNATURE | DATE | LETTER | WEIGHT | SCALE | |
| WORKED | C.P. DATTA | <i>Chandra</i> | | | | 2 : 1 | |
| CHECKED | JIG. SENGH | <i>Jig Singh</i> | | | | | |
| SUPERCD | V.P. SINGH | <i>V.P. Singh</i> | | | | | |
| TESTED | SHARMA | <i>Sharma</i> | | | | | |
| APPROVED | V.P. SINGH | <i>V.P. Singh</i> | | | | | |
| | | | | SHEET 1 | SHEET 10 | HEEP | JIG & TOOL |

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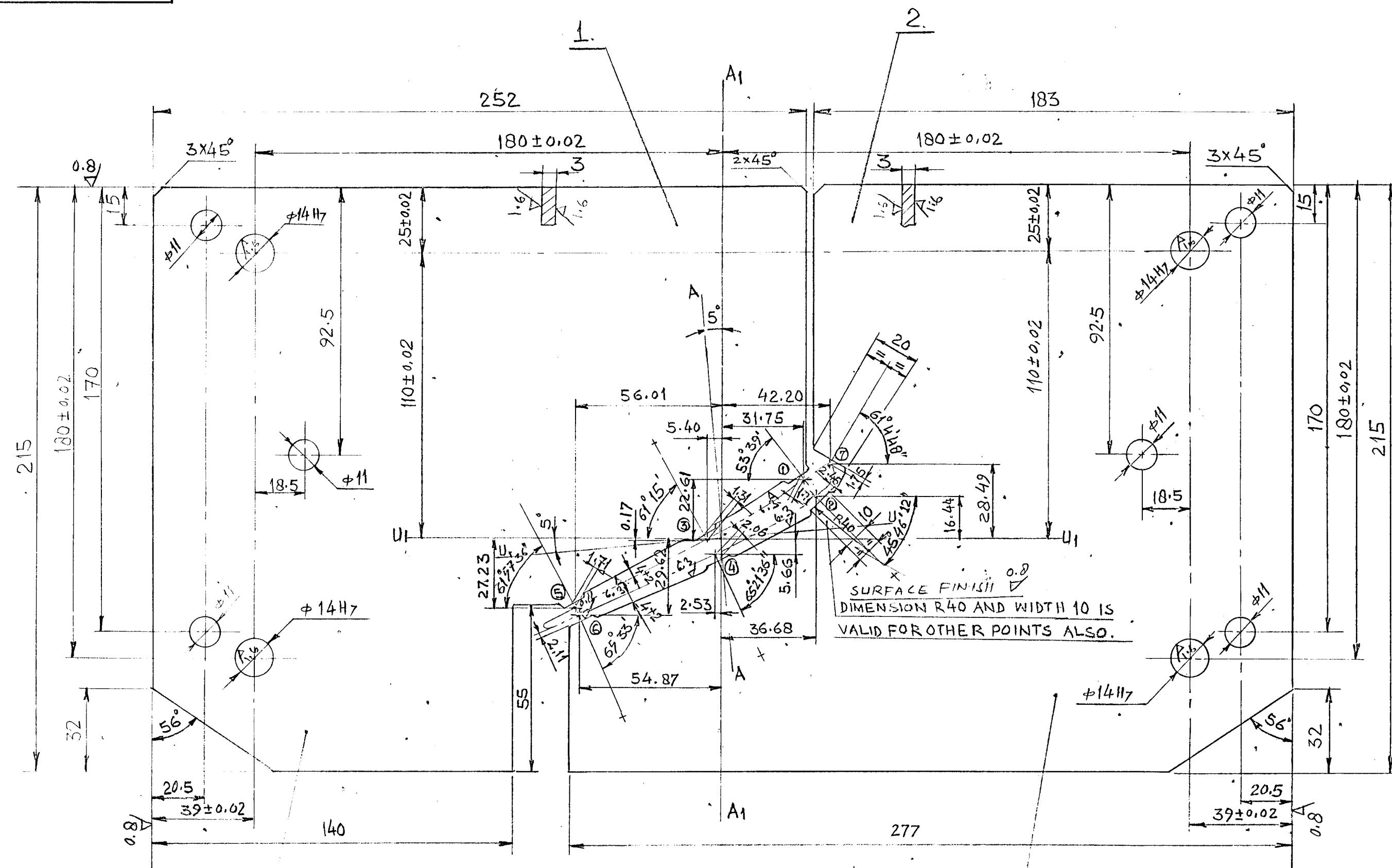
FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

FORM DG 44A

DRAWING NO. R 8392-1032-1033

6.3 THE REST



MARK ON BOTH SIDES.

- 1 MAX. 3.42
- 2 MAX. 4.22
- 3 MAX. 2.62
- 4 MAX. 3.42
- 5 MAX. 3.42
- 6 MAX. 3.82
- 7 MAX. 3.50

MARK
R 8392-1032
SEC. C-C
INNER PROFILE
MEASURING POINT 1,3,4,5
250 M.W. ; L.P.2 L+R

ITEM NO.	W/ORDER NO.	DRAWING NO.
1.	KBM-5038	R8392-1032
2.	KBM-5042	R8392-1033

MARK
R 8392-1033
SEC. C-C
OUTER PROFILE
MEASURING POINT 2,4,6,7
250 M.W. ; L.P.2 L+R

TECH REQ:-

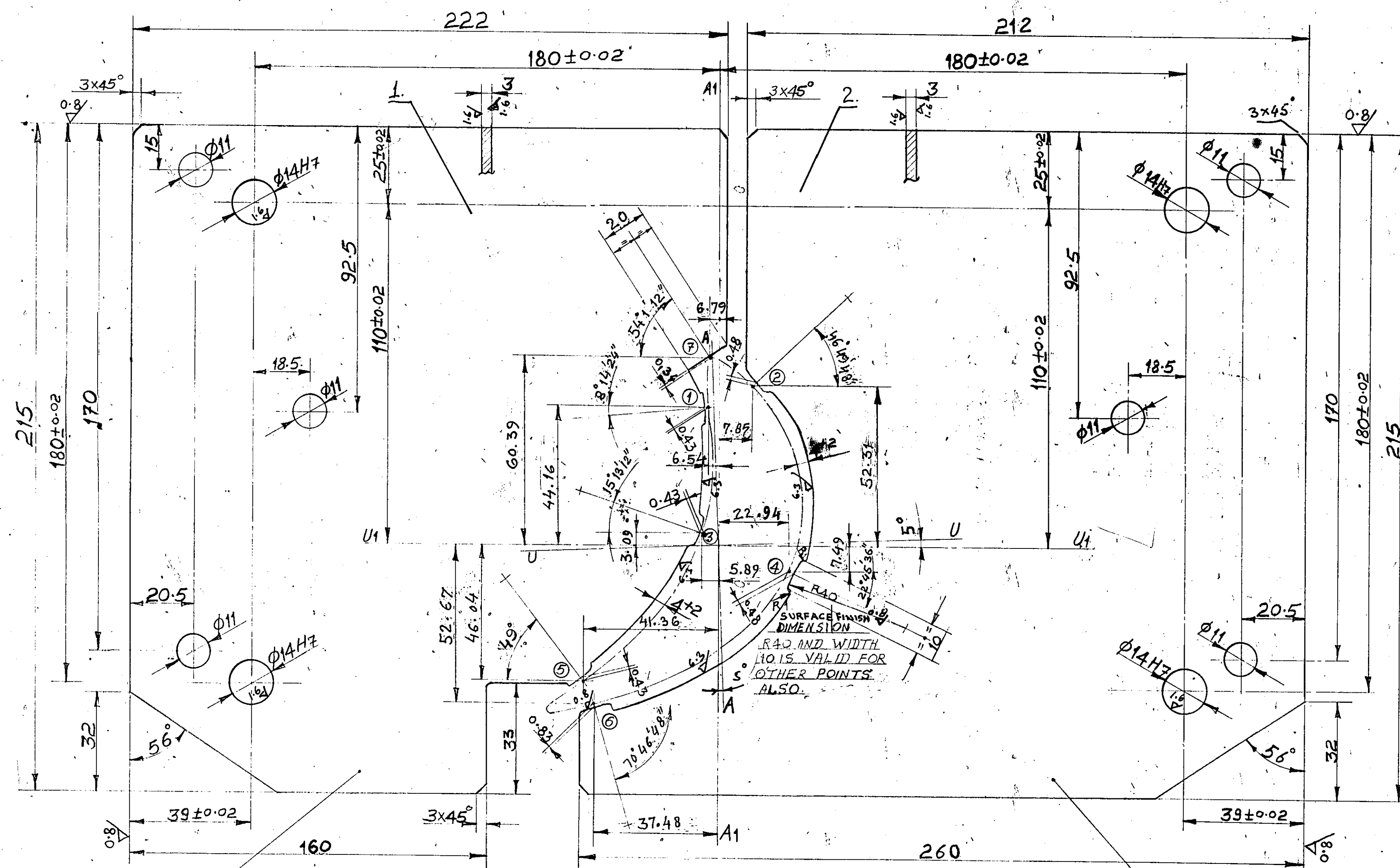
1. HARDEN TO HRC 50±55 (ONLY PROFILE.)
2. TO BE USED WITH WE 0-13-3400.
3. BLADE PROFILE AS PER DRG NO. 21030705021.
4. MANUFACTURING ACCURACY OF PROFILE ±0.02.

VAR. 00	REMARKS	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	T90 M.W. W.C.T.	1-3749	MATERIAL CODE	A	UNIT WEIGHT	65	5	ZONE
59	64	65	75	25	27	29	58	69	60	77	32	33	46
CARD TYPE 3 28 →						28 → CARD TYPE-1		28 → CARD TYPE-2					
GMS NO./GR SP NO.			STATUS OF DRG		TYPE OF PRODUCT		COMP. DRG. NO.		M/C TOOL TRANS NO.		REF. DRG. NO.		
AGREED DEPT.			NAME		SIGN.		DATE		M/C MODEL NO.		INVENTORY NO.		
P.E.B.			P.V. SINGH		11/11/92		28/9/92		V.S. (BIG)				
GRADE OF UNTOL DIM			M/CG-Q/M/F AA 0230208		WELDING-A/B/C/DAA 0621104		GAS CUTTING-T3' AA 0621101		NAME		SIGN		
REV DATE			ALTERED		REV DATE		ALTERED		DRN		V.C. GUPTA		
ZONE			CHECKED		ZONE		CHECKED		CHD		A.P. AGARWAL		
DEPT			CODE		Bharat Heavy Electricals Ltd		HARDWARE		APD		REF TO ASSY DRG.		
TITLE			CHECKING TEMPLATE SEC. C-C (INNER & OUTER) 250 M.W. (F-4)		SCALE		WEIGHT (kg)		NO. OF VAR.		NO. OF ITEMS		
CARD CODE			DRAWING NO.		SHEET NO.		NO. OF SHEETS		REV.				
			R 8392-1032-1033						23		24		

SIZE A2

DRAWING NUMBER
R8392-1036-37

THE REST.



MARK
R8392-1036
SEC. L-L'
INNER PROFILE
MEASURING POINT 13.5, 7
250 M.W. L&R

ITEM NO.	W/ORDER NO.	DRAWING NO.
1.	KBM-5040	R8392-1036
2.	KBM-5044	R8392-1037

MARK
R8392-1037
SEC. L-L'
OUTER PROFILE
MEASURING POINT 24.6
250 M.W. L&R

MARK ON BOTH SIDES.

1. MAX. 0.86
2. MAX. 1.66
3. MAX. 0.86
4. MAX. 1.66
5. MAX. 0.86
6. MAX. 1.26
7. MAX. 0.68

TECH. REQ:-

1. HARDEN TO HRC 50-55 (ONLY PROFILE).
2. TO BE USED WITH WE-0-13-3400.
3. BLADE PROFILE AS PER DRG. NO. 21030705021.
4. MANUFACTURING ACCURACY OF PROFILE ± 0.02 .

VAR.00	REMARKS	ITEM NO.	DESCRIPTION	DRAWING NO.	T90 M.H.G. W.C.Y.2	15:3749	UNIT WT. (Kg)	QTY.	ZONE
59	64	65	76	27	29	31	55	57	73
CARD TYPE-3 28				CARD TYPE-1		CARD TYPE-2			
GMS/GR. SP. NO.				STATUS OF DRG.		TYPE OF PRODUCT			
AGREED DEPT.				NAME		SIGN.		DATE	
P.E.D. P. Singh				11/12/2025		25-3-92			
NAME OF CUSTOMER				PRD. NO.		M/G. TOOL MODEL		V.S. (BIG)	
Bharat Heavy Electricals Ltd.				RANIPUR - HARDWAR		NAME		DATE	
V.C.G.				H.N.S.		A.P.A.		73, 74	
DEPT.				GRADE OF UNFOLD		SCALE		WEIGHT (Kg)	
125				C/M/P		1:1		~25	
TITLE				CHECKING TEMPLATE		DRAWING NO.		REV.	
SEC. L-L' (INNER & OUTER)				250 M.W. (F-4) L&R		R8392-1036-37		22, 23, 24	
SHEET NO.				NO. OF SHEETS:-		SIZE A1			

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1-89440

INVENTORY NO. SIGN & DATE REF. DRG. NO.

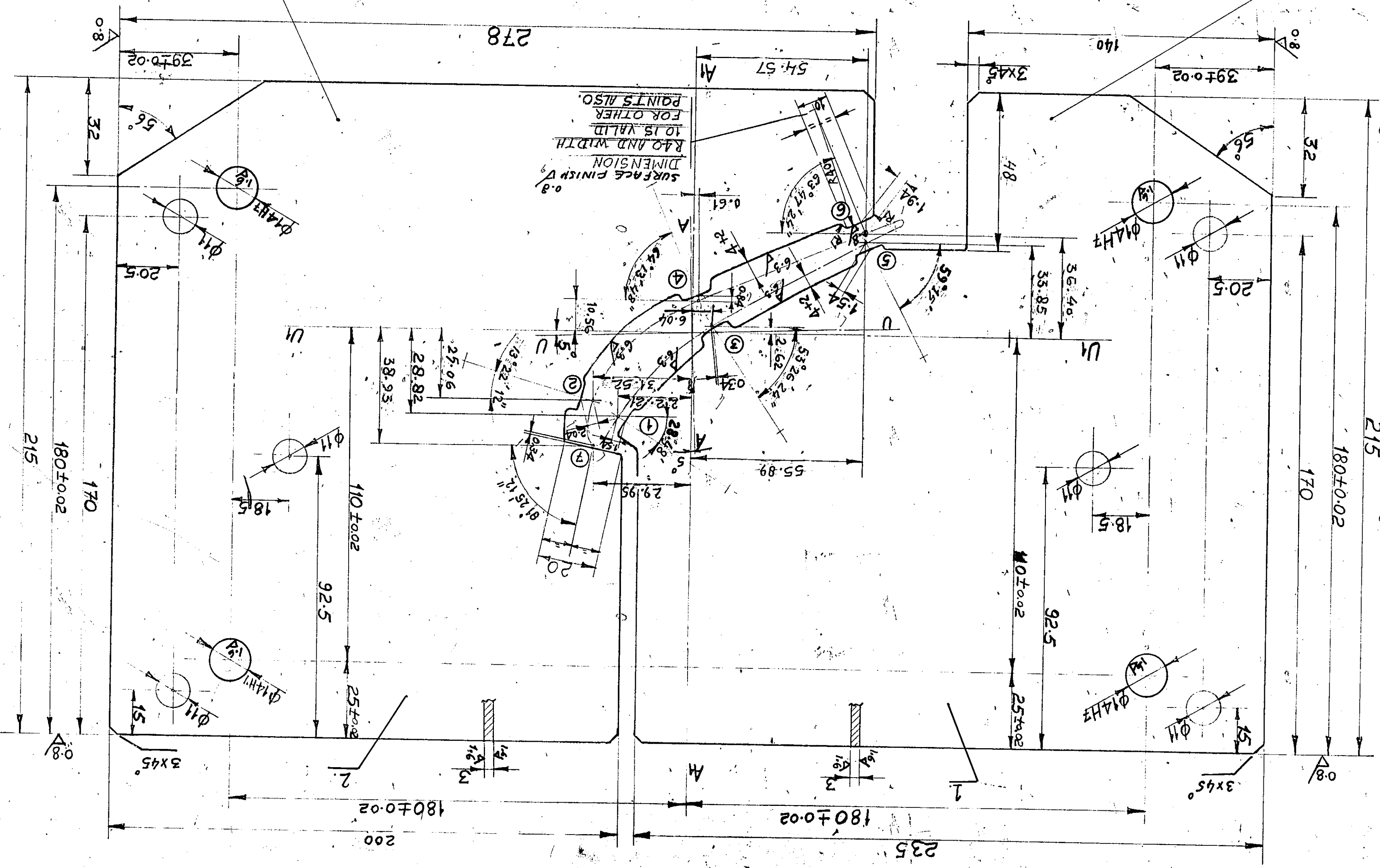
MARK
R8392-1038
SEC. F-F
INNER PROFILE
MEASURING POINT 13.5
250MM W x L&R

ITEM NO.	W/ORDER NO.	DRAWING NO.
1	KBM-5039	R8392-1038
2	KBM-5043	R8392-1039

MARK
R8392-1039
SEC. F-F
OUTER PROFILE
MEASURING POINT 24.42
250MM W x L&R

- TECH. REQ.:-
1. HARDEN TO HRC 50+55 (ONLY PROFILE).
 2. TO BE USED WITH WE-0-13-3400.
 3. BLADE PROFILE AS PER DRG. NO. 21030705021.
 4. MANUFACTURING ACCURACY OF PROFILE ± 0.02 .

- MARK ON BOTH SIDES
1. MAX. 3.08
 2. MAX. 3.88
 3. MAX. 0.68
 4. MAX. 1.48
 5. MAX. 3.08
 6. MAX. 3.48
 7. MAX. 0.68



SHEET NO. 12329		NO. OF SHEETS: 2	
DRAWING NO. R8392-1038-39		CAGE CODE	
TITLE: CHECKING TEMPLATE SEC. F-F (INNER & OUTER)		250MM W. (F-F) L&R	
REV. NO.	DATE	REV. NO.	DATE
1	25.08.20	1	25.08.20
2	25.08.20	2	25.08.20
3	25.08.20	3	25.08.20
4	25.08.20	4	25.08.20
5	25.08.20	5	25.08.20
6	25.08.20	6	25.08.20
7	25.08.20	7	25.08.20
8	25.08.20	8	25.08.20
9	25.08.20	9	25.08.20
10	25.08.20	10	25.08.20
11	25.08.20	11	25.08.20
12	25.08.20	12	25.08.20
13	25.08.20	13	25.08.20
14	25.08.20	14	25.08.20
15	25.08.20	15	25.08.20
16	25.08.20	16	25.08.20
17	25.08.20	17	25.08.20
18	25.08.20	18	25.08.20
19	25.08.20	19	25.08.20
20	25.08.20	20	25.08.20
21	25.08.20	21	25.08.20
22	25.08.20	22	25.08.20
23	25.08.20	23	25.08.20
24	25.08.20	24	25.08.20
25	25.08.20	25	25.08.20
26	25.08.20	26	25.08.20
27	25.08.20	27	25.08.20
28	25.08.20	28	25.08.20
29	25.08.20	29	25.08.20
30	25.08.20	30	25.08.20
31	25.08.20	31	25.08.20
32	25.08.20	32	25.08.20
33	25.08.20	33	25.08.20
34	25.08.20	34	25.08.20
35	25.08.20	35	25.08.20
36	25.08.20	36	25.08.20
37	25.08.20	37	25.08.20
38	25.08.20	38	25.08.20
39	25.08.20	39	25.08.20
40	25.08.20	40	25.08.20
41	25.08.20	41	25.08.20
42	25.08.20	42	25.08.20
43	25.08.20	43	25.08.20
44	25.08.20	44	25.08.20
45	25.08.20	45	25.08.20
46	25.08.20	46	25.08.20
47	25.08.20	47	25.08.20
48	25.08.20	48	25.08.20
49	25.08.20	49	25.08.20
50	25.08.20	50	25.08.20
51	25.08.20	51	25.08.20
52	25.08.20	52	25.08.20
53	25.08.20	53	25.08.20
54	25.08.20	54	25.08.20
55	25.08.20	55	25.08.20
56	25.08.20	56	25.08.20
57	25.08.20	57	25.08.20
58	25.08.20	58	25.08.20
59	25.08.20	59	25.08.20
60	25.08.20	60	25.08.20
61	25.08.20	61	25.08.20
62	25.08.20	62	25.08.20
63	25.08.20	63	25.08.20
64	25.08.20	64	25.08.20
65	25.08.20	65	25.08.20
66	25.08.20	66	25.08.20
67	25.08.20	67	25.08.20
68	25.08.20	68	25.08.20
69	25.08.20	69	25.08.20
70	25.08.20	70	25.08.20
71	25.08.20	71	25.08.20
72	25.08.20	72	25.08.20
73	25.08.20	73	25.08.20
74	25.08.20	74	25.08.20
75	25.08.20	75	25.08.20
76	25.08.20	76	25.08.20
77	25.08.20	77	25.08.20
78	25.08.20	78	25.08.20
79	25.08.20	79	25.08.20
80	25.08.20	80	25.08.20
81	25.08.20	81	25.08.20
82	25.08.20	82	25.08.20
83	25.08.20	83	25.08.20
84	25.08.20	84	25.08.20
85	25.08.20	85	25.08.20
86	25.08.20	86	25.08.20
87	25.08.20	87	25.08.20
88	25.08.20	88	25.08.20
89	25.08.20	89	25.08.20
90	25.08.20	90	25.08.20
91	25.08.20	91	25.08.20
92	25.08.20	92	25.08.20
93	25.08.20	93	25.08.20
94	25.08.20	94	25.08.20
95	25.08.20	95	25.08.20
96	25.08.20	96	25.08.20
97	25.08.20	97	25.08.20
98	25.08.20	98	25.08.20
99	25.08.20	99	25.08.20
100	25.08.20	100	25.08.20

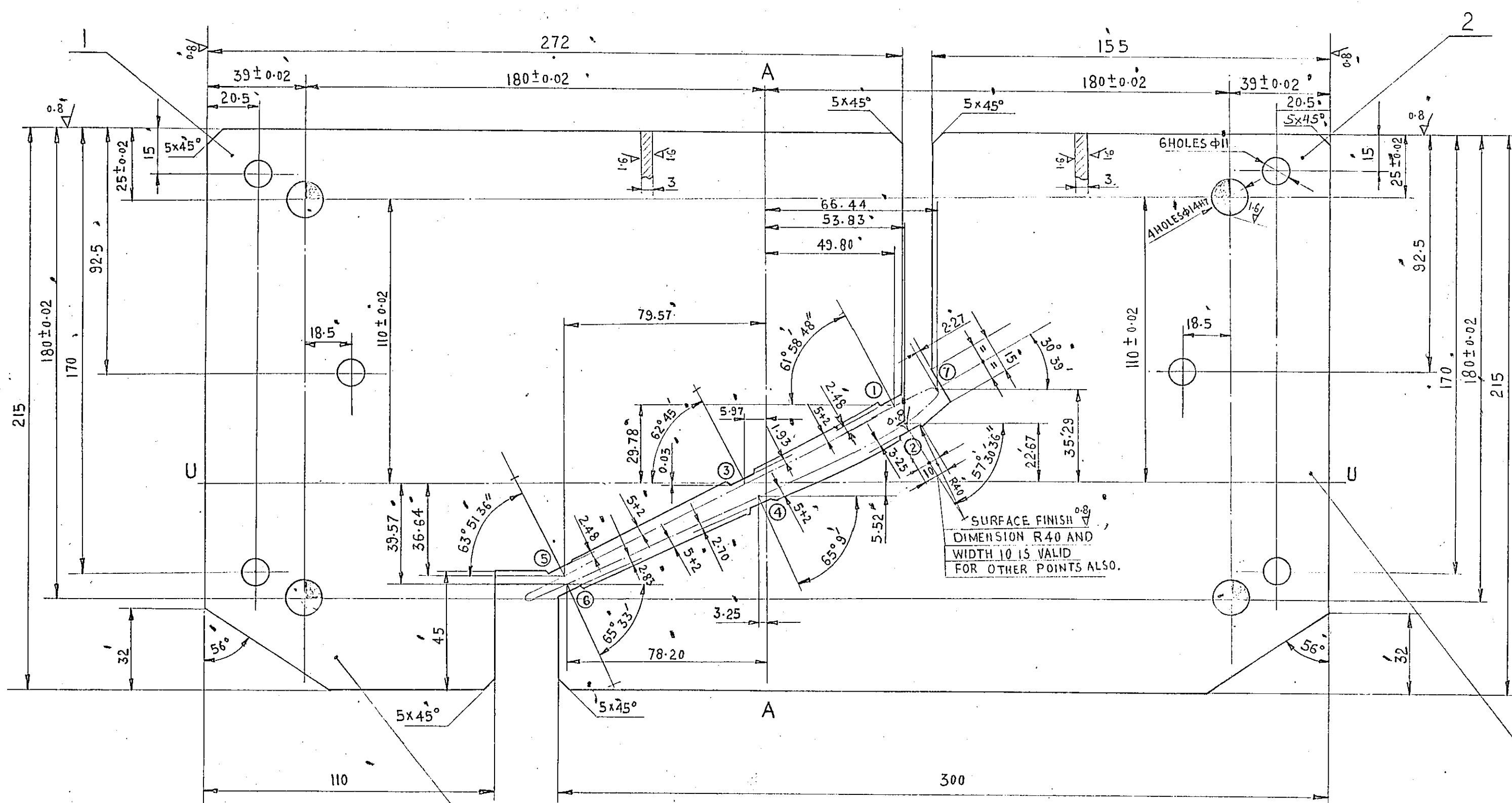
6.3 THE REST

FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN (mm))

DRAWING NUMBER R8392-1038-39

DRAWING NO. R 83 92 - 1051 ÷ 1052

63 THE REST



1. MAX. 4.76
2. MAX. 5.86
3. MAX. 3.66
4. MAX. 4.76
5. MAX. 4.76
6. MAX. 5.31
7. MAX. 4.54

MARK

R 8392 - 1052
SEC. C-C; 250 MW.
OUTER PROFILE
LP-3 L&R

MARK

R 8392 - 1051
SEC. C-C, 250 M.W.
INNER PROFILE
LP-3 L&B

SL.NO	W/O NO	DRG. NO.
1	KBM 5077	R 8392-1051
2	KBM 5081	R 8392-1052

NOTES

1. HARDEN TO HRC 50-55 (ONLY PROFILE)
2. TO BE USED WITH WEO-13-3400
3. BLADE PROFILE AS PER DRG. NO. 21030722022
4. MANUFACTURING ACCURACY OF PROFILE ± 0.02

																		T90mm 2W 50Cr 45																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
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GMS NO./GR SP NO		STATUS OF DRG		TYPE OF PRODUCT		COMP.DRG NO. 1-103-07-22003&6		M/C TOOL TRANS NO.		REF. DRG. NO. WE0-13-4852	
AGREED DEPT.	NAME	SIGN	DATE	250 MW BLADES		W/O NO. KBM-507785081		M/C TOOL MODEL NO.		INV. NO.	
P.E.B	P.V.SINGH	11/10/81	13/10/81								

GRADE OF UNTOL DIM :—
M/CG- C /M/F AA 0230208
WELDING-A/B/C/DAA0621104
GAS CUTTING 'T3' AA 0621101

REV	DATE	ALTERED
		CHECKED
ZONE		

	BHARAT HEAVY ELECTRICALS LTD HARDWAR		NAME	SIGN.	DATE	N
		DRN	S.S.SAXENA	✓		0
		CHD	H.N. SHARMA	H.N.S		VA
		APD	A.P. AGRAWAL			73

REV	DATE	ALTERED	DEPT	JTE		SCALE	WEIGHT (kg)	REF TO ASSY DRG.	ITEM NO	NO
		CHECKED				N.T.S.	~ 1.15 (EACH)			ITE
ZONE			CODE	125						

TITLE	CHECKING TEMPLATE (7 PANS) SEC. C-C (INNER & OUTER) (F-11) LP-3 L&R	1 CARD CODE	3 DRAWING NO. R 8392-1051-1052	RE
			SHEET NO.	NO OF SHEETS

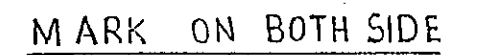
SIZE A2

THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANYWAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

INVENTORY NO.	SIGN & DATE	REF. DRG. NO.
---------------	-------------	---------------

2-1317

63/ THE REST



- | | |
|---------|------|
| 1. MAX. | 1.16 |
| 2. MAX. | 2.26 |
| 3. MAX. | 1.16 |
| 4. MAX. | 2.26 |
| 5. MAX. | 1.16 |
| 6. MAX. | 1.71 |
| 7. MAX. | 0.68 |

R 8392-1106
SEC. 0-0, 250 MW.
INNER PROFILE
LP-3 L&R

R 8392-11.07
SEC. O-O 250MW
OUTER PROFILE
LP-3 L&R

SL. NO	W/O NO.	DRG. NO.
1	KBM - 5079	R8392 - 1106
2	KBM - 5083	R8392 - 1107

1. HARDEN TO HRC 50-55 (ONLY PROFILE.)
2. TO BE USED WITH WE O-13-3400
3. BLADE PROFILE AS PER DRG. NO. 21030722022
4. MANUFACTURING ACCURACY OF PROFILE ± 0.02

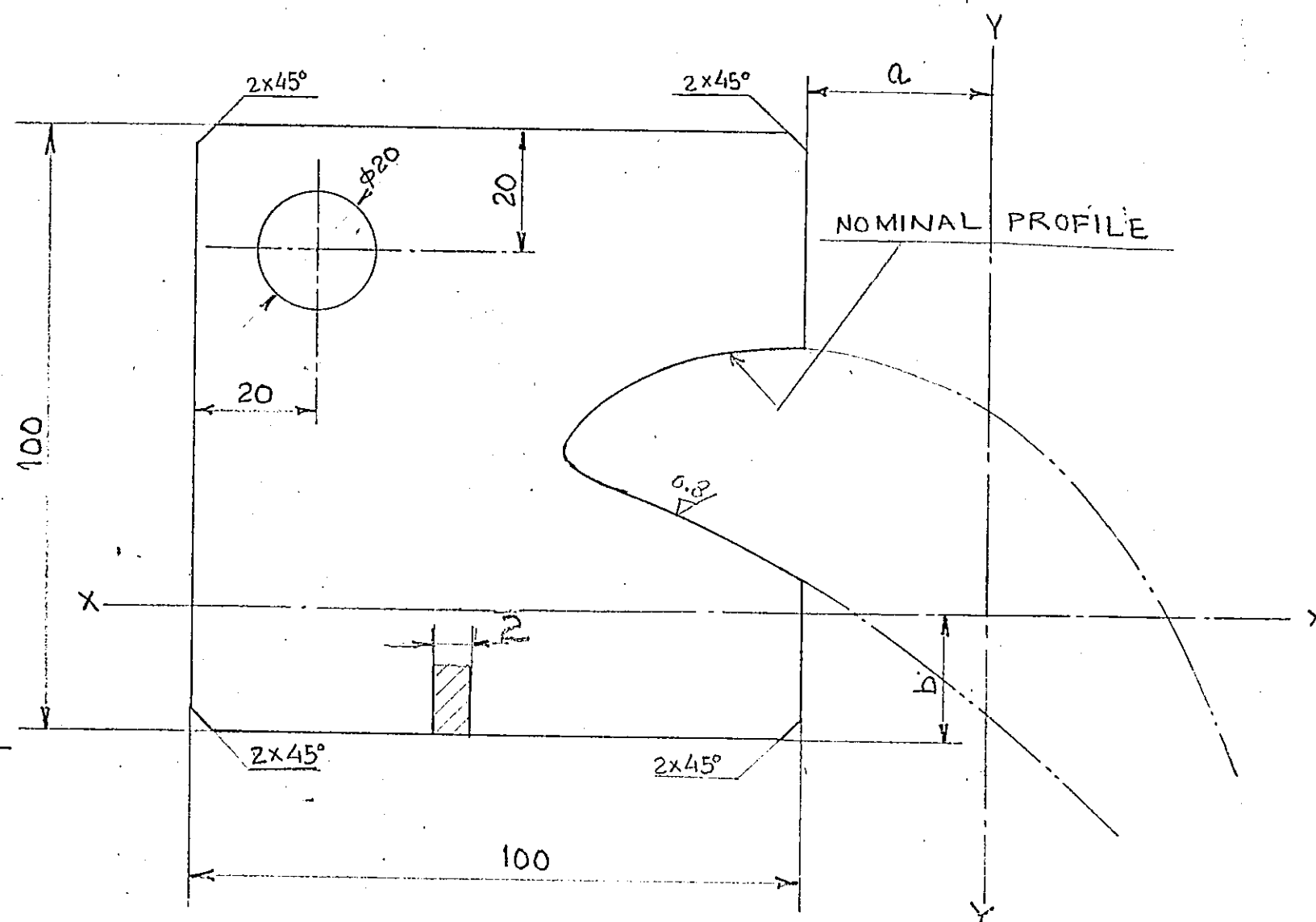
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SIZE A2

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

FORM DG 38(B)

DRAWING NO.
R-8392-1149-11536.3 /
THE REST

SL. NO.	SECTION	a	b	DESIGN W/O NO.	DRG NO.
1	i-l	37	23	K250 WT6 ST-760	R-8392-1149
2	K-K	32	25	K250 WT6 ST-761	R-8392-1150
3	e-c	27	27	K250 WT6 ST-762	R-8392-1151
4	m-m	20	30	K-250 WT6 ST-763	R-8392-1152
5	O-O	15	33	K-250 WT6 ST-764	R-8392-1153

MARK
DRG NO R-
SEC. --- ; F-25

1 PROFILE DRG NO 1-11123-01013.

2. CONSERVATION TO BE DONE AS PER TL-30007

3. TO BE NITRIDED TO VHN > 450 AS PER
PS 0012-0024. PROFILE TO BE CHECKED/MATCHED
PERFECTLY WITH THE HELP OF CORRESPOND-
ING SHADOW-GRAPH.

GRADE OF UNTOL. DIM.

M/CG-C/M/F AA 0230208

WELDING-A/B/C/D AA0621104

GAS CUTTING 'T3' AA0621101

REV DATE ALTERED
CHECKED

GMS NO./GR. SP. NO.

STATUS
OF DRG.

TYPE OF PRODUCT

COMP. DRG NO.

MIC TOOL TRANS NO.

REF. DRG NO.

AGREED DEPT. NAME SIGN DATE
W.T. B. CHAUDHARY (B.L.) 13-1-95250 M.W (S.T)
BLADESDESIGN W/O NO.
SEE - TABLE

MIC TOOL MODEL NO.

INVENTORY NO.

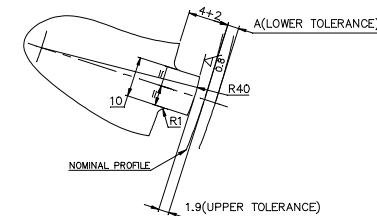
BHARAT HEAVY ELECTRICALS LTD.
HARDWARNAME SIGN DATE NO. OF VAR.
DRN DARGAM 11-8-95 73/74
CHD SHARMA 11-8-95 73/74
APD AGRAWAL 11-8-95 73/74DEPT. JTE
CODE 209SCALE
N.T.S.WEIGHT (kg)
2 each

REF. TO ASSY. DRG.

ITEM NO. 75/77

CHECKING TEMPLATE FOR
INLET EDGE OF STAGE 3L&3R
(F-25)DRAWING NO.
R-8392-1149-1153
SHEET NO. - NO. OF SHEETS -

SIZE A3



SCALE-NTS

DETAIL-'K' FOR ALL POINTS.

 MARK

R8392-1461
SEC. A11-A11
INT. PROFILE
POINTS 1,3,5
800MW₁

◆ MARK

R8392-1462
SEC. A11-A11
EXT. PROFILE
POINTS 2,4,6,7
800MW.

TECH.REQ: —

- 1-SHARP EDGES TO BE ROUNDED OFF.
 *2-THE MAXIMUM TOLERANCE TO BE MARKED ON BOTH SIDES.
 3-HARDEN TO HRC. 50±5 AS PER PS. NO. Q912.008.
 4-TO BE USED WITH WE-013-3400-4537.
 5-PROFILE DRAWING No. 01030758022.
 6-MANUFACTURING ACCURACY OF PROFILE ± 0.02 .
 7-CONSERVATION TO BE DONE AS PER TL-30007.

ITEM NO.	PROFILE POINT	DIMENSION (A)	MAX.TOL. (A±1.9)	W./ORDER NO.	DRG.NO.	WEIGHT (kg)
01.	1	0.5	2.4	B/800/LF/050	R8392-1461	1.23
	3	0.5	2.4			
	5	0.5	2.4			
02.	2	1.9	3.8	B/800/LF/051	R8392-1462	1.48
	4	1.9	3.8			
	6	1.9	3.8			
	7	0.5	2.4			

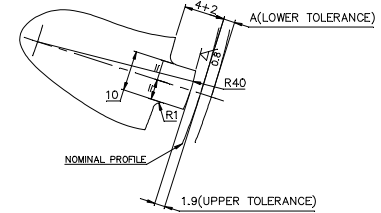
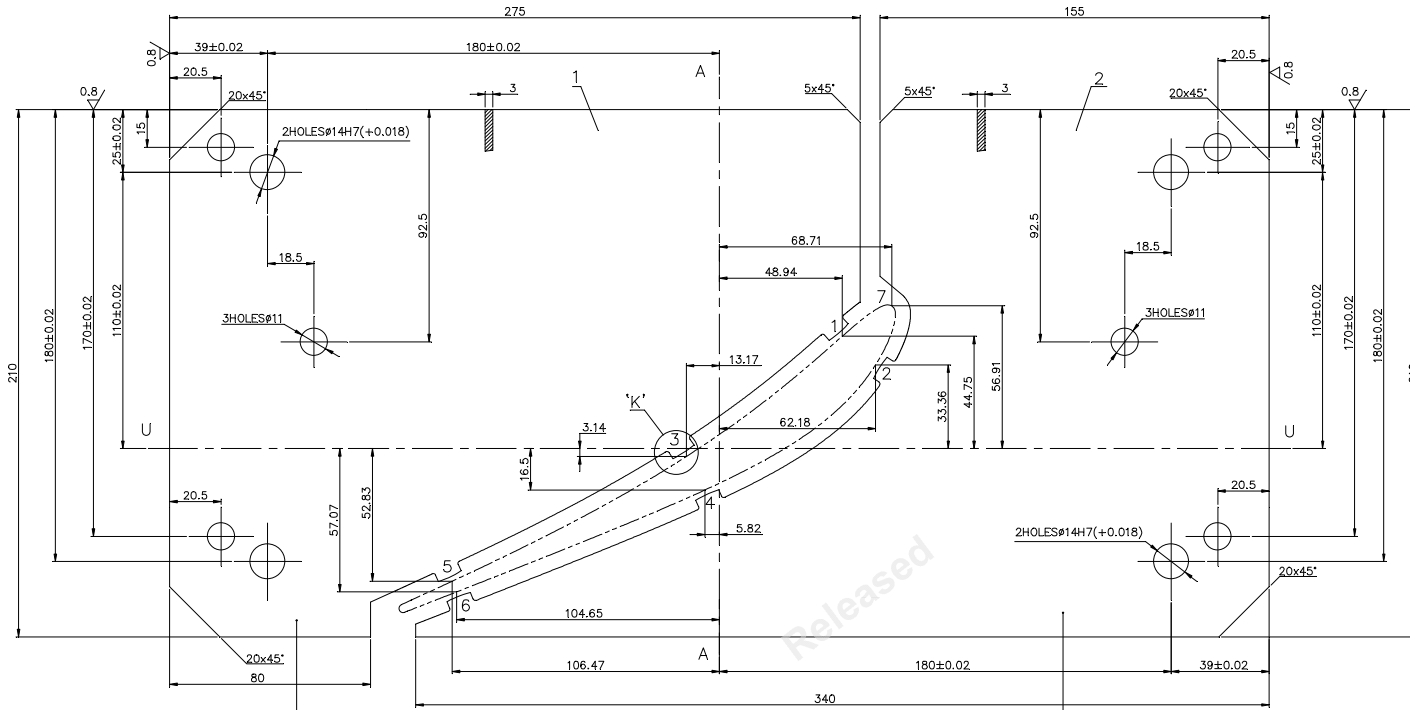
[illegible]

GMS No./GR.SP.No.		STATUS OF DRG.		TYPE OF PRODUCT		COMP. DRG. No. O-103-07-58002 O-103-07-58004		M/C TOOL TRANS No. 2631		REF. DRG. No.	
APPROVED BY TBM		NAME S.KUMAR		SIGN. -sd-		DATE 24-05-13		DESIGN ORDER No. SEE TABLE		R8392-1256	
				800 MW BLADES				MODEL No. BIG V. STAND			
				Incorporated changes				NAME DRLN. PRADEEP		SIGN. -sd-	
				BHEL				CAD CHAM QPD ANKUR		DATE 24-05-13	
				HARDWARE							
REV. DATE		ALTERED CHECKED		DEPT.		JTE		SCALE		WEIGHT(Kg.)	
								1:1		~2.71	
										REF. TO ASSY. DRG.	
										ITEM NO.	
										No. OF SHEETS	
REV. NO.		C/A No.		DATE		TITLE		DRAWING No. R8392-1461:1462		REV.	
						INT.&EXT. PROFILE CHECKING TEMPLATE AT SEC. A11-A11		SHEET No. 01		No. OF SHEET 01	

DRAWING No. R8392-1461-1461-1462

FIRST ANGLE PROJECTION (ALL DIMENSIONS IN m.m.)

FORM DG 45(B)



SCALE-NTS
DETAIL-'K' FOR ALL POINTS.

MARK

R8392-1461
SEC. A11-A11
INT. PROFILE
POINTS 1,3,5
800MW.

MARK

R8392-1462
SEC. A11-A11
EXT. PROFILE
POINTS 2,4,6,7
800MW.

TECH. REQ.:-

- 1-SHARP EDGES TO BE ROUNDED OFF.
- *2-THE MAXIMUM TOLERANCE TO BE MARKED ON BOTH SIDES.
- 3-HARDEN TO HRC. 50±55 AS PER PS. No. 0912.008.
- 4-TO BE USED WITH WE-013-3400-4537.
- 5-PROFILE DRAWING No. 01030758022.
- 6-MANUFACTURING ACCURACY OF PROFILE ±0.02.
- 7-CONSERVATION TO BE DONE AS PER TL-30007.

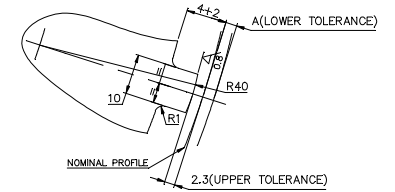
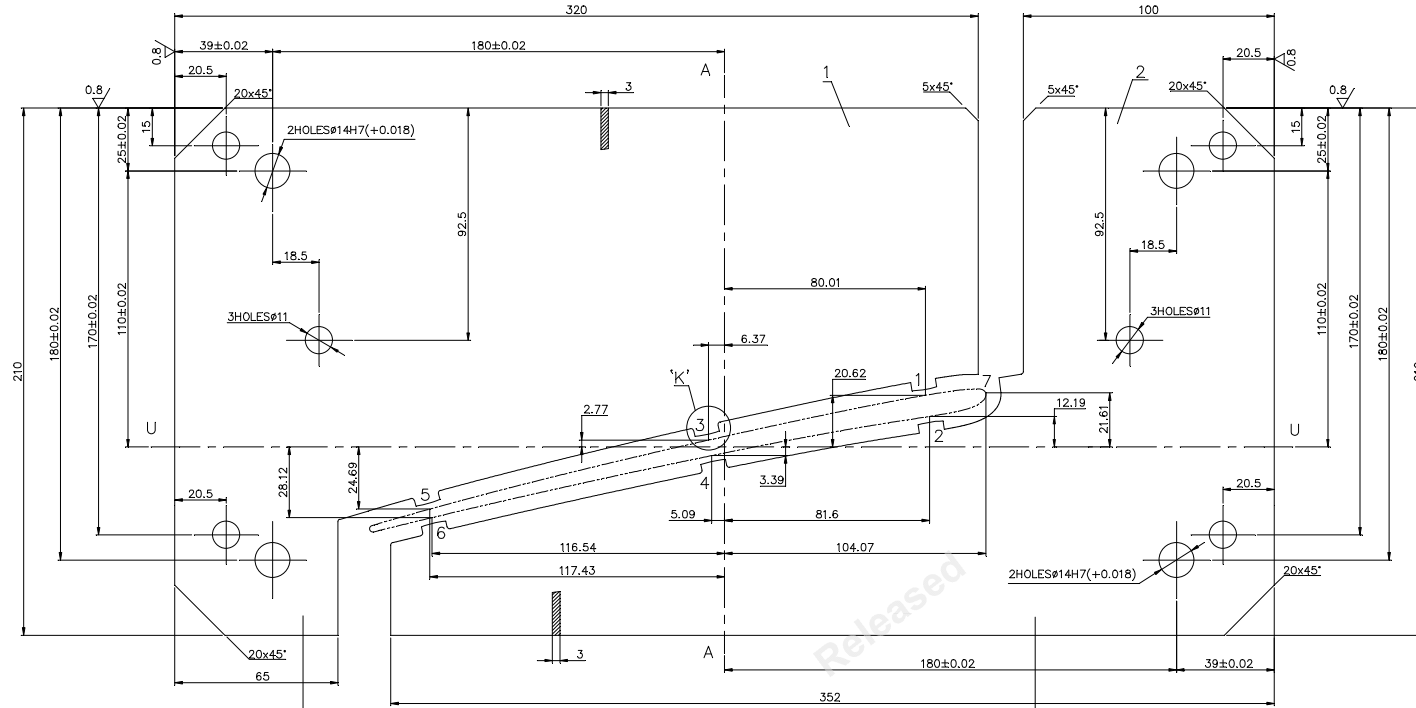
ITEM NO.	PROFILE POINT	DIMENSION (A)	*MAX.TOLE. (A±1.9)	W./ORDER NO.	DRG.NO.	WEIGHT (kg)
01.	1	0.5	2.4	B/800/LF/050	R8392-1461	1.23
	3	0.5	2.4			
	5	0.5	2.4			
02.	2	1.9	3.8	B/800/LF/051	R8392-1462	1.48
	4	1.9	3.8			
	6	1.9	3.8			
	7	0.5	2.4			

02.	TEMPLATE EXT. PROFILE	R8392-1462	T90Mn6WCr2 AA10821	1.48 01
01.	TEMPLATE INT. PROFILE	R8392-1461	T90Mn6WCr2 AA10821	1.23 01
VAR.00	REMARKS	ITEM No.	DESCRIPTION	UNIT WEIGHT
			DRAWING No.	QTY.
GMS No./GR.SP.No.		STATUS OF DRG.		REF. DRG. No.
NAME		TYPE OF PRODUCT		
S.KUMAR		800 MW BLADES		
DATE		COMP. DRG. No.		
--sd--		0-103-07-58002		
		0-103-07-58004		
		DESIGN ORDER No.		
		SEE TABLE		
		M/C TOOL TRANS No.		
		2631		
		MODEL No.		
		BIG V. STAND		
		NAME		
		SIGN.		
		DATE		
		DRN. PRADEEP		
		CHD. RAWI		
		APD. ANKUR		
		REF. TO ASSY. DRG.		
		ITEM No.		
		No. OF SHEET		
		REV.		
		DRAFTING No.		
		R8392-1461-1462		
		SHEET No. 01		
		No. OF SHEET		
		01		
		SIZE A 1		

FIRST ANGLE PROJECTION (ALL DIMENSIONS IN m.m.)

FORM DG 45(B)

DRAWING No. R8392-1463-1464

1.6
THE
REST

SCALE-NTS
DETAIL-'K' FOR ALL POINTS.

◆ MARK
R8392-1463
SEC. A17-A17
INT. PROFILE
POINTS 1,3,5
800MW,
BEFORE HARDENING.

◆ MARK
R8392-1464
SEC. A17-A17
EXT. PROFILE
POINTS 2,4,6,7
800MW,
BEFORE HARDENING.

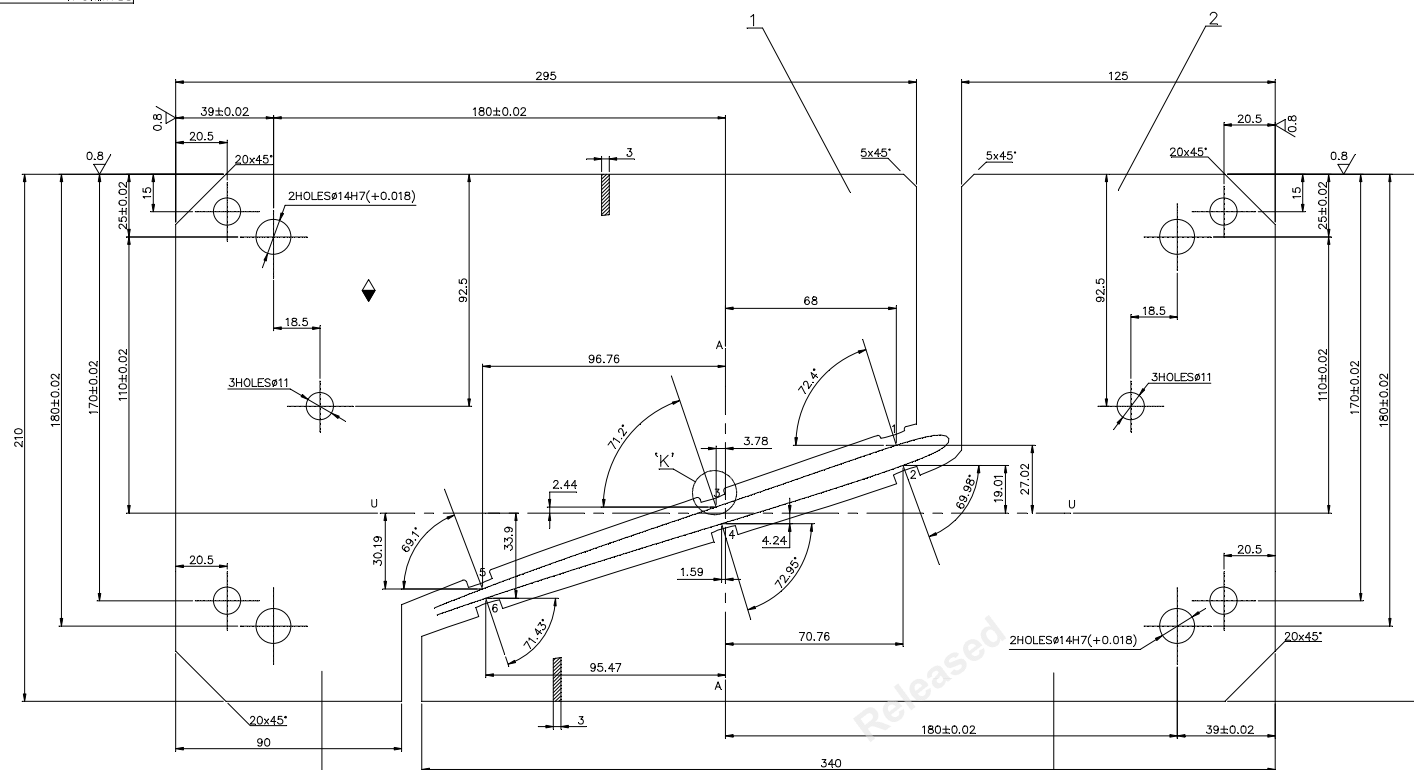
TECH.REQ:-

- 1-SHARP EDGES TO BE ROUNDED OFF.
- *2-THE MAXIMUM TOLERANCE TO BE MARKED ON BOTH SIDES.
- 3-HARDEN TO HRC. 50±55 AS PER PS. No. 0912.008.
- 4-TO BE USED WITH WE-013-3400-4537.
- 5-PROFILE DRAWING No. 01030758022.
- 6-MANUFACTURING ACCURACY OF PROFILE ±0.02.
- 7-CONSERVATION TO BE DONE AS PER TL-30007.

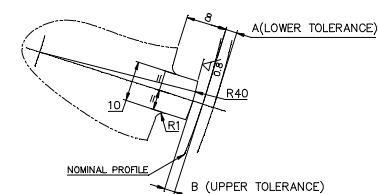
ITEM NO.	PROFILE POINT	DIMENSION (A)	*MAX.TOLE. (A±2.3)	W./ORDER NO.	DRG.NO.	WEIGHT (kg)
01.	1	0.9	3.2	B/800/LF/052	R8392-1463	1.30
	3	0.9	3.2			
	5	0.9	3.2			
02.	2	2.3	4.6	B/800/LF/053	R8392-1464	1.48
	4	2.3	4.6			
	6	2.3	4.6			
	7	0.9	3.2			

VAR.00	REMARKS	ITEM No.	DESCRIPTION	STD.	DRAWING No.	VAR.	MATERIAL SPECN.	UNIT WEIGHT	QTY.

GMS No./GR.SP.No.		STATUS OF DRG.		TYPE OF PRODUCT		COMP. DRG. No.		W/C TOOL TRANS No.		REF. DRG. No.	
800 MW BLADES		800 MW BLADES		800 MW BLADES		800 MW BLADES		800 MW BLADES		800 MW BLADES	
DESIGN ORDER No.		SEE TABLE		MODEL No.		BIG V- STAND		NAME		SIGN.	
DATE		DATE		DATE		DATE		DATE		DATE	
REV. DATE		ALTERED CHECKED		REV. DATE		ALTERED CHECKED		REV. DATE		ALTERED CHECKED	
REV. NO.		C/A No.		REV. NO.		C/A No.		REV. NO.		C/A No.	
DATE		DATE		DATE		DATE		DATE		DATE	
TITLE		INT.&EXT. PROFILE CHECKING		TITLE		INT.&EXT. PROFILE CHECKING		TITLE		INT.&EXT. PROFILE CHECKING	
A17-A17,		A17-A17,		A17-A17,		A17-A17,		A17-A17,		A17-A17,	



1.6/ THE REST



SCALE-NTS

DETAIL-'K' FOR ALL POINTS.

MARK

R8392-1537
SEC. A15-A15
INT. PROFILE
POINTS 1.3.5
250MW,
AFTER FLAME
HARDENING

MARK

R8392-1538
SEC. A15-A15
EXT. PROFILE
POINTS 2,4,6
250MW,
AFTER FLAME
HARDENING

NOTES: —

- 1-SHARP EDGES TO BE ROUNDED OFF.
*2-THE MAXIMUM TOLERANCE TO BE MARKED ON BOTH SIDES.
3-HARDEN TO HRC 50±5 AS PER P.S.No. 0912.008.
4-TO BE USED WITH BIG VERTICAL STAND.
5-PROFILE DRG. NO. 0-10307-46023.
6-MANUFACTURING ACCURACY OF PROFILE
±0.02.
7-CONSERVATION TO BE DONE AS PER TL 30007.

ITEM NO.	PROFILE POINT	DIMENSION (A)	DIMENSION (B)	MAX. TOL. (A+B)	W./ORDER NO.	DRG.NO.	WEIGHT (kg)
1.	3	0.7	4.2	4.9	NBF/2020	R8392-1537	1.08
	4	0.7	3.4	4.1			
	5	0.7	2.3	3.0			
2.	2	4.0	2.0	6.0	NBF/2021	R8392-1538	0.91
	4	3.3	2.0	5.3			
	6	2.3	2.0	4.3			

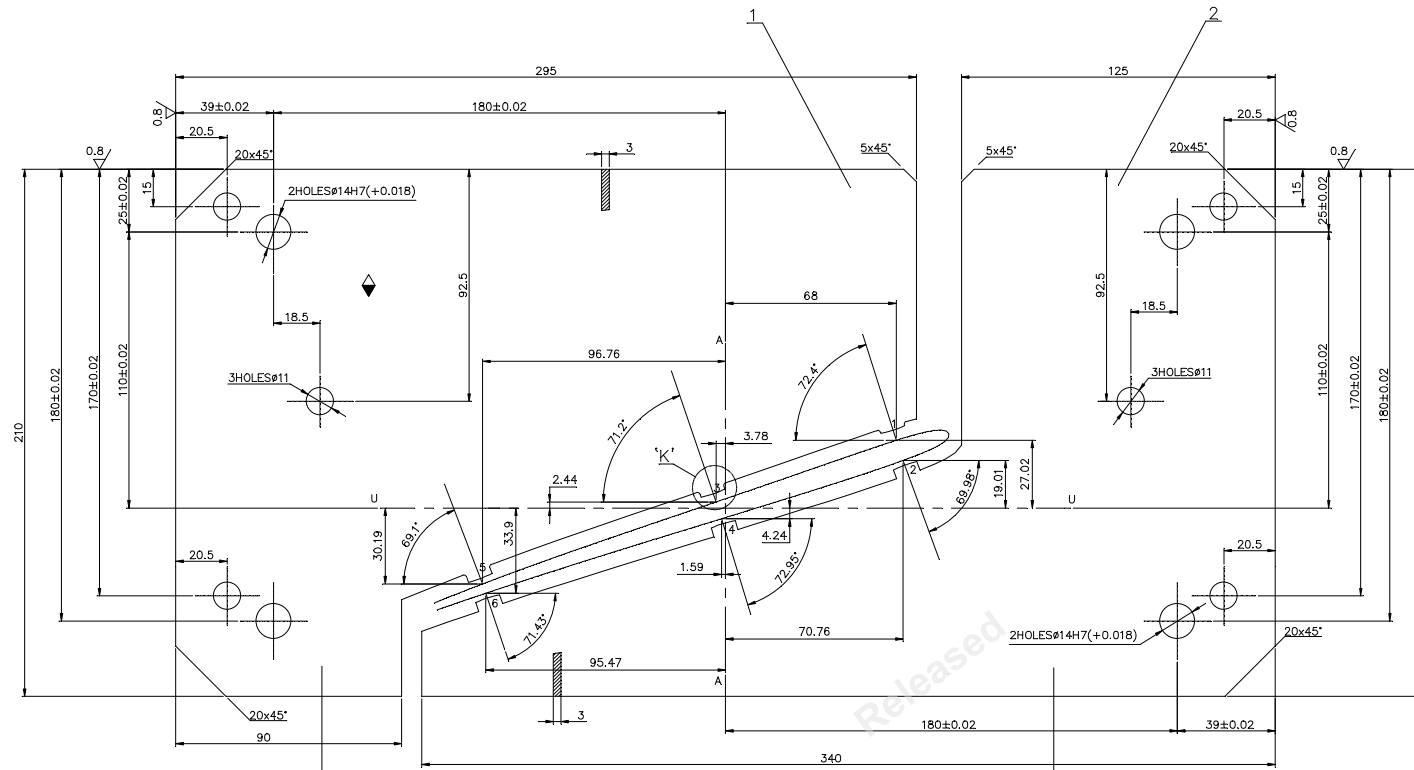
Q2.	TEMPLATE EXT. PROFILE	R8392-1538	T90Mn6WCr2	01	ZONE				
			AA10821						
	01.	TEMPLATE INT. PROFILE	R8392-1537	T90Mn6WCr2		01			
				AA10821					
VAR.00	REMARKS	ITEM No.	DESCRIPTION	SID.	DRAWING No.	MATERIAL CODE A	UNIT WEIGHT	QTY.	ZONE
						VAR. MATERIAL SPECN. C			

GMS No./GR.SP.No.		STATUS OF DRG.		TYPE OF PRODUCT		COMP. DRG. NO.		M/C TOOL TRANS. No.		REF. DRG. No.	
				250 MW		01030746003-00				R8392-1533-153	
APPROVED BY		NAME		SIGN.		DATE		DESIGN ORDER No.		MODEL No.	
TSM		ANIL		-sd-		19.08.16		SEE TABLE		B6 VERTICAL STAND	
104											
101											
REV. DATE		ALTERED CHECKED		SHEET		SCALE		WEIGHT(Kg.)		REF. TO ASSY. DRG.	
				DPT. JTE		1:1		SEE TABLE		ITEM No.	
				CODE 209						No. of IT	
REV. No.		C/A No.		DATE		TITLE		DRAWING No.		REF.	
						7 POINT CHECKING TEMPLATE AT ASSY A15-A15 (N1 & EXT. PROFILE) AFTER FLAME HARDENING (FORM-17)		R8392-1533-153		RE	
								32		15 OF 38	

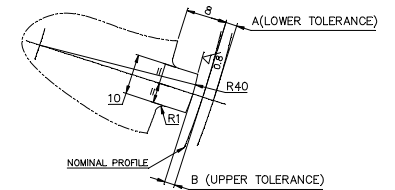
FIRST ANGLE PROJECTION (ALL DIMENSIONS IN m.m.)

FORM DG 45(B)

DRAWING No. R8392-1537-1538



1.6 / THE REST



SCALE-NTS

DETAIL-'K' FOR ALL POINTS.

♦ MARK
R8392-1537
SEC. A15-A15
INT. PROFILE
POINTS 1,3,5
250MW
AFTER FLAME
HARDENING

♦ MARK
R8392-1538
SEC. A15-A15
EXT. PROFILE
POINTS 2,4,6
250MW
AFTER FLAME
HARDENING

NOTES: -

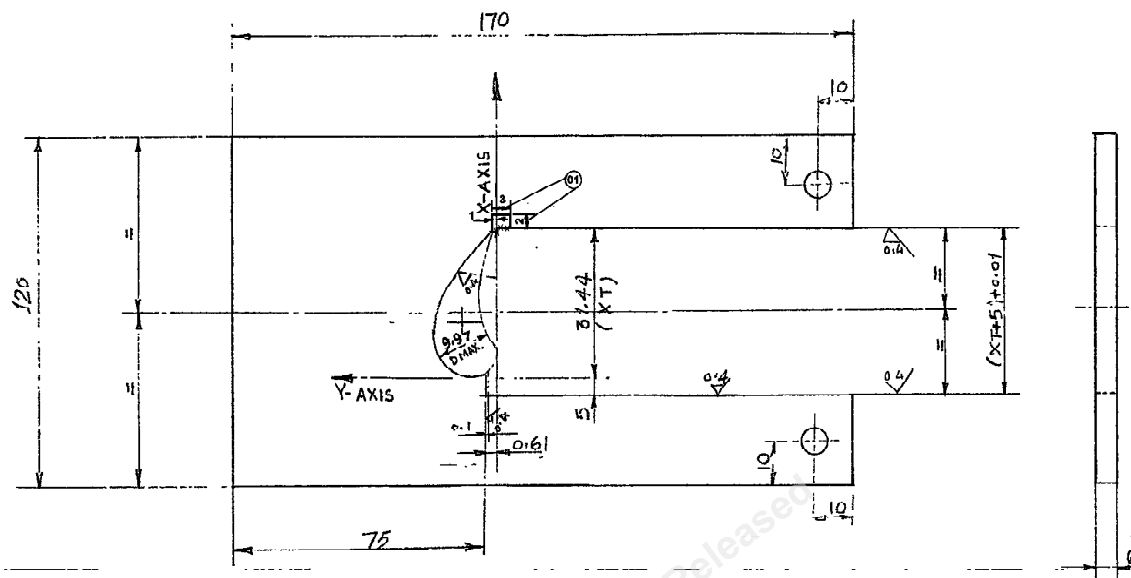
- 1-SHARP EDGES TO BE ROUNDED OFF.
- *2-THE MAXIMUM TOLERANCE TO BE MARKED ON BOTH SIDES.
- 3-HARDEN TO HRC 50±55 AS PER P.S.No. 0912.008.
- 4-TO BE USED WITH BIG VERTICAL STAND.
- 5-PROFILE DRG. NO. 0-10307-46023.
- 6-MANUFACTURING ACCURACY OF PROFILE ±0.02
- 7-CONSERVATION TO BE DONE AS PER TL 30007.

ITEM NO.	PROFILE POINT	DIMENSION (A)	DIMENSION (B)	*MAX TOLE. (A+B)	W./ORDER NO.	DRG.NO.	WEIGHT (kg)
1.	1	0.7	4.2	4.9	NBF/2020	R8392-1537	1.08
	3	0.7	3.4	4.1			
	5	0.7	2.3	3.0			
2.	2	4.0	2.0	6.0	NBF/2021	R8392-1538	0.91
	4	3.3	2.0	5.3			
	6	2.3	2.0	4.3			

02.	TEMPLATE EXT. PROFILE	R8392-1538	T90Mn6WCr2 AA10821	01
01.	TEMPLATE INT. PROFILE	R8392-1537	T90Mn6WCr2 AA10821	01
VAR.00	REMARKS	ITEM No.	DESCRIPTION	STD.
			DRAWING No.	
			VAR. MATERIAL SPECN.	UNIT WEIGHT QTY.

GMS No./GR.SP.No.		STATUS OF DRG.		TYPE OF PRODUCT		COMP. DRG. No.		M/C TOOL TRANS No.		REF. DRG. No.	
01030746003-00		---		250 MW		01030746003-00		---		R8392-1533-1534	
DESIGN ORDER No.		SEE TABLE		MODEL No.		BIG VERTICAL STAND		NAME		SIGN.	
DATE		19.08.16		DATE		19.08.16		DATE		19.08.16	
NAME		ANIL		NAME		ANIL		NAME		ANIL	
SIGN.		---		SIGN.		---		SIGN.		---	
DATE		19.08.16		DATE		19.08.16		DATE		19.08.16	
GAS CUTTING-T3-AA0621101		---		GAS CUTTING-T3-AA0621101		---		GAS CUTTING-T3-AA0621101		---	
REV. DATE		ALTERED CHECKED		REV. DATE		ALTERED CHECKED		REV. DATE		ALTERED CHECKED	
REV. NO.		C/A No.		REV. NO.		C/A No.		REV. NO.		C/A No.	
DATE		---		DATE		---		DATE		---	
TITLE		7 POINT CHECKING TEMPLATE AT SEC A15-A15 (INT. & EXT. PROFILE) AFTER FLAME HARDENING (FORM-17)		TITLE		7 POINT CHECKING TEMPLATE AT SEC A15-A15 (INT. & EXT. PROFILE) AFTER FLAME HARDENING (FORM-17)		TITLE		7 POINT CHECKING TEMPLATE AT SEC A15-A15 (INT. & EXT. PROFILE) AFTER FLAME HARDENING (FORM-17)	
DRAWING No.		R8392-1537-1538		DRAWING No.		R8392-1537-1538		DRAWING No.		R8392-1537-1538	
SHEET No.		01		SHEET No.		01		SHEET No.		01	
No. OF SHEET		01		No. OF SHEET		01		No. OF SHEET		01	
SIZE		A 1		SIZE		A 1		SIZE		A 1	

3.2/ THE REST



MARK
R-8730-7153/00
TX-28

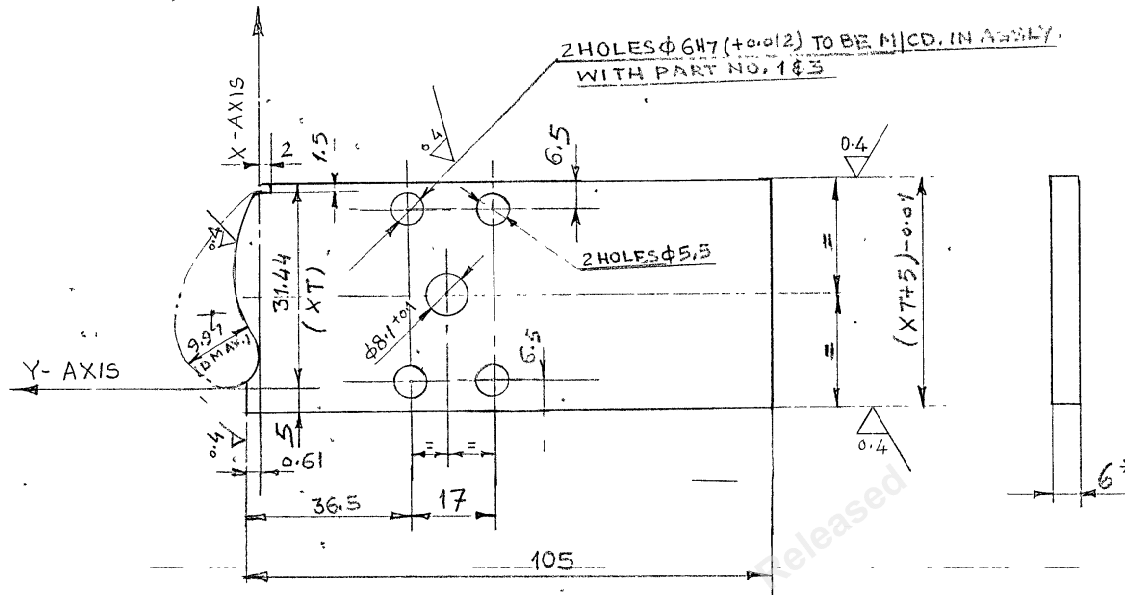
4 PROFILE AS PER DRG NO 1-14600-35. (NOMINAL)

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FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

FORM DG 38(B)

DRAWING NO
R-8730-7153/00463/
THE REST

NOTES:-

1. TO BE HARDENED TO $HRC 50 \pm 60$ AS PER P.S. NO 0912008
2. PROFILE IS TO BE PERFECTLY MATCHED WITH CORRESPONDING SHADOW GRAPH WITH NO. 22
- * 3. TO BE GROUND WITH ITEM NO 2 FOR ACHIEVING THE SAME THICKNESS.
4. PRO FILE AS PER DRG NO T-14-600-35223 -

MARK

R-8730-7153/004

Tx-28

(DRG. SIEMENS (NOMINAL))

VAR 00	REMARKS	ITEM NO.	DESCRIPTION	STD	DRAWING NO	MATERIAL CODE	UNIT WEIGHT
59	64	65	75	25	27	29	58
28	28	28	28	28	28	28	28

CARD TYPE 3 28 → 28 → CARD TYPE-1

28 → CARD TYPE-2

GMS NO./GR. SP. NO.				STATUS OF DRG.				TYPE OF PRODUCT OR NAME OF CUSTOMER / PROJECT						
AGREED	DEPT	NAME	SIGN	DATE										
GRADE OF UNTOX. DIM				M/CG-C/M/F AA 0230208				NAME				SIGN	DATE	NO OF
WELDING-A/B/C/D AA 0621104								DRN				DARGAN	18/7/77	VAR
GAS CUTTING 'T3' AA 0621101								CHD				TIWARI	13/11/77	73/74
REV DATE				ALTERED	REV DATE	ALTERED	DEPT. J.T.E	SCALE	WEIGHT (kg)	REF TO ASSY. DRG	ITEM NO	NO OF		
CHECKED				CHECKED	CODE 209				N.T.S	~ 0.435	-	5	75/77	
								TITLE				DRAWING NO.		
								TEMPLATE				R-8730-7153/004		
								SHEET NO				NO OF SHEETS		

SIZE A3

2-15780 INVENTORY NO.	SIGN & DATE	REF. DRG. NO.
--------------------------	-------------	---------------

2-15780
INVENTORY

7

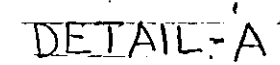
6

5

4

2

6.3 ✓ THE REST



STARTING POINT
OF THE PROFILE

TX-36

4. PROFILE AS PER DRG. NO. 1-14600-35228 (SIEMENS DRG.)

28 → CARD TYPE-2'

	NAME	SIGN	DATE	NO.
DRN	VE G.	<i>W. G.</i>		OF
CHD	RPT	<i>Stewart</i>	27/1/88	8AR.
APP	11118			-

ITEM NO	NO OF ITEMS
---------	-------------

3 DRAWING NO.	REV.
7 R8730-7156/002	23 23 24

SHEET NO. — NO. OF SHEETS —

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BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY
OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

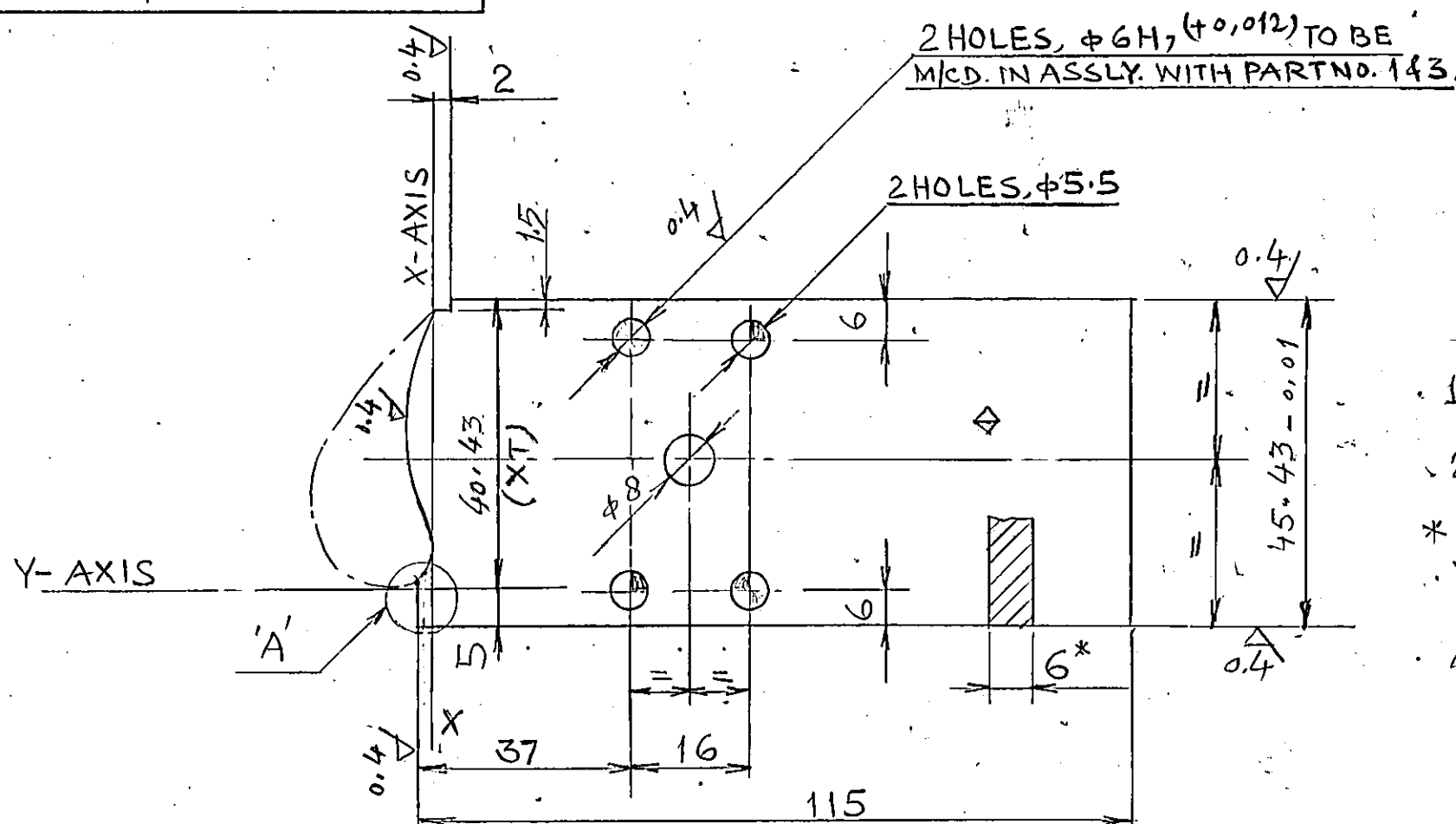
FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

FORM: DG-38(B)

DRAWING NO. R8730-7156/004

6.3/ THE REST



NOTE:-

1. TO BE HARDENED TO HR 55÷65 AS PER P.S.NO. 0912008
2. PROFILE IS TO BE PERFECTLY MATCHED WITH CORRESPONDING SHADOWGRAPH WITHIN 0.02.
- * 3. TO BE GROUND WITH ITEM NO. 2 FOR ACHIEVING THE SAME THICKNESS.
4. PROFILE AS PER DRG. NO. 1-14600-35228 (SIEMENS)

MARK

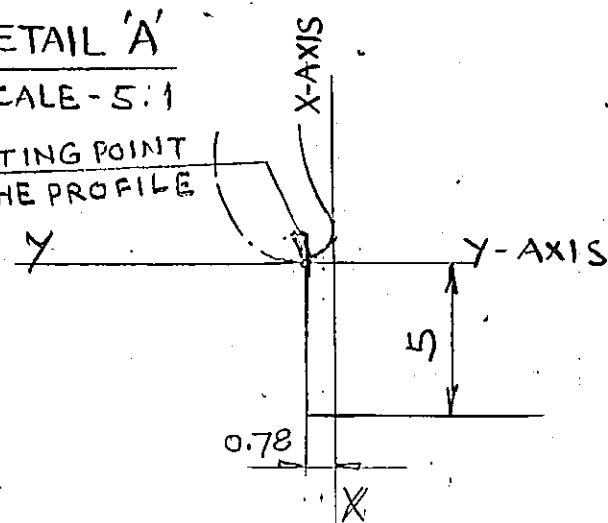
R8730-7156/004

Tx-36

DETAIL 'A'

SCALE-5:1

STARTING POINT OF THE PROFILE



VAR. 00	REMARKS	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	T90Mn6WCr2 AA 1082L	MATERIAL CODE	A	UNIT WEIGHT
59	64 65	75 25 27 29	58 69 60	77	78	29 31 VAR 32 33 48	MATERIAL SPECN	C	58 65 71 72
CARD TYPE-3			CARD TYPE-1			CARD TYPE-2			

GMS NO./GR. SP. NO.

STATUS OF DRG.

TYPE OF PRODUCT

OR

NAME OF CUSTOMER/ PROJECT

AGREED DEPT.	NAME	SIGN	DATE

GRADE OF UNTOL. DIM.:-

M/CG- V/C/M/F AA 0230208

WELDING-A/B/C/D-AA621104

GAS CUTTING-T3'AA0621101

REV.	DATE	ALTERED
		CHECKED

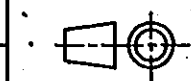
REV.	DATE	ALTERED
		CHECKED

BHARAT HEAVY ELECTRICALS LTD.
HARDWAR

DEPT. JTE

CODE 209

TITLE



SCALE

NTS.

WEIGHT(Kg.)

~0.115

REF. TO ASSY. DRG.

DRAWING NO.

R8730-7156/004

SHEET NO. -

NO.OF SHEETS -

SIZE A3

CONFIDENTIAL AND COPYRIGHT

INVENTORY NO.

SIGN & DATE

REF. DRG NO.

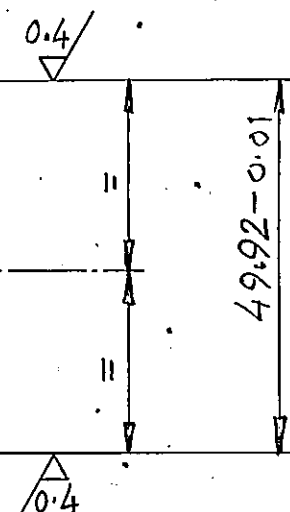
(ALL DIMENSIONS ARE IN mm).

FORM: DG-38(B)

DRAWING NO. 00770

2 HOLES $\phi 6H7$ TO BE M/C/D IN ASSLY. WITH PART NO. 284

∴ $\frac{6.3}{\triangle}$ THE REST



0.86 0.5
X

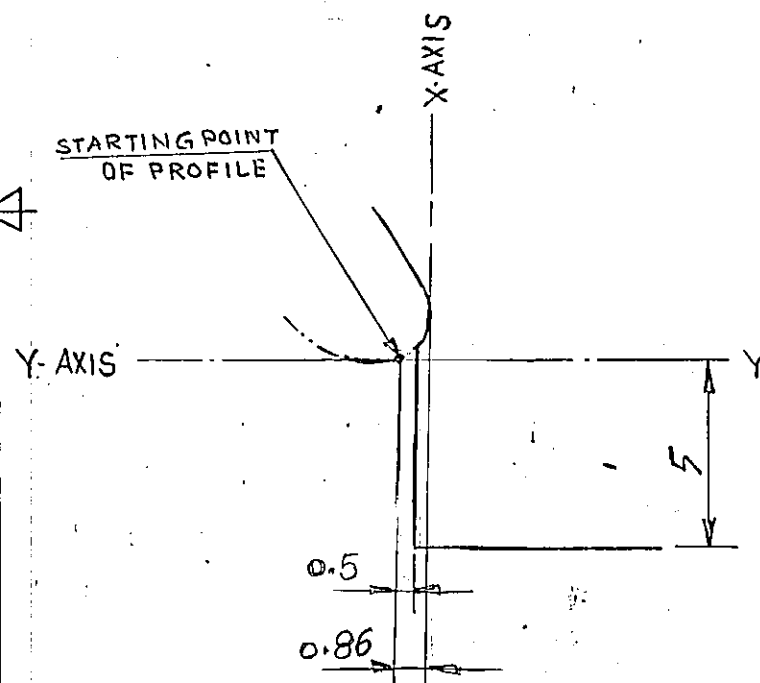
NOTE:—

1. HARDEN TO HRC. 50÷55 AS PER P.S.No.0912,008.
2. PROFILE IS TO BE PERFECTLY MATCHED WITH THE CORRESPONDING SHADOW GRAPH WITHIN 0.02
- * 3. TO BE GROUND WITH ITEM No. 3 FOR ACHIEVING THE SAME THICKNESS.
4. PROFILE SHOULD BE AS PER DRG.No. 1-14600-35228.-
(DRG.SIEMEN)

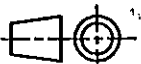
MARK

R8730-7159/001

Tx-40



		-	-			T55Si2Mn90			02.43
						AISI 54			1
VAR. 00	REMARKS	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	MATERIAL CODE	A	UNIT WEIGHT	
59	64	65	75	25	27	29	58	65	
				58	69	60	77		
						MATERIAL SPECN		QUANTITY	
						29 31 VAR 32 33	54 55 56 57	66	71 72
CARD TYPE-3 28 →						28 → CARD TYPE-1			
						28 → CARD TYPE-2			

			GMS NO./GR. SP. NO.		STATUS OF DRG.		TYPE OF PRODUCT OR NAME OF CUSTOMER/ PROJECT																						
			AGREED DEPT.		NAME		SIGN		DATE																				
GRADE OF UNTOL. DIM.:—							भारत भारती BH BHARAT HEAVY ELECTRICALS LTD. HARDWAR													DRN		NAME		SIGN		DATE		NO.OF VAR.	
M/CG— Y/D/M/F AA 0230208																				CHD		R.P.TIWARI		SIGN		4-7-98		—	
WELDING—A/B/C/D—AA621104																				APD		H.N.SHARMA		SIGN				73, 74	
GAS CUTTING—T3'AA0621101																													
REV.		DATE		ALTERED CHECKED		REV.		DATE		ALTERED CHECKED		DEPT. J & T E				SCALE 1:1		WEIGHT(Kg.) 0.243		REF. TO ASSY. DRG. —				ITEM NO. 1		NO.OF ITEMS —			
														CODE 209												75, 77			
														TITLE <u>TEMPLATE</u>							1 3		DRAWING NO. R 8730-7159/001				—		
																					7 22 23 24		SHEET NO. —				NO.OF SHEETS =		

SIZE A3

7

6

5

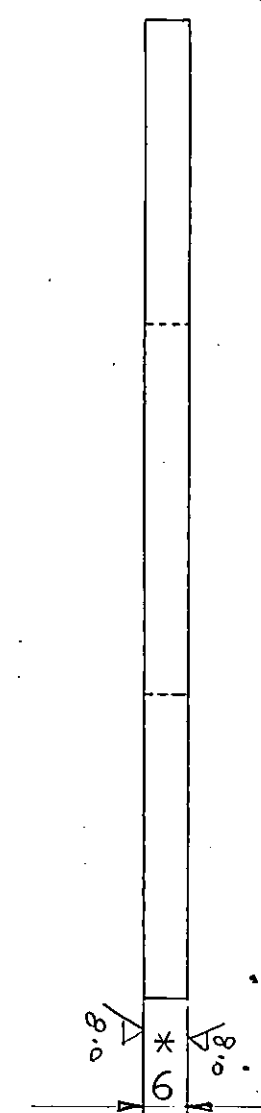
6.

2

3

1

6.3 / THE REST



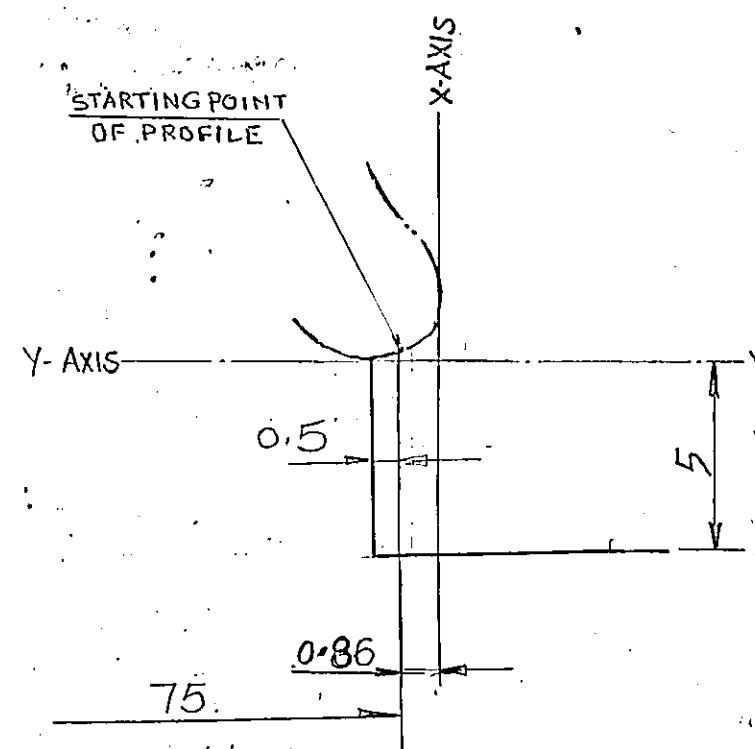
DETAIL 'A'
(SCALE :- 5:1)

MARK

R 8730-7159/003

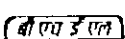
Tx-40

- 1. HARDEN TO HRC. 50÷55 AS PER P.S. No. 0912,008.
- 2. PROFILE IS TO BE PERFECTLY MATCHED WITH THE CORRESPONDING SHADOW-GRAPH WITHIN 0.02
- *
- 3. TO BE GROUND WITH ITEM No. 1 FOR ACHIEVING THE SAME THICKNESS.
- 4. PROFILE SHOULD BE AS PER DRG. No. 1-14600-35228. (SIEMEN DRG.)



															T55 S42 Mn90						0546														
															AST 54						1														
VAR. 00			REMARKS			ITEM NO.			DESCRIPTION			STD			DRAWING NO.			MATERIAL CODE			UNIT WEIGHT			QUANTITY			ZONE								
59	64	65	75	25	27	29	58	69	60	77	32	33	34	35	36	54	55	56	57	66	71	72	73	74											
CARD TYPE 3												CARD TYPE-1												CARD TYPE-2											

GMS NO./GR SP NO			STATUS OF DRG	TYPE OF PRODUCT OR NAME OF CUSTOMER / PROJECT
AGREED DEPT.	NAME	SIGN	DATE	

GRADE OF UNTOL DIM —		DEPT.		NAME		SIGN		DATE		NAME OF CUSTOMER / PROJECT									
M/CG-C/M/F AA 0230208						BHARAT HEAVY ELECTRICALS LTD		HARDWAR		NAME		SIGN		DATE		NO. OF			
WELDING-A/B/C/DAA0621104										DRN		K.K.S. —		OKB				VAR	
GAS CUTTING 'T3' AA 0621101										CHD		R.P. TIWARI		Sw —		4-7-98			
REV DATE		ALTERED		REV DATE		ALTERED		DEPT J&TE		SCALE :-		WEIGHT (kg)		REF TO ASSY DRG.		ITEM NO			
CHECKED		CHECKED		CHECKED		CHECKED		CODE 209		1:1		~ 1.2		—		3			
ZONE		ZONE		ZONE		ZONE		TITLE		DRAWING NO.		REV.		NO. OF		ITEMS			
								TEMPLATE BODY		R 8730-7159/003		—		22		23, 24			
										SHEET NO. —		NO. OF SHEETS							

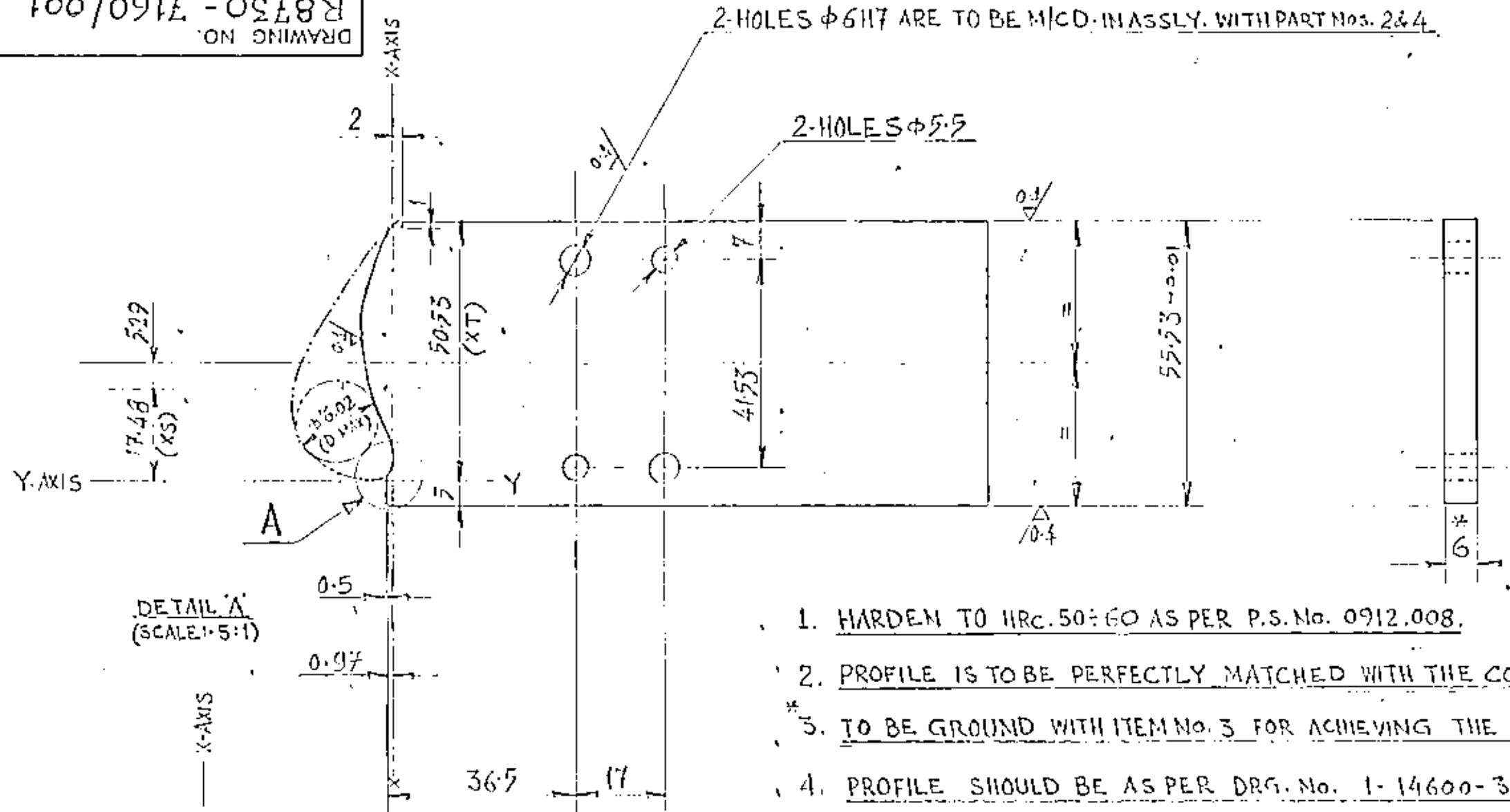
FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

FORM: DG-38(B)

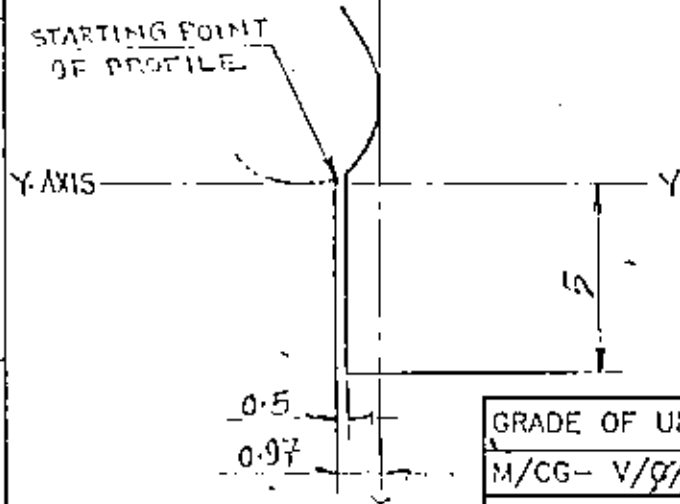
DRAWING NO. R8730-7160/001

6.3/
THE REST



MARK
R8730-7160/001
Tx-45

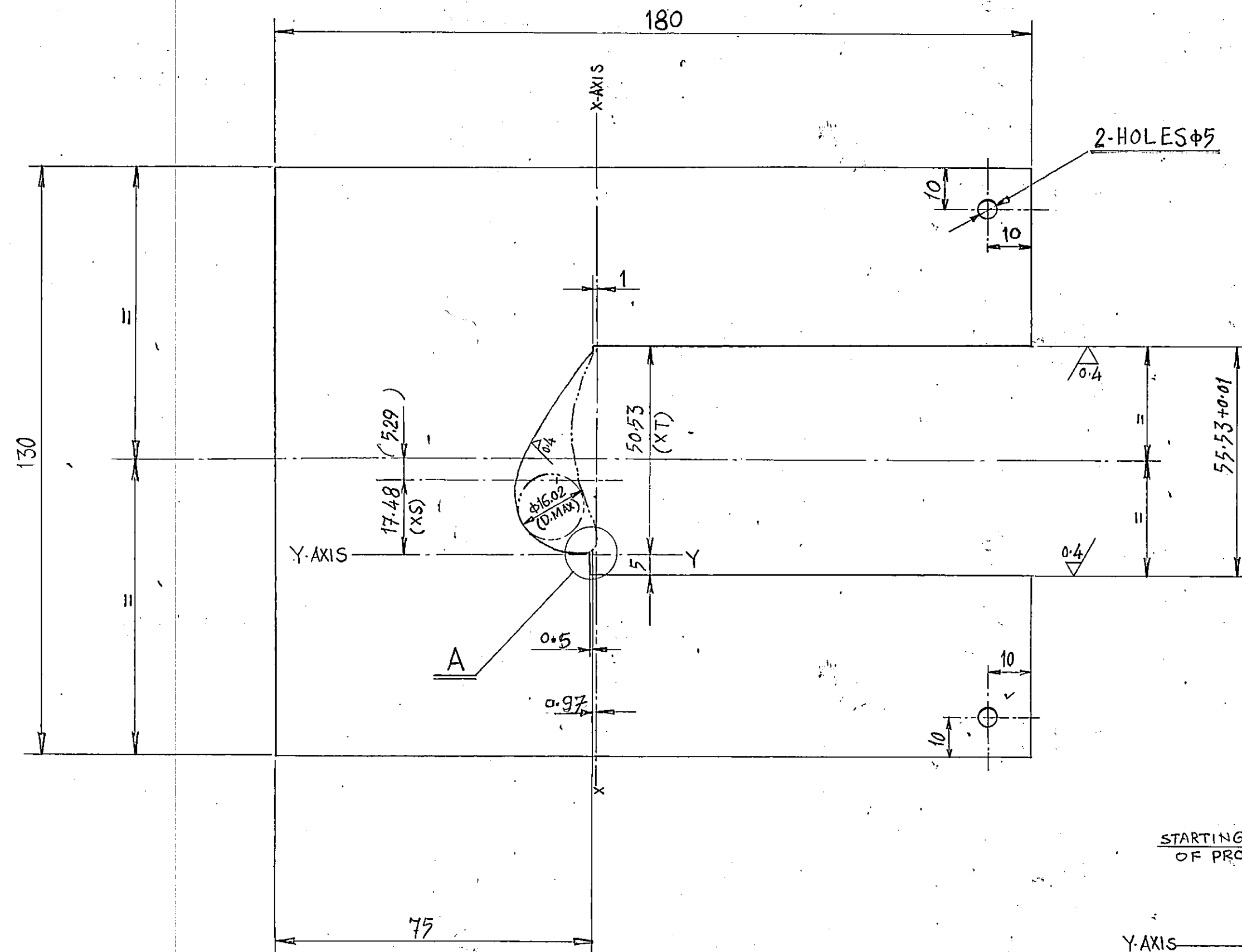
1. HARDEN TO HRC. 50±60 AS PER P.S.No. 0912.008.
2. PROFILE IS TO BE PERFECTLY MATCHED WITH THE CORRESPONDING SHADOW GRAPH WITHIN 0.2.
3. TO BE GROUND WITH ITEM NO. 3 FOR ACHIEVING THE SAME THICKNESS.
4. PROFILE SHOULD BE AS PER DRG. No. 1-14600-35228, (SIEMENS)



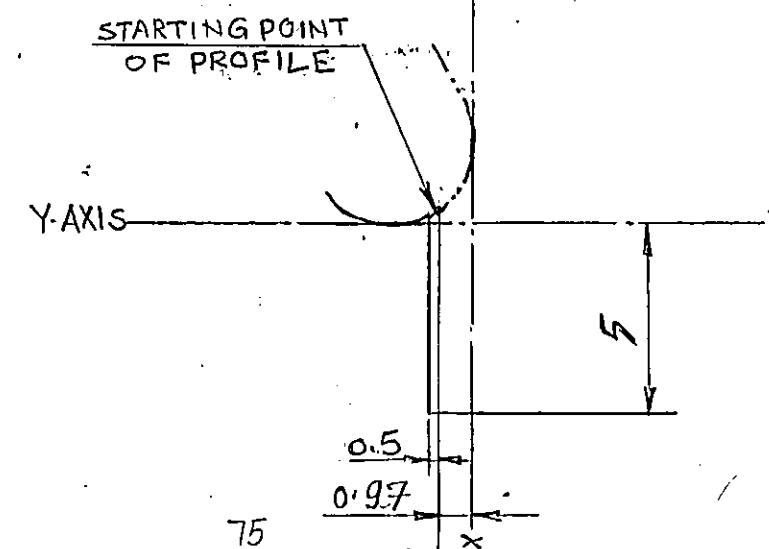
VAR. 00	REMARKS	ITEM NO.	DESCRIPTION	DWG. NO.	MATERIAL CODE	UNIT WEIGHT
52	61 63	75 25 27 29	28	28	28	28
CARD TYPE-3				CARD TYPE-1		CARD TYPE-2
GMS NO./GR. SP. NO.			TYPE OF PRODUCT OR NAME OF CUSTOMER/ PROJECT			
AGREED	NAME	SIGN	DATE	BHARAT HEAVY ELECTRICALS LTD. HARDWAR		
GRADE OF UNTOL. DIM.:-			DEPT. JTE			
M/CG- V/G/J/F AA 0230208			CODE 203			
WELDING-A/B/C/D-AA621104			SCALE 1:1			
GAS CUTTING-T3'AA0621101			WEIGHT(Kg.)			
REV.	DATE	ALTERED	REV.	DATE	ALTERED	REF. TO ASSY. DRG.
		CHECKED			CHECKED	
TITLE			DRAWING NO. R8730-7160/001			
SHEET NO.			NO. OF SHEETS			

SIZE A3

DRAWING NO. R 8730-7160/003



DETAIL 'A'
(SCALE: 5:1)



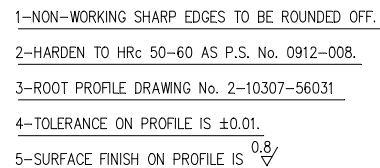
6.3/
THE REST

MARK
R 8730-7160/003
Tx-45

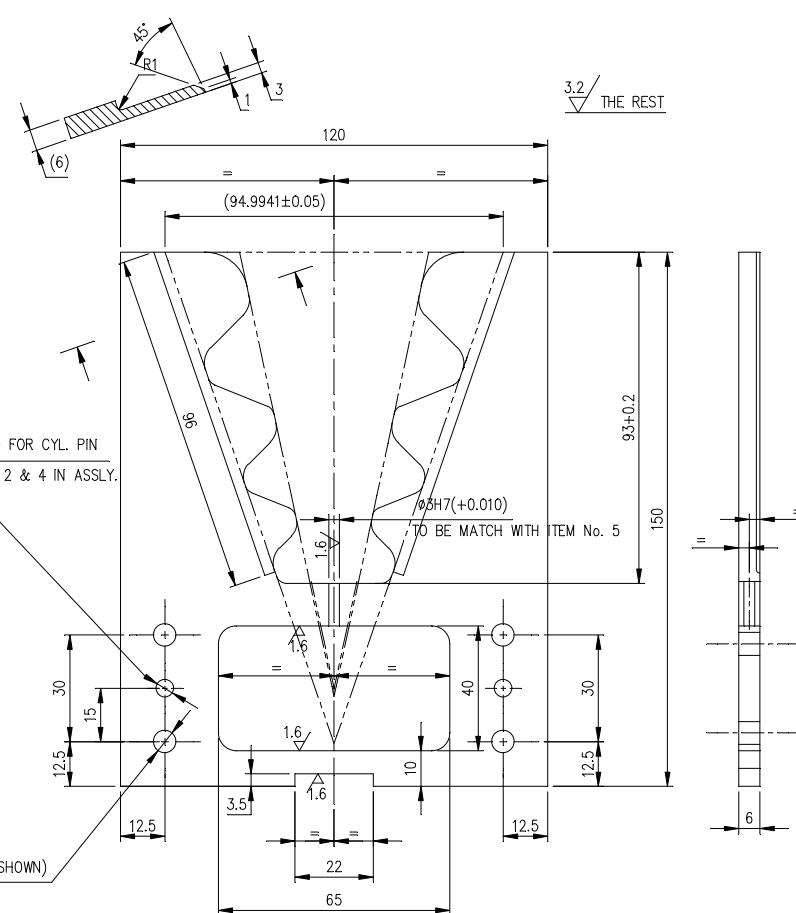
1. HARDEN TO HRC 50:55 AS PER P.S.No. 0912.008.
2. PROFILE IS TO BE MATCHED PERFECTLY WITH THE CORRESPONDING SHADOW GRAPH WITH IN 0.02
3. TO BE GROUND WITH ITEM No. 1 FOR ACHIEVING THE SAME THICKNESS.
4. PROFILE SHOULD BE AS PER DRG.No. 1-14600-35228.(DRG.SIEMEN)

VAR. 00	REMARKS	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	T 55 S 12 M 7 9 0 15 37 48	0534
29 31	VAR 32 33 46	54 55 56 57 66	MATERIAL SPECN	C	UNIT	QUANTITY	ZONE
CARD TYPE 3 28 → 28 → CARD TYPE-1				28 → CARD TYPE-2			
GMS NO./GR SP NO		STATUS OF DRG		TYPE OF PRODUCT OR NAME OF CUSTOMER / PROJECT			
AGREED DEPT.	NAME	SIGN	DATE				
GRADE OF UNTOL DIM —				BHARAT HEAVY ELECTRICALS LTD HARDWAR			
M/CG-C/M/F AA 0230208				DRN K.K.S.			
WELDING-A/B/C/DAA0621104				CHD RPT			
GAS CUTTING T3 AA 0621101				APD HNTS			
REV/DATE	ALTERED CHECKED	REV/DATE	ALTERED CHECKED	DEPT J&TE	SCALE :-	WEIGHT (kg)	REF TO ASSY DRG.
ZONE		ZONE		CODE 209	1:1	0.534	ITEM NO 3
TITLE				TEMPLATE-BODY		CARD CODE	DRAWING NO. R 8730-7160/003
						SHEET NO. —	NO. OF SHEETS —

10

[illegible]

GMS No./GR.SP.No.				STATUS OF DRG.		TYPE OF PRODUCT													
AGREED DEPT.		NAME		SIGN.		DATE													
_____		_____		_____		_____													
भारत भारती BHEL								BHARAT HEAVY ELECTRICALS LTD.										No. of	
								HARDWAR										VA	
								DRN.		NAME		SIGN.		DATE					
								CHD		M.P.S.		-Sd-							
								APD		RAVI/ANKUR		-Sd-							
REV.		DATE		ALTERED CHECKED		DEPT.		JTE				SCALE		WEIGHT(Kg.)		REF. TO ASSY. DRG.		ITEM No.	
						CODE		209		NTS		~ 0.481		R8739-6077		03		No. of	
								TITLE										RE	
								BLOCK GAUGE										DRAWING No.	
																		R8739-6077/002	
																		SHEET No. 01	
																		No. OF SHEET	
																		20	



2-HOLES , $\varnothing 5$ H7(+0.012) FOR CYL. PIN
TO BE MADE WITH ITEM No. 2 & 4 IN ASSLY.

4-HOLES , $\phi 6.5$ (AS SHOWN)

