

DRG No.

REV

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REF. DRG. No.

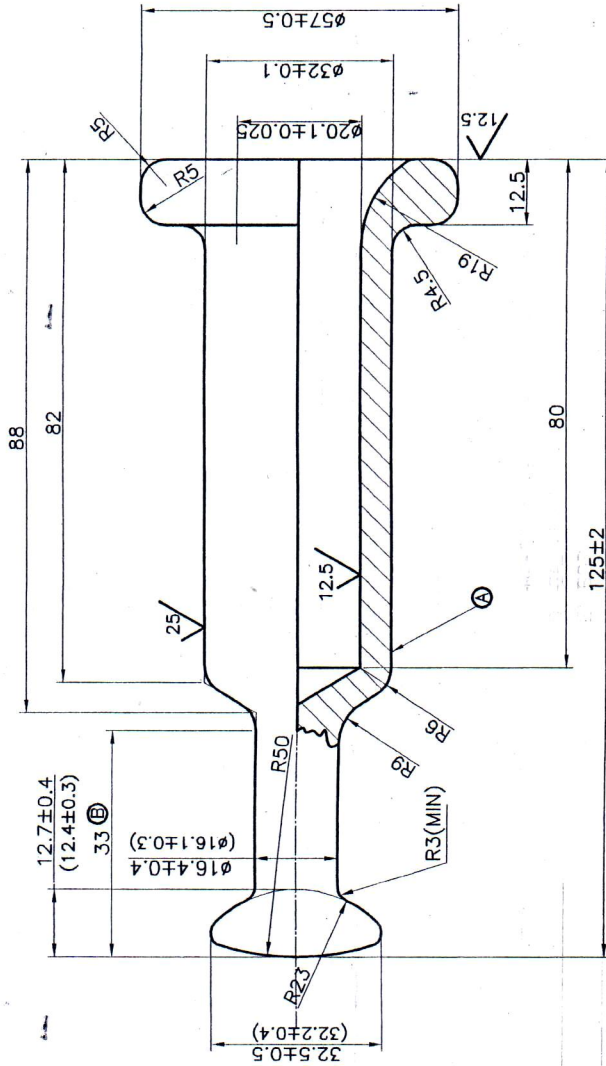
INVENTORY NO.

[illegible]

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SUPERSEDES DRG. No.

SHT.24 SIZE A3 420 x 297



NOTES ::

- 1 ALL DIMENSIONS ARE AFTER HOT- DIP GALVANISING
A THICKNESS OF 0.15 mm MAY BE ASSUMED FOR GALVANISING
- 2 DIMENSIONS INDICATED IN BRACKET REFERS TO BEFORE GALVANISING STAGE
- 3 BALL FITTINGS ARE TO BE MADE BY FORGING PROCESS ONLY
- 4 MATERIAL TO CONFORM TO PURCHASING SPEC. EL:PS:36000103
- 5 IF THE FORGING SURFACE IS NOT SMOOTH AT THE PORTION (B)
BALL FITTINGS ARE TO BE MACHINED AT THAT PLACE WITH HELP
OF A 'FORM TOOL' TO GE A SMOOTH SURFACE
- 6 AFTER GALVANISING THE BALL PORTION SHOULD ANSWER TO ALL THE
RELEVANT "GO AND NO GO" GAUGES RECOMMENDED BY IEC Pub.60120
OR LATEST (16 'B' DESIGNATION) UP TO PORTION (B)
- 7 SUPPLIER'S IDENTIFICATION MARK & RATING SHALL BE PROVIDED
IN DEPRESSED FORM IN 6 mm LETTER SIZE AT PLACE SHOWN AS (A)
- 8 SEQUENCE OF OPERATIONS :
 - A) BALL FITTINGS ARE NORMALISED AFTER FORING
 - B) MACHINING (IF NECESSARY SEE NOT No. 5)
 - C) HARDENING & TEMPERING AND SHOT BLASTING
 - D) GALVANISING
 - E) BORING
- 9 BEFORE GALVANISING THE BALL PORTION SHOULD ANSWER TO
"GO AND NO GO" GAUGES TODRG. No. 4 SK 0260 LATEST REVISION
4 SK 0261 LATEST REVISION AND CLAUSES B7,B8 & B9 OF IEC Pub. 60120
(16 'B' DESIGNATION) UPTO PORTION (B)
- 10 BALL FITTING SHALL WITHSTAND A MINIMUM TENSILE STRENGTH OF 113 kN
- 11 MPI TEST TO BE CARRIED OUT ON ALL FORGED FITTINGS
- 12 BORE HAS TO BE DONE ONLY AFTER GALVANISING
- 13 DIM $\phi 20.1 \pm 0.025$ TO BE CHECKED BY "GO & NO GO" GAUGESTO DRG No.
4 SK 2330 LATEST REVISION.
- 14 THE WEIGHT OF FORGED BALL FITTING AT BLACK STAGE IS 0.8 kg (APPROX)

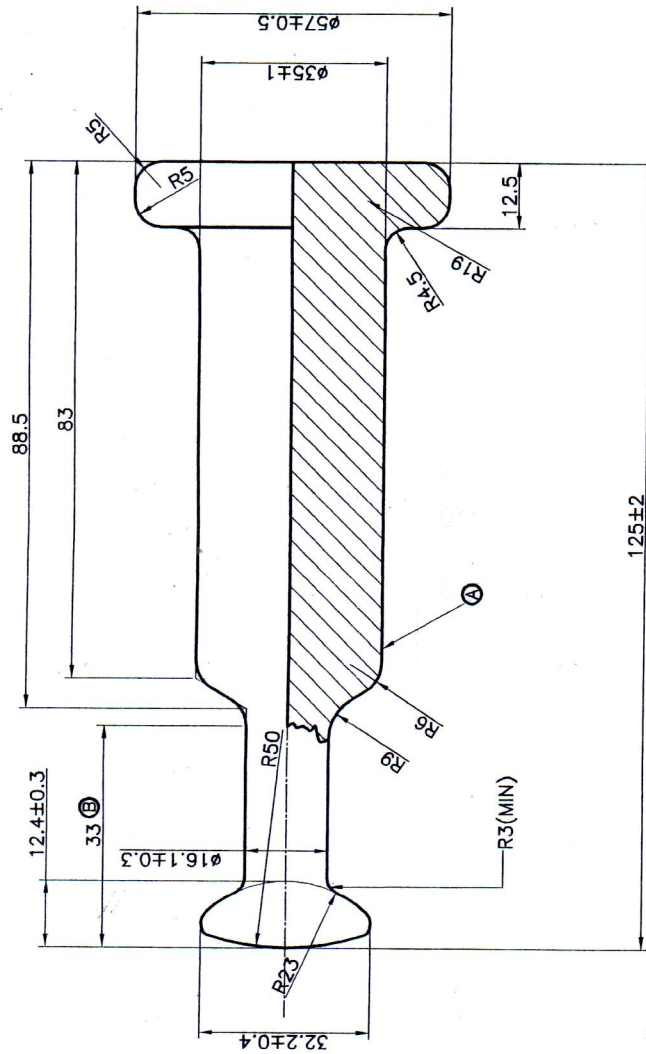
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ALL DIMENSIONS ARE IN' mm.

3 987 08 30532

DRG No.

REV



NOTES :

- 1 BALL FITTINGS ARE TO BE MADE BY FORGING PROCESS ONLY
- 2 MATERIAL TO CONFORM TO PURCHASING SPEC. EL:PS:3600103
- 3 SUPPLIER'S IDENTIFICATION MARK & RATING SHALL BE PROVIDED IN DEPRESSED FORM IN 6 mm LETTER SIZE AT PLACE SHOWN AS (A)
- 4 SEQUENCE OF OPERATIONS :
 - A) BALL FITTINGS ARE NORMALISED AFTER
 - B) HARDENING & TEMPERING AND SHOT BLASTING
- 5 BEFORE GALVANISING THE BALL PORTION SHOULD ANSWER TO "GO AND NO GO" GAUGES TO DRG. No. 4 SK 0260 LATEST REVISION
- 6 4 SK 0261 LATEST REVISION AND CLAUSES B7,B8 & B9 OF IEC Pub. 60120 (16 mm 'B' DESIGNATION) UPTO PORTION (B)
- 6 BALL FITTING SHALL WITHSTAND A MINIMUM TENSILE STRENGTH OF 113 kN
- 7 MPI TEST TO BE CARRIED OUT ON ALL FORGED FITTINGS

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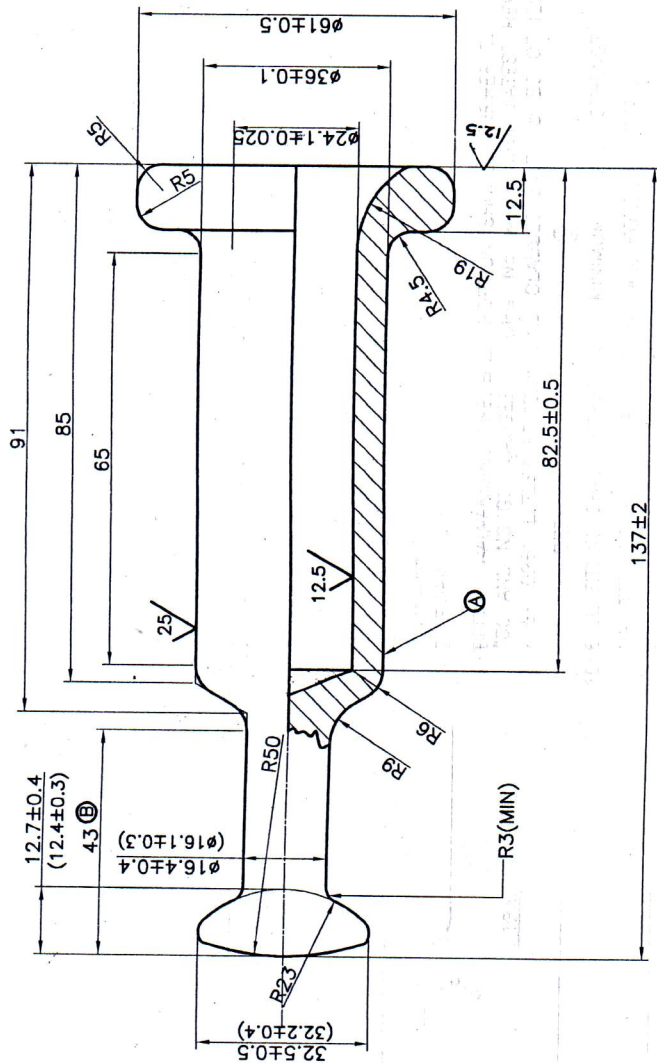
SIGN AND	REV	DATE	ALTERED CHECKED	REV	DATE	ALTERED CHECKED	REV	DATE	ALTERED CHECKED	INVENTORY No.																												
 BHARAT HEAVY ELECTRICALS LTD. ELECTROPORCELAINS DIVISION BANGALORE 560 012 <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td>DRN</td> <td>N. CHIKKANNA</td> <td>SIGN</td> <td>DATE</td> </tr> <tr> <td>CHD</td> <td>S S P</td> <td></td> <td>18/12</td> </tr> <tr> <td>APPD</td> <td>S S P</td> <td></td> <td>19/12</td> </tr> </table> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td>DEPT</td> <td>GRADE OF TOL DIM C/M/F</td> <td>SCALE N T S</td> <td>WEIGHT (kg) 0.8</td> <td>REF TO ASSY.DRG</td> </tr> <tr> <td>CODE</td> <td></td> <td></td> <td></td> <td></td> </tr> </table> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td>TITLE</td> <td>DRAWING No.</td> <td>REV.</td> </tr> <tr> <td> BALL FITTING PRE BORING STAGE FOR 70-90kN COMPOSITE LONG ROD INSULATOR </td> <td>3 987 08 30532</td> <td>00</td> </tr> </table>											DRN	N. CHIKKANNA	SIGN	DATE	CHD	S S P		18/12	APPD	S S P		19/12	DEPT	GRADE OF TOL DIM C/M/F	SCALE N T S	WEIGHT (kg) 0.8	REF TO ASSY.DRG	CODE					TITLE	DRAWING No.	REV.	BALL FITTING PRE BORING STAGE FOR 70-90kN COMPOSITE LONG ROD INSULATOR	3 987 08 30532	00
DRN	N. CHIKKANNA	SIGN	DATE																																			
CHD	S S P		18/12																																			
APPD	S S P		19/12																																			
DEPT	GRADE OF TOL DIM C/M/F	SCALE N T S	WEIGHT (kg) 0.8	REF TO ASSY.DRG																																		
CODE																																						
TITLE	DRAWING No.	REV.																																				
BALL FITTING PRE BORING STAGE FOR 70-90kN COMPOSITE LONG ROD INSULATOR	3 987 08 30532	00																																				
										No. OF SHEETS																												

22203 90 786 £

DRG No.

REV 10

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NOTES :

- 1 ALL DIMENSIONS ARE AFTER HOT- DIP GALVANISING
A THICKNESS OF 0.15 mm MAY BE ASSUMED FOR GALVANISING
- 2 DIMENSIONS INDICATED IN BRACKET REFERS TO BEFORE GALVANISING STAGE
- 3 BALL FITTINGS ARE TO BE MADE BY FORGING PROCESS ONLY
- 4 MATERIAL TO CONFORM TO PURCHASING SPEC. EL:PS:3600103
- 5 IF THE FORGING SURFACE IS NOT SMOOTH AT THE PORTION (B) & (C) BALL FITTINGS ARE TO BE MACHINED AT THAT PLACE WITH HELP OF A 'FORM TOOL' TO GET A SMOOTH SURFACE
- 6 AFTER GALVANISING THE BALL PORTION SHOULD ANSWER TO ALL THE RELAVANT "GO AND NO GO" GAUGES RECOMMENDED BY IEC Pub.60120 OR LATEST (16 mm DESIGNATION) UP TO PORTION (B)
- 7 SUPPLIER'S IDENTIFICATION MARK & RATING SHALL BE PROVIDED IN DEPRESSED FORM IN 6 mm LETTER SIZE AT PLACE SHOWN AS (A)
- 8 SEQUENCE OF OPERATIONS :
A) BALL FITTINGS ARE NORMALISED AFTER FORING
B) MACHINING (IF NECESSARY SEE NOTE No. 5)
C) HARDENING & TEMPERING AND SHOT BLASTING
D) GALVANISING
E) BORING
- 9 BEFORE GALVANISING THE BALL PORTION SHOULD ANSWER TO "GO AND NO GO" GAUGES TO DRG. No. 4 SK 0260 LATEST REVISION
4 SK 0261 LATEST REVISION AND CLAUSES B7,B8 & B9 OF IEC Pub. 60120 (16 mm DESIGNATION) UPTO PORTION (B)
- 10 BALL FITTING SHALL WITHSTAND A MINIMUM TENSILE STRENGTH OF 113 kN
- 11 MPI TEST TO BE CARRIED OUT ON ALL FORGED FITTINGS
- 12 BORE HAS TO BE DONE ONLY AFTER GALVANISING
- 13 DIM $\phi 24.1 \pm 0.025$ TO BE CHECKED BY "GO & NO GO" GAUGES.
- 14 THE WEIGHT OF FORGED BALL FITTING AT BLACK STAGE IS 1.0 kg (APPROX)
- 15 DIM 82.5 ± 0.5 TO BE CHECKED BY "GO & NO GO" GAUGES OF DRG. No. 4 SK 2719

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BHARAT HEAVY ELECTRICALS LTD.
ELECTROPORCELAINS DIVISION
BANGALORE 560 012

DEPT
CODE
TITLE

REV 01
DATE 04/02/11
ALTERED
CHECKED
1. DRAWING REDRAWN & REVISED
2. DIM 82.5 ± 0.5 WAS 82.5
3. NOTE NO. 15 ADDED
REFER TO PH No.5429

INVENTORY No.

GRADE OF
TOL DIM
C/M/F

SCALE
N T S

WEIGHT (kg)
0.7
(Approx)

REF TO ASSY.DRG

ITEM No.
No. OF ITEMS

NAME
SIGN

DATE

DRN
N.CHIKKANA

CHD
S S P

APPD
S S P

DRAWING No.
3 987 06 30222

REV.
01

CARD CODE

NO. OF SHEETS

SH.T.24 SIZE A3 420 x 297

SUPERSEDES DRG. No.

DATE

REV.

NO. OF SHEETS

SH.T.24 SIZE A3 420 x 297

SUPERSEDES DRG. No.

DATE

DRG No. 30232

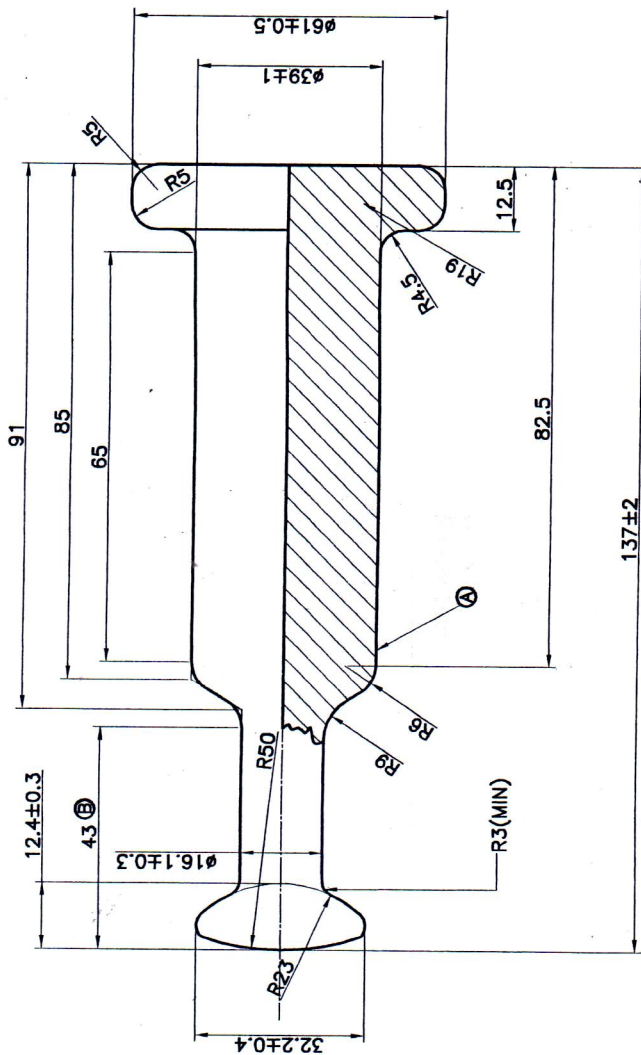
REV. 00

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REF. DRG. No.

SIGN AND DATE

INVENTORY No.



NOTES :

- 1 BALL FITTINGS ARE TO BE MADE BY FORGING PROCESS ONLY
- 2 MATERIAL TO CONFORM TO PURCHASING SPEC. EL:PS:3600103
- 3 SUPPLIER'S IDENTIFICATION MARK & RATING SHALL BE PROVIDED IN DEPRESSED FORM IN 6 mm LETTER SIZE AT PLACE SHOWN AS (A)
- 4 SEQUENCE OF OPERATIONS :
 - A) BALL FITTINGS ARE NORMALISED AFTER FORGING
 - B) HARDENING & TEMPERING AND SHOT BLASTING
- 5 BEFORE GALVANISING THE BALL PORTION SHOULD ANSWER TO "GO AND NO GO" GAUGES TO DRG. No. 4 SK 0260 LATEST REVISION
- 4 SK 0261 LATEST REVISION AND CLAUSES B7,B8 & B9 OF IEC Pub. 60120 (16 mm 'B' DESIGNATION) UPTO PORTION (B)
- 6 BALL FITTING SHALL WITHSTAND A MINIMUM TENSILE STRENGTH OF 113 KN
- 7 MPI TEST TO BE CARRIED OUT ON ALL FORGED FITTINGS

CONTROLLED COPY

		BHARAT HEAVY ELECTRICALS LTD.		NAME	SIGN	DATE
ELECTROPORCELAINS DIVISION		BANGALORE 560 012		DRN	N. CHIKKANNA	23/11/10
SCALE		WEIGHT (kg)		CHD	S S P	21/1/10
TOL DIM		REF TO ASSY.DRG		APPD	S S P	21/1/10
GRADE OF		N T S		ITEM No. OF		
C/M/F		(Approv)		ITEMS		
DEPT		CODE		DRAWING No.		
TITLE		BALL FITTING		REV. 00		
PRE BORING STAGE FOR 70-90kN		CARD CODE		3 987 06 30232		
COMPOSITE LONG ROD INSULATOR		No. OF SHEETS		SHT. 24 SIZE A3 420 x 297		

02
REV
22202 1 786 5
DRG No.

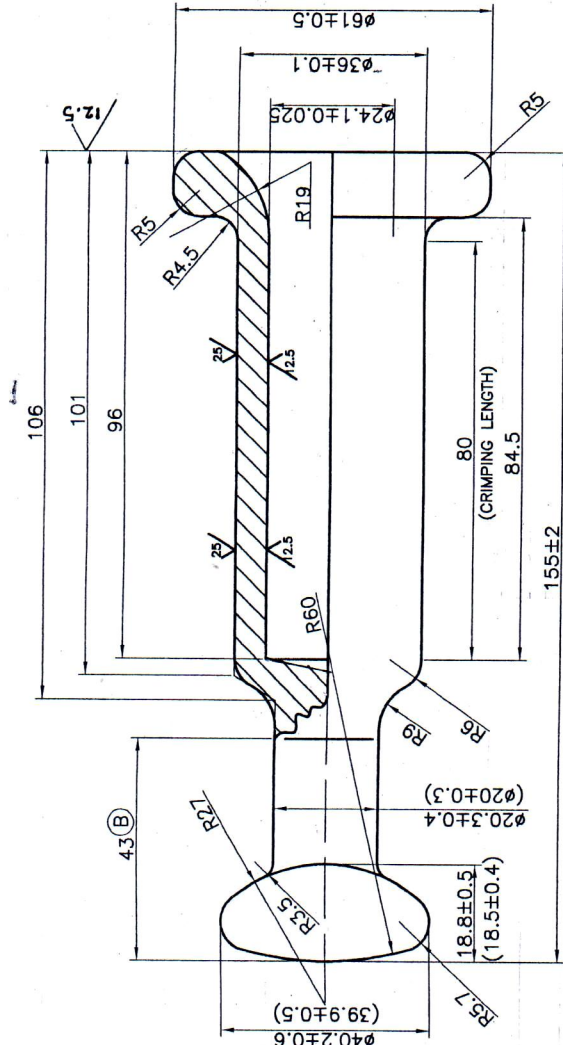
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REF. DRG. No.

SIGN AND DATE

INVENTORY No.

REV. DATE ALTERED CHECKED
02 14/11/11
1. DRAWING REDRAWN & REVISED
2. DIM 106 WAS 105, 101 WAS 100
AND 96 WAS 97
3. NOTE NO. 15 ADDED
REFER TO PH No. 5429



NOTES :

- 1 ALL DIMENSIONS ARE-AFTER HOT- DIP GALVANISING
A THICKNESS OF 0.15 mm MAY BE ASSUMED FOR GALVANISING
- 2 DIMENSIONS INDICATED IN BRACKET REFERS TO BEFORE GALVANISING STAGE
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BALL FITTINGS ARE TO BE MACHINED AT THAT PLACE WITH HELP
OF A 'FORM TOOL' TO GET A SMOOTH SURFACE
- 6 AFTER GALVANISING THE BALL PORTION SHOULD ANSWER TO ALL THE
RELEVANT "GO AND NO GO" GAUGES RECOMMENDED BY IEC Pub. 60120
OR LATEST (20 mm DESIGNATION) UP TO PORTION (B)
- 7 SUPPLIER'S IDENTIFICATION MARK & RATING SHALL BE PROVIDED
IN DEPRESSED FORM IN 6 mm LETTER SIZE AT PLACE SHOWN AS (A)
- 8 SEQUENCE OF OPERATIONS :
A) BALL FITTINGS ARE NORMALISED AFTER FORGING
B) MACHINING (IF NECESSARY SEE NOT No. 5)
C) HARDENING & TEMPERING AND SHOT BLASTING
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- 9 BEFORE GALVANISING THE BALL PORTION SHOULD ANSWER TO
"GO AND NO GO" GAUGES TO DRG. No. 4 SK 0260 LATEST REVISION
4 SK 0261 LATEST REVISION AND CLAUSES B7,B8 & B9 OF IEC Pub. 60120
(20 mm DESIGNATION) UP TO PORTION (B)
- 10 BALL FITTING SHALL WITHSTAND A MINIMUM TENSILE STRENGTH OF 150 kN
- 11 MPI TEST TO BE CARRIED OUT ON ALL FORGED FITTINGS
- 12 BORE HAS TO BE DONE ONLY AFTER GALVANISING
- 13 DIM $\phi 24.1 \pm 0.025$ TO BE CHECKED BY "GO & NO GO" GAUGES.
- 14 THE WEIGHT OF FORGED BALL FITTING AT BLACK STAGE IS 1.0 kg (APPROX)
- 15 DIM 96 TO BE CHECKED BY "GO & NO GO" GAUGES OF
DRG. No. 4 SK 2711

CONTROLLED COPY

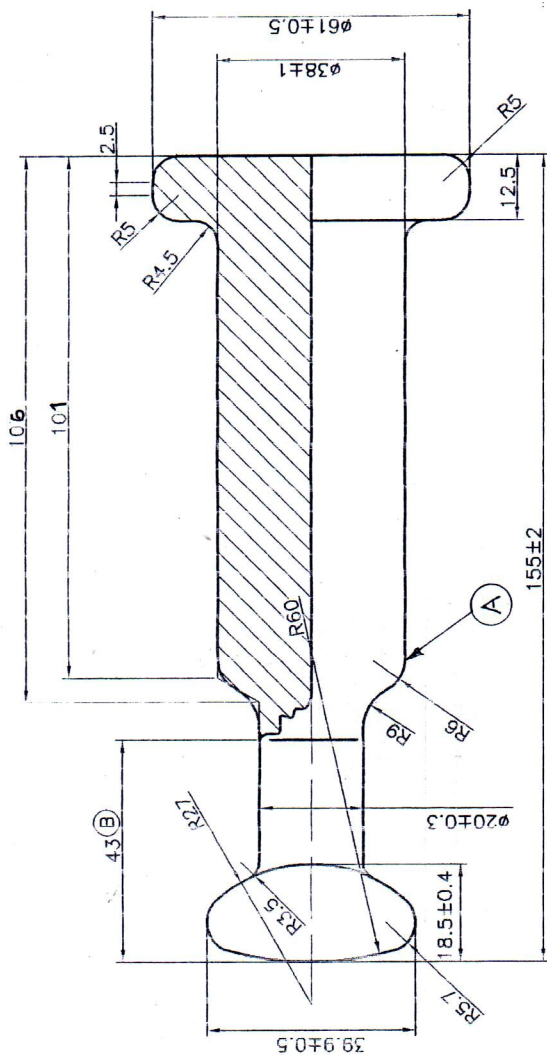
BHARAT HEAVY ELECTRICALS LTD. ELECTROPORCELAINS DIVISION BANGALORE 560 012		DRN	N CHIKKANA	SIGN	DATE
DEPT	GRADE OF TOL DIM C/M/F	CHD	S S P	APPD	7/2/11
CODE	SCALE N T S	WEIGHT (kg)	0.75	REF TO ASSY.DRG	7/2/11
TITLE	BALL FITTING FOR 120 kN COMPOSITE LONG ROD INSULATOR				
REV.	DRAWING No. 3 987 13 30222				
REV.	No. OF ITEMS				
REV.	No. OF SHEETS				

3 987 13 30232

DRG No.

REV

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



NOTES :

- 1 BALL FITTINGS ARE TO BE MADE BY FORGING PROCESS ONLY
- 2 MATERIAL TO CONFORM TO PURCHASING SPEC. EL:PS:3600103
- 3 SUPPLIER'S IDENTIFICATION MARK & RATING SHALL BE PROVIDED IN DEPRESSED FORM IN 6 mm LETTER SIZE AT PLACE SHOWN AS (A)
- 4 SEQUENCE OF OPERATIONS :
 - A) BALL FITTINGS ARE NORMALISED AFTER FORGING
 - B) HARDENING & TEMPERING AND SHOT BLASTING
- 5 BEFORE GALVANISING THE BALL PORTION SHOULD ANSWER TO "GO AND NO GO" GAUGES TODRG. No. 4 SK 0260 LATEST REVISION
 - 4 SK 0261 LATEST REVISION AND CLAUSES B7:B8 & B9 OF IEC Pub. 60120 (20 mm DESIGNATION) UPTO PORTION (B)
- 6 BALL FITTING SHALL WITHSTAND A MINIMUM TENSILE STRENGTH OF 150 kN
- 7 MPI TEST TO BE CARRIED OUT ON ALL FORGED FITTINGS

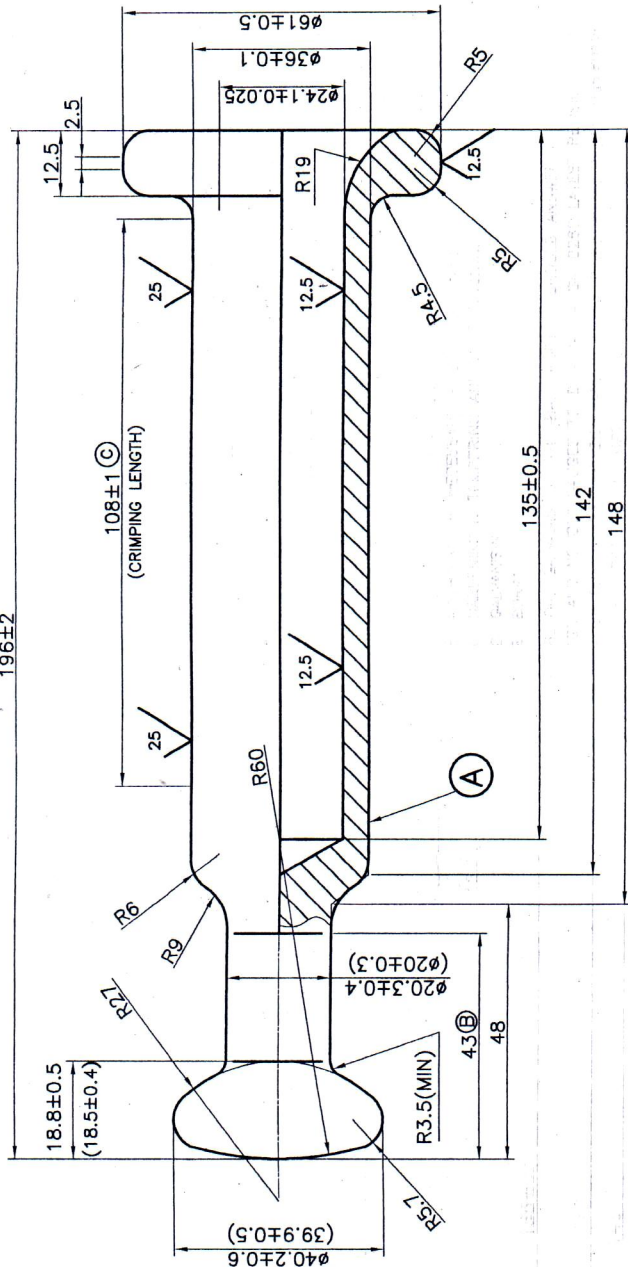
CONTROLLED COPY

SIGN AND D	REV	DATE	ALTERED	CHECKED	REV	DATE	ALTERED	CHECKED	REV	DATE	ALTERED	CHECKED	SIGN	DATE
	02	5.1.11	CHECKED		01	23.10.07	CHECKED		01	23.10.07	CHECKED		NCHIKKANA	23.08.07
DIM. 106 WAS 105 AND DIM. 101 WAS 100.													MARKING POSITION (A) SHOWN	
REF. PH. No. 5429													REF. PH. No. 5152	

DRG No. 72291 60 786 S

REV

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



NOTES:

- ALL DIMENSIONS ARE AFTER HOT-DIP GALVANISING.
A THICKNESS OF 0.15 mm MAY BE ASSUMED FOR GALVANISING.
- DIMENSIONS INDICATED IN BRACKETS REFER TO BEFORE GALVANISING STAGE
- BALL FITTINGS ARE TO BE MADE BY FORGING PROCESS ONLY
- MATERIAL TO CONFORM TO GRADE 080M40 OF BS EN:10083-1:1991 (EN-8)
- IF THE FORGED SURFACE IS NOT SMOOTH AT THE PORTION (B) & (C) BALL FITTINGS ARE TO BE MACHINED AT THAT PLACE WITH THE HELP OF A 'FORM TOOL' TO GET A SMOOTH SURFACE.
- AFTER GALVANIZING THE BALL PORTION SHOULD ANSWER TO ALL THE RELEVANT "GO AND NO GO" GAUGES RECOMMENDED BY IEC Pub.60120 OR LATEST (20 mm DESIGNATION) UP TO PORTION (B)
- SUPPLIER'S IDENTIFICATION MARK & RATING SHALL BE PROVIDED IN DEPRESSED FORM IN 6 mm LETTER SIZE AT PLACE SHOWN AS (A)
- SEQUENCE OF OPERATIONS :
A) BALL FITTINGS ARE NORMALISED AFTER FORGING
B) MACHINING (IF NECESSARY - SEE NOTE No.5)
C) HARDENING & TEMPERING AND SHOT BLASTING.
D) GALVANISING.
E) BORING.
- BEFORE GALVANISING THE BALL PORTION SHOULD ANSWER TO "GO AND NO GO" GAUGES TO DRG. No. 4 SK 0260 LATEST REVISION.
4 SK 0261 LATEST REVISION AND CLAUSES B7.B8 & B9 OF IEC Pub.60120 (20 mm DESIGNATION) UP TO PORTION (B)
- BALL FITTING SHALL WITHSTAND A MINIMUM TENSILE STRENGTH OF 200 kN
- MPI TEST TO BE CARRIED OUT ON ALL FORGED FITTINGS
- BORE HAS TO BE DONE ONLY AFTER GALVANISING
- DIM 135±0.5 TO BE CHECKED BY "GO & NO GO" GAUGES.
- THE WEIGHT OF FORGED BALL FITTING AT BLACK STAGE IS 1.4 kg.(APPROX)
- DIM 135±0.5 TO BE CHECKED BY "GO & NO GO" GAUGES OF DRG. No. 4 SK 2723

CONTROLLED COPY

FERROUS PARTS ARE HOT-DIP GALVANIZED (EXCEPT FEMALE THREADS) AS PER IS:2629 AND TESTS CONFORM TO IS:2633

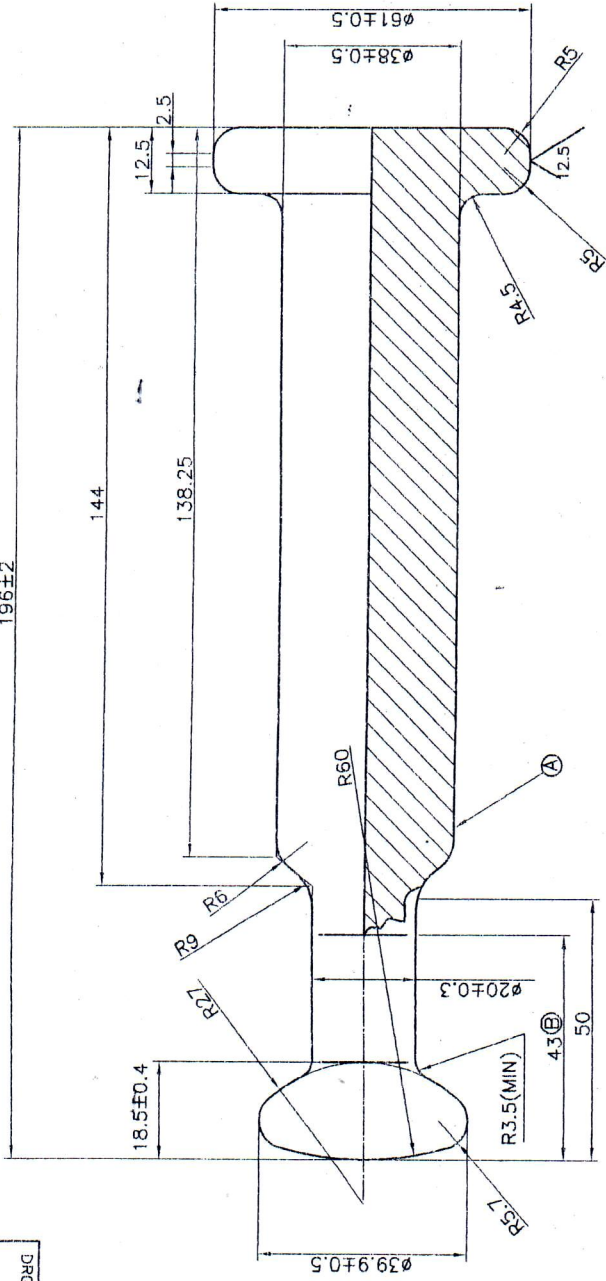
BHARAT HEAVY ELECTRICALS LTD;
ELECTROPORCELAINS DIVISION
BANGALORE 560 012

SIGN AND DATE		NAME		SIGN		DATE	
		N.CHICKANNA				04/02/11	
		CHD		S S P		04/02/11	
		APFD		S S P		04/02/11	
REV		DATE		REV		DATE	
03		04/02/11		03		04/02/11	
ALTERED		CHECKED		ALTERED		CHECKED	
03		04/02/11		03		04/02/11	
INVENTORY No.		REV.		DRAWING No.		REV.	
		03		3 987 09 15322		03	
TITLE		CARD CODE		DRAWING No.		REV.	
BALL FITTING FOR 160KN COMPOSITE		3 987 09 15322		3 987 09 15322		03	
LONG ROD INSULATOR							
DEPT		SCALE		WEIGHT (kg)		ITEM No.	
TOL DIM		N T S		0.9		3 987 09 15322	
C/M/F				(Approx)			
GRADE OF		N T S		0.9			
TOL DIM							
C/M/F							
CODE							
ALTERED		CHECKED		ALTERED		CHECKED	
03		04/02/11		03		04/02/11	
INVENTORY No.		REV.		DRAWING No.		REV.	
		03		3 987 09 15322		03	
TITLE		CARD CODE		DRAWING No.		REV.	
BALL FITTING FOR 160KN COMPOSITE		3 987 09 15322		3 987 09 15322		03	
LONG ROD INSULATOR							
DEPT		SCALE		WEIGHT (kg)		ITEM No.	
TOL DIM		N T S		0.9		3 987 09 15322	
C/M/F				(Approx)			
GRADE OF		N T S		0.9			
TOL DIM							
C/M/F							
CODE							
ALTERED		CHECKED		ALTERED		CHECKED	
03		04/02/11		03		04/02/11	
INVENTORY No.		REV.		DRAWING No.		REV.	
		03		3 987 09 15322		03	
TITLE		CARD CODE		DRAWING No.		REV.	
BALL FITTING FOR 160KN COMPOSITE		3 987 09 15322		3 987 09 15322		03	
LONG ROD INSULATOR							
DEPT		SCALE		WEIGHT (kg)		ITEM No.	
TOL DIM		N T S		0.9		3 987 09 15322	
C/M/F				(Approx)			
GRADE OF		N T S		0.9			
TOL DIM							
C/M/F							
CODE							
ALTERED		CHECKED		ALTERED		CHECKED	
03		04/02/11		03		04/02/11	
INVENTORY No.		REV.		DRAWING No.		REV.	
		03		3 987 09 15322		03	
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LONG ROD INSULATOR							
DEPT		SCALE		WEIGHT (kg)		ITEM No.	
TOL DIM		N T S		0.9		3 987 09 15322	
C/M/F				(Approx)			
GRADE OF		N T S		0.9			
TOL DIM							
C/M/F							
CODE							
ALTERED		CHECKED		ALTERED		CHECKED	
03		04/02/11		03		04/02/11	
INVENTORY No.		REV.		DRAWING No.		REV.	
		03		3 987 09 15322		03	
TITLE		CARD CODE		DRAWING No.		REV.	
BALL FITTING FOR 160KN COMPOSITE		3 987 09 15322		3 987 09 15322		03	
LONG ROD INSULATOR							
DEPT		SCALE		WEIGHT (kg)		ITEM No.	
TOL DIM		N T S		0.9		3 987 09 15322	
C/M/F				(Approx)			
GRADE OF		N T S		0.9			
TOL DIM							
C/M/F							
CODE							
ALTERED		CHECKED		ALTERED		CHECKED	
03		04/02/11		03		04/02/11	
INVENTORY No.		REV.		DRAWING No.		REV.	
		03		3 987 09 15322		03	
TITLE		CARD CODE		DRAWING No.		REV.	
BALL FITTING FOR 160KN COMPOSITE		3 987 09 15322		3 987 09 15322		03	
LONG ROD INSULATOR							
DEPT		SCALE		WEIGHT (kg)		ITEM No.	
TOL DIM		N T S		0.9		3 987 09 15322	
C/M/F				(Approx)			
GRADE OF		N T S		0.9			
TOL DIM							
C/M/F							
CODE							
ALTERED		CHECKED		ALTERED		CHECKED	
03		04/02/11		03		04/02/11	
INVENTORY No.		REV.		DRAWING No.		REV.	
		03		3 987 09 15322		03	
TITLE		CARD CODE		DRAWING No.		REV.	
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LONG ROD INSULATOR							
DEPT		SCALE		WEIGHT (kg)		ITEM No.	
TOL DIM		N T S		0.9		3 987 09 15322	
C/M/F				(Approx)			
GRADE OF		N T S		0.9			
TOL DIM							
C/M/F							
CODE							
ALTERED		CHECKED		ALTERED		CHECKED	
03		04/02/11		03		04/02/11	
INVENTORY No.		REV.		DRAWING No.		REV.	
		03		3 987 09 15322		03	
TITLE		CARD CODE		DRAWING No.		REV.	
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LONG ROD INSULATOR							
DEPT		SCALE		WEIGHT (kg)		ITEM No.	
TOL DIM		N T S		0.9		3 987 09 15322	
C/M/F				(Approx)			
GRADE OF		N T S		0.9			
TOL DIM							
C/M/F							
CODE							
ALTERED		CHECKED		ALTERED		CHECKED	
03		04/02/11		03		04/02/11	
INVENTORY No.		REV.		DRAWING No.		REV.	
		03		3 987 09 15322		03	
TITLE		CARD CODE		DRAWING No.		REV.	
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LONG ROD INSULATOR							
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TOL DIM		N T S		0.9		3 987 09 15322	
C/M/F				(Approx)			
GRADE OF		N T S		0.9			
TOL DIM							
C/M/F							
CODE							
ALTERED		CHECKED		ALTERED		CHECKED	
03		04/02/11		03		04/02/11	
INVENTORY No.		REV.		DRAWING No.		REV.	
		03		3 987 09 15322		03	
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TOL DIM		N T S		0.9		3 987 09 15322	
C/M/F				(Approx)			
GRADE OF		N T S		0.9			
TOL DIM							
C/M/F							
CODE							
ALTERED		CHECKED		ALTERED		CHECKED	
03		04/02/11		03		04/02/11	
INVENTORY No.		REV.		DRAWING No.		REV.	
		03		3 987 09 15322		03	
TITLE		CARD CODE		DRAWING No.		REV.	
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C/M/F				(Approx)			
GRADE OF		N T S		0.9			
TOL DIM							
C/M/F							
CODE							
ALTERED		CHECKED		ALTERED		CHECKED	
03		04/02/11		03		04/02/11	
INVENTORY No.		REV.		DRAWING No.		REV.	
		03		3 987 09 15322		03	
TITLE		CARD CODE		DRAWING No.		REV.	
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TOL DIM		N T S		0.9		3 987 09 15322	
C/M/F				(Approx)			
GRADE OF		N T S		0.9			
TOL DIM							
C/M/F							
CODE							
ALTERED		CHECKED		ALTERED		CHECKED	
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INVENTORY No.		REV.		DRAWING No.		REV.	
		03		3 987 09 15322		03	
TITLE		CARD CODE		DRAWING No.		REV.	
BALL FITTING FOR 160KN COMPOSITE		3 987 09 15322		3 987 09 15322		03	
LONG ROD INSULATOR							
DEPT		SCALE		WEIGHT (kg)		ITEM No.	
TOL DIM		N T S		0.9		3 987 09 15322	
C/M/F				(Approx)			
GRADE OF		N T S		0.9			
TOL DIM							
C/M/F							
CODE							
ALTERED		CHECKED		ALTERED		CHECKED	
03		04/02/11		03		04/02/11	
INVENTORY No.		REV.		DRAWING No.		REV.	
		03		3 987 09 15322		03	
TITLE		CARD CODE		DRAWING No.		REV.	
BALL FITTING FOR 160KN COMPOSITE		3 987 09 15322		3 987 09 15322		03	
LONG ROD INSULATOR							
DEPT		SCALE		WEIGHT (kg)		ITEM No.	
TOL DIM		N T S		0.9		3 987 09 15322	
C/M/F				(Approx)			
GRADE OF		N T S		0.9			
TOL DIM							
C/M/F							
CODE							
ALTERED		CHECKED		ALTERED		CHECKED	
03		04/02/11		03		04/02/11	
INVENTORY No.		REV.		DRAWING No.		REV.	
		03		3 987 09 15322		03	
TITLE							

FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm.

00	REV
200901	60
786	£
DRG NO	



NOTES :

- 1 BALL FITTINGS ARE TO BE MADE BY FORGING PROCESS ONLY
- 2 MATERIAL TO CONFORM TO PURCHASING SPEC. EL:PS:3600103
- 3 SUPPLIER'S IDENTIFICATION MARK & RATING SHALL BE PROVIDED IN DEPRESSED FORM IN 6 mm LETTER SIZE AT PLACE SHOWN AS (A)
- 4 SEQUENCE OF OPERATIONS :
 - A) BALL FITTINGS ARE NORMALISED AFTER FORING
 - B) HARDENING & TEMPERING AND SHOT BLASTING
- 5 BEFORE GALVANISING THE BALL PORTION SHOULD ANSWER TO "GO AND NO GO" GAUGES TO DRG. No. 4 SK 0260 LATEST REVISION
- 4 SK 0261 LATEST REVISION AND CLAUSES B7:B8 & B9 OF IEC Pub. 60120 (20 mm DESIGNATION) UPTO PORTION (B)
- 6 BALL FITTING SHALL WITHSTAND A MINIMUM TENSILE STRENGTH OF 200 kN
- 7 MPI TEST TO BE CARRIED OUT ON ALL FORGED FITTINGS

CONTROLLED COPY

SIGN AND DATE		NAME		SIGN		DATE	
		N. CHIKKANA				13.09.07	
REF. DRG. NO.		DRN		CHD		APPD	
						A K S	
INVENTORY No.		BOLT PARTS ARE HOT-DIP GALVANIZED (EXCEPT FEMALE THREADS) AS PER IS:2629 AND TESTS CONFORM TO IS:2635		BHARAT HEAVY ELECTRICALS LTD, ELECTROPORCELAINS DIVISION BANGALORE 560 012		REF TO ASSY.DRG	
REV		DATE		REV		DATE	
ALTERED		CHECKED		ALTERED		CHECKED	
GRADE OF		TOL DIM		SCALE		WEIGHT (kg)	
C/M/F		N T S		N T S		1.6	
DEPT		CODE		GRADE OF		ITEM No.	
						13.09.07	
TITLE		BALL FITTING		CARD CODE		DRAWING No	
PRE BORING STAGE FOR 160kN				3 987 09 15332		REV.	
COMPOSITE LONG ROD INSULATOR						00	
SUPERSEDES DRG. No.		No. OF SHEETS					
		SHT.24 SIZE A3 420 x 297					