CAUTION: THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LTD
IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANYWAYDETERMINTAL TO INTEREST OF THE COMPANY

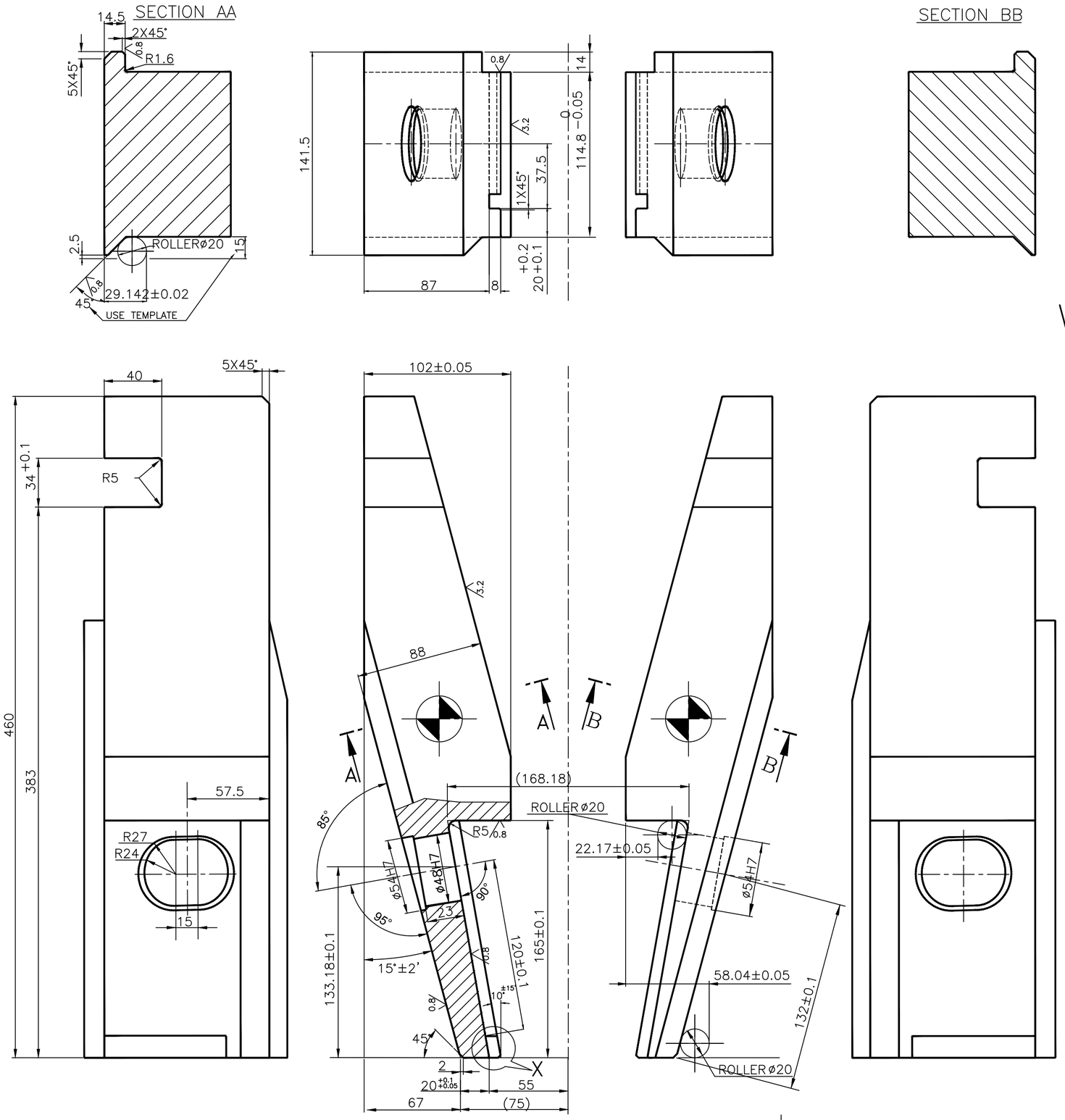
DEVIATIONS OF UNTOLERANCED DIMENTIONS TO BE ASPER IS:2102–1969 MEDIUM

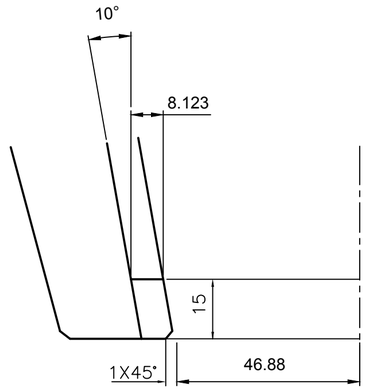
ALL DIMENSIONS ARE IN MILLIMETERS

1.6 / 3.2 / 0.8

48	H7	0 / +0.025

REV	DATE		
02	24.02.15	ALTERED	
		CHECKED	
		APPROVED	N A Nainar
ZONE	ø48H7 HOLE AND 25 WAS CIRCULAR		
REV	DATE		
03	31.01.2018	ALTERED	M RAMESH
		CHECKED	
		APPROVED	M KANNAN
ZONE	MATERIAL EN41B ADDED ø54 WAS 50		





NOTE:

MARK MATERIAL CODE No AS GIVEN

69 23 44 103 8

MATERIAL: IS 1570–61 40Cr2AlMo18 OR EN41B

CHEMICAL COMPOSITION:–

C	Mn	Ni	Cr	Mo	Si	S	P	Al
0.35	0.65	0.40	1.4	0.1	0.1	0.05	0.05	0.9
0.45			1.8	0.25	0.45			1.3

HEAT TREAT TO 100±5Kg/mm^2

TO BE GAS NITRIDED TO 0.8 TO 1mm DEPTH

Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI – 620014	DRN	R.KUMAR	R.Kumar	07.03.15
	CHD	N ARUMUGANAINAR	N A Nainar	
	APPD	M MARUDHAVANAN	M Marudhavanan	

DEPT CODE	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM NO
T E	C/M/F	1:2	56,0	10.....088	01
				REF TO OLD DWG NO 10.....087/08,20....191/00	

TITLE	CARD CODE	DRAWING NO :	REV
CLAMPING JAWS–MODIFIED (800KN TAPER)	U 01	20–ST–221–02–215	03