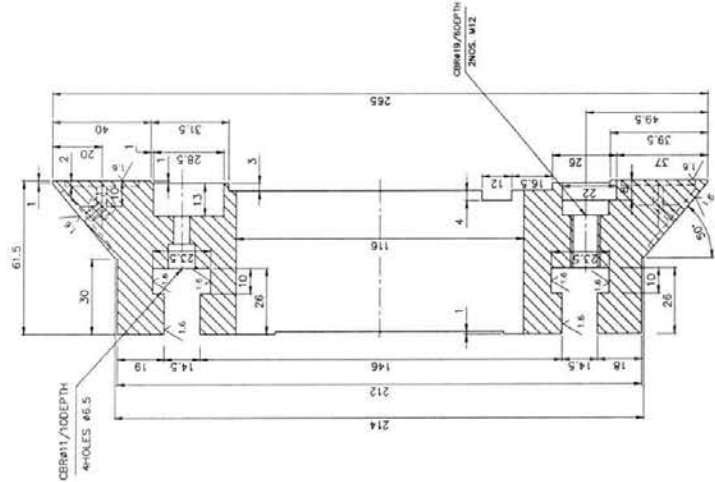
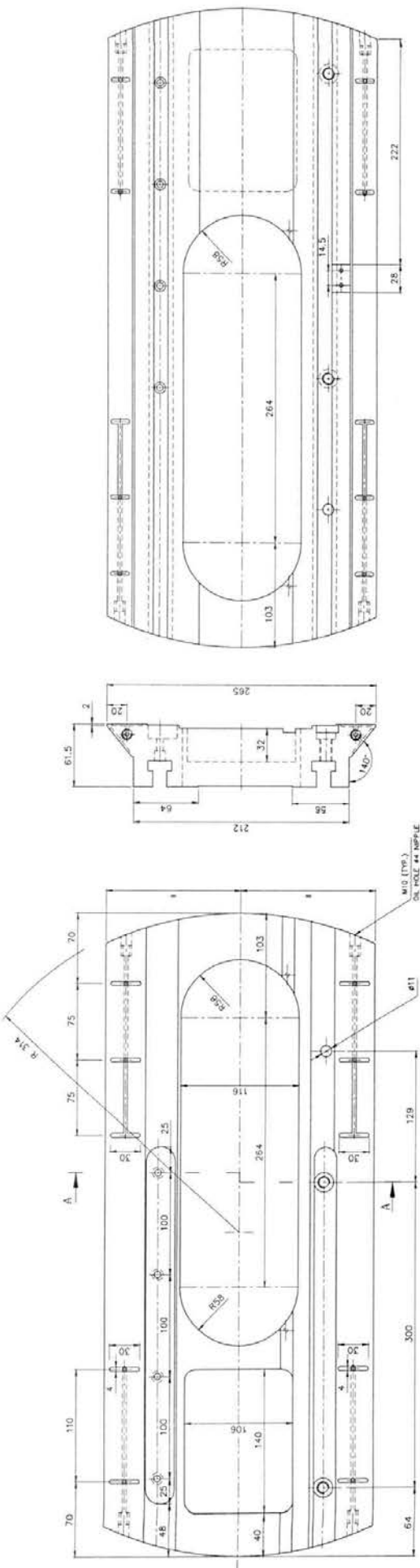


7MD1 B2402789

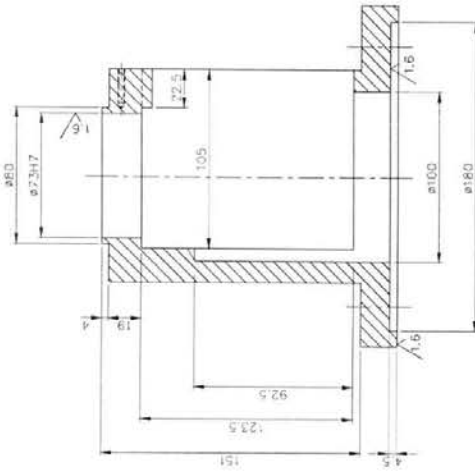
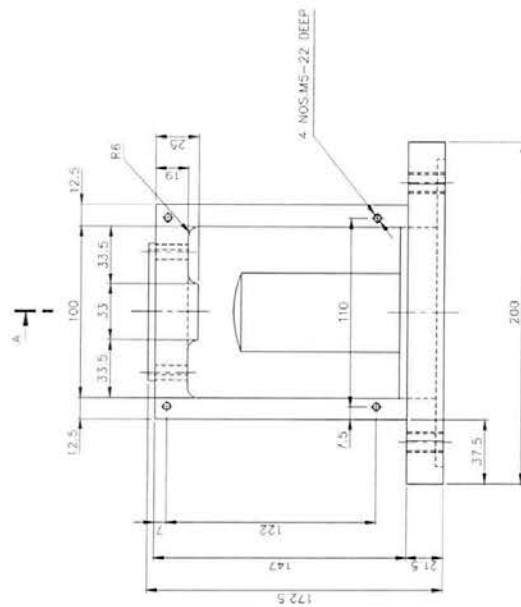


SECTION-AA

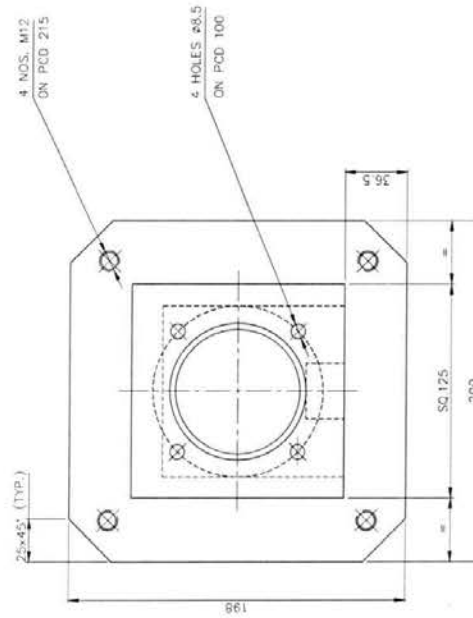
[illegible]

DRAWING NO.
2-M-01B24-05449

NOTE:
SHARP CORNERS TO BE REMOVED



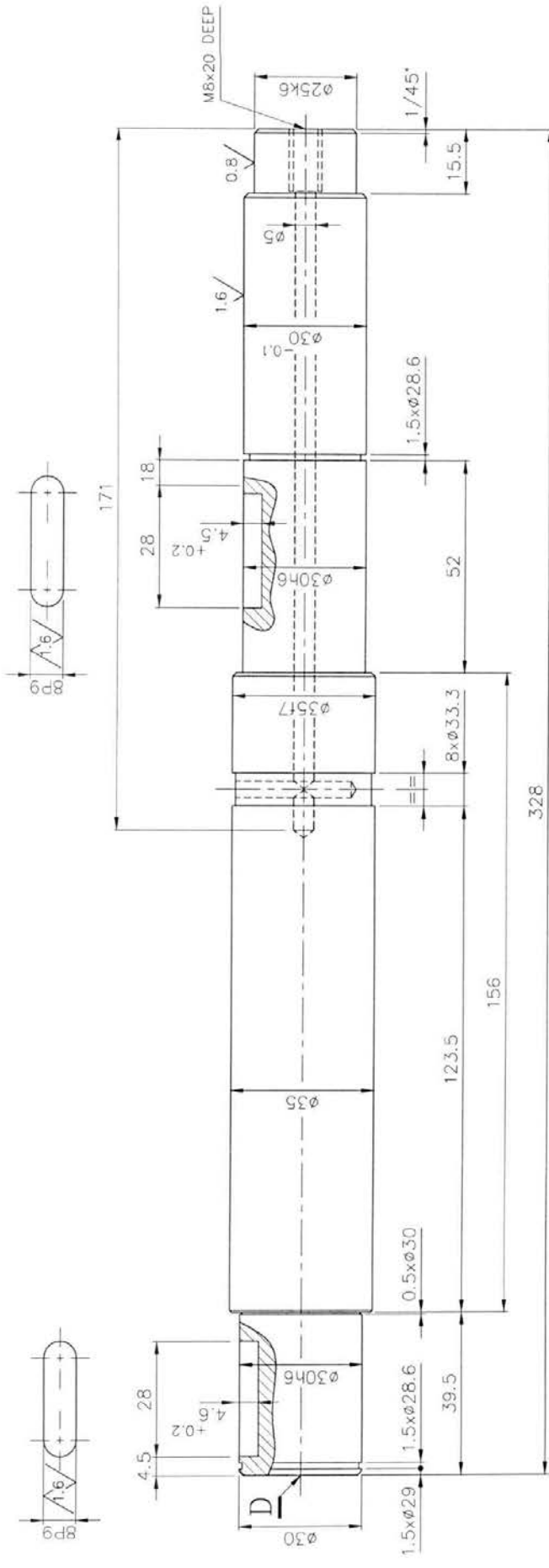
SECTION-AA



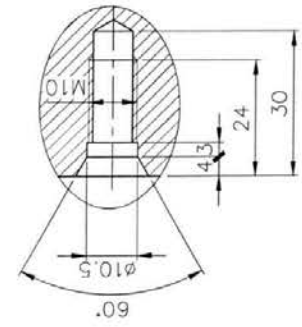
ITEM NO		DESCRIPTION		DRAWING NO		15-210		23.00	
UNIT NO						FG.220		1	
				MATERIAL SPEC		MATERIAL CODE		UNIT KIT	
								0"	
EDP: CNC HORIZONTAL BORING / GEETHA BFT 110  Bharat Heavy Electricals Ltd HIGH PRESSURE BOILER PLANT TRUCHIRAPALLI - 672014									
DATE		GRADE OF MATERIAL		SCALE		WEIGHT (Kg)		ITEM	
MAY 1987		2507		1:2		23.00			
									
TITLE		DRAWING NO :		CARD CODE		U ON		REV	
MOTOR MOUNTING BRACKET								2-M-01B24-05449	
(TABLE DRIVE ASS'Y)									

$$\frac{3.2}{\sqrt{1.5}} \sqrt{0.8}$$

ø30h6	-0.000	ø25k6	+0.015	ø35f7	-0.025	8p9	-0.015
	-0.013		+0.002		-0.050		-0.051



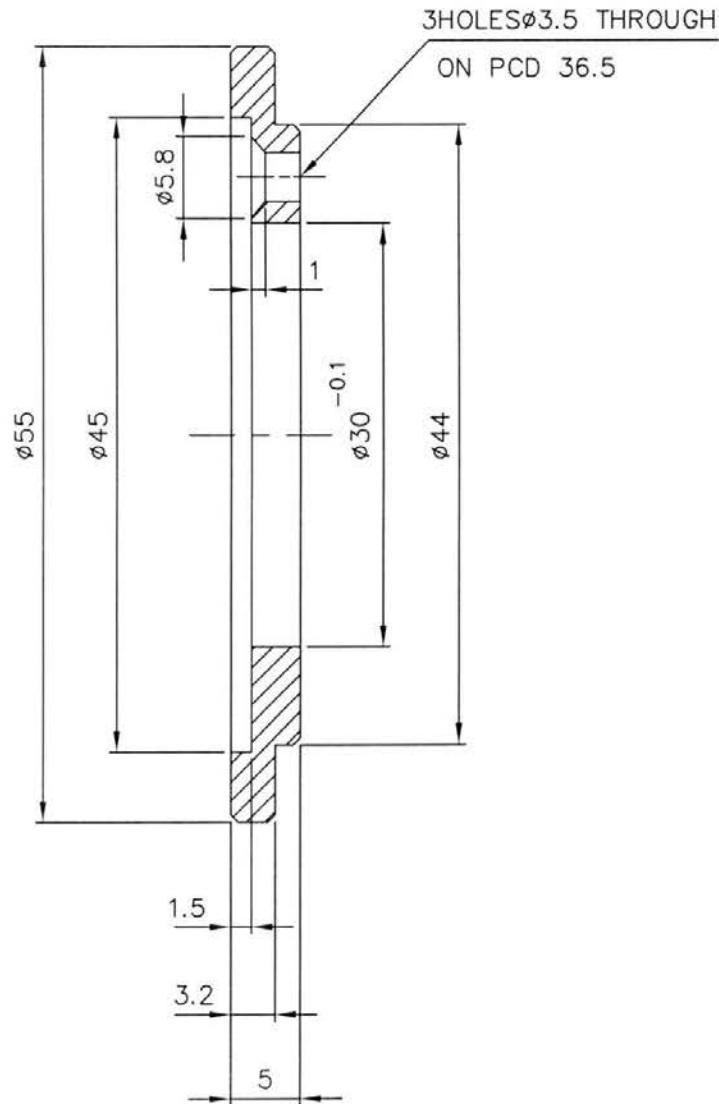
NOTE: —
SHARP CORNERS TO BE REMOVED
HARDENED TO HRC. 35⁺²

DETAIL—'D'

	No. of PAGE		DESCRIPTION REFERENCE:	55C8	IS: 5517	2.47	ITEM No. INDEX
				MATERIAL	STANDARD	NET WT. IN KGS.	
				ALTERATIONS:	DCN REF	DATE	SIG.
SCALE DRAWN				S. Selvamaniakam			
CHECKED				R. RAMAMOORTHY			
1:1				C.S. JAYASHEELAN			
APPROVED							
DATE				28.10.10			
MACHINE: HORIZONTAL BORING CNC.				TYPE:		GEEIHA BFT-110	REV.
TITLE:				DRAWING No:			
				SHAFT $\phi 35 \times 328L$			3M01B2414530
				(SPINDLE GEAR BOX -U AXIS)			
				Sheet No	No. of Sheets		

ALL DIMENSIONS ARE IN MM

3.2/



NOTE:

SHARP CORNERS TO BE REMOVED

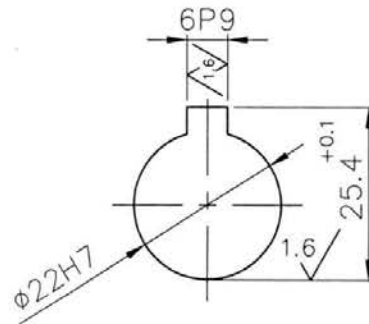
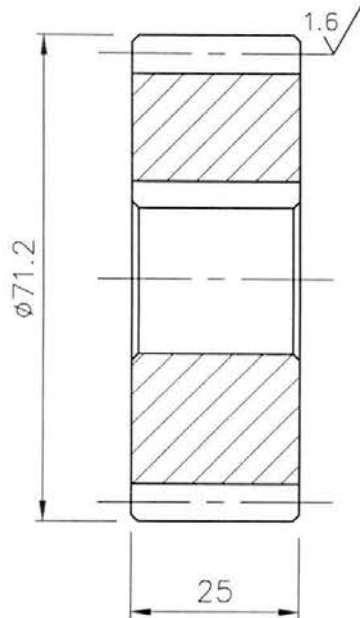
No. of Pieces	PI.5tx $\phi 55$		Fe410WA	IS: 2062	0.06			ITEM No.
	DESCRIPTION		MATERIAL	STANDARD	NET.WT.IN KGS.	DRAWING No.		
SCALE	DRAWN	S.selvamanickam	REFERENCE:	ALTERATIONS:	DCN REF	DATE	SIGN.	INDEX
2:1	CHECKED	R.RAMAMOORTHY						
	APPROVED	C.S.JAYASHEELAN						
	DATE	14/06/10						
MACHINE: HORIZONTAL BORING CNC	TITLE: COVER ID30xOD55x5t		TYPE: GEETHA BFT-110				REV.	
			DRAWING No:					
			4M01B2428566					
		Sheet No:				No. of Sheets:		

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ALL DIMENSIONS ARE IN MM

ø78.1h11	-0.000	6P9	-0.012
	-0.190		-0.042
ø22H7			+0.021
			+0.000

3.2/1.6/



NO.OF STARTS	2
MODULE	2.75
PRESSURE ANGLE	20°
LEAD ANGLE	4° 47' 7"
AXIAL PITCH	8.64
HAND OF HELIX	RH
MATING GEAR NO.OF TEETH	20
MATING GEAR DRAWING NO:	4M01B2428756
CENTRE DISTANCE	-

NOTE:
HARDENED TO HRC 35^{±2}
SHARP CORNERS TO BE REMOVED 1/45°

X		ø72x25L		55C8	IS: 5517	0.65			
No. of Pieces	DESCRIPTION			MATERIAL	STANDARD	NET.WT.IN KGS.	DRAWING No.		ITEM No.
		REFERENCE:			ALTERATIONS:		DCN REF	DATE	SIGN.
SCALE	DRN	G.Govindaraj							
1:1	CHD	R.Ramamorthy							
	APPD	C.S.Jayasheelan							
	DATE	15/11/10							
MACHINE:		HORIZONTAL BORING			TYPE:		GEETHA BFT-110		
TITLE:		WORM SHAFT ø71.2x 2 ST.			DRAWING No:		4M01B2428755		
		(CHUCK ASSY.)							

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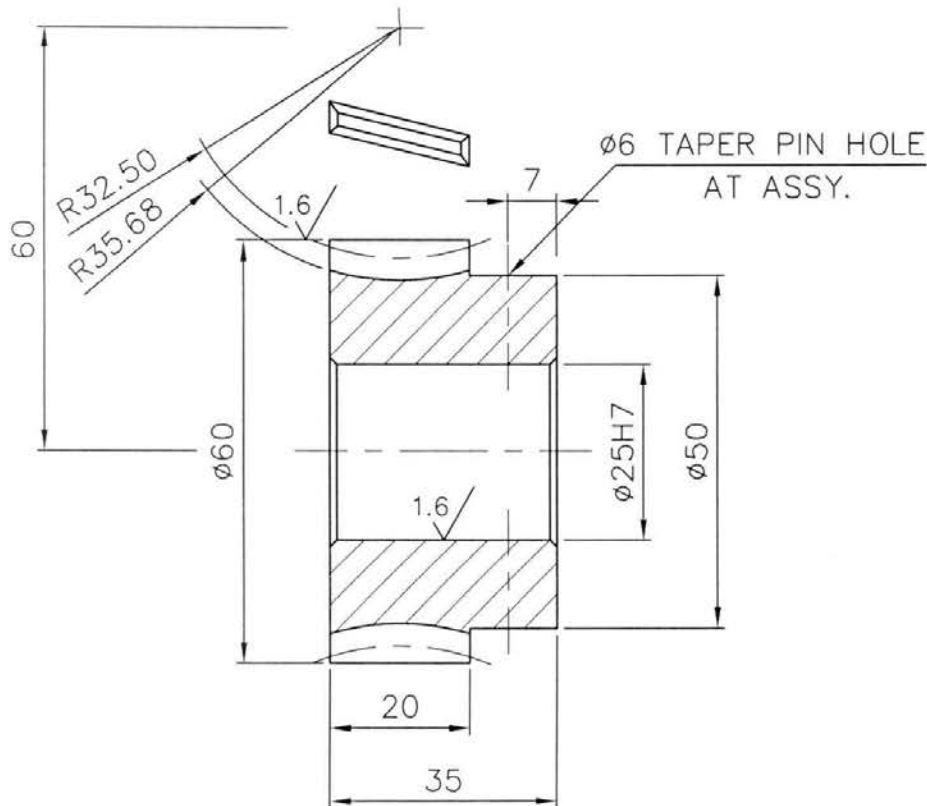
ALL DIMENSIONS ARE IN MM

ø25H7

+0.021

+0.000

3.2/1.6/



NO.OF TEETH	20
MODULE	2.75
PRESSURE ANGLE	20°
HELIX ANGLE	4°50'11"
HAND OF HELIX	RH
WIDTH ACROSS 3 TEETH	21.07 ^{-0.141} _{-0.188}
QTY.&TOL.ZONE	9e DIN 3967
MATING WORM NO.OF STARTS	2
MATING GEAR DRAWING NO:	4M01B2428755
CENTRE DISTANCE	-

NOTE:

SHARP CORNERS TO BE REMOVED 1/45°

X		ø60X35L		PCuSn7	IS: 28	0.50			
No. of Pieces	DESCRIPTION			MATERIAL	STANDARD	NET.WT.IN KGS.	DRAWING No.		ITEM No.
REFERENCE:		ALTERATIONS:			DCN REF	DATE	SIGN.	INDEX	
SCALE	DRAWN	G.GOVINDARAJ							
1:1	CHECKED	R.RAMAMOORTHY							
	APPROVED	C.S.JAYASHEELAN							
	DATE	15/11/10							
MACHINE:		HORIZONTAL BORING			TYPE:		GEETHA BFT-110		
TITLE:		HELICAL GEAR ø66.1X20T			DRAWING No:		REV.		
		(CHUCK ASSY.)			4M01B2428756				

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ALL DIMENSIONS ARE IN MM

ø35H7

+0.025
0.000

3.2/1.6

M8-15 DEEP AT ASSY.

(TYP)

R60

1.6

P ↓

120 -0.1

HOLE ø10-15 DEEP(TYP)

16

(TYP)

-0.1

ø20

1.6

ø35H7

1.6

16

2

1.6

ø50

26

58

26

110

31

45

10SQ

M3-8 DEEP(TYP)

NOTE: -

CHAMFER CORNERS FOR 1/45°

VIEW-P

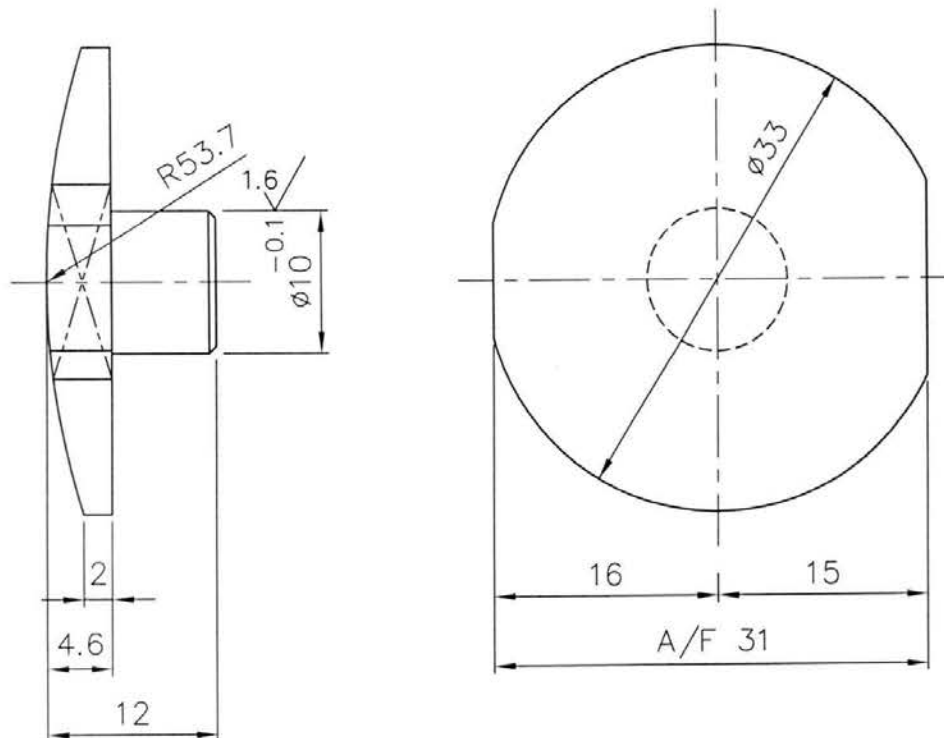
PCuSn7		IS: 28	1.30			
No. of Pieces	DESCRIPTION	MATERIAL	STANDARD	NET.WT. IN KGS.	DRAWING No.	ITEM No.
REFERENCE:	ALTERATIONS:		DCN REF	DATE	SIGN.	INDEX
SCALE	DRAWN	S.selvamanickam				
1:1	CHECKED	R.RAMAMOORTHY				
	APPROVED	C.S.JAYASHEELAN				
	DATE	29.10.10'				
MACHINE: HORIZONTAL BORING CNC.			TYPE: GEETHA BFT-110			
TITLE: SUPPORT (CHUCK ASSY.)			DRAWING No:			REV.
			4M01B2428771			
			Sheet No:			No. of Sheets:

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CAUTION:

ALL DIMENSIONS ARE IN MM

3.2/1.6



NOTE: -

SHARP CORNERS TO BE REMOVED

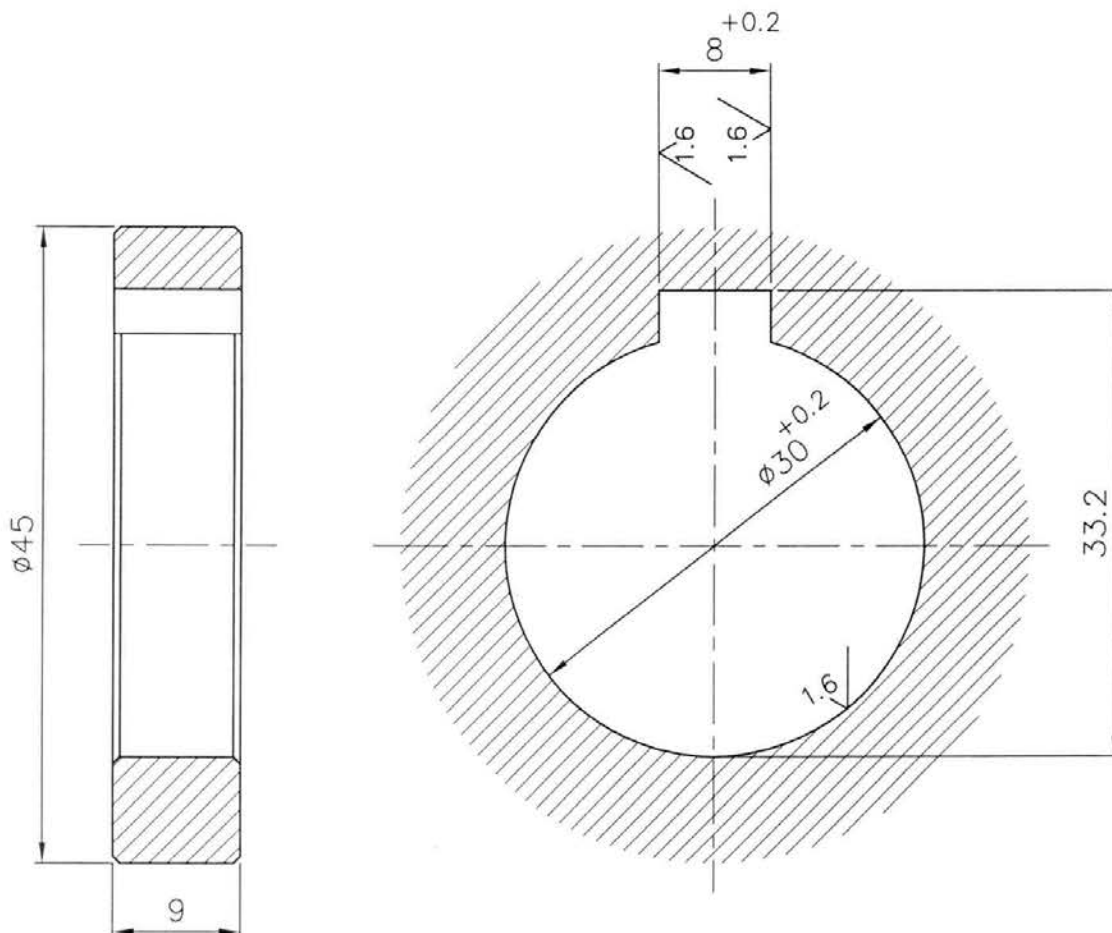
X		ø33x12t	Fe410WA	IS: 2062	0.04			
No. of Pieces	DESCRIPTION		MATERIAL	STANDARD	NET.WT.IN KGS.	DRAWING No.		ITEM No.
REFERENCE:		ALTERATIONS:		DCN REF	DATE	SIGN.	INDEX	
SCALE	DRAWN	S.selvamanickam						
2:1	CHECKED	R.RAMAMOORTHY						
	APPROVED	C.S.JAYASHEELAN						
	DATE	29.10.10						
MACHINE: HORIZONTAL BORING CNC.				TYPE: GEETHA BFT-110				
TITLE: END CAP (CHUCK ASSY.)				DRAWING No:				REV.
				4M01B2428772				
				Sheet No:				No. of Sheets:

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CAUTION:

ALL DIMENSIONS ARE IN MM

3.2/1.6



NOTE: -

SHARP CORNERS TO BE REMOVED

No. of Pieces	DESCRIPTION		MATERIAL	STANDARD	NET.WT.IN KGS.	DRAWING No.		ITEM No.
	REFERENCE:		ALTERATIONS:	DCN REF	DATE	SIGN.	INDEX	
SCALE 2:1	DRAWN	S.selvamanickam						
	CHECKED	R.RAMAMOORTHY						
	APPROVED	C.S.JAYASHEELAN						
	DATE	29.10.10						
	MACHINE: HORIZONTAL BORING CNC.			TYPE: GEETHA BFT-110			REV.	
	TITLE: SPACER OD45xID30x9L			DRAWING No:				
	(CHUCK ASSY.)			4M01B2428773				
	Sheet No:			No. of Sheets:				

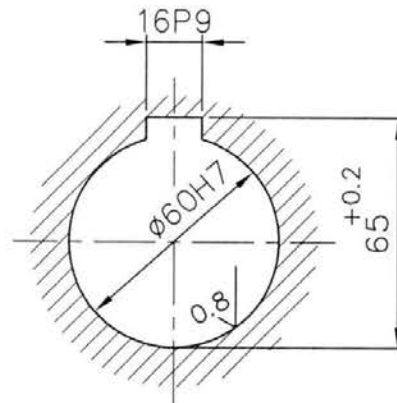
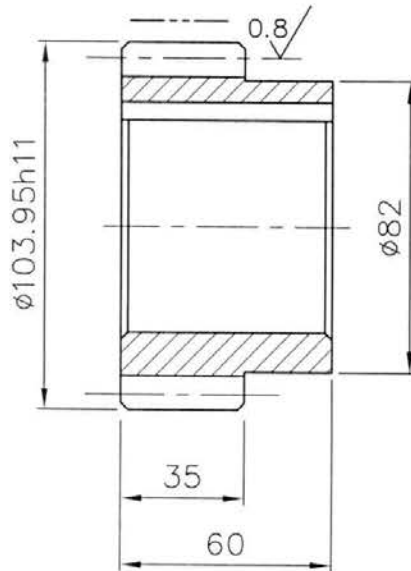
THIS DRAWING IS OUR SOLE PROPERTY AND SHOULD NOT BE USED IN ANY FORM FOR ANY PURPOSE WITHOUT THE WRITTEN PERMISSION OF BHARAT HEAVY ELECTRICALS LIMITED TRICHIRAPPALLI - 620 014.

CAUTION:

ALL DIMENSIONS ARE IN MM

ø103.95h11	-0.000	16P9	-0.018
	-0.220		-0.061
ø60H7	+0.030		
	0.000		

1.6/0.8



NOTE: -

----- HARDENED TO HRC. 60 ±2

CASE DEPTH- 0.8 mm

CHAMFER CORNERS FOR 1/45°

NO.OF TEETH	20
MODULE	4.5
PRESSURE ANGLE	20°
WITH ACROSS 3 TEETH	-0.079 -0.132 36.399
CORRECTION FACTOR	+0.55
QLTY.&TOL.ZONE	9e DIN 3967
MATING GEAR NO.OF TEETH	55
MATING GEAR DRAWING NO:	-
CENTRE DISTANCE	168

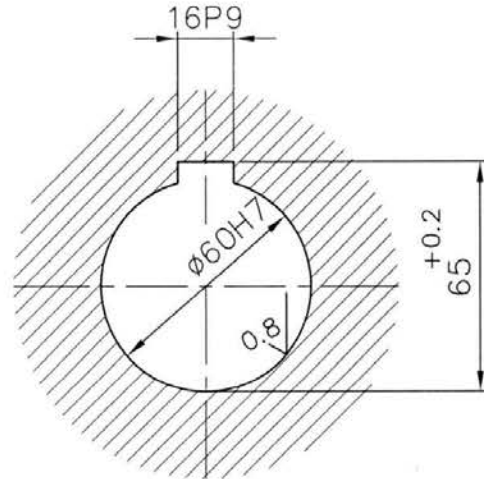
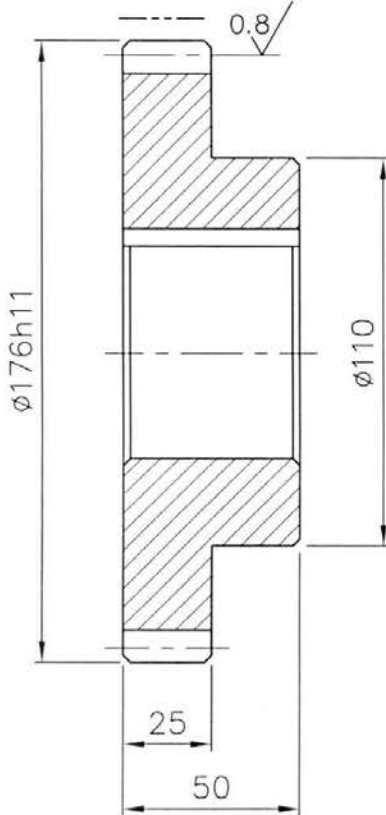
X		ø103.95x60t		13Ni13Cr.3	IS: 4432	1.84			
No.of Pieces	DESCRIPTION			MATERIAL	STANDARD	NET.WT.IN KGS.	DRAWING No.		ITEM No.
		REFERENCE:			ALTERATIONS:		DCN REF	DATE	SIGN.
		DRG.NO: BFT-110-01-015-3N-1134							
SCALE	DRAWN/TCD	S.selvamanickam							
1:2	CHECKED	R.RAMAMOORTHY							
	APPROVED	C.S.JAYASHEELAN							
	DATE	10.01.11'							
MACHINE: HORIZONTAL BORING				TYPE: CNC-GEETHA-BFT110					
TITLE:				DRAWING No:				REV.	
SPUR GEAR ø103.95x20T				4M01B2428829					
(HEAD STOCK ASSY.)				Sheet No:				No.of Sheets:	

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ALL DIMENSIONS ARE IN MM

ø176h11	-0.000	16P9	-0.018
	-0.250		-0.061
ø60H7	+0.030		
	0.000		

1.6/0.8/



NOTE: -

----- HARDENED TO HRC. 60 ±2
CASE DEPTH- 0.8 mm
CHAMFER CORNERS FOR 1/45°

NO.OF TEETH	42
MODULE	4
PRESSURE ANGLE	20°
WITH ACROSS 4 TEETH	-0.089 -0.148 55.49
CORRECTION FACTOR	-
QLTY.&TOL.ZONE	9e DIN 3967
MATING GEAR NO.OF TEETH	42
MATING GEAR DRAWING NO:	4M01B2438831
CENTRE DISTANCE	168

No. of Pieces	ø176x50t		13Ni13Cr.3	IS: 4432	5.15			
	DESCRIPTION		MATERIAL	STANDARD	NET.WT.IN KGS.	DRAWING No.		ITEM No.
SCALE	DRAWN/TC	REFERENCE:		ALTERATIONS:	DCN REF	DATE	SIGN.	INDEX
		DRG.NO: BFT-110-1-014-4N1-1133						
1:2	CHECKED	S.selvamanickam						
	APPROVED	R.RAMAMOORTHY						
	DATE	10.01.11						
MACHINE: HORIZONTAL BORING				TYPE: CNC-GEETHA-BFT110				
TITLE:				DRAWING No:				REV.
SPUR GEAR ø176x42T				4M01B2428830				
(HEAD STOCK ASSY.)				Sheet No:				No. of Sheets:

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ALL DIMENSIONS ARE IN MM

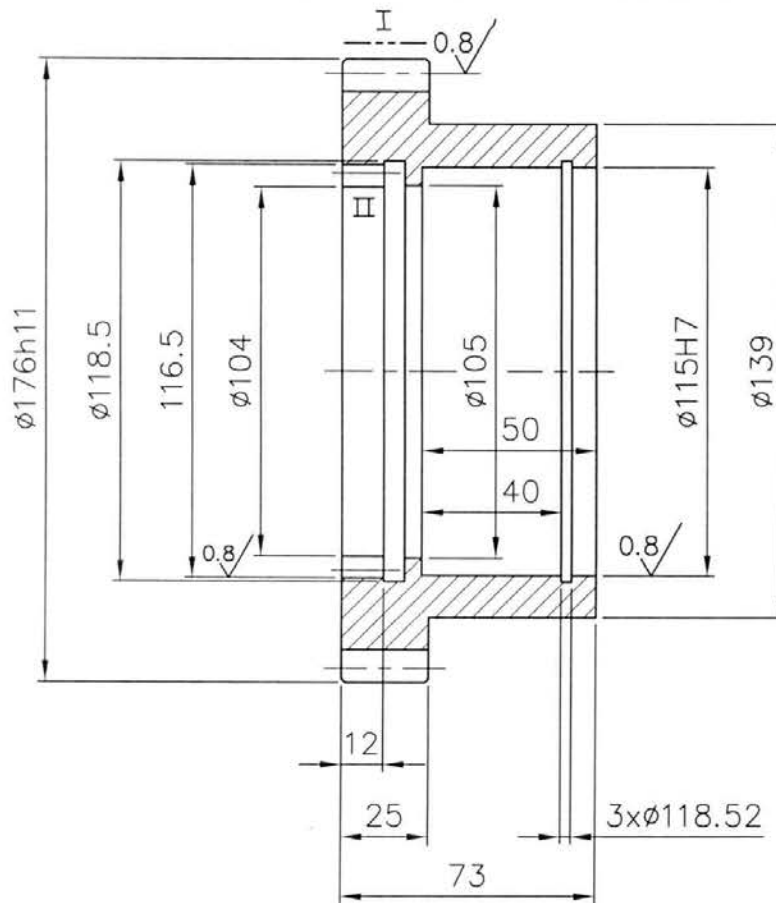
ø176h11

-0.000
-0.250

ø115H7

+0.035
0.000

1.6/0.8/



I

II

NO.OF TEETH	42	27
MODULE	4	4
PRESSURE ANGLE	20°	20°
WITH ACROSS 4 TEETH	55.49 -0.089 -0.148	-
CORRECTION FACTOR	-	-
QLTY.&TOL.ZONE	9e DIN 3967	9e DIN 3967
MATING GEAR NO.OF TEETH	42	27
MATING GEAR DRAWING NO:	4M01B2438830	-
CENTRE DISTANCE	168	-

NOTE: -

HARDENED TO HRC. 60 ±2

CASE DEPTH- 0.8 mm

CHAMFER CORNERS FOR 1/45°

X		ø176x73t		13Ni13Cr.3		IS: 4432		8.43			
No. of Pieces	DESCRIPTION		MATERIAL		STANDARD		NET.WT.IN KGS.		DRAWING No.		ITEM No.
REFERENCE:		DRG.NO: BFT-110-01-014-4N2-1091		ALTERATIONS:		DCN REF		DATE		SIGN.	
SCALE	DRAWN/TC	S.selvamanickam									
1:2	CHECKED	R.RAMAMOORTHY									
	APPROVED	C.S.JAYASHEELAN									
	DATE	10.01.11'									
MACHINE: HORIZONTAL BORING				TYPE: CNC-GEETHA-BFT110							
TITLE: SPUR GEAR ø176x42T				DRAWING No:				REV.			
(HEAD STOCK ASSY.)				4M01B2428831							
Sheet No:				No. of Sheets:							

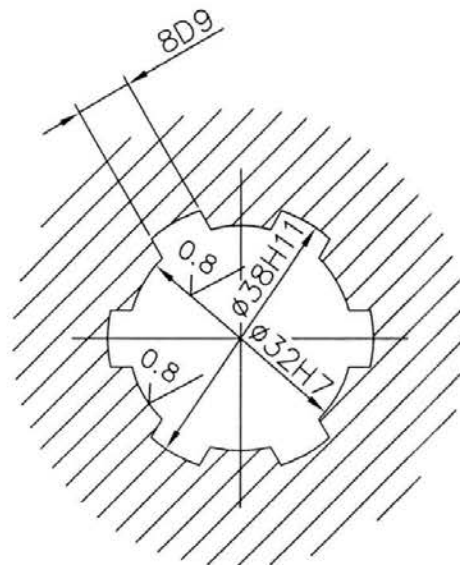
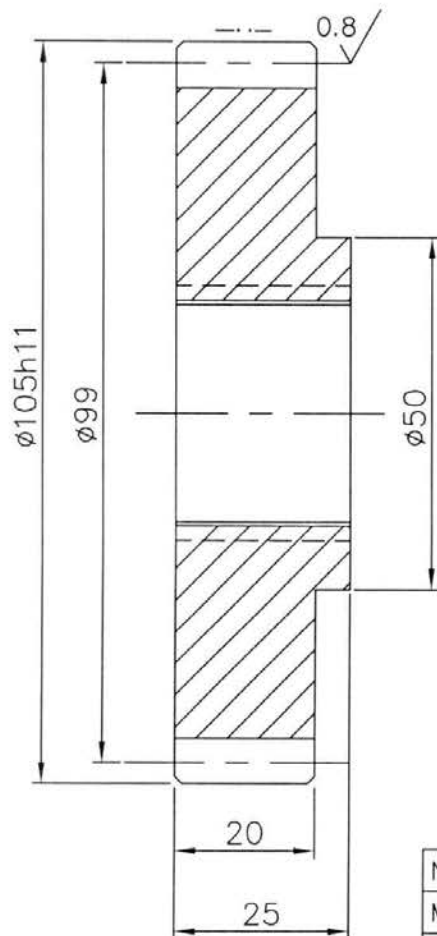
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CAUTION:

ALL DIMENSIONS ARE IN MM

8D9	-0.015 -0.051	ø32H7	+0.025 +0.000
ø105h11	-0.000 -0.220	ø38H11	+0.160 +0.000

1.6/0.8/



SPUR GEAR

NO.OF TEETH	33
MODULE	3
PRESSURE ANGLE	20°
WIDTH ACROSS 3 TEETH	32.4510 -0.141 -0.188
CORRECTION FACTOR	NIL
QLTY.&TOL.ZONE	9e DIN 3967
MATING GEAR NO.OF TEETH	-
MATING GEAR DRAWING NO:	-
CENTRE DISTANCE	99

NOTE: -

--- CASE HARDNED TO HRC 60^{±2}
CASE DEPTH 0.8 mm
CHAMFER CORNERS FOR 1/45°

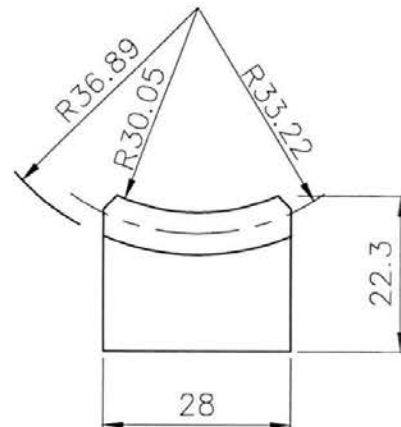
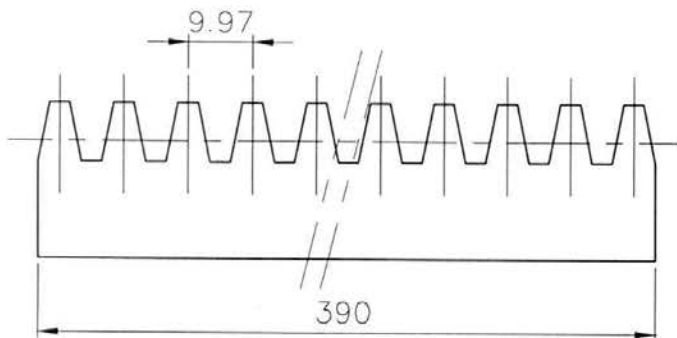
ø105x25L		13Ni 13Cr.3	IS: 4438	1.54		
X						
No. of Pieces	DESCRIPTION	MATERIAL	STANDARD	NET.WT.IN KGS.	DRAWING No.	ITEM No.
REFERENCE:			ALTERATIONS:	DCN REF	DATE	SIGN.
SCALE	DRAWN	T.T.BALAKRISHNAN				
1:1	CHECKED	R.RAMAMOORTHY				
	APPROVED	C.S.JAYASHEELAN				
	DATE	07.01.11				
MACHINE: HORIZONTAL BORING		TYPE: CNC-GEETHA-BFT110				
TITLE: SPUR GEAR 33T/ø105 (HEAD STOCK ASSY)		DRAWING No:		REV.		
		4M01B2428833				
		No. of Sheets:		Sheet No:		

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CAUTION:

ALL DIMENSIONS ARE IN MM

3.2/1.6/



NO.OF TEETH	∞
MODULE	3.175(8DP)
PRESSURE ANGLE	20°
LEAD ANGLE	2° 44' 7"
AXIAL PITCH	9.97
HAND OF HELIX	LH
MATING GEAR NO.OF TEETH	WORM
MATING GEAR DRAWING NO:	4M01B2400000
CENTRE DISTANCE	-

NOTE:

SHARP CORNERS TO BE REMOVED 1/45°

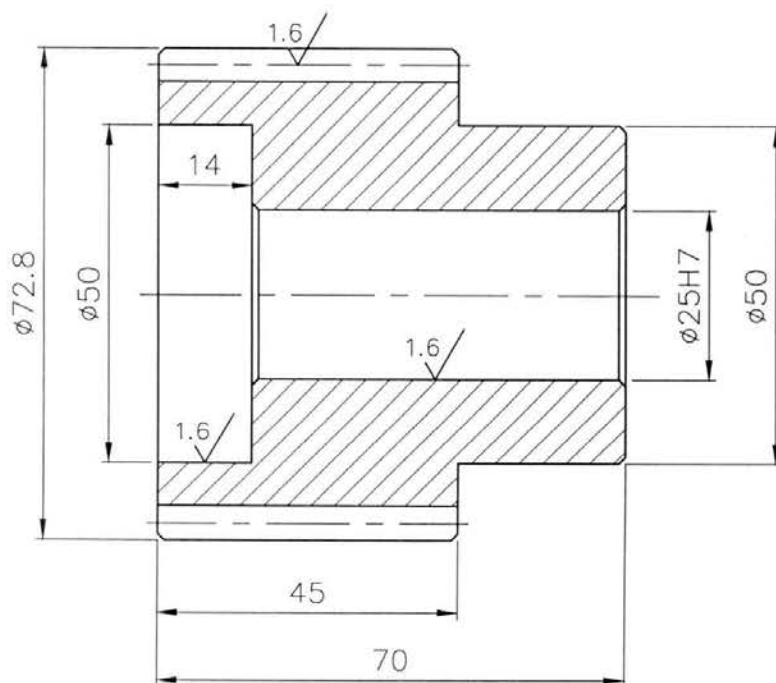
30x25x390		PCuSn7	IS: 28	-			
No. of Pieces	DESCRIPTION	MATERIAL	STANDARD	NET.WT.IN KGS.	DRAWING No.		ITEM No.
	REFERENCE:	ALTERATIONS:		DCN REF	DATE	SIGN.	INDEX
	DRN	P.Albert ross					
	CHED	R.Ramamurthy					
	APPD	K.Ramanan					
1:1	DATE	28/12/12					
	MACHINE: HORIZONTAL BORING		TYPE: GEETHA BFT-110				
	TITLE: RACK		DRAWING No:				REV.
	(CHUCK ASSY.)		4M01B2429636				

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CAUTION:

ALL DIMENSIONS ARE IN MM

3.2/1.6/



NOTE:

HARDENED TO HRC 35^{±2}

SHARP CORNERS TO BE REMOVED 1/45°

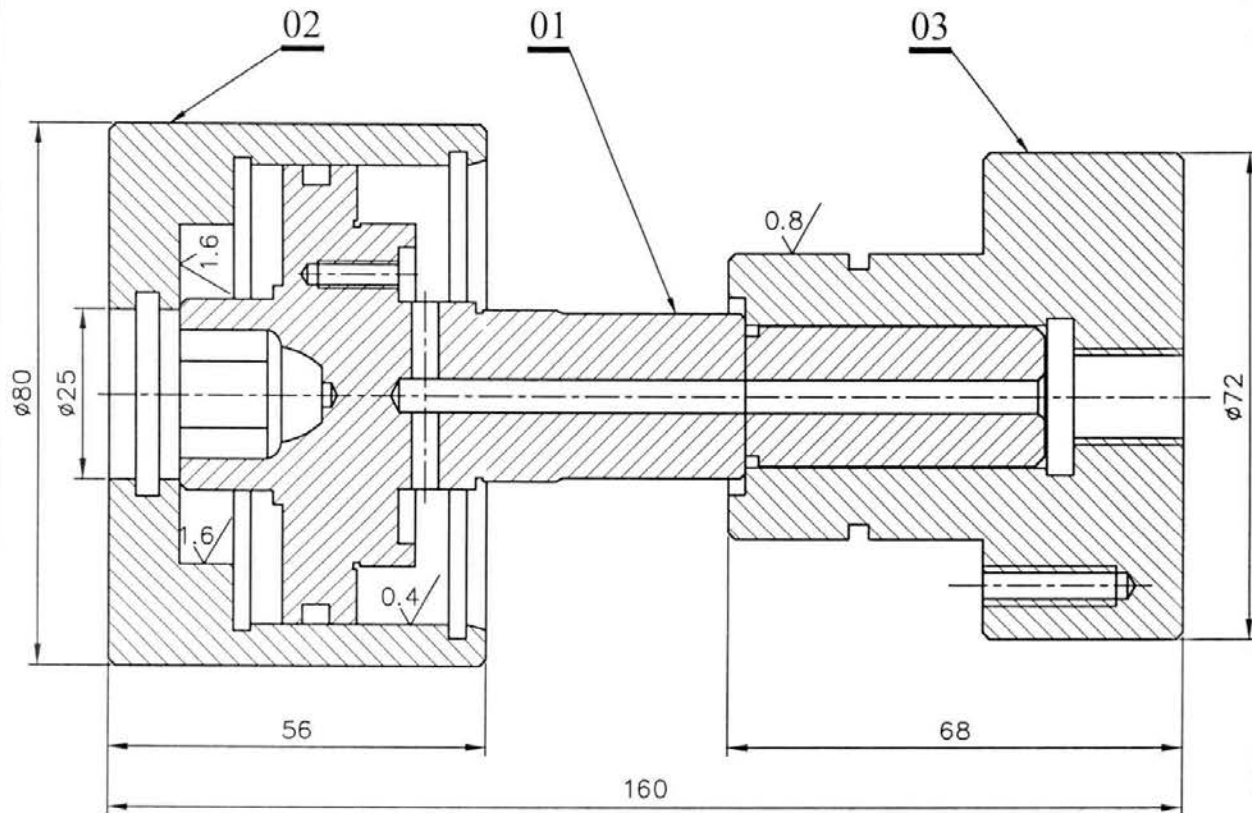
NO.OF STARTS	SINGLE
MODULE	3.175(8DP)
PRESSURE ANGLE	20°
LEAD ANGLE	2° 44' 7"
AXIAL PITCH	9.97
HAND OF HELIX	LH
MATING GEAR NO.OF TEETH	RACK
MATING GEAR DRAWING NO:	4M01B2400000
CENTRE DISTANCE	-

X		ø73x70L	55C8	IS: 5517	-		
No. of Pieces	DESCRIPTION		MATERIAL	STANDARD	NET.WT.IN KGS.	DRAWING No.	ITEM No.
	REFERENCE:			ALTERATIONS:	DCN REF	DATE	SIGN.
SCALE	DRN	P.Albert ross					
1:1	CHED	R.Ramamurthy					
	APPD	K.Ramanan					
	DATE	28/12/12					
	MACHINE: HORIZONTAL BORING			TYPE: GEETHA BFT-110			
	TITLE: PINION ø73x70L			DRAWING No:			REV.
	(CHUCK ASSY.)			4M01B2429637			

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CAUTION:

ALL DIMENSIONS ARE IN MM



ASSY.

NOTE:

1. HARDENED TO HRc.35 ± 2

01	PISTON HEAD $\phi 72 \times 68L$.	45 C8	IS: 7283	1.00	4M01B2428563	03
01	CYLINDER ID68xOD80x56L.	45 C8	IS: 7283	1.20	4M01B2428565	02
01	PISTON ROD $\phi 68 \times 129L$.	55 C8	IS: 5517	1.00	3M01B2414167	01
	ASSY.			3.20		

No. of Pieces	DESCRIPTION	MATERIAL	STANDARD	NET.WT. IN KGS.	DRAWING No.	ITEM No.
	REFERENCE:		ALTERATIONS:	DCN REF	DATE	SIGN.
SCALE	DRAWN	C.PONNUSAMY				
1:1	CHECKED	G.GOVINDARAJ				
	APPROVED	K.RAMANAN				
	DATE	02/04/2013				

MACHINE: HORIZONTAL BORING CNC	TYPE: GEETHA BFT-110		
TITLE: CYLINDER ASSY. (TABLE CLAMPING UNIT)	DRAWING No: 4M01B2429668		REV.
	Sheet No: 1	No. of Sheets: 1	

CAUTION: THIS DRAWING IS OUR SOLE PROPERTY AND SHOULD NOT BE USED IN ANY FORM FOR ANY PURPOSE WITHOUT THE WRITTEN PERMISSION OF BHARAT HEAVY ELECTRICALS LIMITED. TRICHYAPALLI - 620 014.

3NOs. M3-12 DEEP
ON PCD 35

Technical drawing of a mechanical part, showing a cross-section with dimensions 3, 4, and 0.8, and a section line labeled g-g.

1.6/IN MM

2

AR

54

NOTES

CNS

IME

2

ALL

7

014

WRITTEN PERMISSION
CRITICALS LIMITED

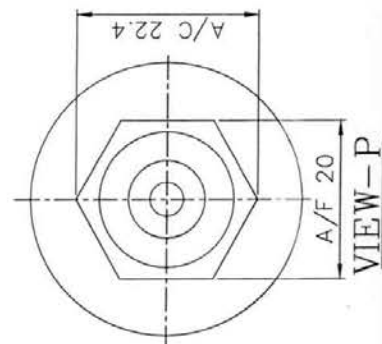
IN ANY FORM FOR A

SOLE PROPERTY AND

NOTE: -

01.CHAMFER CORNERS TO 1/45°

02.HARDENED TO HRC.35⁺²



	Ø68x129 L		55 C8	IS: 5517	1.00			ITEM No.
	No of Pieces		MATERIAL	STANDARD	NET WT. IN KGS.	DRAWING No.		INDEX
	REFERENCE:		ALTERNATIONS:		DCN REF	DATE	SIGN	
	SCALE		DRAWN P. A. ROSS CHECKED R. RAMAMOORTHY APPROVED C. S. JAYASHEELAN DATE 11-06-10					
MACHINE: HORIZONTAL BORING CNC			TYPE: GEETHA-BFT 110				REV:	
TITLE:			DRAWING No:					
PISTON ROD Ø68x129 (TABLE CLAMPING UNIT)			3M01B2414167				Sheet No. No of Sheets	

CAUTION:

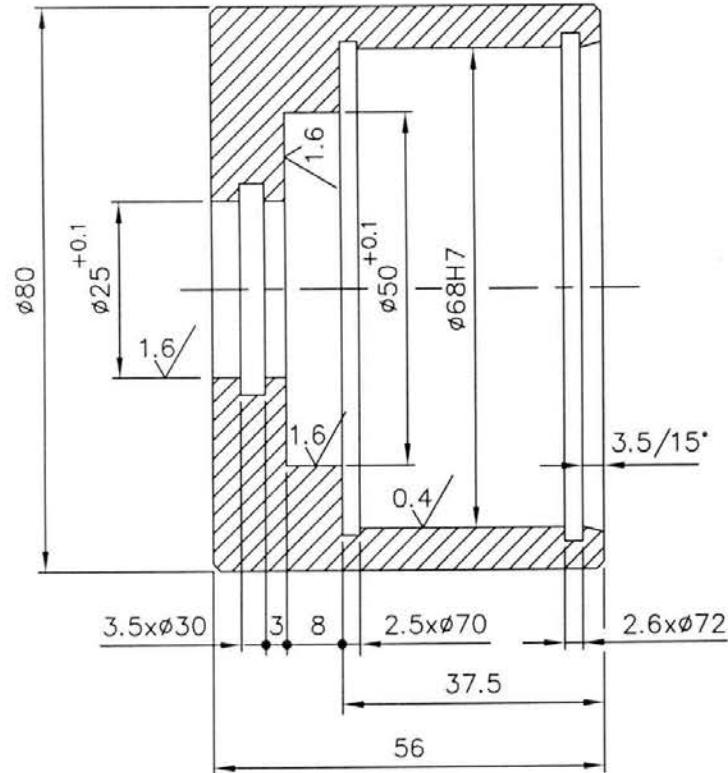
ALL DIMENSIONS ARE IN MM

ø68H7

+0.030

0.000

3.2/0.4/1.6/



NOTE:

CHAMFER CORNERS FOR 1.5/45°

No. of Pieces	ø80x56L		45C8	IS: 7283	1.20	DRAWING No.		ITEM No.
	DESCRIPTION		MATERIAL	STANDARD	NET.WT.IN KGS.	DATE		SIGN.
SCALE	REFERENCE:		ALTERATIONS:		DCN REF	DATE		SIGN.
	1:1		DRAWN		S.selvamanickam	DATE		SIGN.
1:1	CHECKED		R.RAMAMOORTHY		DATE		SIGN.	INDEX
	APPROVED		C.S.JAYASHEELAN		DATE		SIGN.	INDEX
DATE		14/06/10'		DATE		DATE		INDEX
MACHINE:		HORIZONTAL BORING CNC		TYPE:		GEETHA BFT-110		REV.
TITLE:		CYLINDER		DRAWING No:		4M01B2428565		REV.
ID68xOD80x56L		(TABLE CLAMPING UNIT)		Sheet No:		No. of Sheets:		REV.

THIS DRAWING IS OUR SOLE PROPERTY AND SHOULD NOT BE USED IN ANY FORM FOR ANY PURPOSE WITHOUT THE WRITTEN PERMISSION OF BHARAT HEAVY ELECTRICALS LIMITED TRICHIRAPPALLI - 620 014.

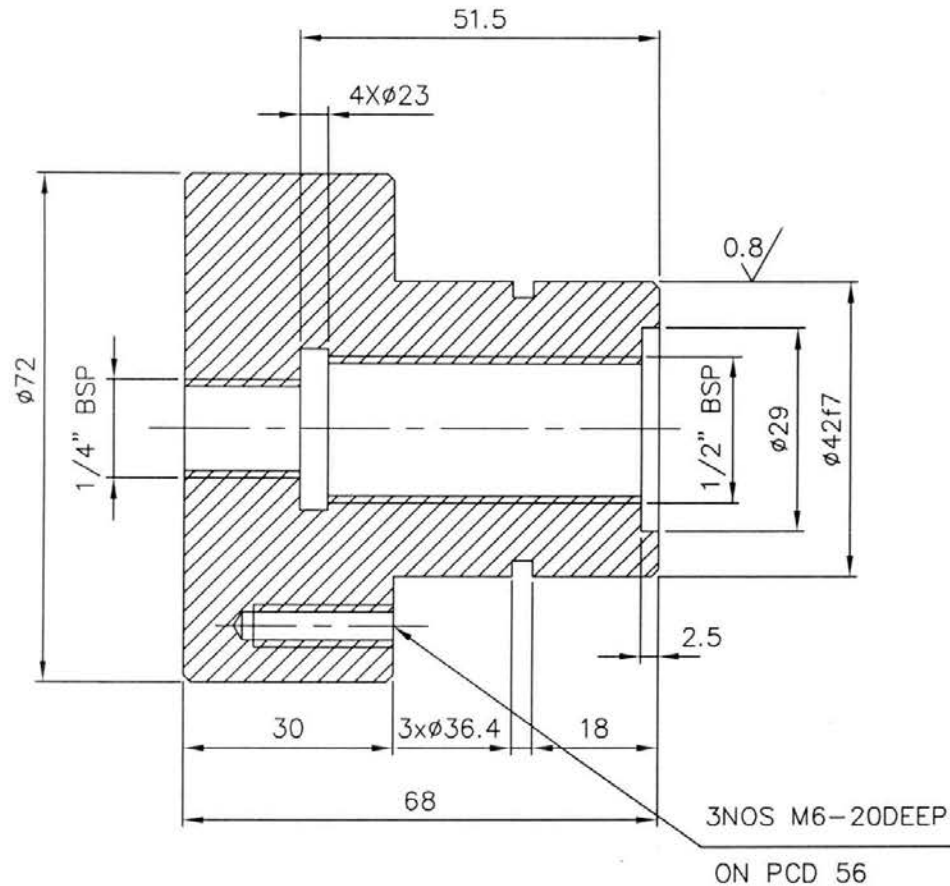
CAUTION:

ALL DIMENSIONS ARE IN MM

ø42f7

-0.025
-0.050

3.2/0.8/



NOTE:

CHAMFER CORNERS FOR 1.5/45°

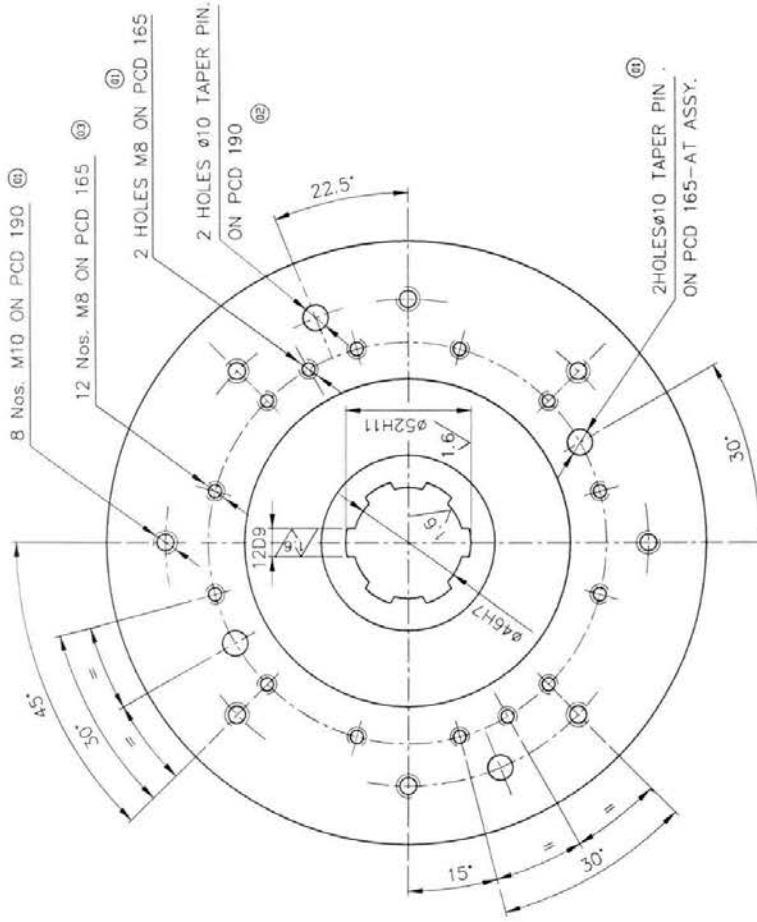
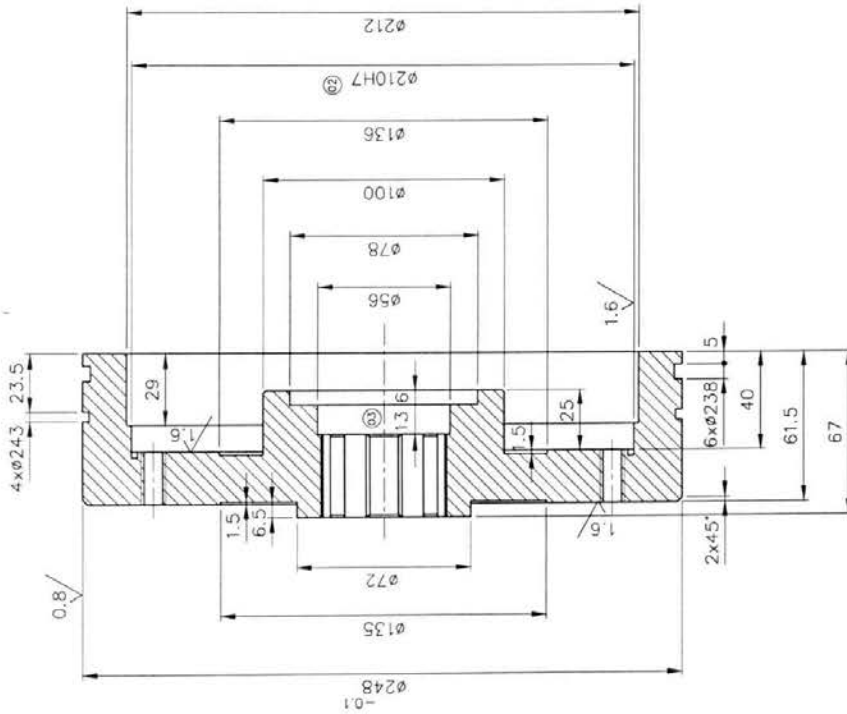
No. of Pieces	ø72x68L		45C8	IS: 7283	1.20			
	DESCRIPTION		MATERIAL	STANDARD	NET.WT.IN KGS.	DRAWING No.		ITEM No.
SCALE	DRAWN	S.selvamanickam	REFERENCE:	ALTERATIONS:	DCN REF	DATE	SIGN.	INDEX
1:1	CHECKED	R.RAMAMOORTHY						
	APPROVED	C.S.JAYASHEELAN						
	DATE	11/06/10						
MACHINE: HORIZONTAL BORING CNC	TITLE: PISTON HEAD ø72x68L		TYPE: GEETHA BFT-110					
	DRAWING No:		4M01B2428563				REV.	
	Sheet No:				No. of Sheets:			



SECTION-AA

ALL DIMENSIONS ARE IN MM

CAUTION: THIS DRAWING IS OUR SOLE PROPERTY AND SHOULD NOT BE USED IN ANY FORM FOR ANY PURPOSE WITHOUT THE WRITTEN PERMISSION OF BRAHAT HEAVY ELECTRICALS LIMITED
TRICHYRAIPALLI - 620 014



12 D9	+0.093 +0.050	±S2 H11	+0.190 +0.000	±46 H7	+0.025 +0.000	±210 H7	+0.046 +0.000	3.2/1.6/0.8/
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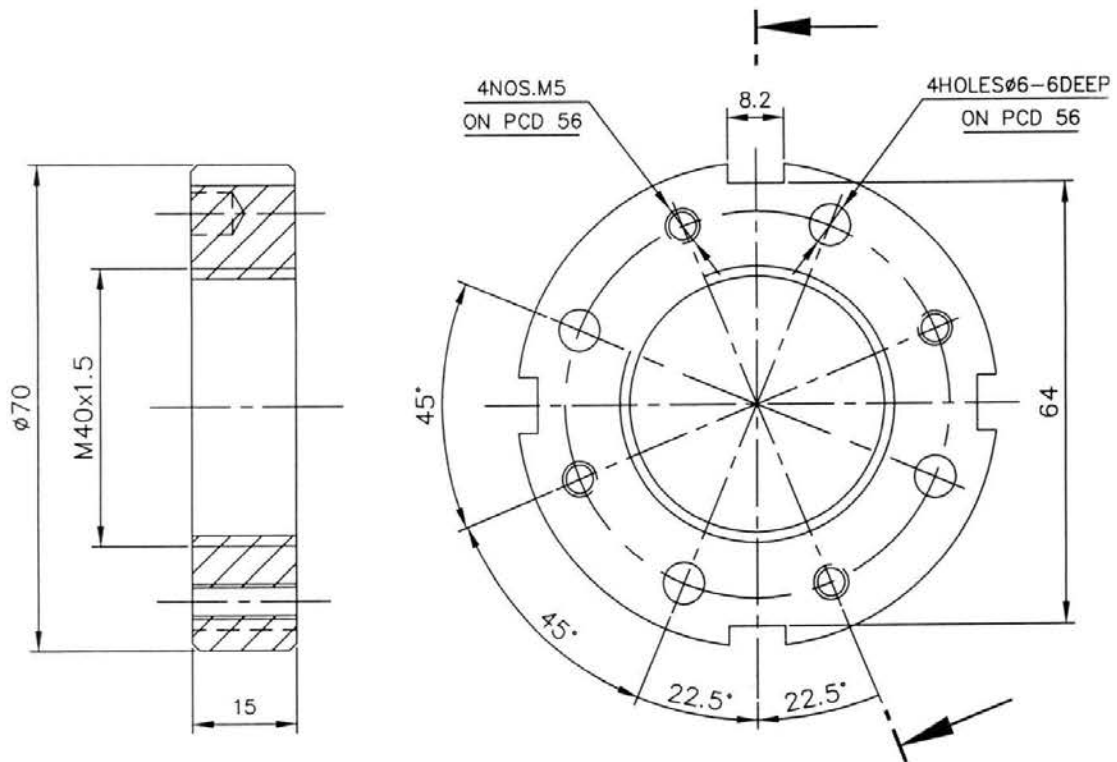
ITEM 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THIS DRAWING IS OUR SOLE PROPERTY AND
SHOULD NOT BE USED IN ANY FORM FOR ANY
PURPOSE WITHOUT THE WRITTEN PERMISSION
OF BHARAT HEAVY ELECTRICALS LIMITED
TRICHIRAPPALLI - 620 014.

CAUTION:

ALL DIMENSIONS ARE IN MM

3.2/✓✓✓



NOTE: -

CHAMFER CORNERS FOR 1/45°

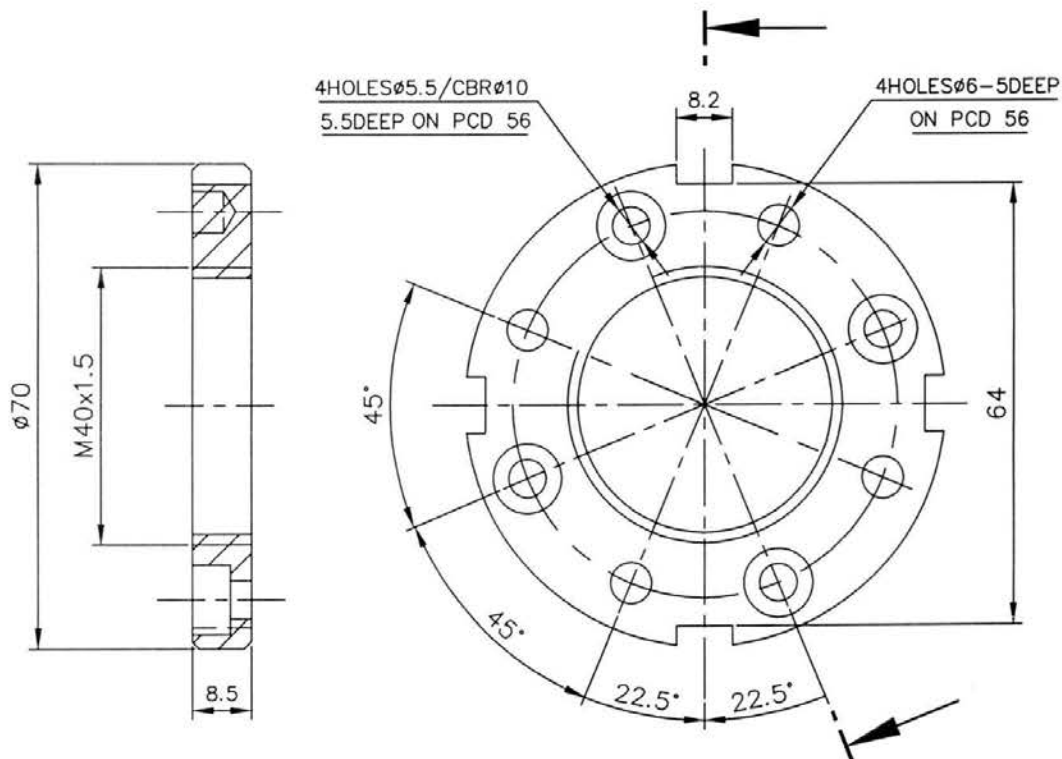
MATING SCREW REF.DRG.NO: 3-M-08F12-12231

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No. of Pieces	DESCRIPTION			MATERIAL	STANDARD	NET.WT.IN KGS.	DRAWING No.		ITEM No.
	REFERENCE:			ALTERATIONS:		DCN REF	DATE	SIGN.	INDEX
SCALE	DRAWN	M. MANOHAR	DRG. MODIFIED TO DATE			15.03.12	CSJ	01	
1:1	CHECKED	R.RAMAMOORTHY							
	APPROVED	C.S.JAYASHEELAN							
	DATE	09.11.04							
MACHINE: CNC SLANT BED LATHE				TYPE: HMT-STC 25					
TITLE: LOCK NUT M40x1.5-15t. (TURRET HEAD ASSY.)				DRAWING No:				REV.	
				4M08F122751701					
				Sheet No:				No. of Sheets:	

CAUTION: THIS DRAWING IS OUR SOLE PROPERTY AND SHOULD NOT BE USED IN ANY FORM FOR ANY PURPOSE WITHOUT THE WRITTEN PERMISSION OF BHARAT HEAVY ELECTRICALS LIMITED TRICHIRAPPALLI - 620 014.

ALL DIMENSIONS ARE IN MM

Item no. 210



NOTE: -

CHAMFER CORNERS FOR 1/45°

MATING SCREW REF.DRG.NO: 3-M-08F12-12231

No. of Pieces	DESCRIPTION		MATERIAL	STANDARD	NET.WT.IN KGS.	DRAWING No.		ITEM No.
	REFERENCE:		ALTERATIONS:	DCN REF	DATE	SIGN.	INDEX	
SCALE	DRAWN	M. MANOHAR	DRG. MODIFIED TO DATE			15.03.12	CSJ	01
1:1	CHECKED	R.RAMAMOORTHY						
	APPROVED	C.S.JAYASHEELAN						
	DATE	09.11.04						
MACHINE: CNC SLANT BED LATHE			TYPE: HMT-STC 25					
TITLE: LOCK NUT M40x1.5-8.5t. (TURRET HEAD ASSY.)			DRAWING No:			REV.		
			4M08F122751801					
			Sheet No:			No. of Sheets:		