



PLANT PURCHASING SPECIFICATION
HEEP - HARDWAR

HW 10892

PAGE 1 OF 54

SIGN & DATE

SUPERSEDES INVENTORY No.

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SIGN & DATE

INVENTORY No.

P-3114

TOOL STEEL, FLATS T90Mn6WCr2

1. GENERAL :

This specification governs the quality of annealed Manganese- Chromium- Tungsten tool steels- flats.

2.0 APPLICATION

For the manufacture of tools capable of being hardened and tempered.

3.0 CONDITION OF DELIVERY :

3.1 The material shall be supplied in Hot Rolled & annealed condition followed by rough machining.

3.2 When specified in the order, the material shall be supplied in hot rolled & annealed, ground & tempered condition. The material should be properly annealed so that there is no bend during wire cutting operation.

4. COMPLIANCE WITH NATIONAL STANDARD

The material shall comply with the requirements of :-

- IS : 4430-79 (REAFFIRMED-²⁰⁰⁴95) } (a) Tool and mould steels.
- Gr : T90Mn6WCr2, Annealed } (a)

5.0 DIMENSIONS AND TOLERANCES :

5.1 Sizes : Flats of thickness 2,3,4,5,6,8, & 10 mm in different widths and lengths.

5.2 Tolerances

5.2.1 The tolerances on flats- Hot rolled, annealed and rough

				NAME	SIGN. & DATE
			DRAWN		
			WORKED	<i>Prakash S. Nabiyal</i>	<i>1-7-89</i>
MTE	J. P. MEENA	<i>14/3/90</i>	CHECKED	S. KUMAR	<i>Sudhan 10-7-89</i>
AGREED DEPT.	NAME	SIGN & DATE	SUPERVISED	PRAKASH SINGH	<i>12/2/90</i>
REVISION: 01			APPROVED: PLANT		PS
			STANDARDIZATION COMMITTEE		2.60
REV- 01	(REAFFIRMED)	REV02	PREPARED:	ISSUED:	DATE:
DT-2-2-2008		17-11-08	TSX	STANDARDS DIVISION	19/3/90



Plant Purchasing Specification

HW 10692

HEEP - HARDWAR

PAGE 2 OF 54

SIGN & DATE

SUPERSEDES INVENTORY No.

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SIGN & DATE

INVENTORY No.

P-3114

machined shall be as follows :

- Thickness ± 0.1 mm
- Width * 6mm, -0
- Length + 10mm, -0

5.2.2 The tolerances on flats- Hot rolled annealed, ground and tempered shall be as follows :

- Thickness ± 0.05 mm
- Width + 6.00 mm, -0
- Length + 10.00 mm, -0

Flatness off hardened blank is permissible up to 0.05/100 limiting to 0.2/600 .

6.0 MANUFACTURE

Material shall be manufactured from Killed Steel. Steel shall be made by the Electric or any other approved process as agreed to , between the purchaser & the manufacturer. Sufficient reduction and discards shall be made from each in got to ensure freedom from piping, segregation and other harmful defects. The material shall be rough machined, chipped or ground to remove all surface imperfections which are likely to produce defects in the finished products. If the material is conditioned by grinding or chipping, depth of conditioning shall be exceed half the machining allowance per side & width of conditioning shall be atleast four times its greatest depth.

7. FREEDOM FROM DEFECTS :

The finished material shall be free^{from} all internal and surface defects such as seams, cracks , pipes, flakes and segregations.

8. CHEMICAL COMPOSITION :

In ladle analysis of steel and permissible variation in the composition of the finished product from the ladle analysis shall be as follows :

REVISION 01	REV.02	WORKED BY <i>Shriy S. N. Singh</i>	17.89
	DATE:17.11.08	CHECKED BY <i>S. KUMAR</i>	<i>Sudhu</i> 10.7.89



Plant Purchasing Specification

HEEP - HARDWAR

HW 408 92

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INVENTORY No.

P-3114

Element	Percent		Permissible variation percent max. (a)
	Min.	Max.	
Carbon	0.85	0.95	± 0.03
Silicon	0.10	0.35	± 0.03
Manganese	1.25	1.75	± 0.06
Chromium	0.30	0.60	± 0.05
Tungsten	0.40	0.60	± 0.04 (a)
Vanadium	-	0.25	± 0.02
Sulphur	-	0.035	+ 0.005 + 0.005 (a)
Phosphorus	-	0.035	+ 0.005 + 0.005 (a)

NOTE :

Elements not quoted above shall not be added to the steel, except when agreed to, other than for the purpose of finishing the heat and shall not exceed the following limits.

Elements	Percent, Max.
Nickel	0.25
Molybdenum	0.25
Copper	0.35
Cobalt	0.10

9. TEST SAMPLES :

One sample product shall be taken from each case for chemical analysis. For hardness test 5 percent of the no. of pieces in the charged upto a maximum of 10 & minimum of 2 covering all sizes shall be taken.

10. MECHANICAL PROPERTIES :

Hardness as Received conditions :

When tested in accordance with IS:1500-2005, the test pieces shall show a Brinell Hardness of 230 HB Maximum.

11. RESPONSE TO HEAT TREATMENT :

Material shall be capable of responding to the heat treatment specified below and the material must achieve a minimum hardness of 60-65 HRC without showing any sign of

REVISION 01	REV - 02	WORKED BY <i>Shiv S. Nishidhar</i>	17-89
	DATE - 17.11.08	CHECKED BY S. KUMAR	<i>Sudhir</i> 10.7.89



Plant Purchasing Specification

HEEP - HARDWAR

HW 10892

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SIGN & DATE

INVENTORY No.

P-3114

overheating. Harden in oil at a temp. of 800-830°C.
Temper at a suitable temp. between 170-300°C.

12. TEST CERTIFICATE :

Three copies of test certificates shall be supplied unless otherwise stated on the order.

The test certificate shall bear the following information:

12.1 BHEL References :

12.2 BHEL Order No :

12.3 Supplier's Reference :

Name :

Identification No :

Cast No :

Details of Heat Treatment :

13. RESULTS OF TESTS :

Results, of chemical analysis and hardness tests in annealed, hardened and tempered conditions.

14. PACKING AND MARKING :

The material shall be suitably packed in bundles to prevent corrosion and damage during transit.

Material above 25mm in dia or of equivalent cross section shall be stamped HW 10892 and cast no. on the side near the end or on the end face.

A metal lable shall be securely attached to each bundle and shall bear the following information.

HW 10892 : T90Mn6WCr2 Tool Staal flat - Annealed.

BHEL Order No :

Consignment or identification No :

Cast No :

Size and weight :

Supplier's Name :

15. EQUIVILENT STANDARD & GRADES (FOR REFERENCE ONLY) - (A)

BOHLAR : K460

ALSI : 01

DIN : 1-2510 100 MnCrW4

BS : 801

IS : 4430-1979

REVISION 01

REV - 02

DATE - 17-11-00

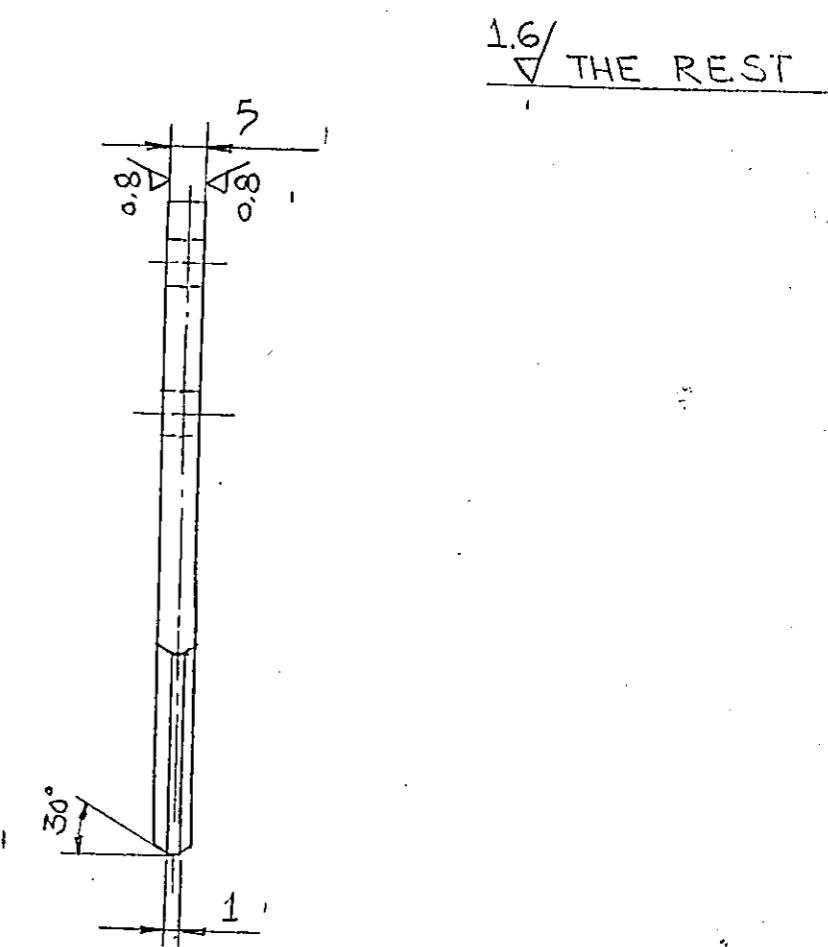
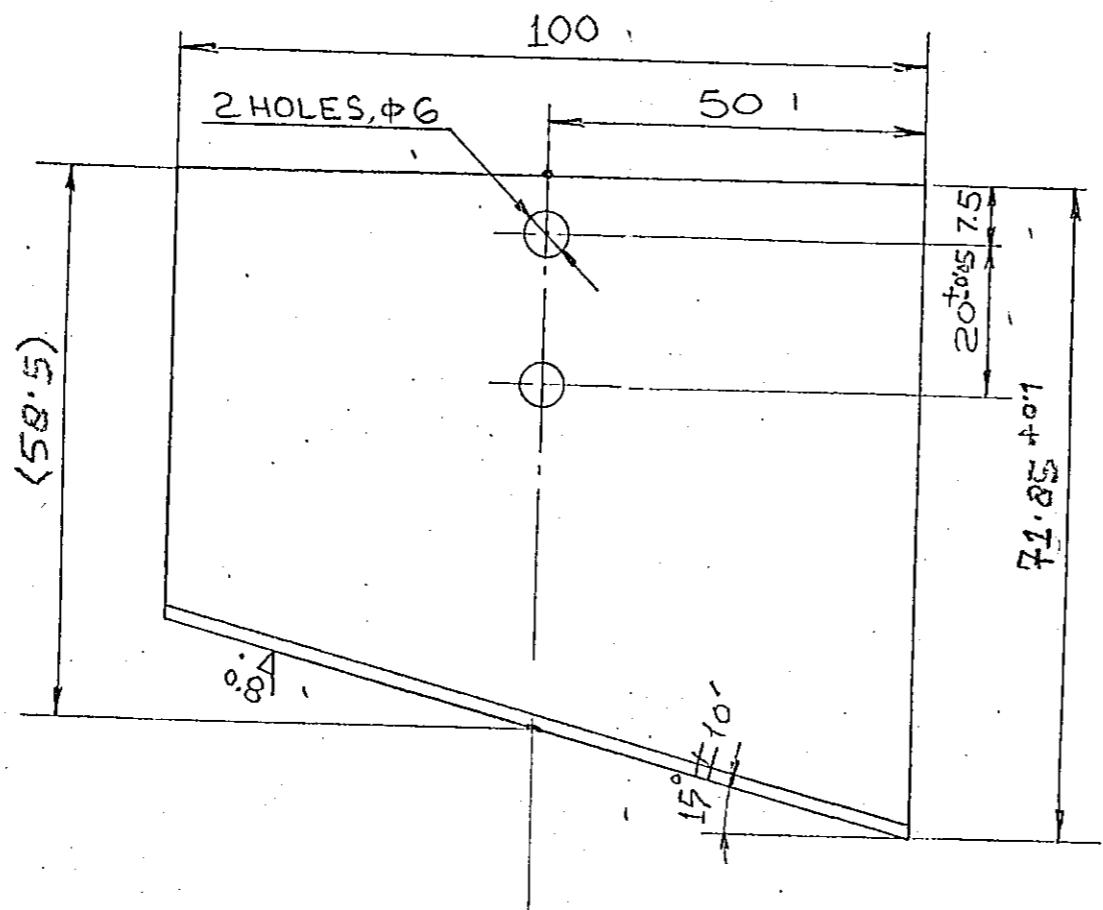
WORKED BY *Chiraf's Nabilal sharma* 1-7-89

CHECKED BY *S. KUMAR Sudhin* 10-7-89

FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

Form DG-38

DRAWING NO. R8381-9509



1.6 / THE REST

1. HARDEN TO HRC 50 ÷ 55.
2. SHARP EDGES TO BE ROUNDED OFF
3. TO BE USED ON STAND DRG. NO. WE 0-13-3400.

MARK
R8381-9509
ND3/1080/3-III

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Ref. Drg. No.

Sign & Date

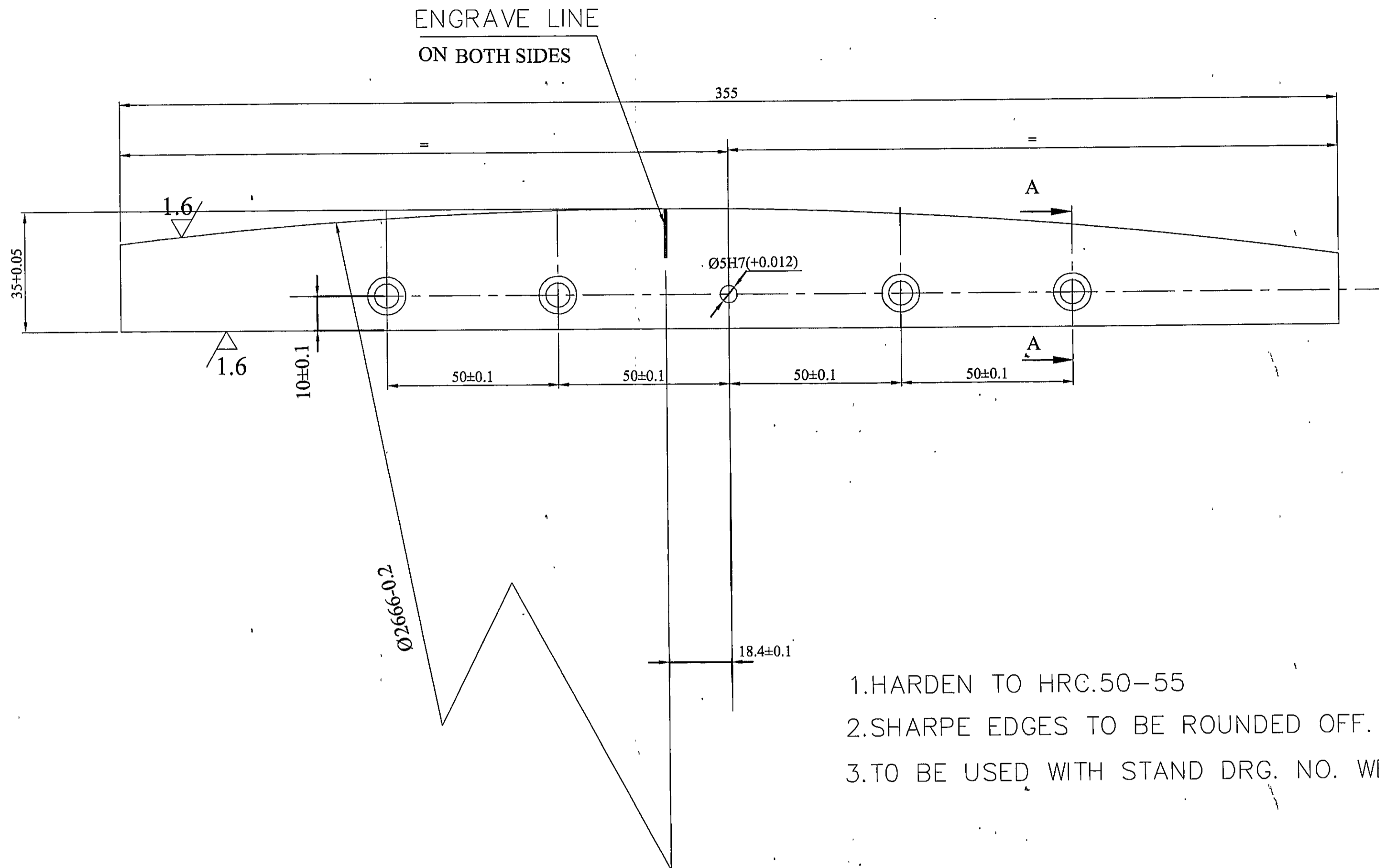
Inventory No. 3-10602

VAR. 00		REMARKS	ITEM NO.	DESCRIPTION	DRAWING NO.	MATERIAL CODE		UNIT WT. (Kg.)
CARD TYPE-3		CARD TYPE-1			CARD TYPE-2		QTY.	
GMS/GR. SP. NO.				STATUS OF DRG.		TYPE OF PRODUCT		COMP DRG. NO.
AGREED DEPT.				NAME		SIGN.		DATE
S.T.T.				P.V. SINGH		[Signature]		
NAME OF CUSTOMER				W/ORDER NO.		M/C TOOL MODEL NO.		REF. DRG. NO.
[Blank]				KBM/3625		-		WE 4-13-4777
NAME OF CUSTOMER				W/ORDER NO.		M/C TOOL TRANS NO.		INVENTORY NO.
[Blank]				KBM/3625		-		
REV				DATE		ALTERED		NO. OF VAR.
[Blank]				[Blank]		[Blank]		73 74
DEPT.				GRADE OF UNTO DIM		SCALE		WEIGHT (Kg)
I & T				C/M/F		1:1		
CODE				[Symbol]		REF. TO ASSY. DRG.		ITEM NO. OF ITEMS
125				[Symbol]		[Blank]		75 77
TITLE				DRAWING NO.		REV.		
TEMPLATE FOR LENGTH CHECKING				R 8381-9509		[Blank]		
OF ND3/1080/3-III				CARD CODE		[Blank]		
[Blank]				SHEET NO.		NO. OF SHEETS:-		
[Blank]				[Blank]		[Blank]		

SIZE A3

DRAWING No. R8381-9512

3.2 / THE REST



♦ MARK
R8381-9512.
ND3/1080/3-III.
Ø2666.

- 1.HARDEN TO HRC.50-55
- 2.SHARPE EDGES TO BE ROUNDED OFF.
- 3.TO BE USED WITH STAND DRG. NO. WE4-13-3400.

THIS DRG. HAS BEEN RETRACED
UNDER THE SAME DRG.NO. 1832
(H.N.SHARMA)

VAR.00	REMARKS	ITEM No.	DESCRIPTION	DRAWING No.	T90(Mn2W50 Cr45) IS-1570	MATERIAL CODE	UNIT WT.(Kg.)	ZONE

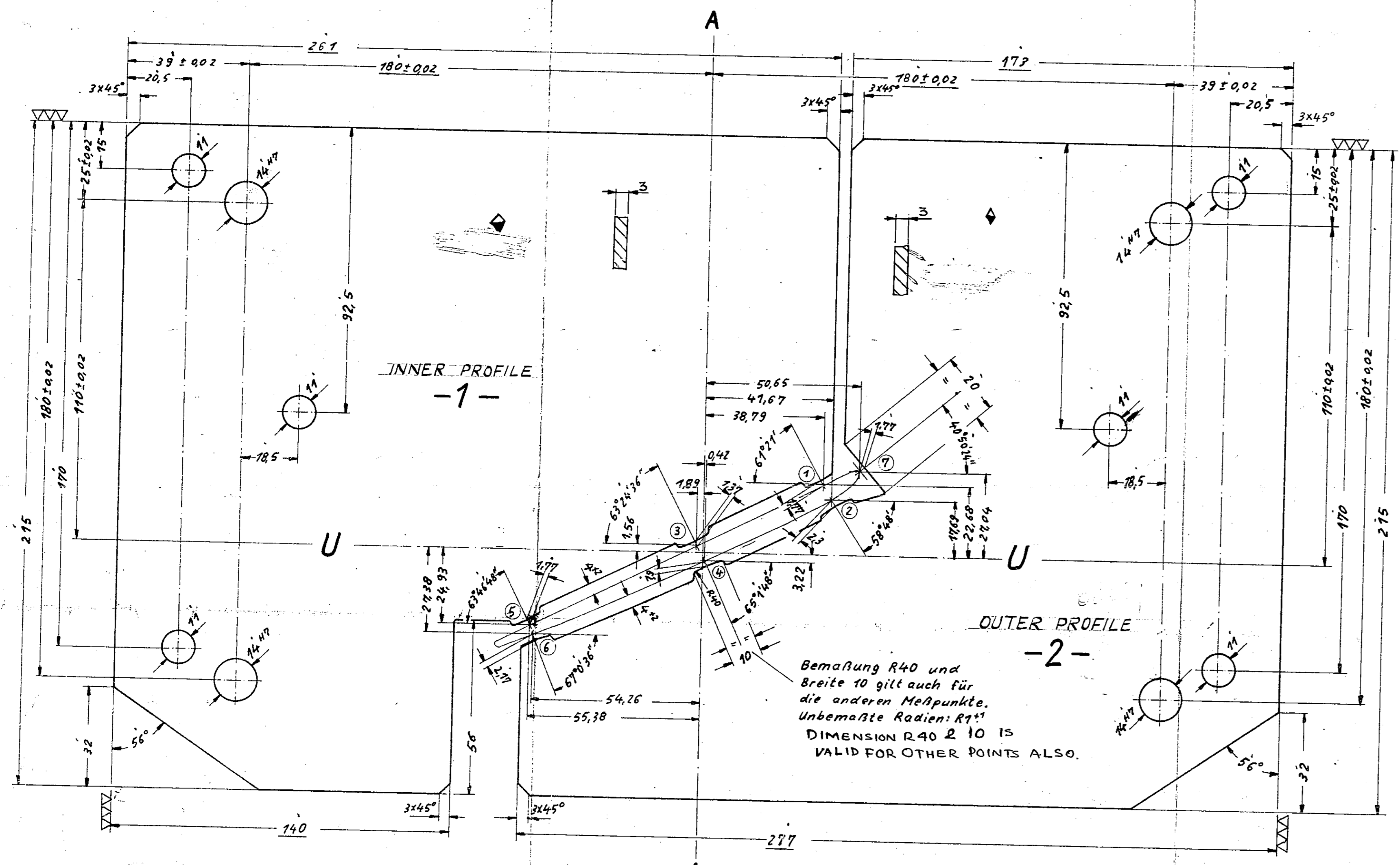
GMS No./GR.SP.No.	STATUS OF DRG.	TYPE OF PRODUCT	COMP.DRG.NO.	M/C TOOL TRANS NO.	REF.DRG.NO.
		500 M.W.KWU.BLADE.	7279-34606		R8383-9504.
AGREED DEPT.	NAME	SIGN.	DATE	W.O.NO.	M/C TOOL MODEL NO.
	P.V.SINGH.	SD..		KBM-3626	

GRADE OF UNTOL.DIM. :-
M/CG-L/M/F AA0230208
WELDING-A/B/C/D-AA0621104
GAS CUTTING-'T3'AA0621101

REV.	DATE	ALTERED	CHECKED

DEPT. JTE	SCALE	WEIGHT(Kg.)	REF. TO ASSY. DRG.	ITEM No.	No. OF ITEM
CODE 209	1:1				
TITLE TEMPLATE FOR RADIUS CHECKING.(ND3/1080/3-III)			DRAWING No. R8381-9512.	REV.	
			SHEET No. 0	No. OF SHEET	01

2-9621-E INVENTORY No. SIGN. & DATE REF. DRG. No. 6-3-2K
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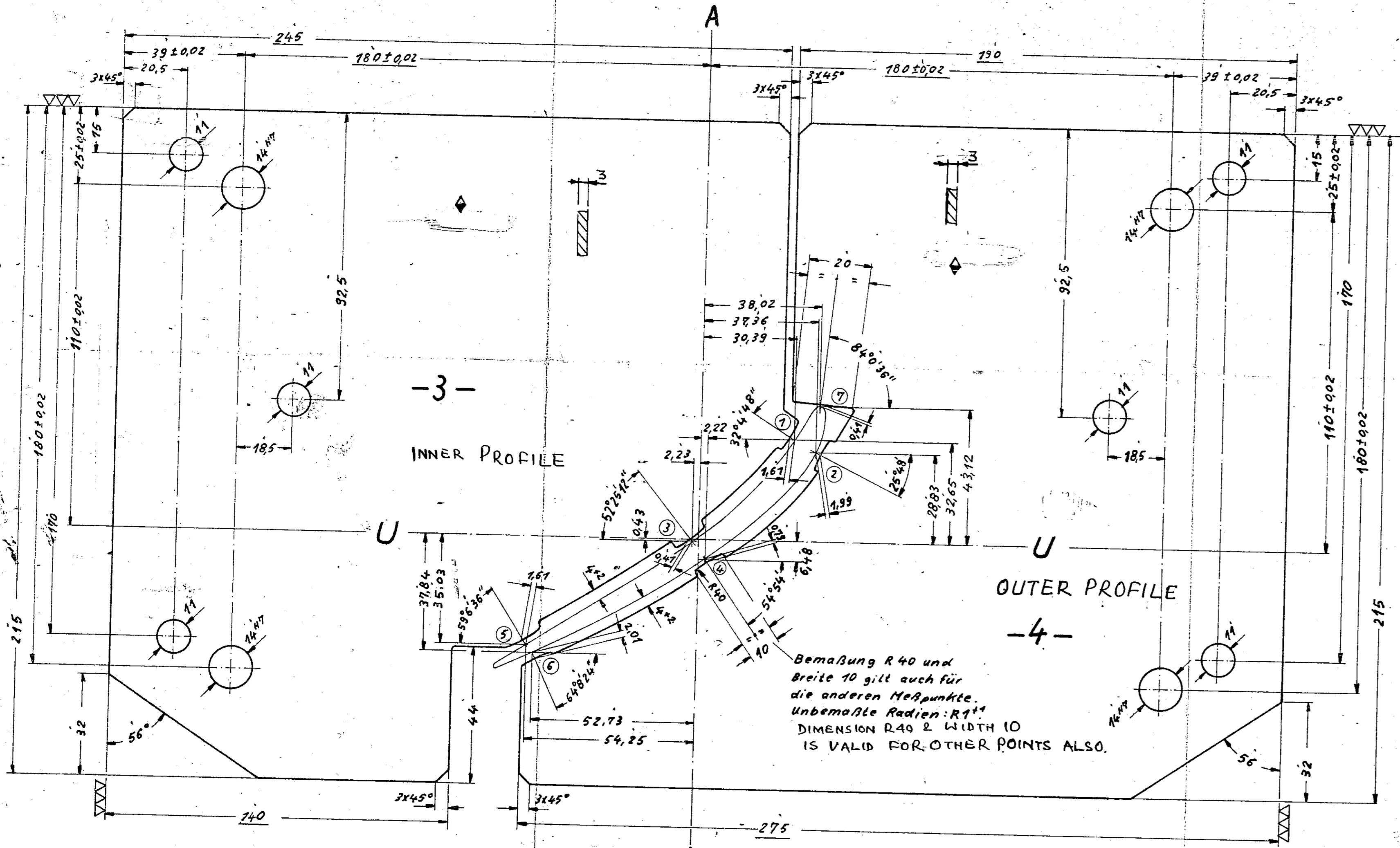


MARK
R8390-0562
ND3/680/3-III
SECTION B-B
MEASURING POINT
1,3,5

MARK
R8390-0566
ND3/680/3-III
SECTION B-B
MEASURING POINT
2,4,6,7

MARK ON BOTH SIDES
Beschriftung der Meßstellen beidseitig:
① max. 3,54
② max. 4,78
③ max. 2,74
④ max. 3,29
⑤ max. 3,54
⑥ max. 3,54
⑦ max. 3,54

PROFILE DRG. NO. SECTION B-B
Profizzeichnung Schnitt B-B 1-34600-17126/11



MARK
R8392-0564
SECTION D-D
ND3/680/3-III L&R
MEASURING POINT
1,3,5

MARK
R8392-0567
ND3/680/3-III
SECTION D-D
MEASURING POINT
2,4,6,7

MARK ON BOTH SIDES
Beschriftung der Meßstellen beidseitig:
① max. 3,22
② max. 3,97
③ max. 0,82
④ max. 1,57
⑤ max. 3,22
⑥ max. 3,62
⑦ max. 0,82

PROFILE DRG. NO. SECTION D-D
Profizzeichnung Schnitt D-D 1-34600-17126/11

0-2294

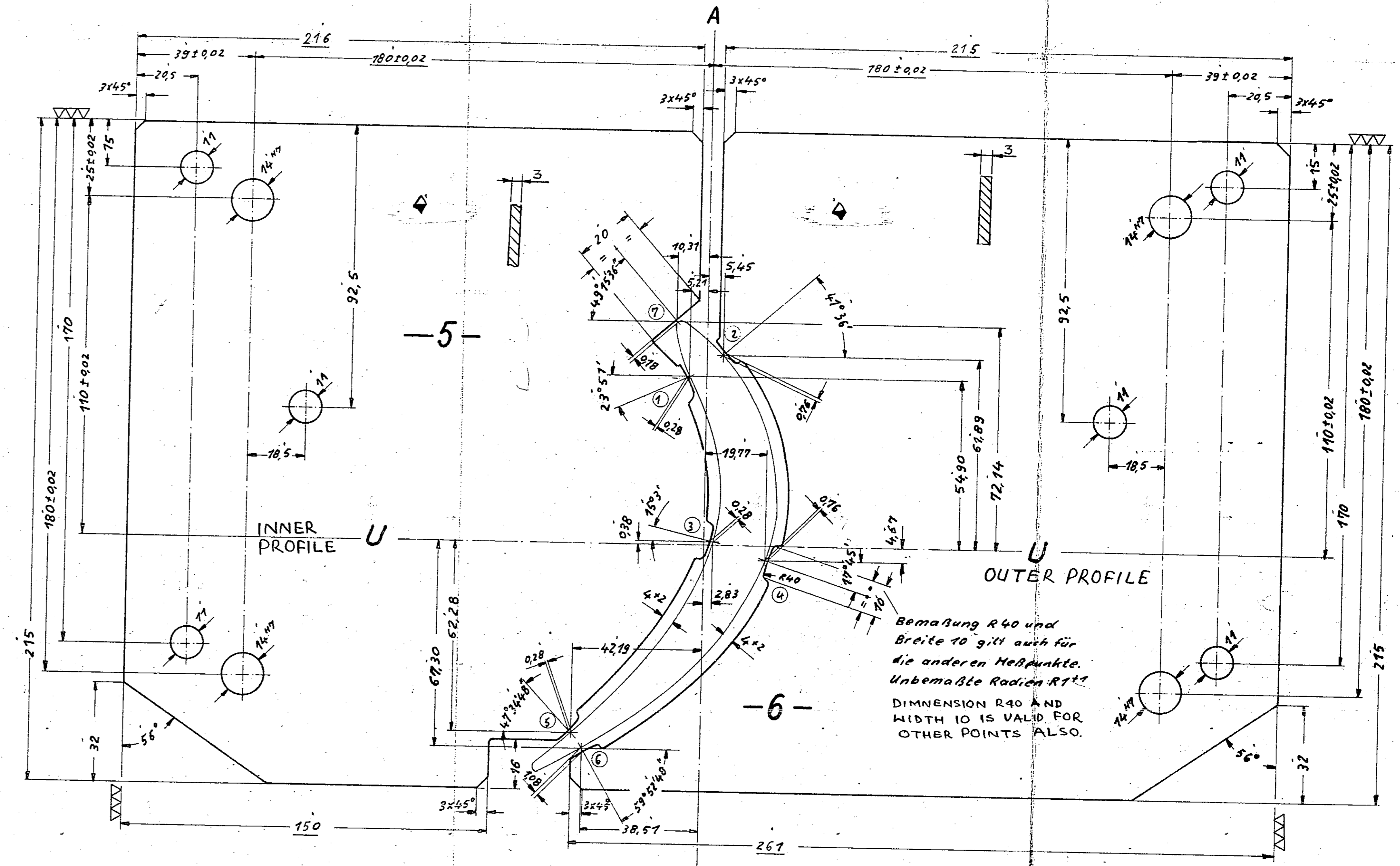
Stückliste	Stückzahl	Bezeichnung	Material	Größe	Einheit
1	1	Lehre	90 Mn V8	1	H
1	1	Lehre	90 Mn V8	2	H
1	1	Lehre	90 Mn V8	3	H
1	1	Lehre	90 Mn V8	4	H
1	1	Lehre	90 Mn V8	5	H
1	1	Lehre	90 Mn V8	6	H

MARK
R8390-0565
ND3/680/3-III
SECTION H-H
MEASURING POINT
1,3,5,7

MARK
R8390-0568
ND3/680/3-III
SECTION H-H
MEASURING POINT
2,4,6

MARK ON BOTH SIDES
Beschriftung der Meßstellen beidseitig:
① max. 0,96
② max. 0,91
③ max. 0,96
④ max. 0,91
⑤ max. 0,96
⑥ max. 0,96
⑦ max. 0,91

Profizzeichnung Schnitt H-H 1-34600-17126/2



SECTION H-H

S.ND	W/ORDER NO.	DRAWING NO.
1	KBM-1262	R8392-0563
2	KBM-1265	R8392-0566
3	KBM-1263	R8392-0564
4	KBM-1266	R8392-0567
5	KBM-1264	R8392-0565
6	KBM-1267	R8392-0568

- 1. HARDEN TO HRC: 50 ± 55 (ONLY PROFILE)
- 2. TO BE USED WITH WEO-13-3400
- 3. PROFILE DRG. NO. 1-34600-17126/12

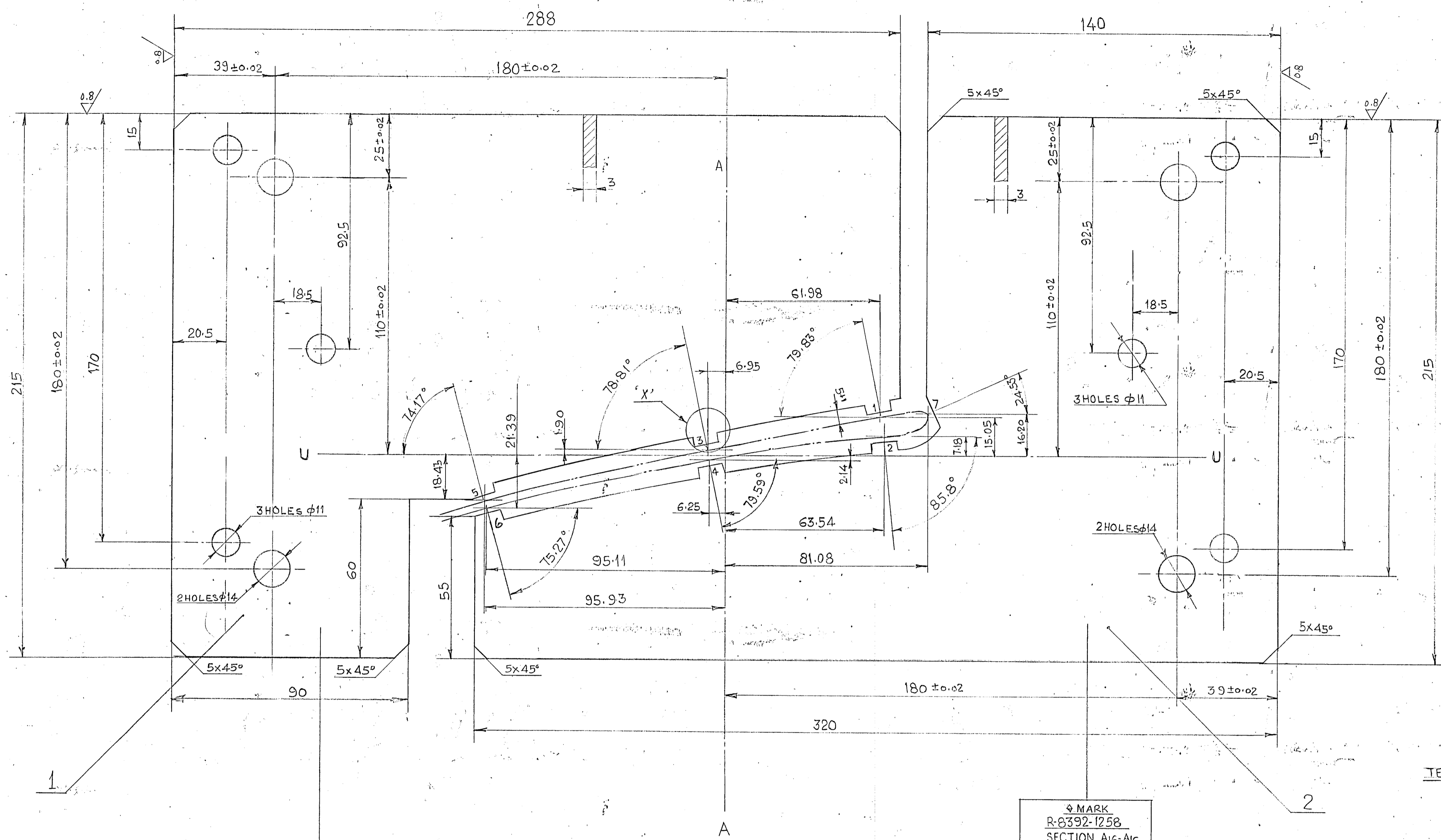
MATERIAL: - 90 Mn V8

XII/14

TYPE OF PRODUCT	W/ORDER NO.	M/C TOOL TRANS. NO.	INVENTORY NO.
COMPR. DRG. NO.	REF. DRG. NO.	MODEL NO.	
BHEL BHARAT HEAVY ELECTRICALS LIMITED			
HARDWAR			
DEPT. / SET	SCALE	WEIGHT (KG)	REP. TO ASSY. DRG.
APPROVED	NAME	SIGN	DATE
STT	CHOUHURY		20/05/99
PROFILE TEMPLATE (CHECKING POINTS)		DRAWN	DATE
		ND3/680/3-III	20/05/99
CARD CODE	DRAWING NO.	CHECKED	DATE
	R8392-0563-0568		
SHEET NO.	NO. OF SHEETS		

DRAWING NO. R-8392-1257-1258

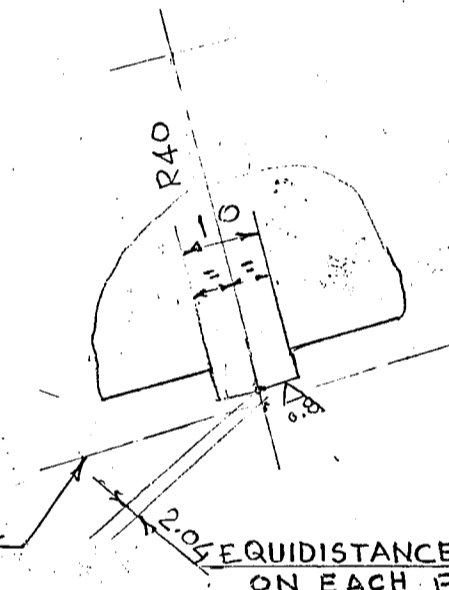
1/6 THE REST



MARK ON BOTH SIDES.

- 1. MAX. 2.98
- 2. MAX. 4.08
- 3. MAX. 2.98
- 4. MAX. 4.08
- 5. MAX. 2.98
- 6. MAX. 4.08
- 7. MAX. 2.98

DETAIL 'X'



NOMINAL PROFILE EQUIVALENT WITH NOMINAL PROFILE ON EACH POINT.

TECH. REQUIREMENTS:-

- 1. HARDEN TO HRC 50±55 AS PER IS 11003(2008) (ONLY PROFILE)
- 2. TO BE USED WITH WE-0-13-3400
- 3. BLADE PROFILE AS PER DRG NO 0-103-07-41023.
- 4. MANUFACTURING ACCURACY OF PROFILE ±0.02
- 5. CONSERVATION TO BE DONE AS PER TL 30007

MARK
R-8392-1257
SECTION A16-A16
INNER PROFILE
MEASURING POINTS 1,3,5
FORM-10; SIMADRI

MARK
R-8392-1258
SECTION A16-A16
OUTER PROFILE
MEASURING POINTS 2,4,6,7
FORM-10; SIMADRI

SL. NO.	DESIGN W/O NO.	DRAWING NO.
1	KBM-6115	R-8392-1257
2	KBM-6116	R-8392-1258

VAR. 00	REMARKS	ITEM NO.	DESCRIPTION	DRAWING NO.	MATERIAL CODE	UNIT WEIGHT	UNIT	NO. OF SHEETS
			2	TEMPLATE OUTER PROFILE	T-90MM6 WCP2	1.1		
			1	TEMPLATE INNER PROFILE	AA-10021/(15:274B)	1		

GMS NO./GR. SP. NO.	STATUS OF DRG	TYPE OF PRODUCT	COMP. DRG. NO.	MIC TOOL TRANS. NO.	REF. DRG. NO.
		500 M.W. (KWU) BLADE SIMADRI	7223-34514	2621	R-8392-0867

REV. DATE	ALTERED CHECKED	REV. DATE	ALTERED CHECKED	DEPT. JTE	SCALE	WEIGHT (kg)	REF. TO ASSY. DRG.	ITEM NO.	NO. OF SHEETS
				209	1:1	~ 2.103			

TITLE TEMPLATE FOR PROFILE (INNER & OUTER) CHECKING SECTION A16-A16
FORM-10; SIMADRI

DRAWING NO. R-8392-1257-1258
SHEET NO. - / NO. OF SHEETS -

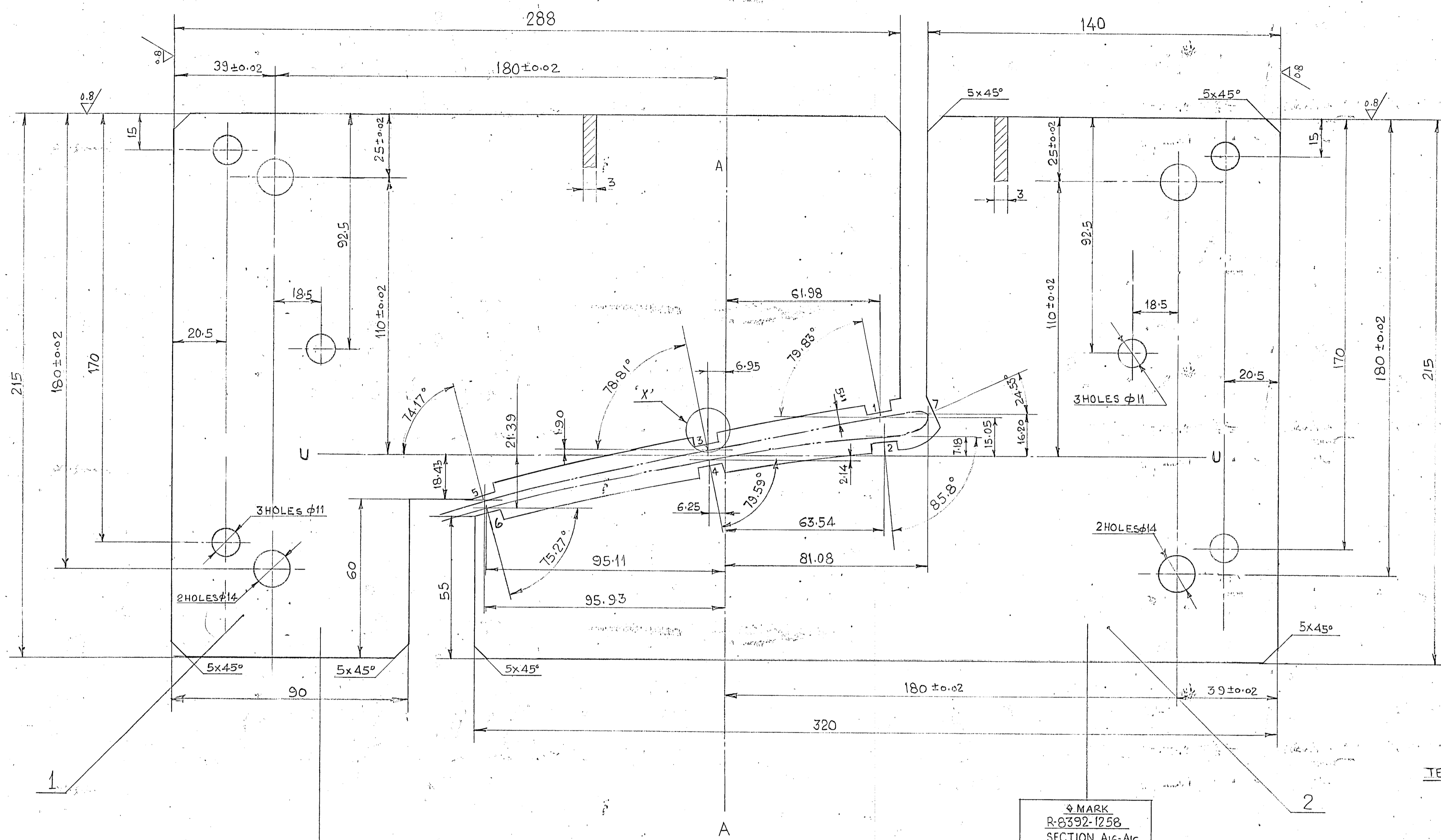
SIZE A1

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10215
7-10542
INVENTORY NO. 19-10-11-98
REF. DRG. NO.

DRAWING NO. R-8392-1257-1258

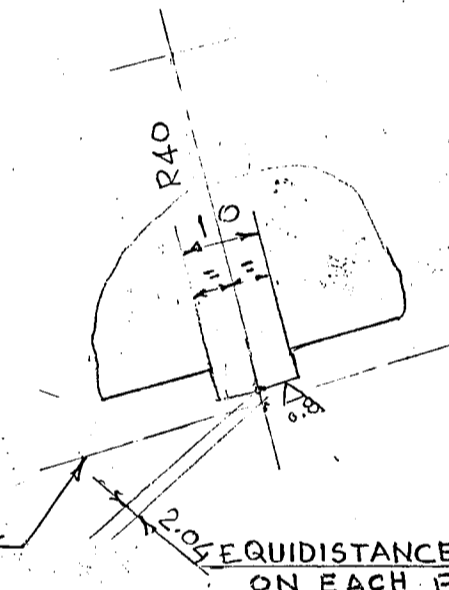
1/6 THE REST



MARK ON BOTH SIDES.

- 1. MAX. 2.98
- 2. MAX. 4.08
- 3. MAX. 2.98
- 4. MAX. 4.08
- 5. MAX. 2.98
- 6. MAX. 4.08
- 7. MAX. 2.98

DETAIL 'X'



NOMINAL PROFILE EQUIVALENT WITH NOMINAL PROFILE ON EACH POINT.

TECH. REQUIREMENTS:-

- 1. HARDEN TO HRC 50±55 AS PER IS 11003(2008) (ONLY PROFILE)
- 2. TO BE USED WITH WE-0-13-3400
- 3. BLADE PROFILE AS PER DRG NO 0-103-07-41023.
- 4. MANUFACTURING ACCURACY OF PROFILE ±0.02
- 5. CONSERVATION TO BE DONE AS PER TL 30007

MARK
R-8392-1257
SECTION A16-A16
INNER PROFILE
MEASURING POINTS 1,3,5
FORM-10; SIMADRI

MARK
R-8392-1258
SECTION A16-A16
OUTER PROFILE
MEASURING POINTS 2,4,6,7
FORM-10; SIMADRI

SL. NO.	DESIGN W/O NO.	DRAWING NO.
1	KBM-6115	R-8392-1257
2	KBM-6116	R-8392-1258

VAR. 00	REMARKS	ITEM NO.	DESCRIPTION	DRAWING NO.	MATERIAL CODE	UNIT WEIGHT	UNIT	NO. OF SHEETS
			2	TEMPLATE OUTER PROFILE	T-90MM6 WCP2	1.1		
			1	TEMPLATE INNER PROFILE	AA-10021/(15:274B)	1		
					T-90MM6 WCP2	1.003		
					AA-10021/(15:274B)	1		

GMS NO./GR. SP. NO.	STATUS OF DRG	TYPE OF PRODUCT	COMP. DRG NO.	MIC TOOL TRANS NO.	REF. DRG NO.
		500 M.W. (KWU) BLADE SIMADRI	7223-34514	2621	R-8392-0867
			DESIGN W/O NO.	MIC TOOL MODEL NO.	0868
			SEE TABLE	V-STAND (S1G)	

REV. DATE	ALTERED CHECKED	REV. DATE	ALTERED CHECKED

DEPT. JTE	SCALE	WEIGHT (kg)	REF. TO ASSY. DRG.	ITEM NO.
209	1:1	~ 2.103		

DRN	NAME	SIGN	DATE	NO. OF VAR.
CHD	SHARMA		11/11	
APD	A.P. AGRAWAL		11/11	

TITLE TEMPLATE FOR PROFILE (INNER & OUTER) CHECKING SECTION A16-A16
FORM-10; SIMADRI

DRAWING NO. R-8392-1257-1258
SHEET NO. - / NO. OF SHEETS -

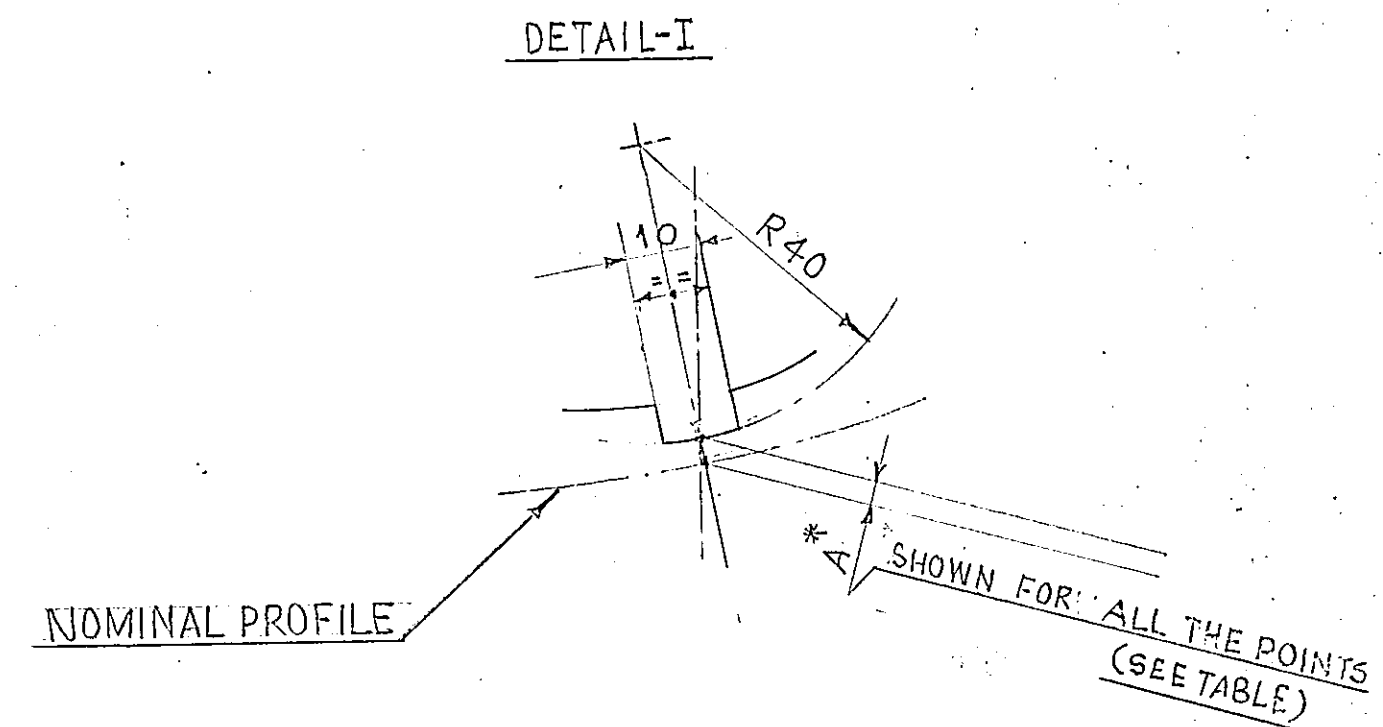
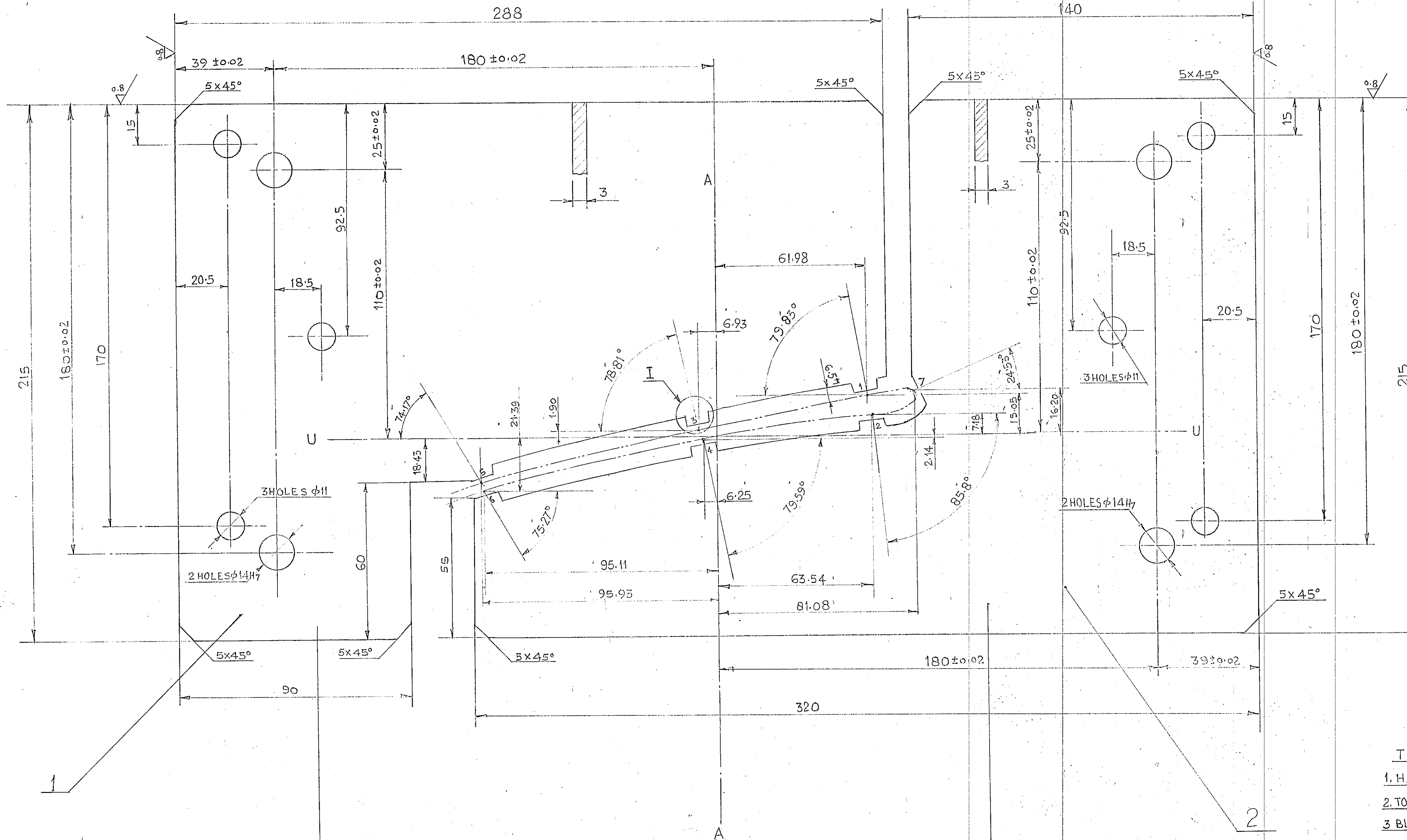
SIZE A1

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10215
7-10542
INVENTORY NO. 19-10-11-98
REF. DRG. NO.

DRAWING NO R-8392-1262-1263

1/6 THE REST



MARK ON BOTH SIDES

1	MAX	4.94
2	MAX	5.04
3	MAX	3.54
4	MAX	4.64
5	MAX	3.74
6	MAX	4.84
7	MAX	3.94

DIMENSION A*

1	4.00
2	2.04
3	2.60
4	2.04
5	2.04
6	2.80
7	3.00

TECH. REQUIREMENTS:-

1. HARDEN TO HRc 50±5 AS PER P.S. NO 0912008 ONLY PROFILE
2. TO BE USED WITH WE-0-13-34-00
3. BLADE PROFILE AS PER DRG NO 0-103-07-41023
4. MANUFACTURING ACCURACY OF PROFILE ±0.02.
5. CONSERVATION TO BE DONE AS PER TL-30007.

4 MARK
R-8392-1262
SECTION A16-A16
MEASURING POINTS 1, 3 & 5
FORM 10-3; SIMHADRI

4 MARK
R-8392-1263
SECTION A16-A16
MEASURING POINTS 2, 4, 6 & 7
FORM 10-3; SIMHADRI

SL. NO	DESIGN W/O NO	DRG NO
1	KBM-6117	R-8392-1262
2	KBM-6118	R-8392-1263

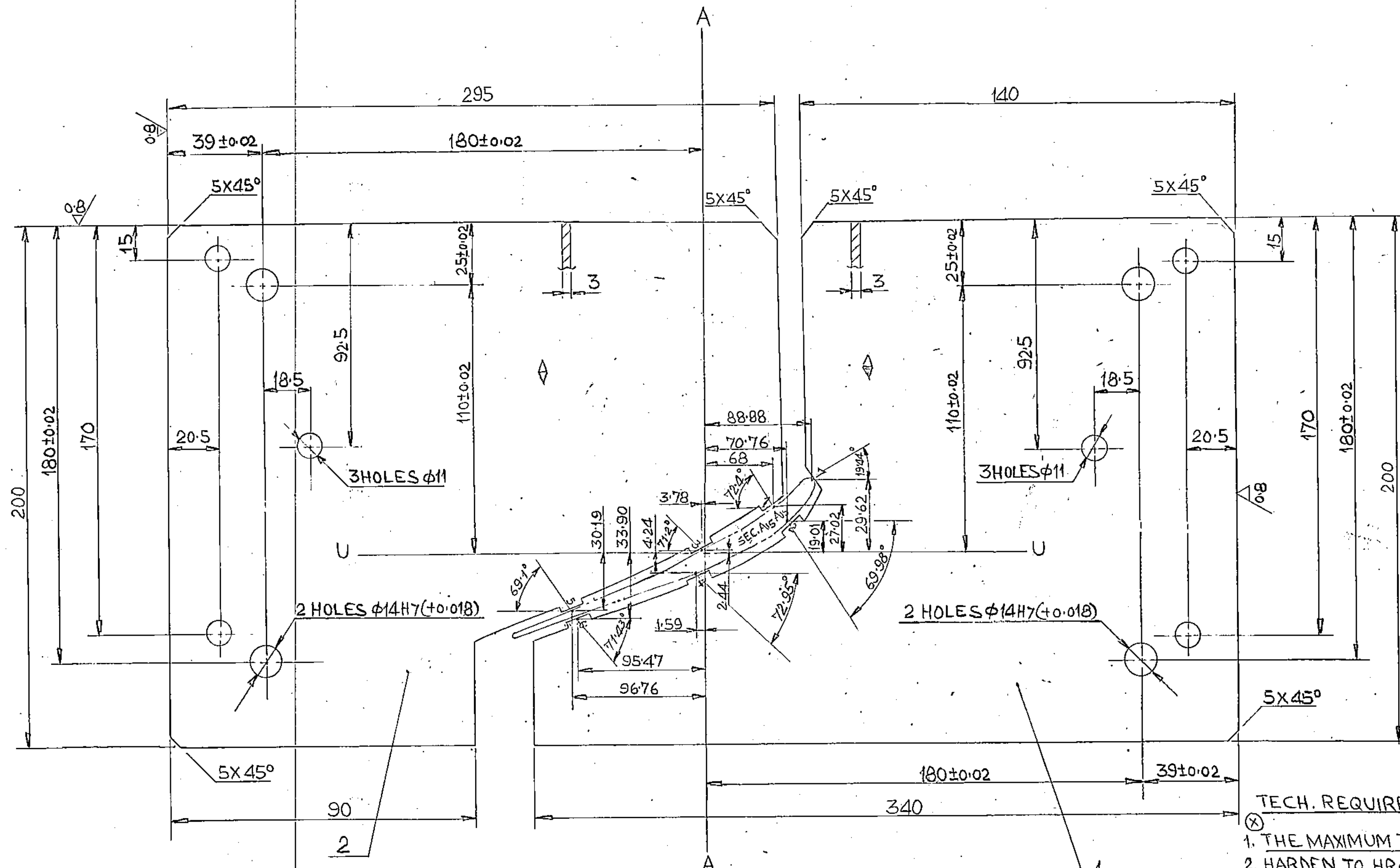
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INVENTORY NO. 10907
REF. DRG. NO. 21-3-2007
DATE

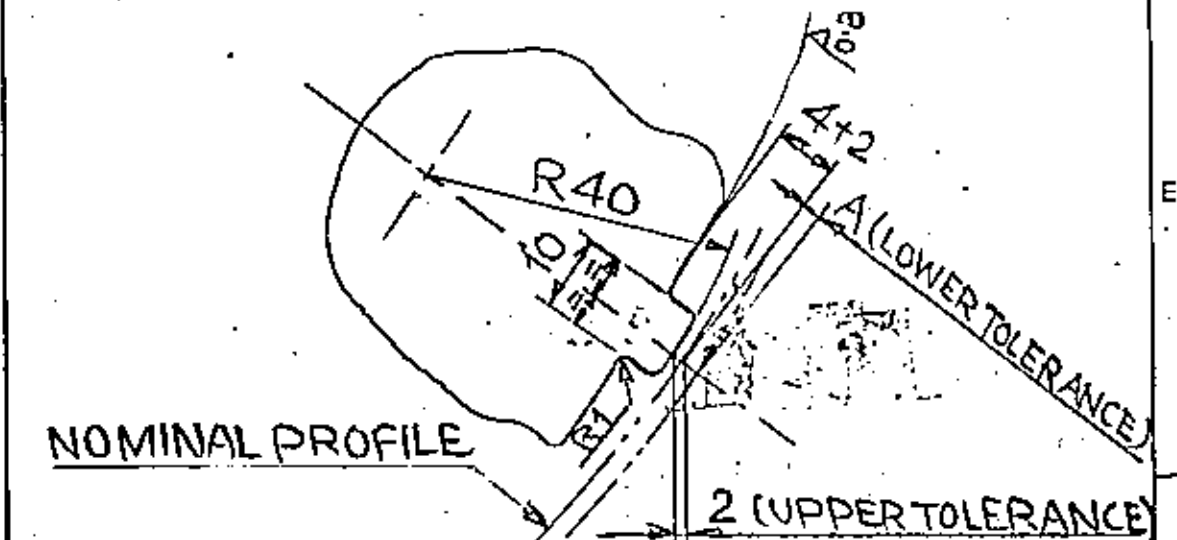
2	TEMPLATE OUTER PROFILE			T-90MM6WCF2	1.106														
1	TEMPLATE INNER PROFILE			AA-10921(16:3778)	1														
VAR. 00	REMARKS	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	MATERIAL CODE	UNIT WEIGHT												
59	64	65	75	25	27	29	58	59	60	77	32	33	34	55	56	57	71	72	73
CARD TYPE 3			28			CARD TYPE-1			28			CARD TYPE-2							
GMS NO./GR. SP. NO.	STATUS OF DRG	TYPE OF PRODUCT	COMP. DRG NO	MIC TOOL TRANS NO	REF DRG. NO														
AGREED	NAME	SIGN	DATE	500 M.W K.W.U	0-103-07-41003														
PE.B	VCG/B.DASS			SIMHADRI	DESIGN W/O NO														
					KBM-6117, KBM-6118														
					MIC TOOL MODEL NO														
					V. STAND (BIG)														
					R-8392-1257; 1258														
GRADE OF UNTOL. DIM. :-	M/CG-0/M/F AA0230208	WELDING-A/B/C/D AA0621104	GAS CUTTING-T3 AA0621101	BHARAT HEAVY ELECTRICALS LTD.	DRN DARGAH	CHD SHARMA	APD A.P. AGRAWAL	HARDWAR	NO. OF VAR.										
REV DATE	ALTERED	CHECKED	REV DATE	ALTERED	CHECKED	DEPT. J.T.E	SCALE	WEIGHT (kg)	REF. TO ASSY. DRG. NO	ITEM NO									
						CODE 209	1:1	~ 2.110	11	75/77									
ZONE			ZONE			TITLE	TEMPLATE FOR INNER & OUTER PROFILE CHECKING FORM 10-3 AFTER HARDENING SECTION A16-A16		DRAWING NO.	NO. OF SHEETS									
									R-8392-1262+1263	22/23/24									
									SHEET NO.	NO. OF SHEETS									
										SIZE A1									

DRAWING NO. R8392-1400-1401

1/6 THE REST



DETAIL-I
(SHOWN FOR ALL THE POINTS)



TECH. REQUIREMENTS:-

1. THE MAXIMUM TOLERANCE TO BE MARKED ON BOTH THE SIDES
2. HARDEN TO HRC 50±55 AS PER P.S.NO.0912-008 ONLY PROF
3. TO BE USED WITH WE 0-13-3400 (VERTICAL STAND),
4. PROFILE DRG. NO. 0-103-07-46023.
5. MANUFACTURING ACCURACY OF PROFILE POINTS ±0.02.
6. CONSERVATION TO BE DONE AS PER TL 30007,

MARK
R8392-1401
SECTION, A15-A15
FORM-17

MARK
R8392-1400
SECTION, A15-A15
FORM-17

ITEM NO.	PROFILE POINT	DIMENSION A	MAX TOLERANCE (2+A)	W./ORDER NO	DRG. NO.
1.	2	2.0	4.0	KBM-7405	R8392-1400
	4	2.0	4.0		
	6	2.0	4.0		
	7	0.7	2.7		
2.	1	0.7	2.7	KBM-7406	R8392-1401
	3	0.7	2.7		
	5	0.7	2.7		

ITEM NO.	DESCRIPTION	DRAWING NO.	VAR	MAT. CODE	UNIT WT.
2.	TEMP INT. PROF.	R8392-1401		T90MM6 WCY 2	
1.	TEMP. EXT. PROF.	R8392-1400		AA10892(CS:3748)	

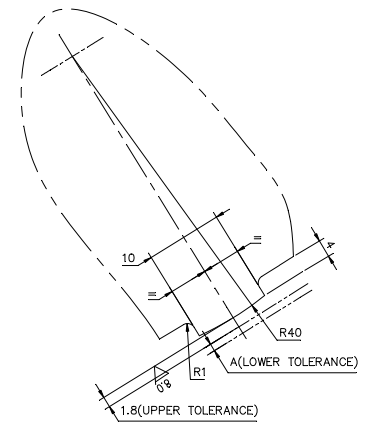
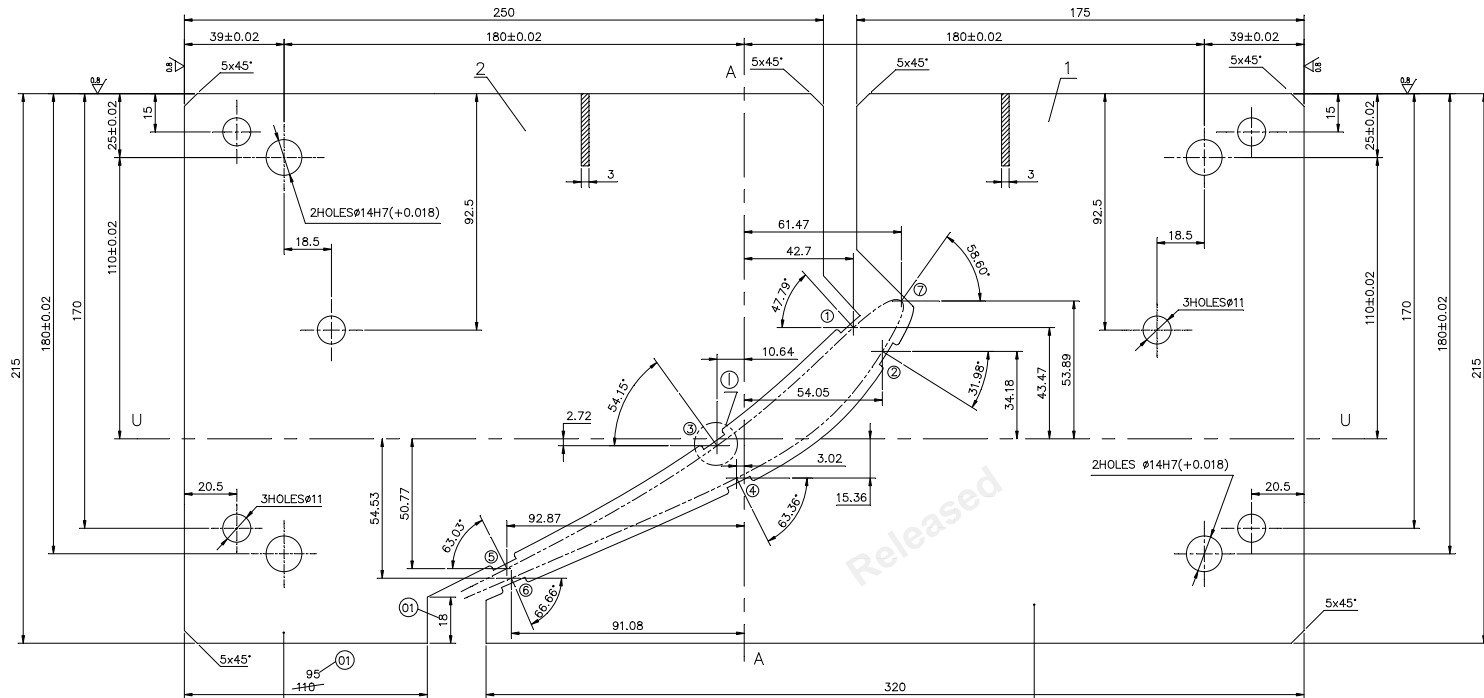
CBOM/GMS No	STATUS OF DRG	TYPE OF PRODUCT	COMP. DRG. NO.	M/CTOOL TRANS NO.	REF. OF DRG.
DESIGN NAME	DATE	250 M.W. (PANIPAT)	0-103-07-46023	2521	R8392-1386
DESIGNER	SIGN	DESIGN ORDER NO	SEE TABLE	M/CTOOL MODEL NO	÷1387
Bharat Heavy Electricals Ltd. Hardwar		DRN	D.K. DOVAL	CHD	H.N. SHARMA
GAS CUTTING: T3 AA 0621101		APD	A.P. AGARWAL		
REV	DATE	ALTERED	CHECKED	CODE	SCALE
ZONE		ZONE		DEPT. 209	N.T.S.
TITLE			DRAWING No.		
EXT. INT. PROFILE CHECKING			R8392-1400-1401		
SECTION A15-A15 (FORM 17)			SHEET NO. 1		

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INVENTORY NO. 11247
SIGN & DATE: 27/02/23

DRAWING No. R8392-1402-1403

1.6 / THE REST



SCALE-NTS
DETAIL-'1' FOR ALL POINTS.

MARK
R8392-1403
SEC-A11-A11
INNER PROFILE
POINTS 1,3,5
FORM17.

MARK
R8392-1402
SEC-A11-A11
EXT. PROFILE
POINTS 2,4,6,7
FORM17.

DRG. REDRAWN FROM ORIGINAL
DRN:-ASHOK 25-01-11
CHD:-RAVI 25-01-11
APD:-ANKUR 27-01-11

TECH.REQ:-

- *1:-THE MAXIMUM TOLERANCE TO BE MARKED ON BOTH THE SIDES.
- 2:-HARDEN TO HRc 50-55 AS PER PS-Q912.008 (ONLY PROFILE).
- 3:-TO BE USED WITH WE 0-13-3400 (VERTICAL STAND).
- 4:-BLADE PROFILE AS PER DRG. NO.0-103-07-46023.
- 5:-MANUFACTURING ACCURACY OF PROFILE ±0.02.
- 6:-CONSERVATION TO BE DONE AS PER TL-30007.

ITEM NO.	PROFILE POINT	DIMENSION A	*MAX.TOLERANCE (1.8+A)	W./ORDER NO.	DRG.NO.
01.	2	1.8	3.6	KBM-7407	R8392-1402
	4	1.8	3.6		
	6	1.8	3.6		
	7	0.5	2.3		
02.	1	0.5	2.3	KBM-7408	R8392-1403
	3	0.5	2.3		
	5	0.5	2.3		

VAR.00	REMARKS	ITEM No.	DESCRIPTION	STP.	DRAWING No.	MATERIAL CODE	UNIT WEIGHT	QTY.
02.	TEMPLATE INT.PROFILE		R8392-1403		T30Mn6Wcr2 AA10892			
01.	TEMPLATE EXT. PROFILE		R8392-1402		T90Mn6Wcr2 AA10892		01	

GMS No./GR.SP.No.	STATUS OF DRG.	TYPE OF PRODUCT	COMP. DRG. No.	M/C TOOL TRANS No.	REF. DRG. No.
		250 MW (PANIPAT)	0-103-07-46003+6	2621	R8392-1257+1258

REV.	DATE	ALTERED CHECKED	SJTERS S/TEAM	DEPT. JTE	SCALE	WEIGHT(Kg)	REF. TO ASSY. DRG.	ITEM No. OF ITEM
01	01	JTE-11-F0008	2-01-11	209	1:1			

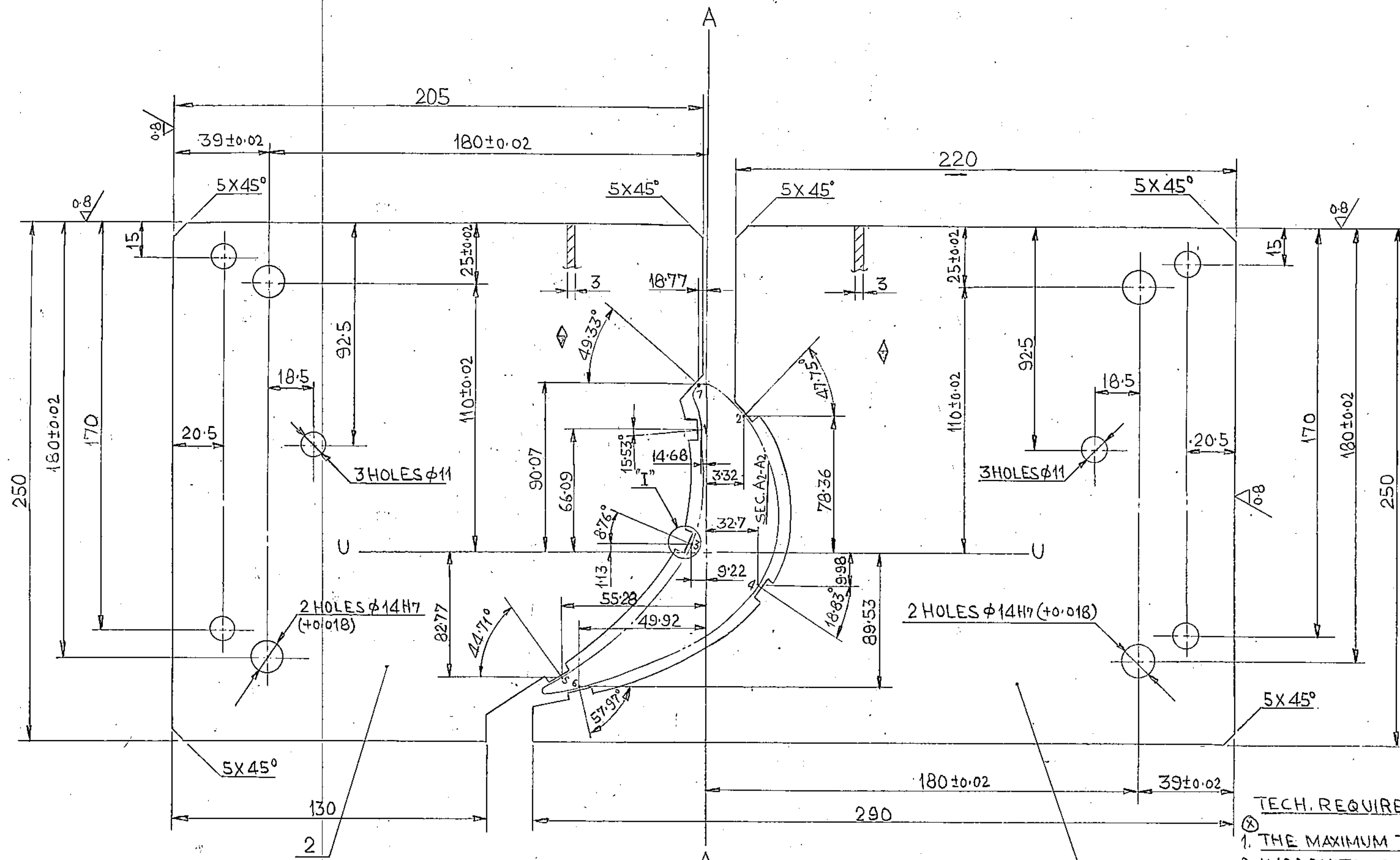
DRG. NO. R8392-1402-1403
SHEET No. 01 OF SHEET 01

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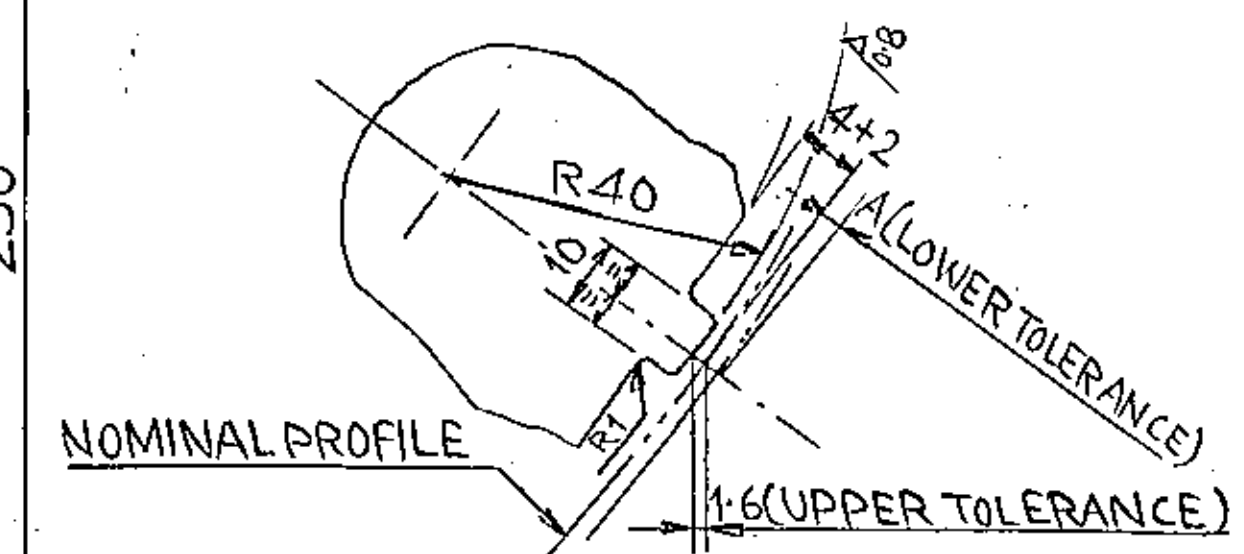
INVENTORY No.IGN. & DATE REF. DRG. No.

DRAWING NO. R8392-1404-1405

16/ THE REST



DETAIL-I
(SHOWN FOR ALL THE POINTS)



TECH. REQUIREMENTS:-

1. THE MAXIMUM TOLERANCE TO BE MARKED ON BOTH THE SIDES
2. HARDEN TO HRC 50±55 AS PER P.S. NO.0912-008 ONLY DROF.
3. TO BE USED WITH WE 0-13-3400 (VERTICAL STAND)
4. PROFILE DRG. NO. 0-103-07-46023.
5. MANUFACTURING ACCURACY OF PROFILE ±0.02
6. CONSERVATION TO BE DONE AS PER TL 30007.

MARK
R8392-1405
SECTION-A2-A2
FORM-17

MARK
R8392-1404
SECTION-A2-A2
FORM-17

ITEM NO.	PROFILE POINT	DIMENSION A	MAX. TOLERANCE W./ORDER NO. (1.6+A)	DRG. NO.
1.	2	1.6	3.2	KBM-7409 R8392-1404
	4	1.6	3.2	
	6	1.6	3.2	
	7	0.3	1.9	
2.	1	0.3	1.9	KBM-7410 R8392-1405
	3	0.3	1.9	
	5	0.3	1.9	

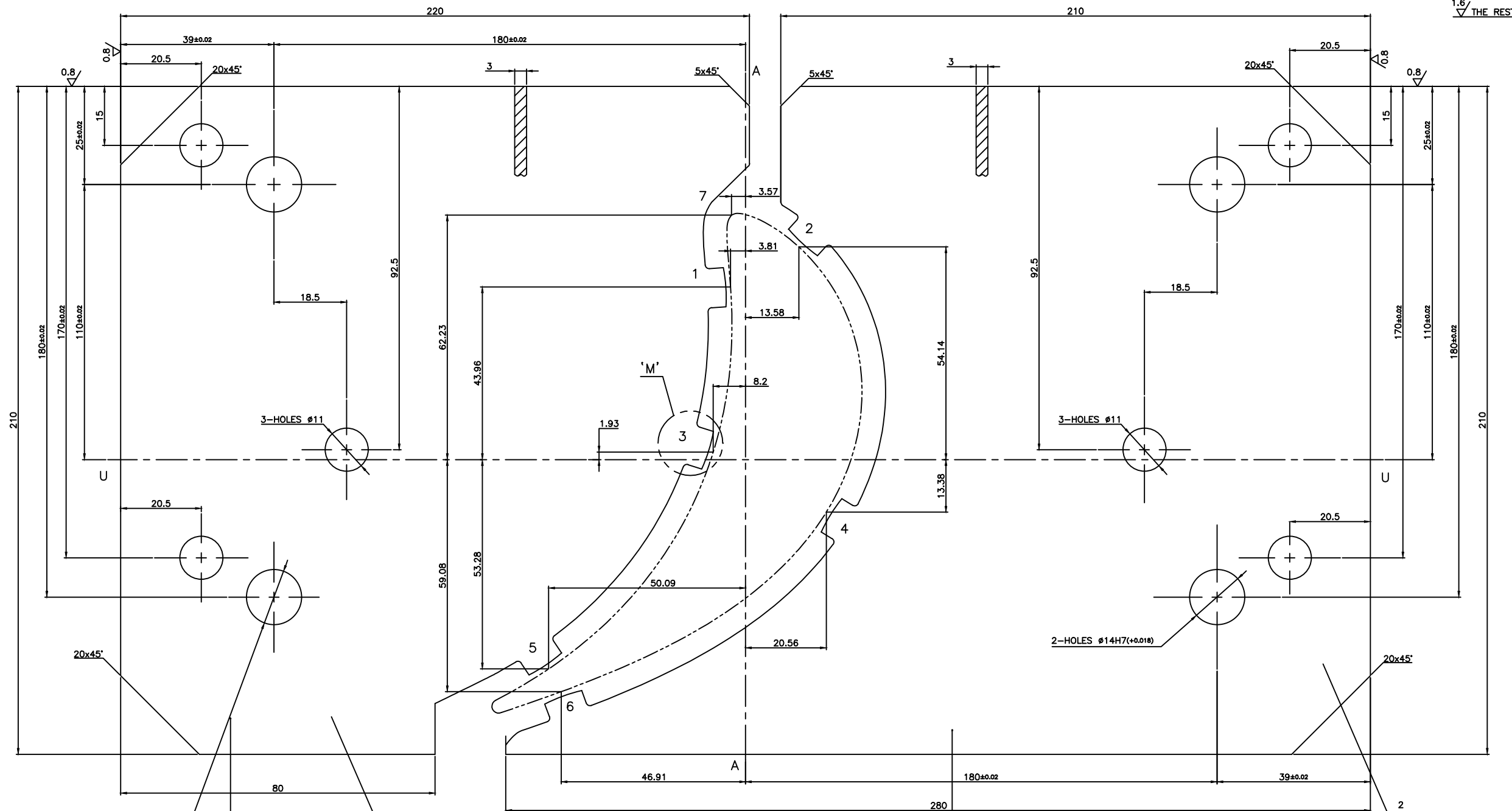
ITEM NO.	DESCRIPTION	DRAWING NO.	VAR	MAT. CODE	UNIT	WT.	QTY.
2.	TEMP. INT. PROF.	R8392-1405		T90Mh 6Wcy 2			
1.	TEMP. EXT. PROF.	R8392-1404		AA10892(15:3748)			

CBOM/GMS No	STATUS OF DRG	TYPE OF PRODUCT	COMP. DRG. NO.	MIC. TOOL TRANS. NO.	REF. OF DRG.
AA 230208	17.10.21	250M.W. (PANIPAT)	0-103-07-46023	2621	R8392-1390
WELDING-NB/C/D AA 0621104			DESIGN ORDER NO	MIC. TOOL MODEL NO	4-1391
GAS CUTTING-T3 AA 0621101			SEE TABLE	V. STAND (RIG)	
REV DATE	ALTERED CHECKED	REV DATE	ALTERED CHECKED	CODE 209	SCALE N.T.S.
ZONE		ZONE		DEPT. JTE	WEIGHT (kg)
Bharat Heavy Electricals Ltd.		Bharat Heavy Electricals Ltd.		Bharat Heavy Electricals Ltd.	
DRN D.K. DOVAL		DRN D.K. DOVAL		DRN D.K. DOVAL	
CHD H.N. SHARMA		CHD H.N. SHARMA		CHD H.N. SHARMA	
APD A.P. AGARWAL		APD A.P. AGARWAL		APD A.P. AGARWAL	
TITLE: TEMPLATE FOR EXIT/INT. PROFILE CHECKING SEC. A2-A2 (FORM-17)		DRAWING No. R8392-1404-1405		SHEET NO. 1	

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INVENTORY NO. R8392-1404-1405

DRAWING No. R8392-1531-1532

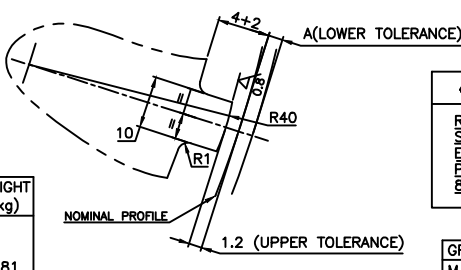


MARK
R8392-1531
SEC. A3-A3
INT. PROFILE
POINTS 1,3,5,7
800MW.

MARK
R8392-1532
SEC. A3-A3
EXT. PROFILE
POINTS 2,4,6
800MW.

- TECH.REQ:-**
- 1-SHARP EDGES TO BE ROUNDED OFF.
 - *2-THE MAXIMUM TOLERANCE TO BE MARKED ON BOTH SIDES.
 - 3-HARDEN TO HRC. 50±55 AS PER PS. No. 0912.008.
 - 4-TO BE USED WITH BIG VERTICAL STAND.
 - 5-PROFILE DRAWING No. 01030758021.
 - 6-MANUFACTURING ACCURACY OF PROFILE ±0.02.
 - 7-CONSERVATION TO BE DONE AS PER TL-30007.

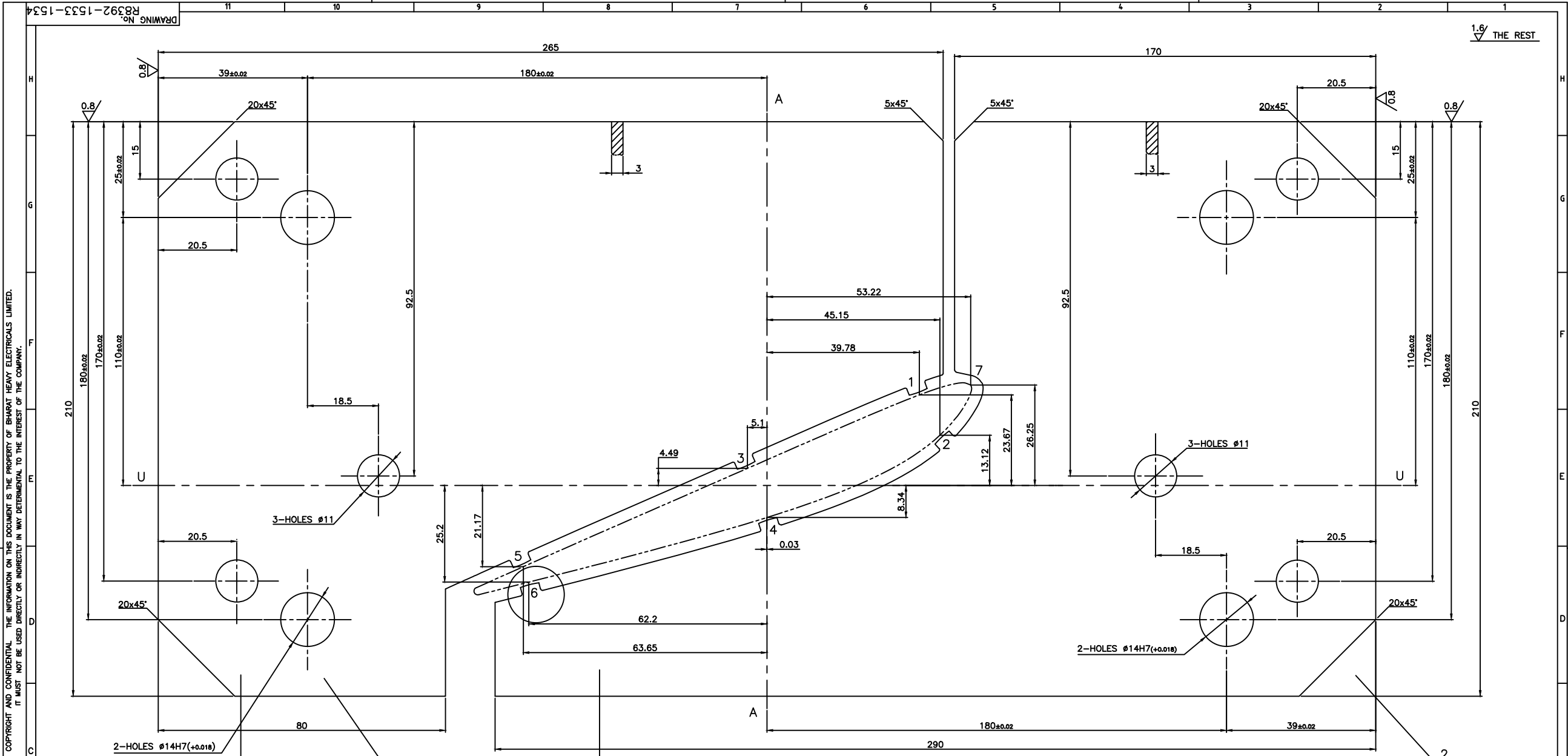
ITEM NO.	PROFILE POINT	DIMENSION (A)	*MAX.TOLE. (A+1.2)	W./ORDER NO.	DRG.NO.	WEIGHT (kg)
01.	1	0.3	1.5	NBF/1998	R8392-1531	0.81
	3	0.3	1.5			
	5	0.3	1.5			
	7	0.3	1.5			
02.	2	1.2	2.4	NBF/1999	R8392-1532	1.05
	4	1.2	2.4			
	6	1.2	2.4			



SCALE-NTS
DETAIL-'M' FOR ALL POINTS.

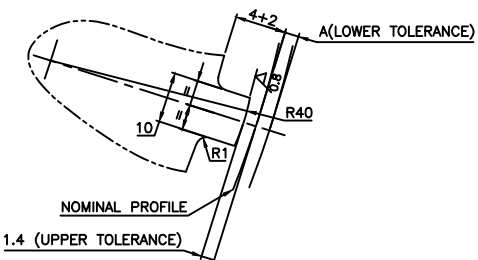
02. TEMPLATE EXT. PROFILE	R8392-1532	T90Mn6WCr2	-	01							
01. TEMPLATE INT. PROFILE	R8392-1531	T90Mn6WCr2	-	01							
VAR.00	REMARKS	ITEM No.	DESCRIPTION	STD.	DRAWING No.	VAR.	MATERIAL SPECN.	UNIT	WEIGHT	QTY.	
GMS No./GR.SP.No.		STATUS OF DRG.		TYPE OF PRODUCT		COMP. DRG. No.		M/C TOOL TRANS No.		REF. DRG. No.	
M/CG-E/M/A/AA0230208		TBM ANIL KUMAR -sd-25-07-16		800 MW		01030758001		3-1000		R8392-1461	
WELDING-A/B/C/D-AA0621104		SIGN. DATE		DESIGN ORDER No.		MODEL No.		NAME		SIGN. DATE No. OF VAR.	
GAS CUTTING-T3'AA0621101		ANIL KUMAR -sd-25-07-16		SEE TABLE		3-1000		DRN DEEPAK -sd-25-07-16		OF	
REV. DATE		ALTERED CHECKED		DEPT. JTE		SCALE		WEIGHT(Kg.)		REF. TO ASSY. DRG.	
REV. NO.		C/A No.		DATE		209		~1.86		ITEM No. OF ITEM	
REV. NO.		C/A No.		DATE		TITLE		DRAWING No.		REV.	
REV. NO.		C/A No.		DATE		INT&EXT.PROFILE CHECKING TEMPLATE		R8392-1531-1532		SHEET No. 01 No. OF SHEET 01	
REV. NO.		C/A No.		DATE		AT SEC.A3-A3		R8392-1531-1532		SIZE A 1	

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◆ MARK
R8392-1533
SEC. A21-A21
INT. PROFILE
POINTS 1,3,5
800MW.

◆ MARK
R8392-1534
SEC. A21-A21
EXT. PROFILE
POINTS 2,4,6,7
800MW.



- NOTES:-
- 1-SHARP EDGES TO BE ROUNDED OFF.
 - *2-THE MAXIMUM TOLERANCE TO BE MARKED ON BOTH SIDES.
 - 3-HARDEN TO HRC 50±55 AS PER P.S.No. 0912.00B.
 - 4-TO BE USED WITH BIG VERTICAL STAND.
 - 5-PROFILE DRG. NO. 0-10307-58021.
 - 6-MANUFACTURING ACCURACY OF PROFILE ±0.02.
 - 7-CONSERVATION TO BE DONE AS PER TL 30007.

ITEM NO.	PROFILE POINT	DIMENSION (A)	*MAX.TOLE. (A+1.4)	W./ORDER NO.	DRG.NO.	WEIGHT (kg)
01.	1	0.5	1.9	NBF/2002	R8392-1533	0.66
	3	0.5	1.9			
	5	0.5	1.9			
02.	2	1.4	2.8	NBF/2003	R8392-1534	0.80
	4	1.4	2.8			
	6	1.4	2.8			
	7	0.5	1.9			

SCALE-NTS
DETAIL-'M' FOR ALL POINTS.

VAR.00	REMARKS	ITEM No.	DESCRIPTION	STD.	DRAWING No.	T90Mn6WCr2	AA10B21	UNIT	WEIGHT	QTY.
		2.	TEMP. EXT. PROFILE		R8392-1534	T90Mn6WCr2	AA10B21		1	
		1.	TEMP. INT. PROFILE		R8392-1533	T90Mn6WCr2	AA10B21		1	

GMS No./GR.SP.No.	STATUS OF DRG.	TYPE OF PRODUCT	COMP. DRG. No.	M/C TOOL TRANS No.	REF. DRG. No.
		800MW	01030758001-00	3-101	R8732-1461
APPROVED BY: TBM	NAME: ANL KUMAR	SIGN. DATE: -Sd-25-07-16	DESIGN ORDER No. SEE TABLE	MODEL No.	
GRADE OF UNTOOL.DIM. :- M/CG-B/M/G/AA0230208 WELDING-A/B/C/D-AA0621104 GAS CUTTING-T3'AA0621101			Bharat Heavy Electricals Ltd. HARDWAR		
REV. DATE	ALTERED CHECKED	REV. DATE	ALTERED CHECKED	DEPT. JTE	SCALE NTS
				209	WEIGHT(Kg.) SEE TABLE
TITLE 7 POINT CHECKING TEMPLATE AT SEC A21-A21 (INT. & EXT. PROFILE)			DRAWING No. R8392-1533-1534 SHEET No. 01 No. OF SHEET 01		

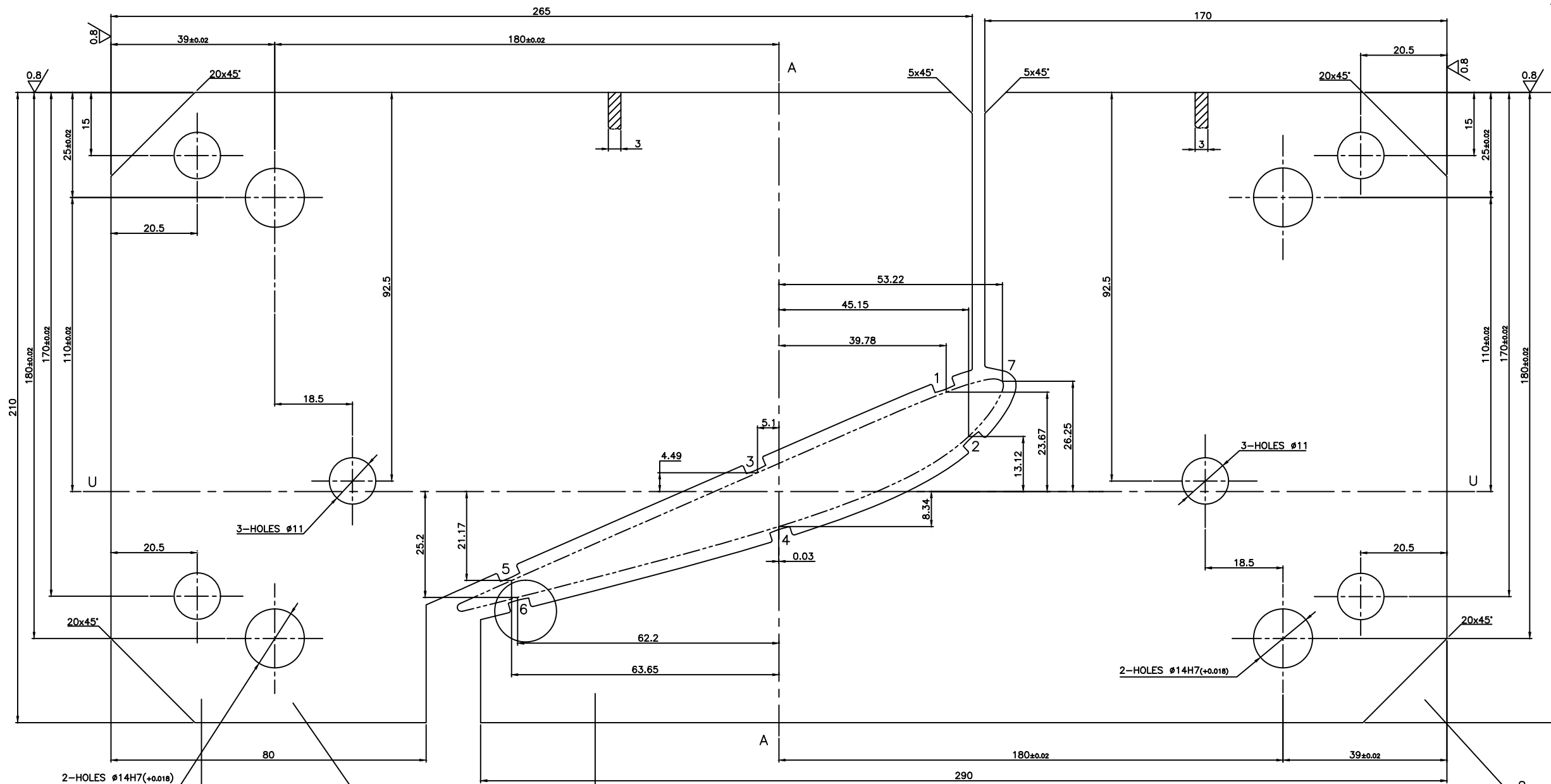
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INVENTORY NO. DESIGN. & DATE REF. DRG. No.

1.6/ THE REST

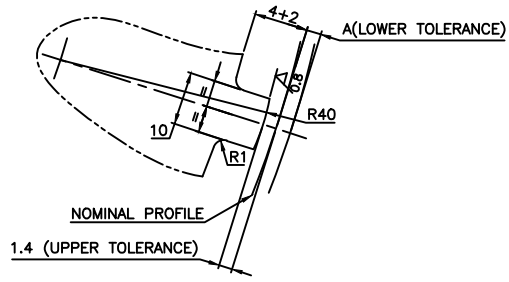
DRAWING No. R8392-1533-1534

1.6/ THE REST



MARK
R8392-1533
SEC. A21-A21
INT. PROFILE
POINTS 1,3,5
800MW.

MARK
R8392-1534
SEC. A21-A21
EXT. PROFILE
POINTS 2,4,6,7
800MW.



SCALE-NTS
DETAIL-'M' FOR ALL POINTS.

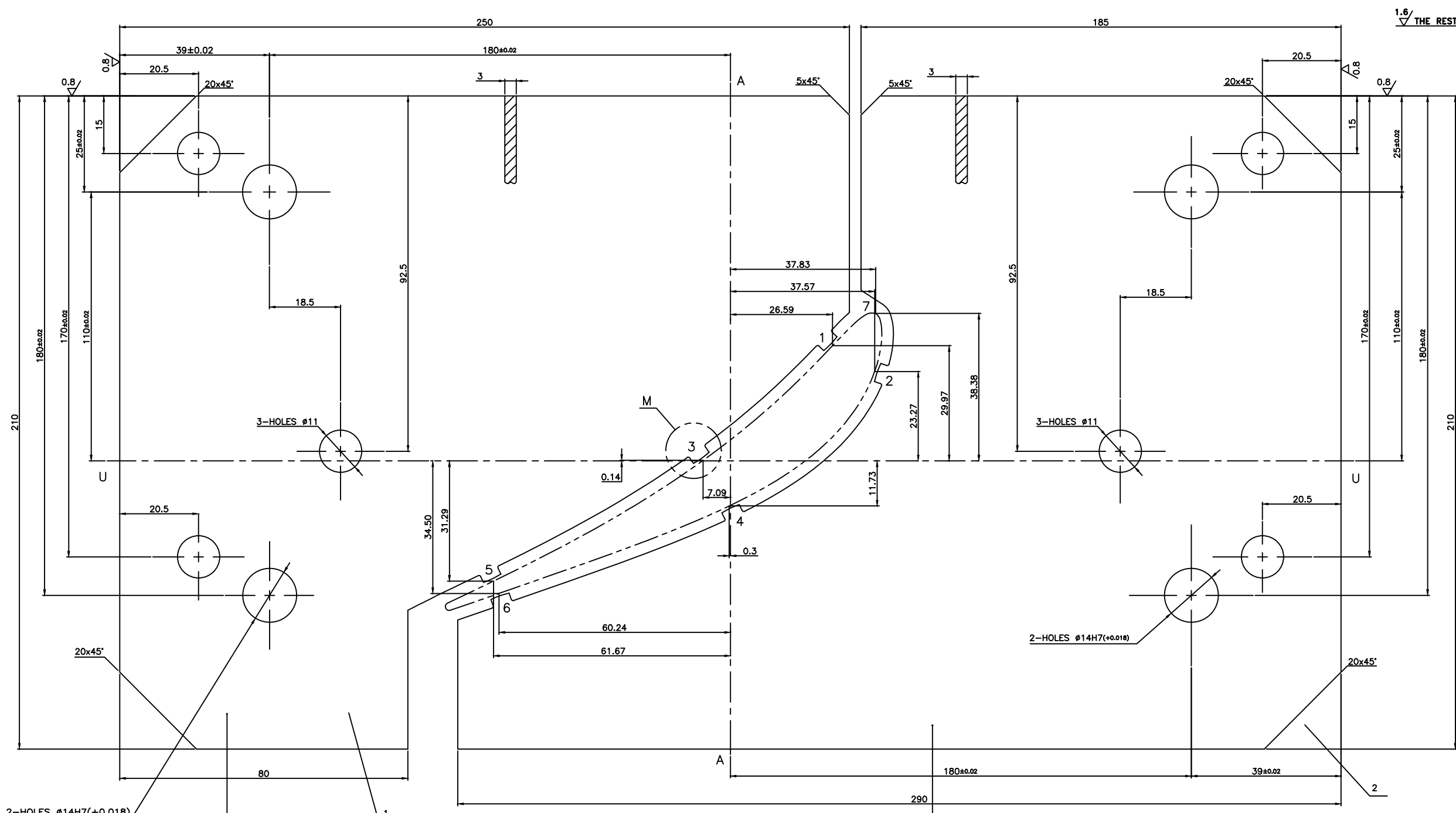
- NOTES:-**
- 1-SHARP EDGES TO BE ROUNDED OFF.
 - *2-THE MAXIMUM TOLERANCE TO BE MARKED ON BOTH SIDES.
 - 3-HARDEN TO HRC 50±55 AS PER P.S.No. 0912.008.
 - 4-TO BE USED WITH BIG VERTICAL STAND.
 - 5-PROFILE DRG. NO. 0-10307-58021.
 - 6-MANUFACTURING ACCURACY OF PROFILE ±0.02.
 - 7-CONSERVATION TO BE DONE AS PER TL 30007.

ITEM NO.	PROFILE POINT	DIMENSION (A)	*MAX.TOLE. (A+1.4)	W./ORDER NO.	DRG.NO.	WEIGHT (kg)
01.	1	0.5	1.9	NBF/2002	R8392-1533	0.66
	3	0.5	1.9			
	5	0.5	1.9			
02.	2	1.4	2.8	NBF/2003	R8392-1534	0.80
	4	1.4	2.8			
	6	1.4	2.8			
	7	0.5	1.9			

VAR.00	REMARKS	ITEM No.	DESCRIPTION	STATUS OF DRG.	DRAWING No.	MATERIAL CODE	UNIT	UNIT WEIGHT	ZONE
		2.	TEMP. EXT. PROFILE		R8392-1534	T90Mn6WCr2	AA10821	1	
		1.	TEMP. INT. PROFILE		R8392-1533	T90Mn6WCr2	AA10821	1	

GMS No./GR.SP.No.	STATUS OF DRG.	TYPE OF PRODUCT	COMP. DRG. No.	M/C TOOL TRANS No.	REF. DRG. No.
		800MW	01030758001-00	3-101	R8732-1461
DESIGN ORDER No.	MODEL No.	BHMEL BHARAT HEAVY ELECTRICALS LTD.			
SEE TABLE	3-101	DRN. DEEPAK -Sd- 25-07-16			
SCALE NTS		CHD RAVI -Sd- 25-07-16			
SEE TABLE		APD ANKUR -Sd- 26-07-16			
REF. TO ASSY. DRG.		DEPT. JTE			
ITEM No. OF ITEM		CODE 209			
TITLE 7 POINT CHECKING TEMPLATE AT SEC A21-A21 (INT. & EXT. PROFILE)		DRAWING No. R8392-1533-1534			
SHEET No. 01		REV. No. OF SHEET 01			

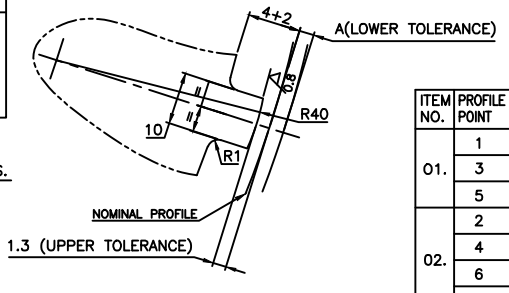
DRAWING No. R8392-1535-1536



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- TECH.REQ:-
- 1-SHARP EDGES TO BE ROUNDED OFF.
 - *2-THE MAXIMUM TOLERANCE TO BE MARKED ON BOTH SIDES.
 - 3-HARDEN TO HRc. 50+55 AS PER P.S. No. 0912.008.
 - 4-TO BE USED WITH BIG VERTICAL STAND.
 - 5-PROFILE DRAWING No. 01030758021.
 - 6-MANUFACTURING ACCURACY OF PROFILE ±0.02.
 - 7-CONSERVATION TO BE DONE AS PER TL-30007.

MARK
R8392-1536
SEC. A15-A15
INT. PROFILE
POINTS 1,3,5
800MW.



ITEM NO.	PROFILE POINT	DIMENSION (A)	*MAX.TOLE. (A+1.3)	W./ORDER NO.	DRG.NO.	WEIGHT (kg)
01.	1	0.4	1.7	NBF/2000	R8392-1536	0.66
	3	0.4	1.7			
	5	0.4	1.7			
02.	2	1.3	2.6	NBF/2001	R8392-1535	0.80
	4	1.3	2.6			
	6	1.3	2.6			
	7	0.4	1.7			

MARK
R8392-1535
SEC. A15-A15
EXT. PROFILE
POINTS 2,4,6,7
800MW.

2.	TEMP. EXT. PROFILE	R8392-1535	T90Mn6WCr2	AA10B21	01		
1.	TEMP. INT. PROFILE	R8392-1536	T90Mn6WCr2	AA10B21	01		
VAR.00	REMARKS	ITEM No.	DESCRIPTION	STD. DRAWING No.	VAR. MATERIAL SPECN.	UNIT WEIGHT	QTY.

GMS No./GR.SP.No.	STATUS OF DRG.	TYPE OF PRODUCT	COMP. DRG. No.	M/C TOOL TRANS No.	REF. DRG. No.
		800MW	01030758001-00	3-101	R8732-1507

APPROVED	NAME	SIGN.	DATE
TBM	ANIL KUMAR	-sd	25-07-16

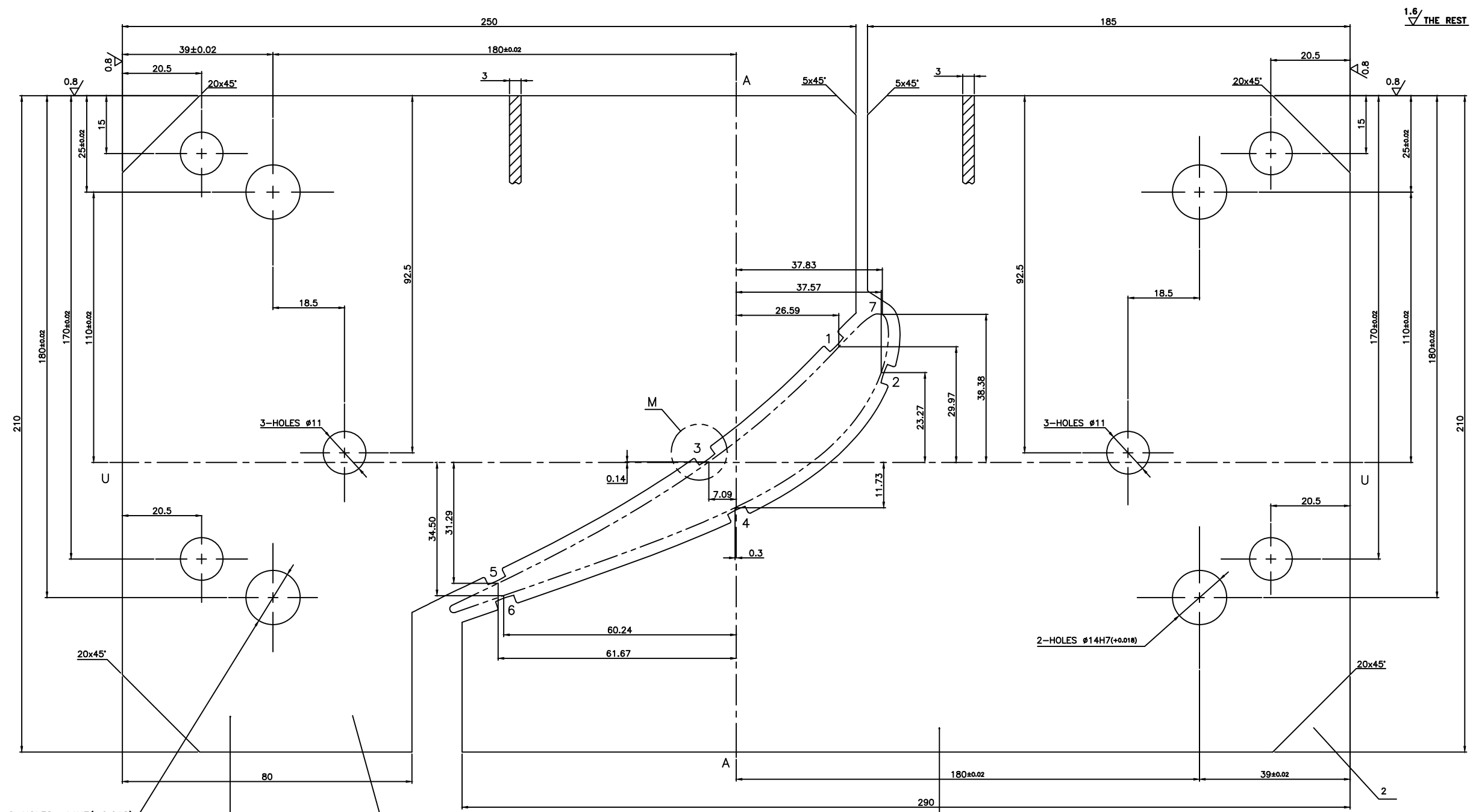
GRADE OF UNTOL.DIM. :-	M/CG-2/M/F AA0230208
WELDING-A/B/C/D-AA0621104	
GAS CUTTING-T3'AA0621101	

DEPT.	JTE	SCALE	WEIGHT(Kg.)	REF. TO ASSY. DRG.	ITEM No.	No. OF ITEM
CODE	209	NTS				

TITLE- 7 POINT CHECKING TEMPLATE AT SEC A15-A15 (INT. & EXT. PROFILE)		DRAWING No. R8392-1535-1536	REV. No. OF SHEET 01
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SCALE-NTS
DETAIL-'M' FOR ALL POINTS.

DRAWING No. R8392-1535-1536

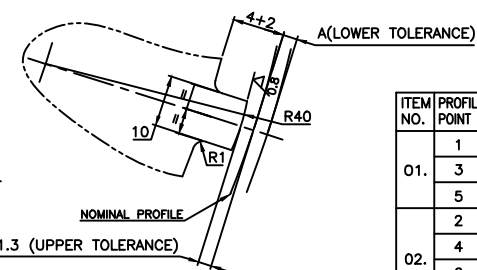


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INVENTORY No. DESIGN. & DATE REF. DRG. No.

- TECH.REQ:-
- 1-SHARP EDGES TO BE ROUNDED OFF.
 - *2-THE MAXIMUM TOLERANCE TO BE MARKED ON BOTH SIDES.
 - 3-HARDEN TO HRC. 50±5 AS PER P.S. No. 0912.008.
 - 4-TO BE USED WITH BIG VERTICAL STAND.
 - 5-PROFILE DRAWING No. 01030758021.
 - 6-MANUFACTURING ACCURACY OF PROFILE ±0.02.
 - 7-CONSERVATION TO BE DONE AS PER TL-30007.

MARK
R8392-1536
SEC. A15-A15
INT. PROFILE
POINTS 1,3,5
800MW.



SCALE-NTS
DETAIL-'M' FOR ALL POINTS.

ITEM NO.	PROFILE POINT	DIMENSION (A)	*MAX.TOLE. (A+1.3)	W./ORDER NO.	DRG.NO.	WEIGHT (kg)
01.	1	0.4	1.7	NBF/2000	R8392-1536	0.66
	3	0.4	1.7			
	5	0.4	1.7			
02.	2	1.3	2.6	NBF/2001	R8392-1535	0.80
	4	1.3	2.6			
	6	1.3	2.6			
	7	0.4	1.7			

MARK
R8392-1535
SEC. A15-A15
EXT. PROFILE
POINTS 2,4,6,7
800MW.

GRADE OF UNTOL.DIM. :-
M/CG-Z/M/F AA0230208
WELDING-A/B/C/D-AA0621104
GAS CUTTING-T3'AA0621101

VAR.00	REMARKS	ITEM No.	DESCRIPTION	DRG. No.	MATERIAL CODE	UNIT WEIGHT	QTY.	ZONE
	2. TEMP. EXT. PROFILE		R8392-1535		T90Mn6WCr2		01	
	1. TEMP. INT. PROFILE		R8392-1536		T90Mn6WCr2		01	

GMS No./GR.SP.No.	STATUS OF DRG.	TYPE OF PRODUCT	COMP. DRG. No.	M/C TOOL TRANS No.	REF. DRG. No.
		800MW	01030758001-00	3-101	R8732-1507

REV.	DATE	ALTERED CHECKED	REV.	DATE	ALTERED CHECKED	DEPT.	JTE	SCALE	WEIGHT(Kg.)	REF. TO ASSY. DRG.	ITEM No.	No. OF ITEM
								NTS				

BHEL BHARAT HEAVY ELECTRICALS LTD.
HARDWAR

DRN. DEEPAK -sd- 25-07-16
CHD RAVI -sd- 25-07-16
APP ANKUR -sd- 26-07-16

TITLE- 7 POINT CHECKING TEMPLATE AT SEC A15-A15 (INT. & EXT. PROFILE)

DRAWING No. R8392-1535-1536
SHEET No. 01 | No. OF SHEET 01
SIZE A 1