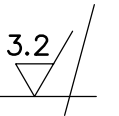
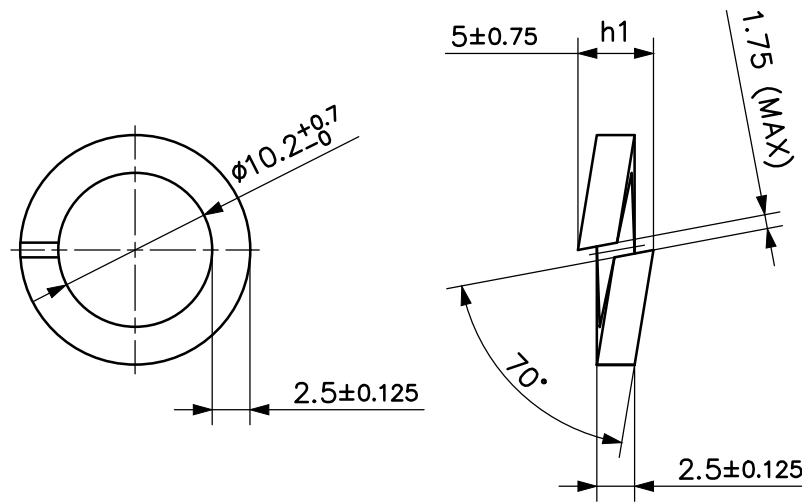


.2/



1. STEEL SPRING WASHER SHALL HAVE HARDNESS 41.5–49.5 (ROCKWELL HARDNESS EQUIVALENT TO HRC 40–48).
2. ON WASHER SURFACE, THERE SHALL BE NO SCALES, BURRS, CRACKS AND CORROSION.
3. ENDS OF WASHER SHALL HAVE A FLAT CUTTING EDGE, FORMED BY CUTTING PLANE AND SUPPORT SURFACE OF WASHER SHALL BE SHARP.
4. HEIGHT OF SEPARATION OF ENDS OF WASHERS 'h₁' AFTER THRICE COMPRESSING THEM TO FLAT POSITION AND RETAINING THEM FOR 24 HOURS IN THAT CONDITION, SHALL BE MINIMUM 1.65 TIMES ACTUAL THICKNESS (2.5 mm) OF WASHER.
5. SPRING WASHER SHALL NOT BREAK OR HAVE CRACKS UPON BENDING THEIR ENDS BY 45°.
6. PICKLE AND PASSIVATION AS PER APPROVED PROCEDURE.

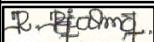
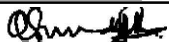
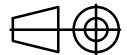


		SHEET 2. 5						0. 002	
					SS420	A			
VARIANT NUMBER	ITEM NUMBER	DESCRIPTION	STD	DRAWING NUMBER	ITEM NO	MATERIAL CODE	A/C	UNIT	UNIT WEIGHT
					VAR NO	MATERIAL SPECN		D1	QUANTITY

TOLERANCE IF UNSPECIFIED SHALL BE AS PER IS:2102-1969 (FOR MACHINED PARTS) ALL DIMENSIONS ARE IN MM UNLESS SPECIFIED OTHERWISE					
LINEAR				ANGULAR	
DIMENSIONS	TOL	DIMENSIONS	TOL	DIMENSIONS	TOL
UP TO 6	±0.1	315 TO 1000	±0.8	UP TO 10	±1°
6 TO 30	±0.2	1000 TO 2000	±1.2	10 TO 50	±30'
30 TO 120	±0.3	2000 TO 4000	±2.0	50 TO 120	±20'
120 TO 315	±0.5	4000 TO 8000	±3.0	120 TO 400	±10'
RADI AND CHAMFERS	0.5 TO 3	3 TO 6	6 TO 30	400 UPWARDS	±5°
TOLERANCE				PERMISSIBLE DEVIATIONS: FOR RANGE OF LENGTHS IN MILLIMETERS, OF THE SHORTER SIDE OF THE ANGLE CONCERNED	
±0.2		±0.5		±1.0	

REV	DATE	ALTERED
01		CHECKED

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

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT				BARC / RPV - B3 W.O. D163 TO D164-001-1-90-629 REF : B3/04/04-84/PT/1240 PRODN. DRG.							
 05-229/D Bharat Heavy Electricals Ltd UNIT: HIGH PRESSURE BOILER PLANT TIRUCHIRAPALLI - 620014				DRN	NAME K.R	SIGNATURE 	DATE 060416	NO. OF VAR			
				CHD	260213		120416				
				APPD	A.S		120416				
DEPT NC	GRADE OF UNTOL DIM C/M/F		SCALE 1:2 2:1	WEIGHT (Kg) 0.002	REF TO ASSY / OLD DWG 0-90-629-00311			ITEM NO 42	No OF ITEMS		
CODE 150											
TITLE SPRING WASHER-10					CARD CODE U 01	DRAWING NO : 3-90-629-01435			REV 00		