

DRAWING NO:

~~1.6 / 0.8~~

SIGNATURE

HEAT TREAT TO 100 Ka/mm²

HARDNESS 41-45 HRC

CAUTION: 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.

REV	DATE	ALTERED
06	07.03.14	CHECKED
		APPROVED

SL.No.27-32 ADDED

DRAWING NO :

DRAWING NO :
30-ST-211-01-005

REV 06

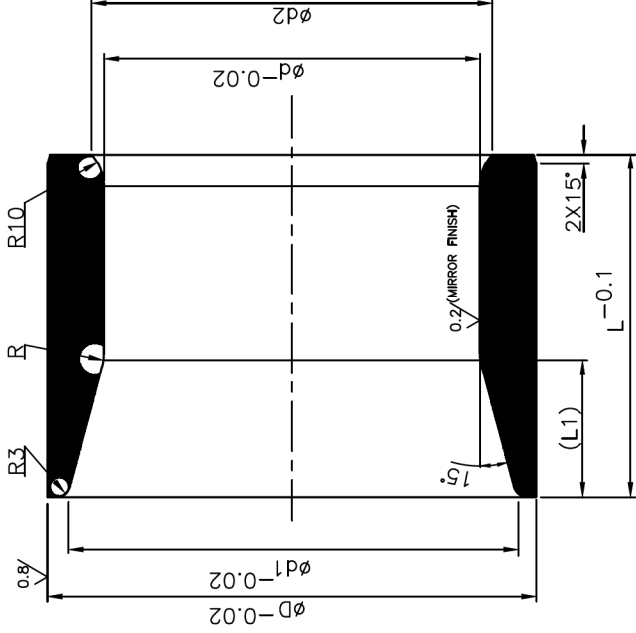
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ALL DIMENSIONS ARE IN MILLIMETRES

30-ST-112-101-000

DRAWING NO.:

SL.No.	FOR MATERIAL CODE No	Ød	Ød1	Ød2	R	L1	L	ØD
03	69 21 22 0010	18	25	23	10	13.6	40	31
04	69 21 22 0028	20	30	25	10	18.66	50	36
05	69 21 22 0036	23	32	28	15	16.8	45	41
06	69 21 22 0044	25	35	30	15	18.66	45	41
07	69 21 22 0052	26	38	31	15	22.39	49	46
08	69 21 22 0060	30	40	35	15	18.66	49	46
09	69 21 22 0079	31	45	36	15	26.12	70	58
10	69 21 22 0087	36	52	41	20	29.8	70	58
11	69 21 22 0095	42	62	47	20	37.32	80	68
12	69 21 22 0109	42	60	47	20	33.6	55	68
13	69 21 22 0117	46	62	51	20	29.86	70	68
14	69 21 22 0125	50	62	55	25	22.39	72	68
15	69 21 22 0133	50	68	60	25	33.59	68	74
16	69 21 22 0141	55	75	60	25	37.32	76	81
17	69 21 22 0150	55	75	60	25	37.32	76	81
18	69 21 22 0168	62	80	67	30	33.6	70	86
19	69 21 22 0176	66	80	71	30	26.12	70	86
20	69 21 22 0184	74	86	79	35	22.39	80	92
21	69 21 22 0192	80	95	85	40	27.99	70	100
22	69 12 22 0206	70	81	75	35	20	70	86
23	69 21 22 0214	58	75	63	25	30	76	81
24	69 21 22 0229	27	38	32	15	20.53	49	46
25	69 21 22 0230	50	68	55	25	33.59	72	74
26	69 21 22 0249	46	74	51	20	52.25	80	84
27	69 21 22 0250	40	62	45	20	41.05	80	68
28	69 21 22 0080	37	53	42	20	29.8	70	58
29	69 21 22 0090	43	63	48	20	37.32	80	68
30	69 21 22 0110	47	63	52	20	29.86	70	68
31	69 21 22 0130	50.5	69	61	25	33.59	68	74
32	69 21 22 0160	63.0	81	68	30	33.6	70	86



MATERIAL:TUNGSTEN CARBIDE

TUNGSTEN (W) : 85%
COBALT (Co) : 15%
HARDNESS : 1200 HV

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ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT	MATL SPEC	QTY
EQPT:						
Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	R.KUMAR	SIGNATURE	DATE	06.03.14
		CHD	S.UDHAYAKUMAR	S.UDHAYAKUMAR	07.03.14	
		APPD	N. ARUMUGANANAR	N. Ar	08.03.14	
DEPT		SSTP/TE		WEIGHT (kg)		ITEM
456		ES-2102		/		01
GRADE OF UNTOL DIM		SCALE		N T S		
Ø/Ø/Ø		N T S				
REF TO OLD DWG NO		REF TO ASSY DWG NO		30-ST-211.01.002/08		
RH143.1.15.018-080 LS						
DRAWING NO :		30-ST-211-01-003		REV		11
CARD CODE		U 01				
TITLE		POINTING BUSH (FOR POINTING DIE)				
SL.No.27-32 ADDED						

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0.00

30-S1-271-01-002

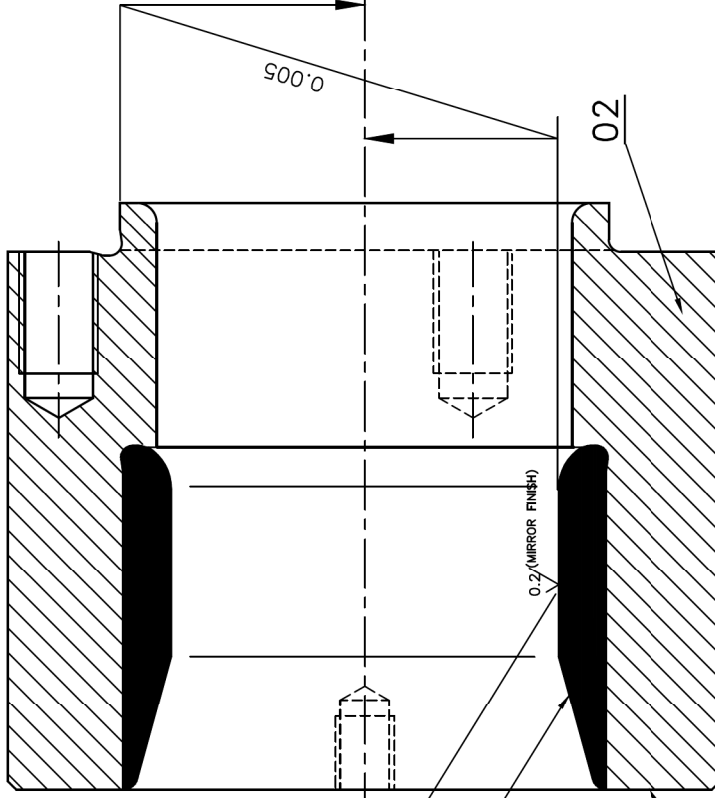
DRAWING NO:

SL.No.	MATERIAL CODE	Nd.	(HOLLOW) TUBE DIA	POINTING DIA	DEMAG REF.DRG.No.
03	69 21 22 0010	24		18	RH.143.1.15.018 LS
04	69 21 22 0028	25, 26, 27		20	RH.143.1.15.020 LS
05	69 21 22 0036	30		23	
06	69 21 22 0044	32		25	RH.143.1.15.025 LS
07	69 21 22 0052	35, 36		26	
08	69 21 22 0060	36, 37		30	RH.143.1.15.030 LS
09	69 21 22 0079	42.4		31	
10	69 21 22 0087	42.4, 44.5, 48		36	RH.143.1.15.036 LS
11	69 21 22 0095	51		42	RH.143.1.15.042 LS
12	69 21 22 0109	51		42	
13	69 21 22 0117	54, 57		46	RH.143.1.15.046 LS
14	69 21 22 0125	55, 57		50	RH.143.1.15.050 LS
15	69 21 22 0133	60.3, 63.5		50	RH.143.1.15.050 LS
16	69 21 22 0141	62, 63.5, 70		55	RH.143.1.15.055 LS
17	69 21 22 0150	62, 63.5, 70		55	
18	69 21 22 0168	70		62	RH.143.1.15.062 LS
19	69 21 22 0176	76.1		66	
20	69 21 22 0184	81, 82.5		74	RH.143.1.15.074 LS
21	69 21 22 0192	88.9		80	RH.143.1.15.080 LS
22	69 21 22 0206	76.1		70	
23	69 21 22 0214	63.5, 70		58	
24	69 21 22 0229	33.4, 35		27	
25	69 21 22 0230	60.3, 63.5		50	
26	69 21 22 0249	47.63		46	
27	69 21 22 0250	44.5, 47.63		40	
28	69 21 22 0080	42.4, 44.5, 48		37	
29	69 21 22 0090	51		43	
30	69 21 22 0110	54, 57		47	
31	69 21 22 0130	60.3, 63.5		50.5	
32	69 21 22 0160	70		63	

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0.005



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