

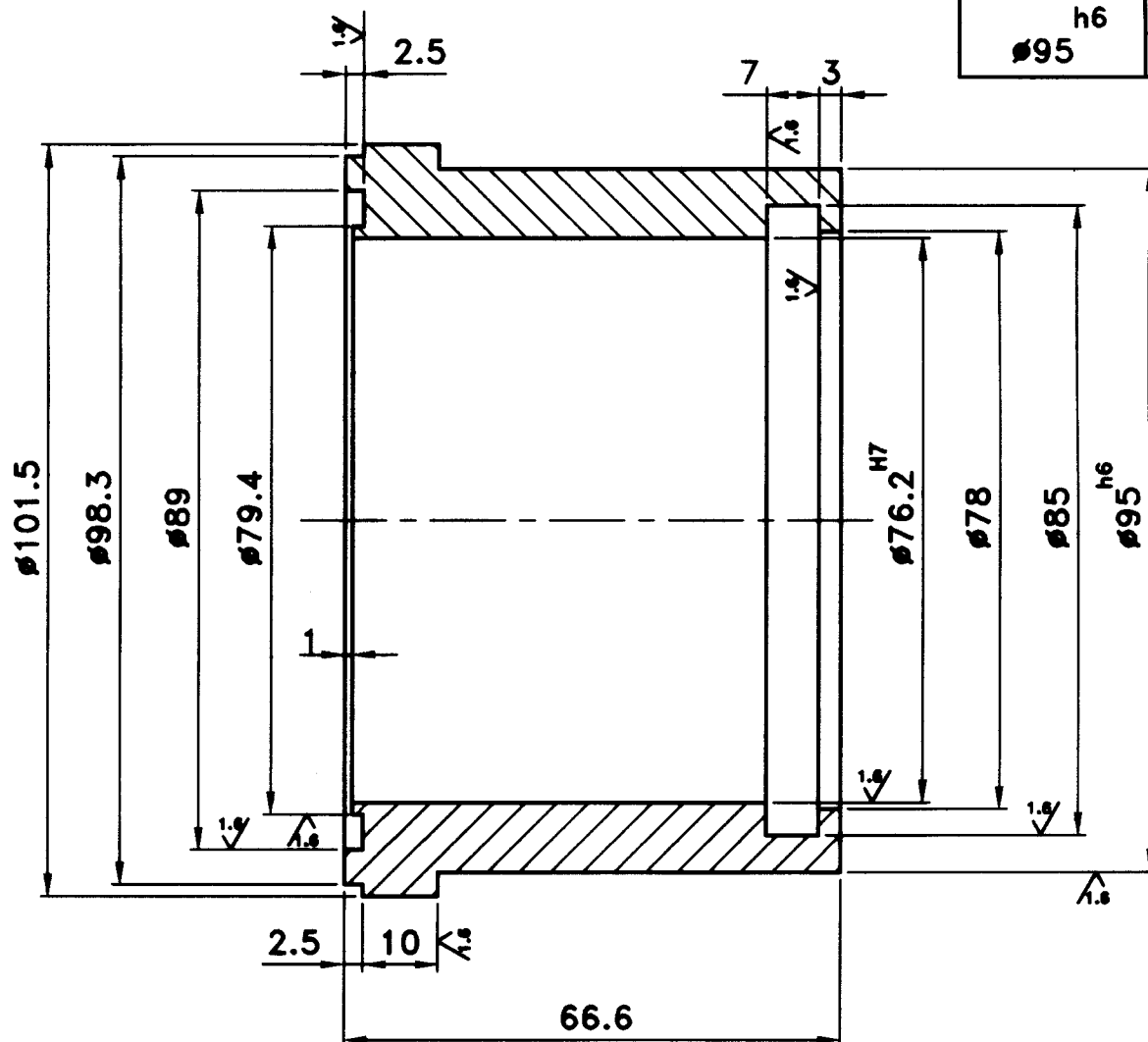
ALL DIMENSIONS ARE IN MM

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

REV	DATE	ALTERED
9		CHECKED
		APPROVED

3.2//1.6//

$\phi 76.2$ H7	+0.030
	0
$\phi 95$ h6	0
	-0.022



NOTE :-

REMOVE SHARP EDGES BY 0.25x45°

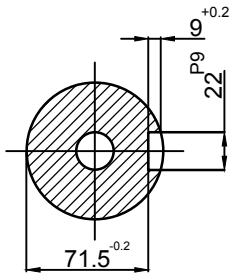
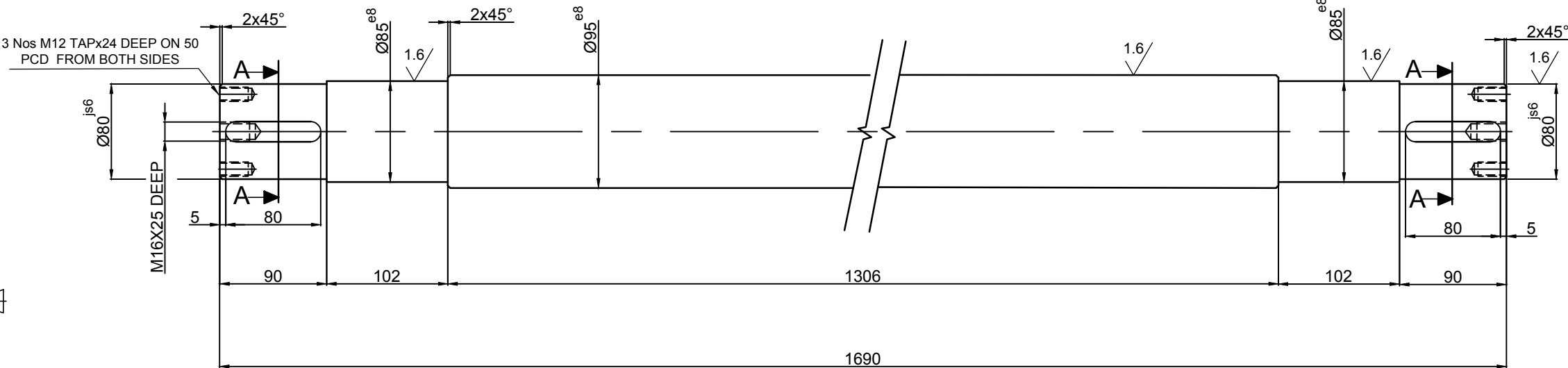
				CIGrFG200 IS:210			
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE		UNIT WT		
			MATL SPEC		QTY		
EQPT: T.F. FROM MBF TO RDF (MANDREL BAR CIRCULATION)							
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME X.M.T.A.SATHEESH	SIGNATURE 	DATE 22.6.99		
		CHD	A.AROCKIAM		8.7.99		
		APPD	S.SHANMUGASUNDARAM		8.7.99		
DEPT MPG	GRADE OF UNTOL DIM C/M/F	SCALE 1:1	WEIGHT (Kg) 1.1	REF TO ASSY DRG		ITEM NO	
CODE				REF TO OLD DRG			
TITLE BUSH-RODEND FOR PNEUMATIC CYLINDER 10"x3"x655 STROKE			CARD CODE U 01	DRAWING NO : 4-7-1144-00-05837			REV 00

ALL DIMENSIONS ARE IN MILLIMETRES

19301-01-1011-2-3
DRAWING NO: ON 10-10361

$\sqrt{Ra\ 3.2}$ $\left(\sqrt{Ra\ 1.6}\right)$

$\varnothing 95^{e8}$	-0.06
	-0.106
$\varnothing 85^{e8}$	-0.06
	-0.106
$\varnothing 80^{js6}$	0.0095
	-0.0095
22 ^{P9}	0.106
	0.032



SECTION A-A

NOTE:
HARDENED & TEMPERED TO 45 HRC

REV	DATE	ALTERED	PPN.Kumar/B.N
01	31.08.18	CHECKED	PPN.Kumar
		APPROVED	D.Abhighna

HARDNESS NOTE ADDED
MATERIAL SPECIFICATION ADDED

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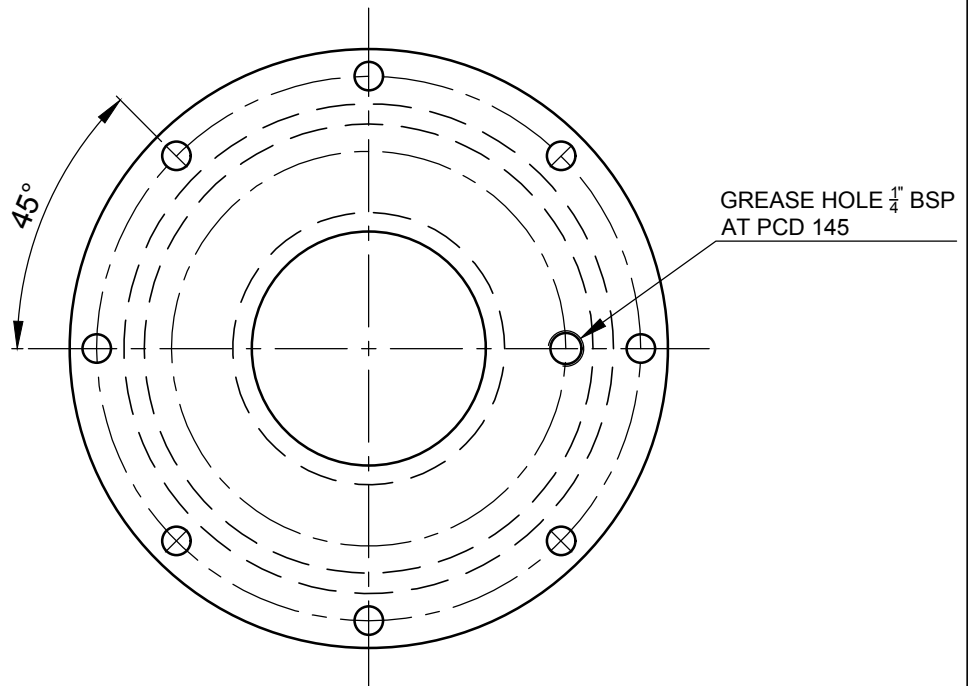
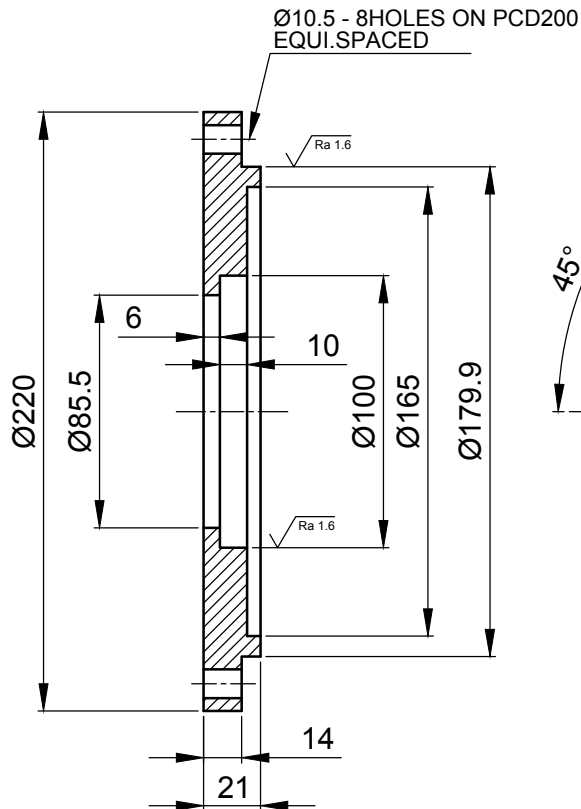
			40Cr1Mo28 IS:1570			
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT		
			MATL SPEC	QTY		
EQPT: ROTARY HEARTH FURNACE						
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI – 620014		DRN	NAME SSN.KUMAR/B.N	SIGNATURE <i>SSN.Kumar/B.N</i>	DATE 18.06.18	
		CHD	D.CHANDRASEKAR	<i>D.Chandrasekar</i>	18.06.18	
		APPD	D.CHANDRASEKAR	<i>D.Chandrasekar</i>	18.06.18	
DEPT SSTP	GRADE OF UNTOL. DIM Ø/M/F IS: 2102		SCALE 1:1	WEIGHT (Kg) 8.61	REF TO ASSY DWG NO	ITEM
CODE 456			REF TO OLD DWG NO			
TITLE RHF - L.T.SHAFT BOOM ASSY			CARD CODE U 01	DRAWING NO : 3-7-1101-10-10361		REV 01

A3-SIZE

ALL DIMENSIONS ARE IN MM

REV 01	DATE 20.11.18	ALTERED <i>S.P.N. Kumar/B.N</i> CHECKED <i>S.P.N. Kumar</i> APPROVED <i>D. Abhighna</i>	REV 02	DATE 24.11.18	ALTERED <i>S.P.N. Kumar/B.N</i> CHECKED <i>S.P.N. Kumar</i> APPROVED <i>D. Abhighna</i>
DRAWING SHAPE WAS CHANGED AS PER USER'S REQUEST			DIMENSION TEXT CLARITY INCREASED		

✓ Ra 3.2 (✓ Ra 1.6)



NOTE :
ALL SHARP CORNERS ARE CHAMFERED TO 0.5x45°
OIL SEAL : (Ø85xØ100x10)

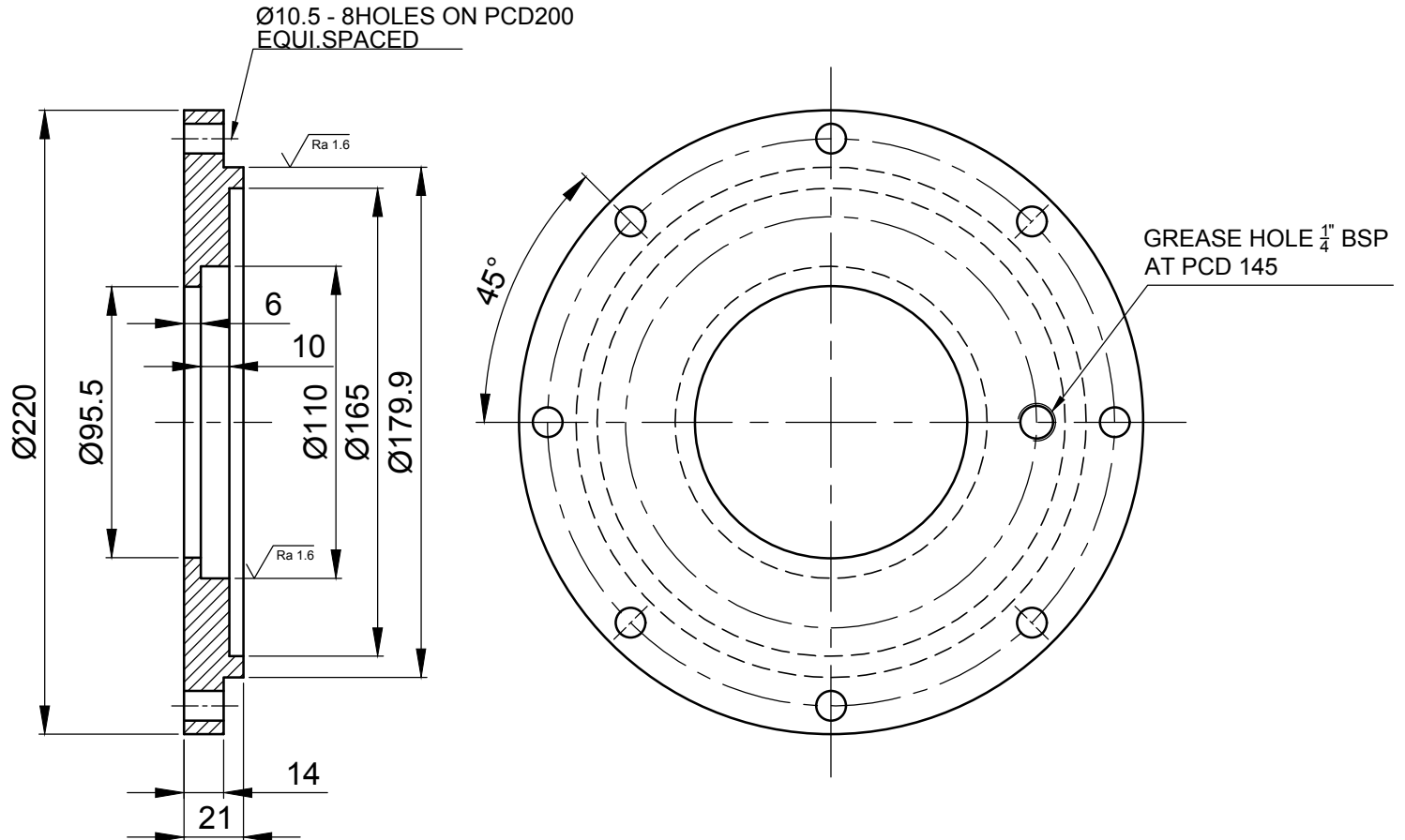
CAUTION: THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

1	PL Ø220x22 IS:1730		E250A IS:2062	4+4 NOS.		
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT		
			MATL SPEC	QTY		
EQPT: ROTARY HEARTH FURNCE						
		Bharat Heavy Electricals Ltd				
		SEAMLESS STEEL TUBE PLANT				
		TIRUCHIRAPALLI – 620014				
		DRN	NAME S.S.N.KUMAR/ K.Nr	SIGNATURE <i>S.P.N. Kumar/ K.Nr</i>	DATE 8-5-15	
		CHD	R.K.SINGH	<i>R.K. Singh</i>	8-5-15	
		APPD	G.LOGANATHAN	<i>G. Loganathan</i>	8-5-15	
DEPT SSTP	GRADE OF UNTOL. DIM		SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO 4-9-1101-10-00116	ITEM -
CODE 456	$\varnothing / M / \sqrt{}$ IS: 2102		1:2.5	3.64	REF TO OLD DWG NO RE/BA/SP/725/4/3	
TITLE RHF-BEARING HOUSING COVER CH. & DIS CH. M/C ASSY.				CARD CODE U 01	DRAWING NO : 4-7-1101-10-10399	REV 02

ALL DIMENSIONS ARE IN MM

REV 01	DATE 20.11.18	ALTERED <i>P.N.Kumar/B.N</i> CHECKED <i>P.N.Kumar</i> APPROVED <i>D.Abhighna</i>	REV 02	DATE 24.11.18	ALTERED <i>P.N.Kumar/B.N</i> CHECKED <i>P.N.Kumar</i> APPROVED <i>D.Abhighna</i>
DRAWING SHAPE WAS CHANGED AS PER USER'S REQUEST			DIMENSION TEXT CLARITY INCREASED		

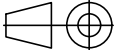
✓ Ra 3.2 (✓ Ra 1.6)



NOTE :

ALL SHARP CORNERS ARE CHAMFERED TO 0.5x45°
OIL SEAL : (Ø95xØ110x10)

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.

1	PL Ø220x22 IS:1730		E250A IS:2062	4+4 NOS.			
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT			
			MATL SPEC	QTY			
EQPT: ROTARY HEARTH FURNCE							
		Bharat Heavy Electricals Ltd					
		SEAMLESS STEEL TUBE PLANT					
		TIRUCHIRAPALLI – 620014					
		DRN	NAME S.S.N.KUMAR/ K.Nr	SIGNATURE <i>S.S.N.Kumar/ K.Nr</i>	DATE 8-5-15		
		CHD	R.K.SINGH	<i>R.K. Singh</i>	8-5-15		
		APPD	G.LOGANATHAN	<i>G.Loganathan</i>	8-5-15		
DEPT SSTP	GRADE OF UNTOL. DIM			SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO 4-9-1101-10-00116	ITEM -
CODE 456	Ø/√/F IS: 2102			1:2.5	3.48	REF TO OLD DWG NO RE/BA/SP/725/4/3	
TITLE RHF-BEARING HOUSING COVER CH. & DIS CH.M/C ASSY.					CARD CODE U 01	DRAWING NO : 4-7-1101-10-10400	REV 02

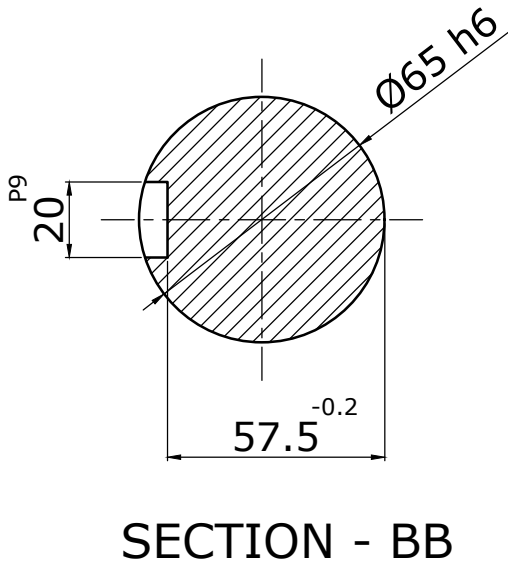
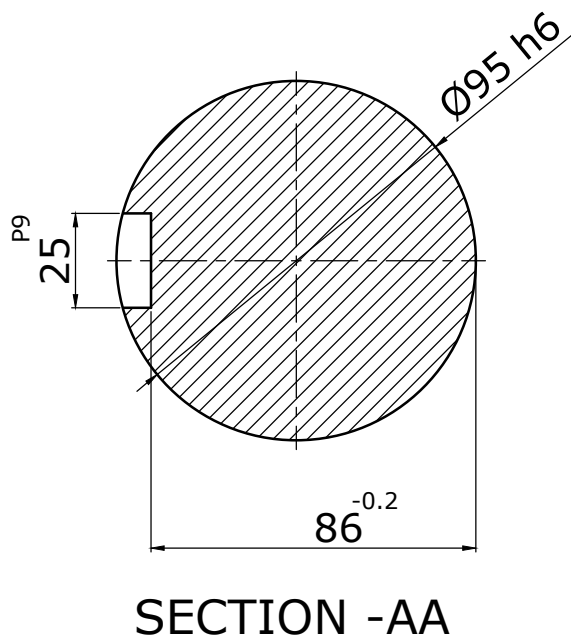
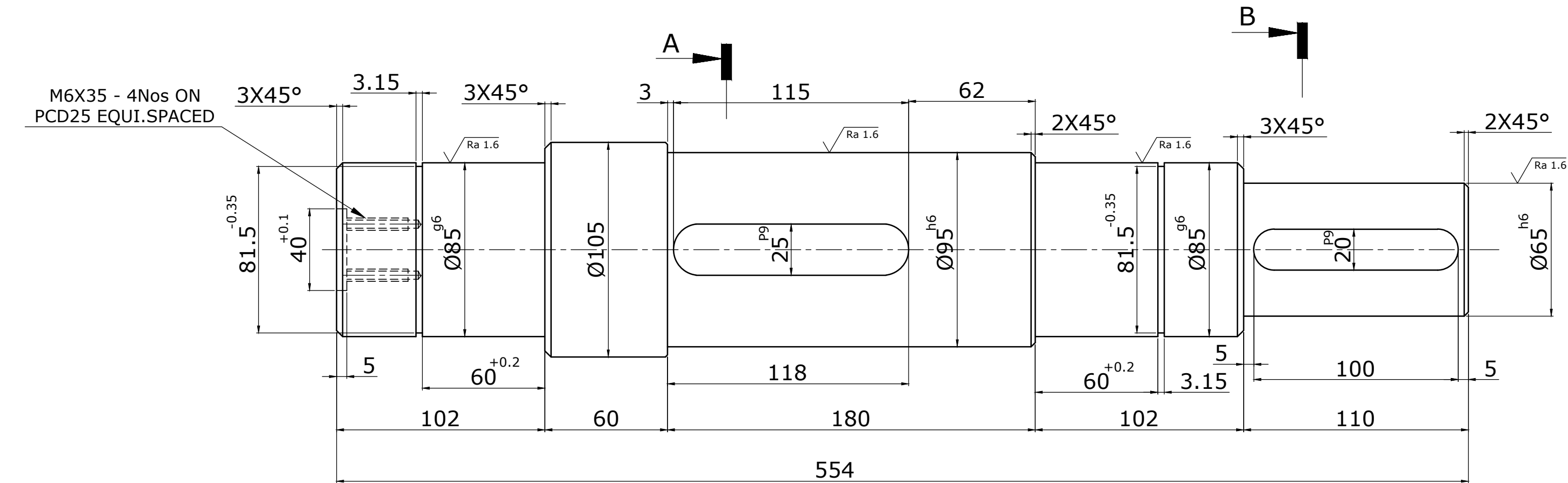
A4-SIZE

2-7-1101-1011-2-2

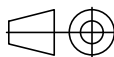
ALL DIMENSIONS ARE IN MILLIMETERS

Ra 3.2 (Ra 1.6)

SIZE	DEVIATION
$\text{Ø}85^{\text{g}6}$	-0.012 -0.034
$\text{Ø}95^{\text{h}6}$	-0.000 -0.022
$\text{Ø}65^{\text{h}6}$	-0.000 -0.019
$\text{p}9_{25}$	-0.022 -0.074
$\text{p}9_{20}$	-0.022 -0.074



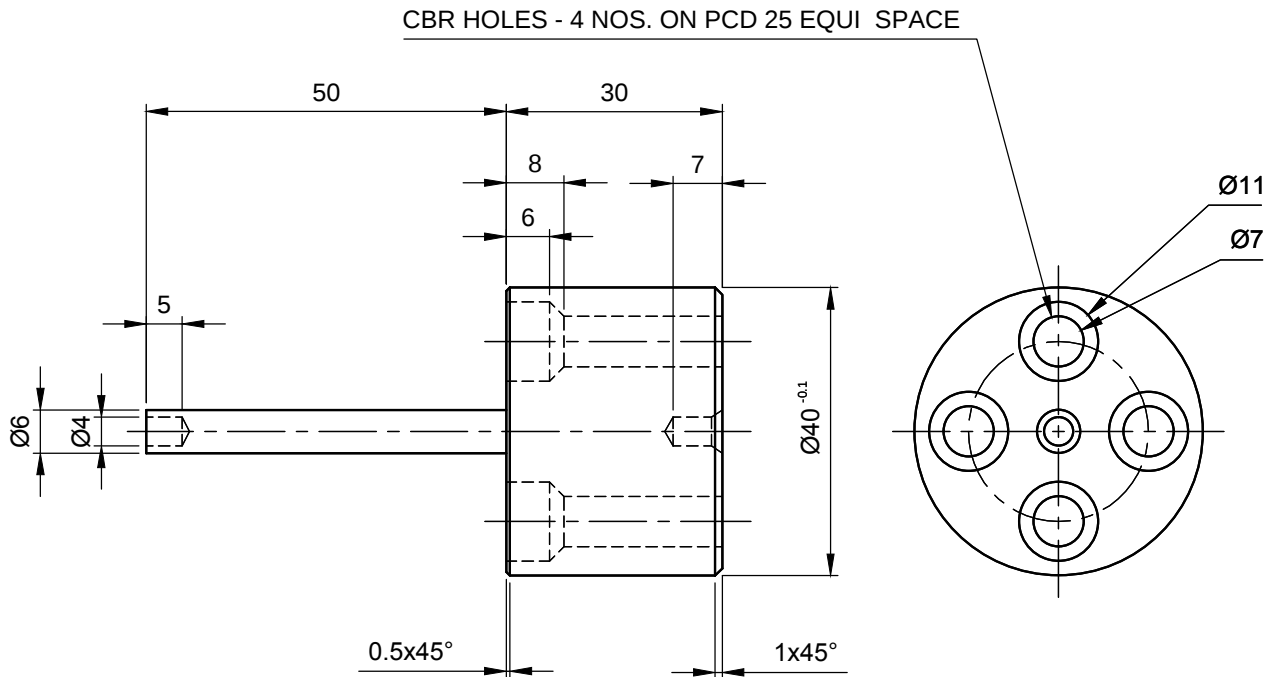
NOTE: 1. ALL SHARP CORNERS CHAMFERED TO 1X45°

ITEM NO	DESCRIPTION	DRAWING NO	40Cr1Mo28 IS:1570				
			MATL CODE	UNIT WT			
			MATL SPEC	QTY			
EQPT: ROTARY HEARTH FURNACE							
	Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI – 620014		DRN	NAME SSN.KUMAR/B.N	SIGNATURE <i>SSN.Kumar/B.N</i>	DATE 15.11.18	
			CHD	SSN.KUMAR	<i>SSN.Kumar</i>	15.11.18	
			APPD	D.ABHIGHNA	<i>D.Abhighna</i>	15.11.18	
DEPT SSTP	GRADE OF UNTOL. DIM $\phi/M/F$ IS: 2102		SCALE NTS	WEIGHT (Kg) –	REF TO ASSY DWG NO		ITEM
CODE 456					REF TO OLD DWG NO 4–9–1101–10–00115, RE/BA/SP/725/3/3		
TITLE RHF - PINION SHAFT BOOM ASSY.			CARD CODE U 01	DRAWING NO : 2-7-1101-10-10163		REV 00	

REV 01	DATE	ALTERED CHECKED APPROVED
-----------	------	--------------------------------

ALL DIMENSIONS ARE IN MM

REV 01	DATE	ALTERED
		CHECKED
		APPROVED



NOTES :

- 1.HARDENED AND TEMPERED TO 40 HRC
2. BEARING NO - 22317 (Ø180xØ85x60)

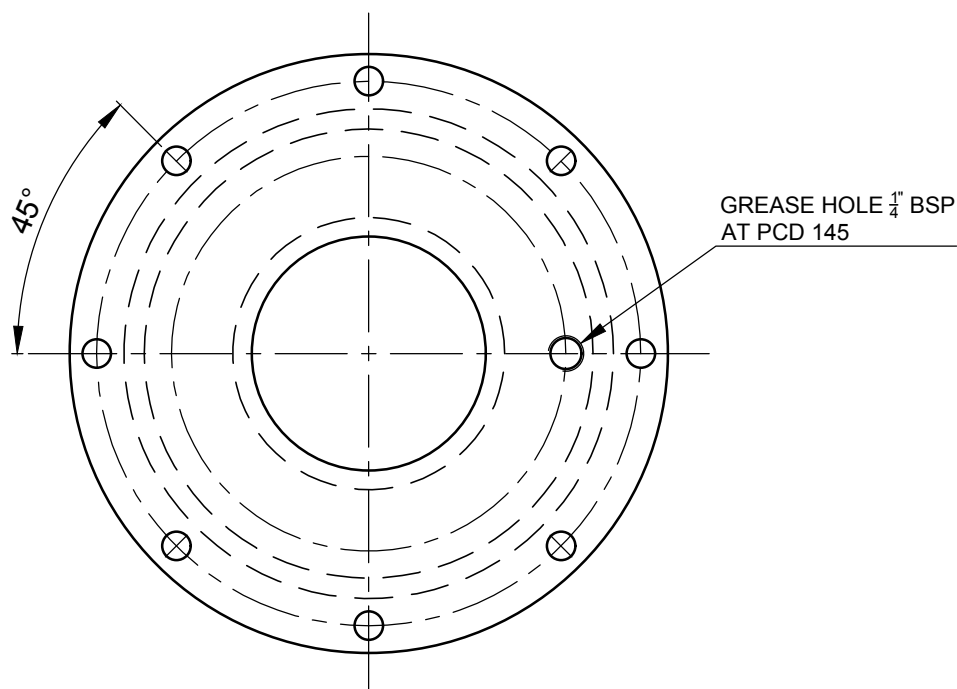
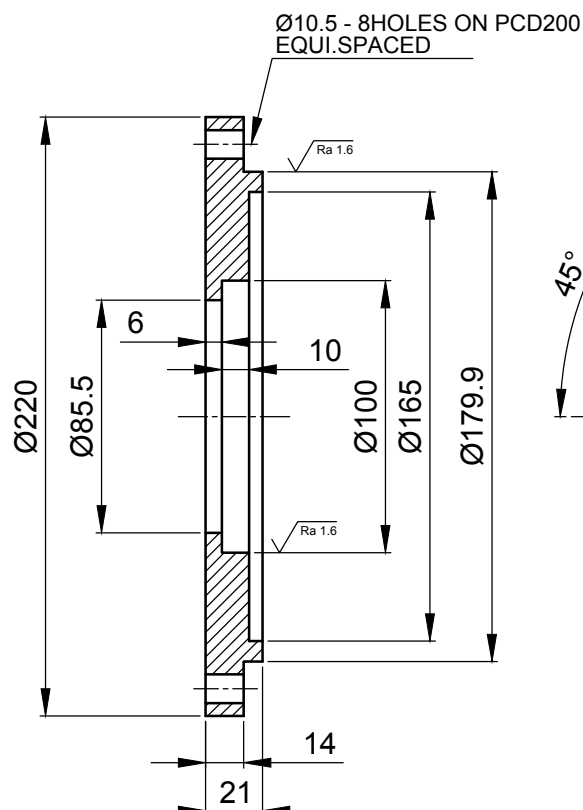
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			EN 19				
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT			
			MATL SPEC	QTY			
EQPT: ROTARY HEARTH FURNACE							
	Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI — 620014		DRN	NAME SSN.KUMAR/YS.M	SIGNATURE <i>SSN.Kumar/ys.m</i>	DATE 15.12.15	
			CHD	R.K.SINGH	<i>R.K.Singh</i>	15.12.15	
			APPD	R.K.SINGH	<i>R.K.Singh</i>	15.12.15	
DEPT SSTP	GRADE OF UNTOL. DIM Ø/M/F IS: 2102		SCALE 1:1	WEIGHT (Kg) 0.250	REF TO ASSY DWG NO —		ITEM —
CODE 456					REF TO OLD DWG NO RE/BA/SP/725/3/3		
TITLE RHF - ADAPTER FOR PINION SHAFT BOOM ASSY.				CARD CODE U 01	DRAWING NO : 4-7-1101-10-10420		REV 00

ALL DIMENSIONS ARE IN MM

REV 01	DATE 20.11.18	ALTERED <i>S.P.N. Kumar/B.N</i> CHECKED <i>S.P.N. Kumar</i> APPROVED <i>D. Abhighna</i>	REV 02	DATE 24.11.18	ALTERED <i>S.P.N. Kumar/B.N</i> CHECKED <i>S.P.N. Kumar</i> APPROVED <i>D. Abhighna</i>
DRAWING SHAPE WAS CHANGED AS PER USER'S REQUEST			DIMENSION TEXT CLARITY INCREASED		

✓ Ra 3.2 (✓ Ra 1.6)



NOTE :

ALL SHARP CORNERS ARE CHAMFERED TO 0.5x45°

OIL SEAL : (Ø85xØ100x10)

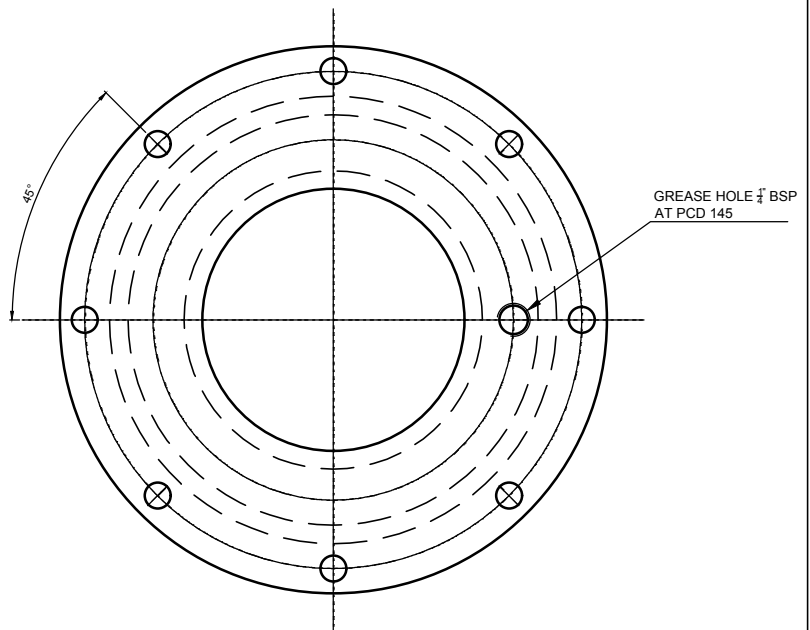
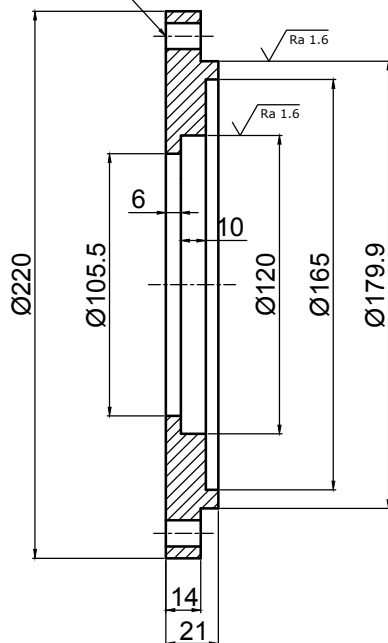
CAUTION: THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED.IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

1	PL Ø220x22 IS:1730		E250A IS:2062	4+4 NOS.		
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT		
			MATL SPEC	QTY		
EQPT: ROTARY HEARTH FURNCE						
		Bharat Heavy Electricals Ltd				
		SEAMLESS STEEL TUBE PLANT				
		TIRUCHIRAPALLI – 620014				
		DRN	NAME S.S.N.KUMAR/ K.Nr	SIGNATURE <i>S.P.N.Kumar/ K.Nr</i>	DATE 8-5-15	
		CHD	R.K.SINGH	<i>R.K. Singh</i>	8-5-15	
		APPD	G.LOGANATHAN	<i>G.Loganathan</i>	8-5-15	
DEPT SSTP	GRADE OF UNTOL. DIM		SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO 4-9-1101-10-00116	ITEM -
CODE	Ø/M/√ IS: 2102		1:2.5	3.64	REF TO OLD DWG NO RE/BA/SP/725/4/3	
456						
TITLE RHF-BEARING HOUSING COVER CH. & DIS CH. M/C ASSY.				CARD CODE U 01	DRAWING NO : 4-7-1101-10-10399	REV 02

ALL DIMENSIONS ARE IN MM

REV 01	DATE	ALTERED
		CHECKED
		APPROVED

Ø10.5 - 8HOLES ON PCD200
EQUI.SPACED

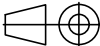


NOTE :

ALL SHARP CORNERS ARE CHAMFERED TO 0.5x45°

OIL SEAL : (Ø105.5xØ120x10)

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1	PL Ø220x22 IS:1730			E250A IS:2062		2+2 NOS.	
	ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE		UNIT WT	
				MATL SPEC		QTY	
EQPT: ROTARY HEARTH FURNCE							
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI – 620014			DRN	NAME S.S.N.KUMAR/ B.N	SIGNATURE <i>S.S.N.Kumar/ B.N</i>	DATE 20.11.18	
			CHD	SSN.KUMAR	<i>SSN.Kumar</i>	20.11.18	
			APPD	D.ABHIGHNA	<i>D.Abhighna</i>	20.11.18	
DEPT SSTP	GRADE OF UNTOL. DIM $\phi / M / f$ IS: 2102		SCALE	WEIGHT (Kg) 3.64	REF TO ASSY DWG NO		ITEM —
CODE 456			1:2.5		REF TO OLD DWG NO		
TITLE RHF - COVERS FOR PINION ASSY.				CARD CODE U 01	DRAWING NO : 4-7-1101-10-10448		REV 00

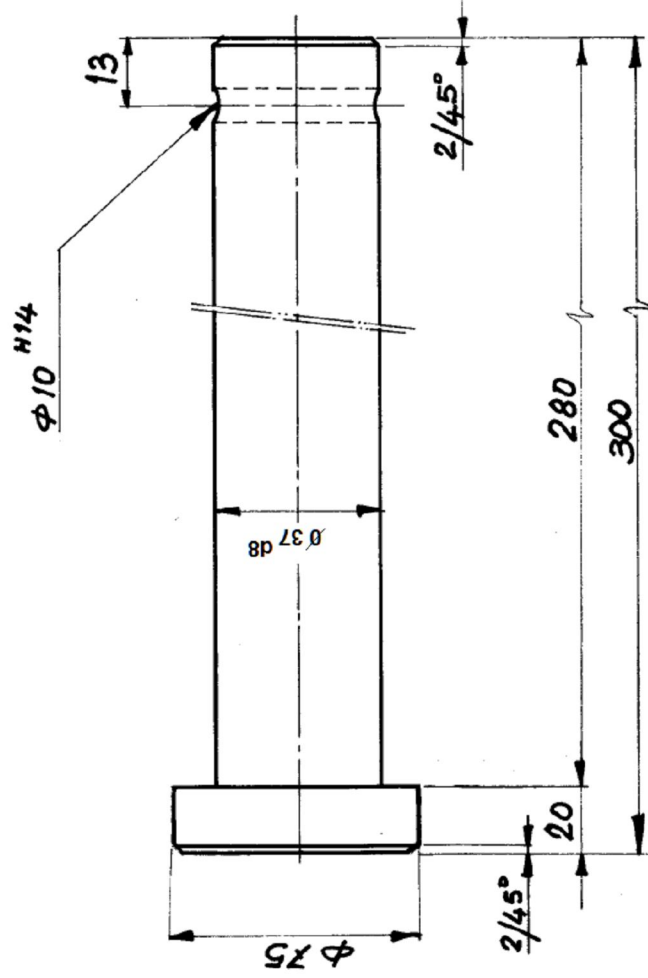
A4-SIZE

FIRST ANGLE PROJECTION (ALL DIMENSIONS IN MILLIMETRES)

REV.	DATE	ALTERED	BY
01	6-4-91	CHECKED	S. Narayan
ZONE	DIMENSIONS 300 AND 20 WERE 290 AND 10 RESPECTIVELY.		

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.

H14	+0,360
$\phi 10$	0,0
$\emptyset 37$ d8	-0,119
	-0,080



ITEM NO.	DESCRIPTION	AISI 304	STAINLESS STEEL	UNIT WT.	QTY.

EQPT: ROTARY HEARTH FURNACE



Bharat Heavy Electricals Ltd.,
SEAMLESS STEEL TUBE PLANT
TIRUCHIRAPALLI-620 014

DRN	NAME	SIGN	DATE
CHR	S. Narayan	S. Narayan	24-4-87
APPD	A. Arackiam	A. Arackiam	21-5-87
			22-05-87

DEPT.	GRADE OF UNFOLDING	SCALE	WEIGHT (KG)
CODE	Q/M/J	1:2	5,-

REF. TO ASSY/OLD DRG.	ITEM NO.
0-7-1101-10-00559	12

TITLE

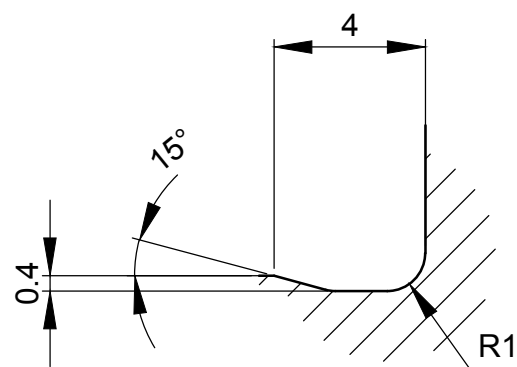
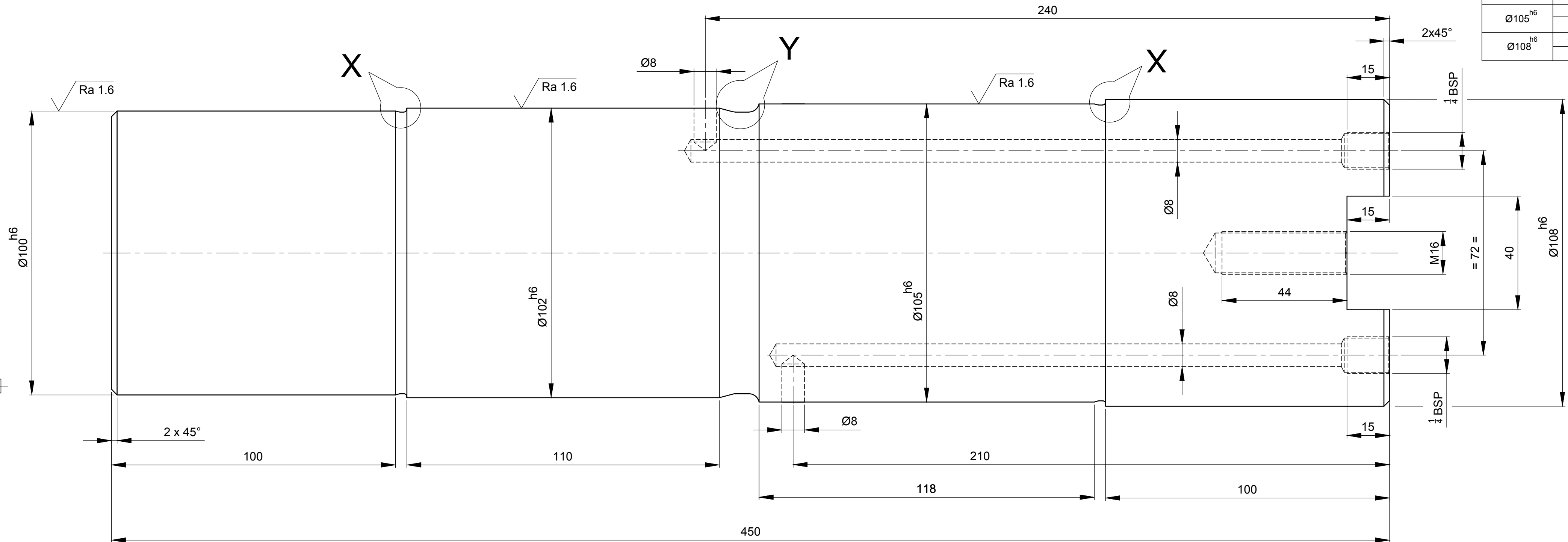
CARD CODE

REV.

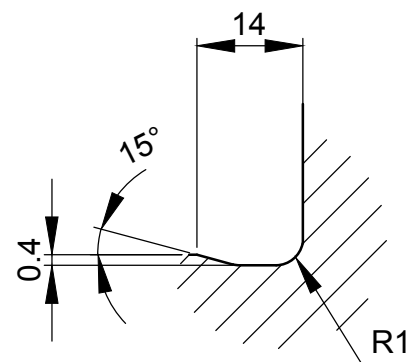
PIN $\phi 50 \times 300L$.
CHARGING & DISCHARGING M/C ASSY

DRAWING NO.
4-7-1101-10-03444 01

SIZE	DEVIATION
Ø100 ^{h6}	-0.000
	-0.022
Ø102 ^{h6}	-0.000
	-0.022
Ø105 ^{h6}	-0.000
	-0.022
Ø108 ^{h6}	-0.000
	-0.022



DETAIL - X

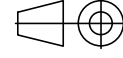


DETAIL - Y

NOTES:

- 1.ALL SHARP CORNERS CHAMFERED TO 0.5x45°
- 2.TEMPERING RANGE 150-200°C

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.

					17Mn1Cr95	IS:1570	
ITEM NO	DESCRIPTION	DRAWING NO			MATL CODE	UNIT WT	
					MATL SPEC	QTY	
EQPT: CROSS PIERCING AND ELONGATION							
	Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI – 620014		DRN	NAME SSN.KUMAR/B.N	SIGNATURE <i>SSN.Kumar/B.N</i>	DATE 10.07.18	
			CHD	D.CHANDRASEKARAN	<i>D. Chandrasekaran</i>	10.07.18	
			APPD	D.CHANDRASEKARAN	<i>D. Chandrasekaran</i>	10.07.18	
DEPT SSTP	GRADE OF UNTOL DIM $\phi/M/\#$ IS: 2102		SCALE 1:1,5:1	WEIGHT (Kg) 27.38	REF TO ASSY DWG NO		ITEM
CODE 456					REF TO OLD DWG NO 0101056-42.000		31
TITLE CPE - SHAFT 3 ROLLER GUIDE				CARD CODE U 01	DRAWING NO : 2-7-1123-42-10155		REV 01

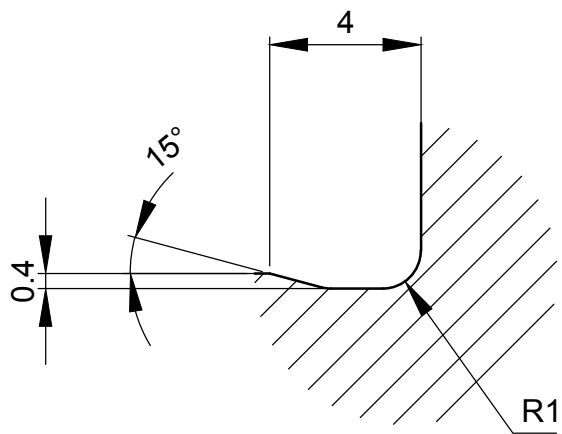
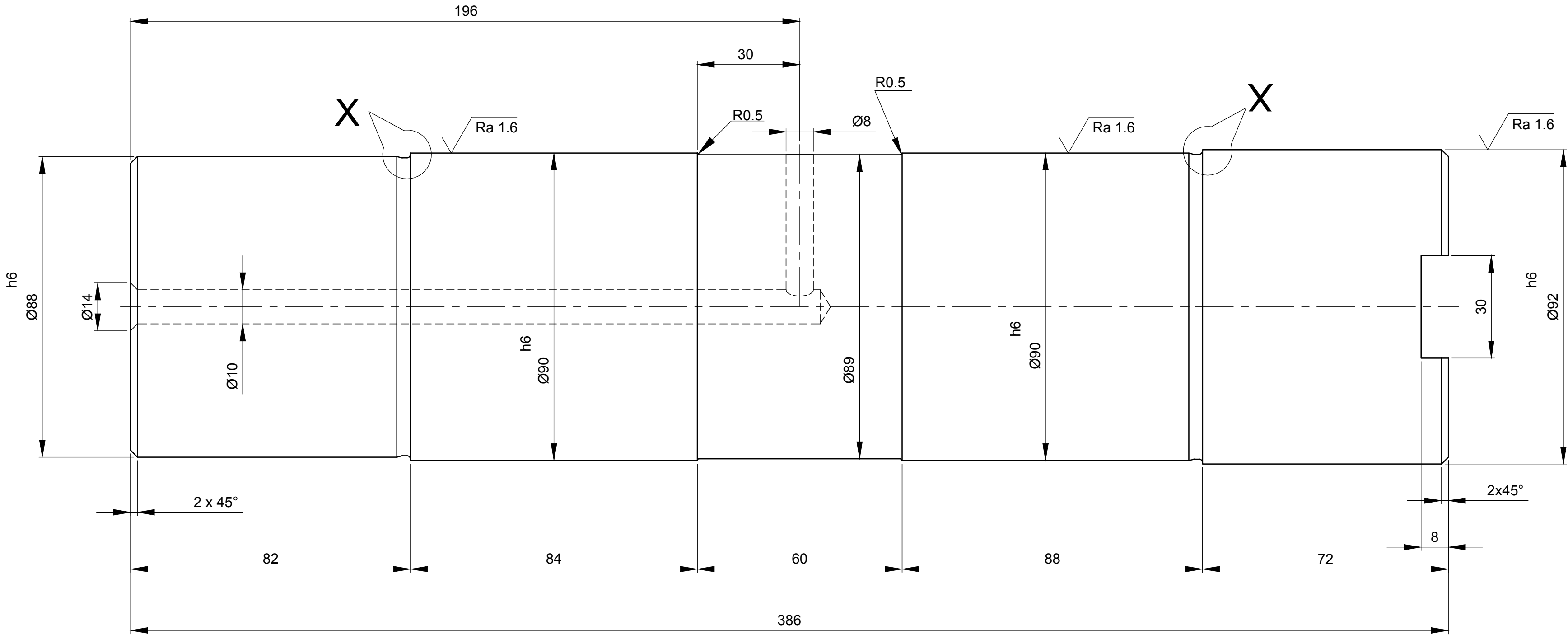
REV 01	DATE 07.12.18	ALTERED CHECKED APPROVED	<i>S.N. Kumar / B.N</i> <i>S.N. Kumar</i> <i>D. Abhigna</i>
MISSING DIMENSIONS ARE ADDED. MATERIAL SPECIFICATION 17Mn1Cr95 IS:1570 WAS 45C8 IS:1875 REVISED AS PER USER'S REQUEST.			

DRAWING NO.: 2-7-1123-42-10156

ALL DIMENSIONS ARE IN MILLIMETERS

$\sqrt{Ra\ 3.2} \left(\sqrt{Ra\ 1.6} \right)$

Ø88 ^{h6}	0
	-0.019
Ø90 ^{h6}	0
	-0.019
Ø92 ^{h6}	0
	-0.019



DETAIL - X

- NOTES:
- 1.ALL SHARP CORNERS CHAMFERED TO 0.5x45°
 - 2.TEMPERING RANGE 150-200°C

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.

						17Mn1Cr95	IS:1570	
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE				UNIT WT	
			MATL SPEC				QTY	
EQPT: CROSS PIERCING AND ELONGATION								
		Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI – 620014		DRN	NAME SSN.KUMAR/B.N	SIGNATURE <i>SSN.Kumar/B.N</i>	DATE 10.07.18	
				CHD	D.CHANDRASEKARAN	<i>D. Chandrasekaran</i>	10.07.18	
				APPD	D.CHANDRASEKARAN	<i>D. Chandrasekaran</i>	10.07.18	
DEPT SSTP	GRADE OF UNTOL. DIM <i>φ/M/#</i> IS: 2102		SCALE 1:1	WEIGHT (Kg) 16.11	REF TO ASSY DWG NO		ITEM	
CODE 456					REF TO OLD DWG NO 0101056-42.000		32	
TITLE CPE - SHAFT 3 ROLLER GUIDE				CARD CODE U 01	DRAWING NO : 2-7-1123-42-10156		REV 01	

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Bharat Heavy Electricals Ltd
SEAMLESS STEEL TUBE PLANT
TIRUCHIRAPALLI - 620014

DRN	NAME SSN.KUMAR/B.N	SIGNATURE SSN.Kumar/B.N	DATE 10.07.18
CHD	D.CHANDRASEKARAN	D. Chandrasekaran	10.07.18
APPD	D.CHANDRASEKARAN	D. Chandrasekaran	10.07.18

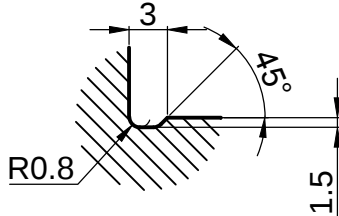
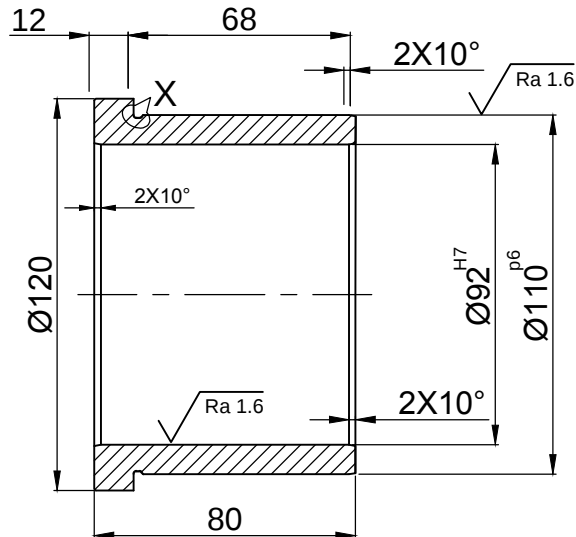
REF TO ASSY DWG NO	ITEM
REF TO OLD DWG NO	0101056-42.000

ALL DIMENSIONS ARE IN MM

REV 01	DATE	ALTERED
		CHECKED
		APPROVED

$\sqrt{Ra\ 3.2}$ ($\sqrt{Ra\ 1.6}$)

$\varnothing 110^{p6}$	+0.059
	+0.037
$\varnothing 92^{H7}$	+0.035
	0



DETAIL - X

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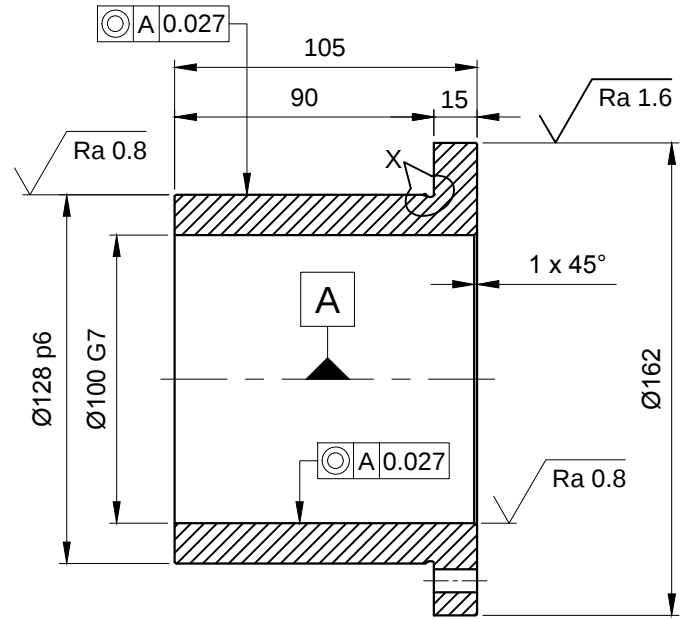
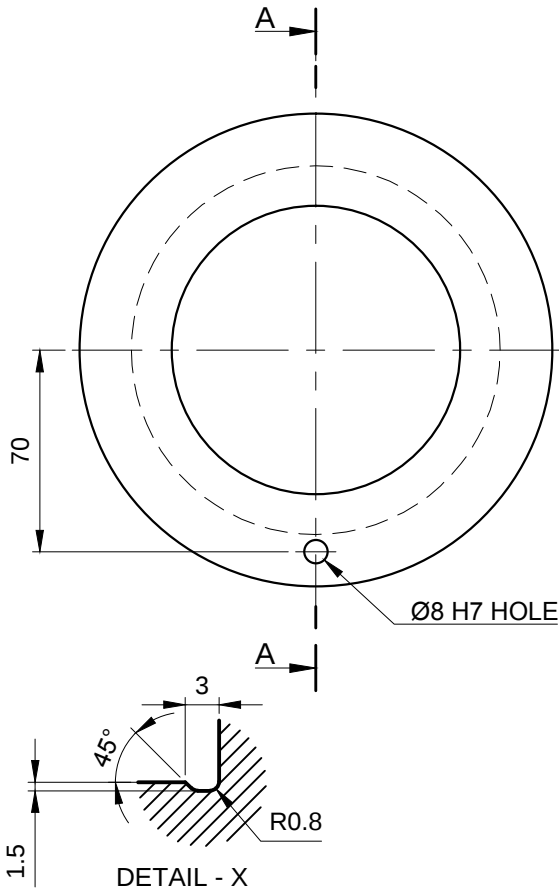
ITEM NO	DESCRIPTION	DRAWING NO	45C8		IS:1875			
			MATL CODE		UNIT WT			
			MATL SPEC		QTY			
EQPT: CROSS PIERCING AND ELONGATION								
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014			DRN	NAME SSN.KUMAR /B.N	SIGNATURE <i>S.S.N. Kumar /B.N</i>	DATE 10.07.18		
			CHD	D.CHANDRASEKARAN	<i>D. Chandrasekaran</i>	10.07.18		
			APPD	D.CHANDRASEKARAN	<i>D. Chandrasekaran</i>	10.07.18		
DEPT SSTP	GRADE OF UNTOL. DIM		SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO 0101056-42.000			
CODE 456	$\phi / M / \#$ IS: 2102		1:2	1.93	REF TO OLD DWG NO			
TITLE CPE - COLLAR BUSH 3-ROLLER GUIDE				CARD CODE U 01	DRAWING NO : 4-7-1123-42-10443	REV 00		

ALL DIMENSIONS ARE IN MM

REV	DATE	ALTERED
01		CHECKED
		APPROVED

√ Ra 3.2 (√ Ra 1.6 √ Ra 0.8)

SIZE	DEVIATION
Ø128 ^{p6}	+0.068 +0.043
Ø100 ^{G7}	+0.047 +0.012
Ø8 ^{H7}	+0.015 0.000



SECTION - AA

NOTE:

1. ALL UNSPECIFIED CHAMFERS TO 0.5 X 45°.
2. MATERIAL: 42CrMo4+QT (QUENCHED & TEMPERED)

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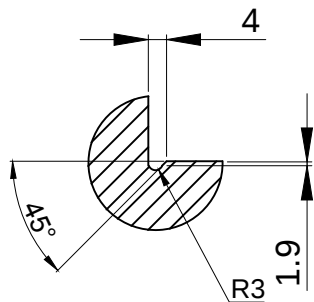
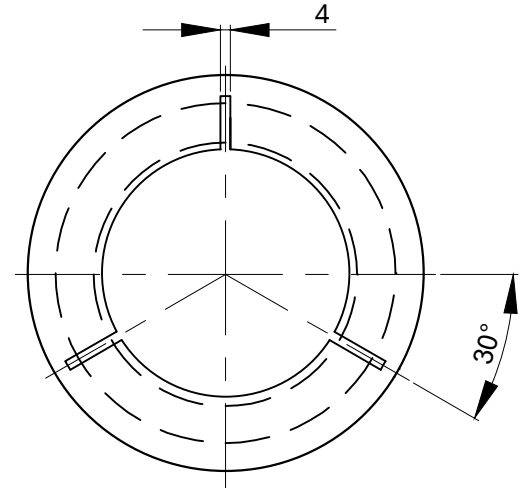
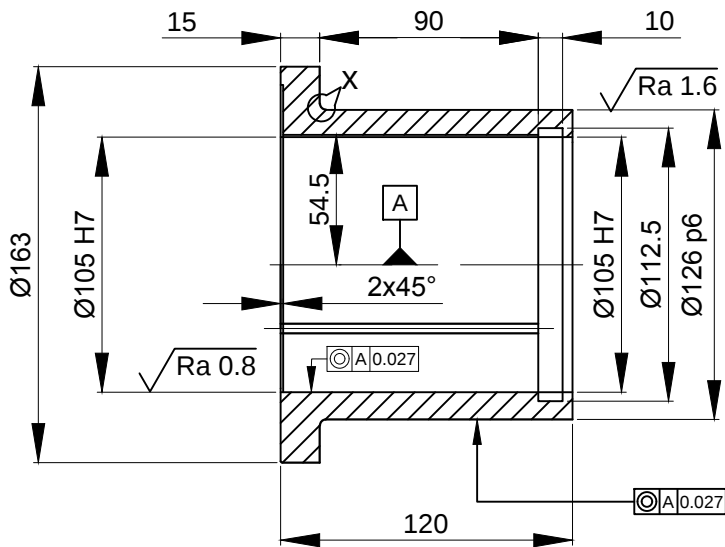
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT
			MATL SPEC	QTY
EQPT: CROSS PIERCING AND ELONGATION				
		Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		
DEPT	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO
SSTP	✓ φ/M/¢ IS: 2102	1:2.5	5.0	0101056-42.000
CODE				REF TO OLD DWG NO
456				
TITLE			DRAWING NO :	REV
CPE - COLLAR BUSH			4-7-1123-42-10444	00
3-ROLLER GUIDE				
CARD CODE				
U 01				

ALL DIMENSIONS ARE IN MM

REV	DATE	ALTERED
01		CHECKED
		APPROVED

$$\sqrt{Ra\ 3.2} \left(\sqrt{Ra\ 1.6} \sqrt{Ra\ 0.8} \right)$$

$\varnothing 105^{H7}$	+0.035
	0.000
$\varnothing 126^{p6}$	+0.068
	+0.043

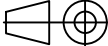


DETAILS X

NOTE :

1. ALL UNSPECIFIED CHAMFERS TO 0.5X45°
2. CASTING SHOULD BE FREE FROM HARMFUL INCLUSION & CRACKS

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.

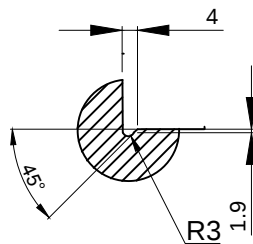
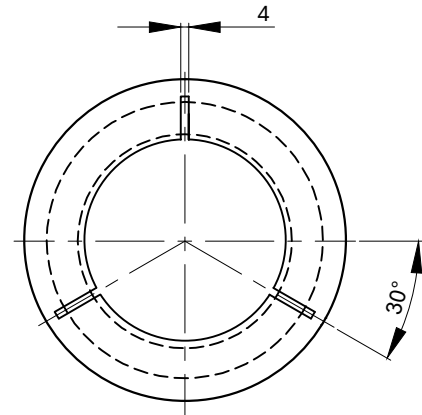
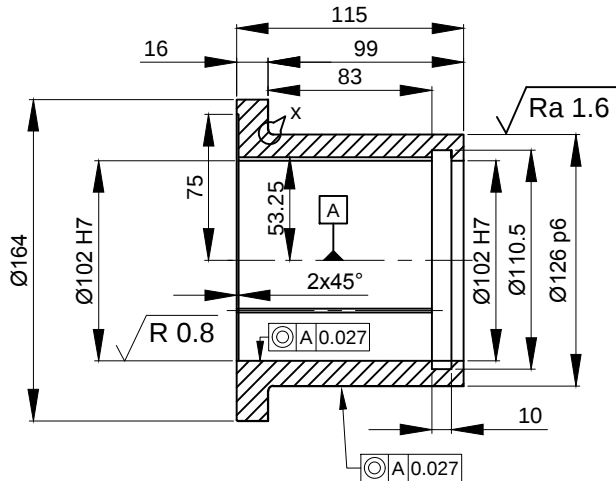
			GZ-CuSn12			
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE		UNIT WT	
			MATL SPEC		QTY	
EQPT: CROSS PIERCING AND ELONGATION						
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI – 620014		DRN	NAME S.S.N.KUMAR/B.N	SIGNATURE <i>S.S.N.Kumar/B.N</i>	DATE 30.06.18	
		CHD	D.CHANDRASEKAR	<i>D. Chandrasekar</i>	30.06.18	
		APPD	D.CHANDRASEKAR	<i>D. Chandrasekar</i>	30.06.18	
DEPT SSTP	GRADE OF UNTOL. DIM  IS: 2102	SCALE 1:2	WEIGHT (Kg) 4.3	REF TO ASSY DWG NO		ITEM
CODE 456				REF TO OLD DWG NO 0101056-42-000-03		60
TITLE CPE-COLLAR BUSH 3-ROLLER GUIDE-1			CARD CODE U 01	DRAWING NO : 4-7-1123-42-10441		REV 00

ALL DIMENSIONS ARE IN MM

REV	DATE	ALTERED
01		CHECKED
		APPROVED

$$\sqrt{Ra\ 3.2} \left(\sqrt{Ra\ 1.6} \sqrt{Ra\ 0.8} \right)$$

$\varnothing 102^{H7}$	+0.035
	0.000
$\varnothing 126^{p6}$	+0.068
	+0.043

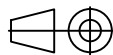


DETAILS X

NOTE :

- 1.ALL UNSPECIFIED CHAMFERS TO 0.5X45°
- 2.CASTING SHOULD BE FREE FROM HARMFUL INCLUSION & CRACKS

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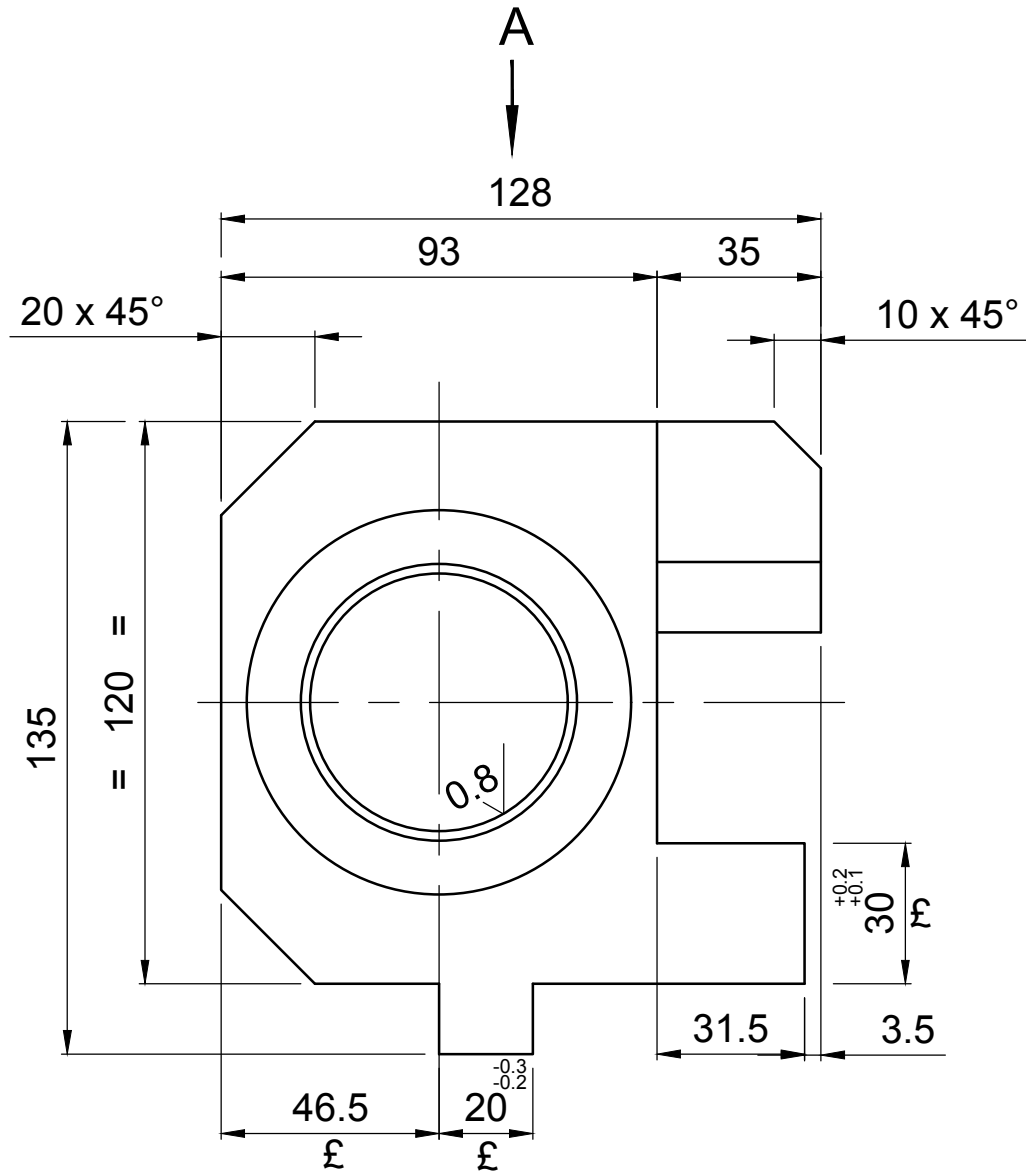
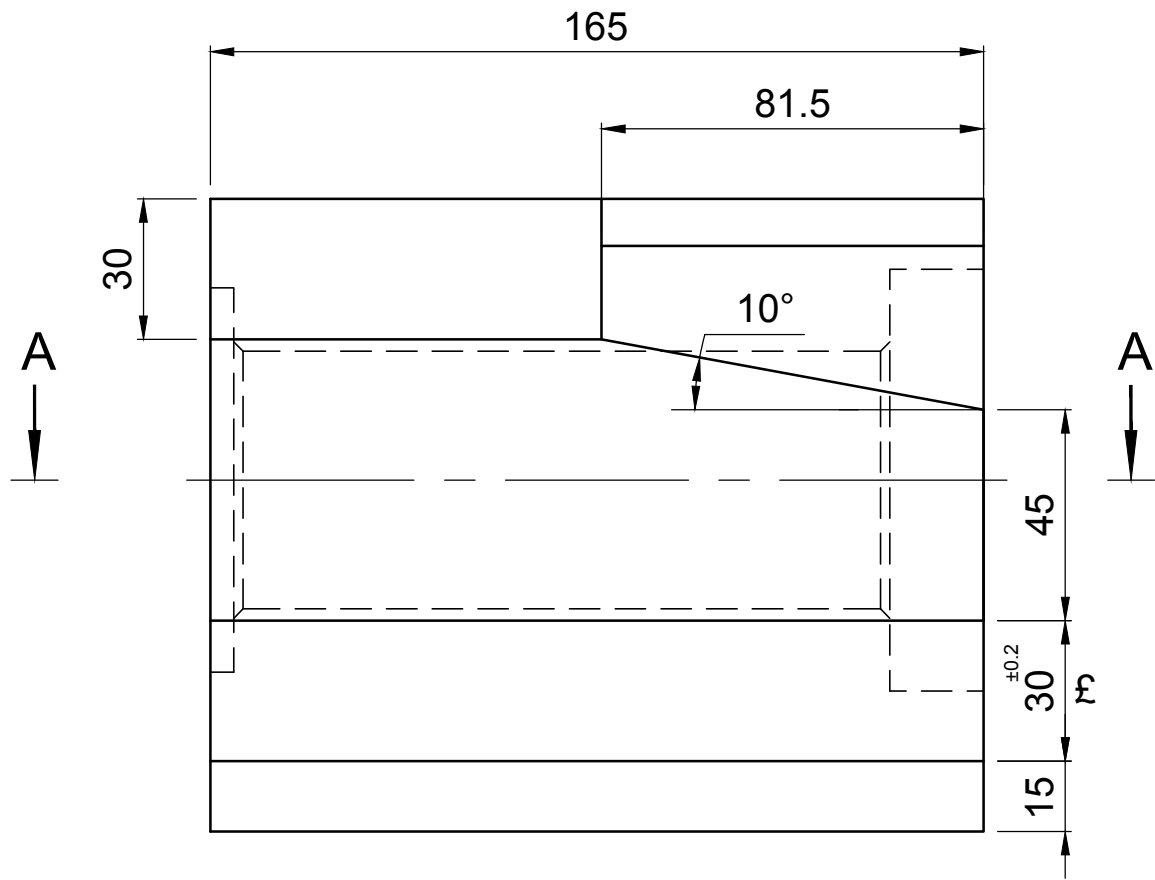
			GZ-CuSn12			
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE		UNIT WT	
			MATL SPEC		QTY	
EQPT: CROSS PIERCING AND ELONGATION						
	Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI – 620014		DRN	NAME S.S.N.KUMAR/ B.N	SIGNATURE S.S.N.Kumar/ B.N	DATE 30.06.18
			CHD	D.CHANDRASEKAR	D. Chandrasekar	30.06.18
			APPD	D.CHANDRASEKAR	D. Chandrasekar	30.06.18
DEPT SSTP	GRADE OF UNTOL. DIM  IS: 2102	SCALE 1:2	WEIGHT (Kg) 3.8	REF TO ASSY DWG NO		ITEM
CODE 456				REF TO OLD DWG NO 0101056-42-000-03		61
TITLE CPE-COLLAR BUSH 3-ROLLER GUIDE-1			CARD CODE U 01	DRAWING NO : 4-7-1123-42-10442		REV 00

2-7-1127-06-10162

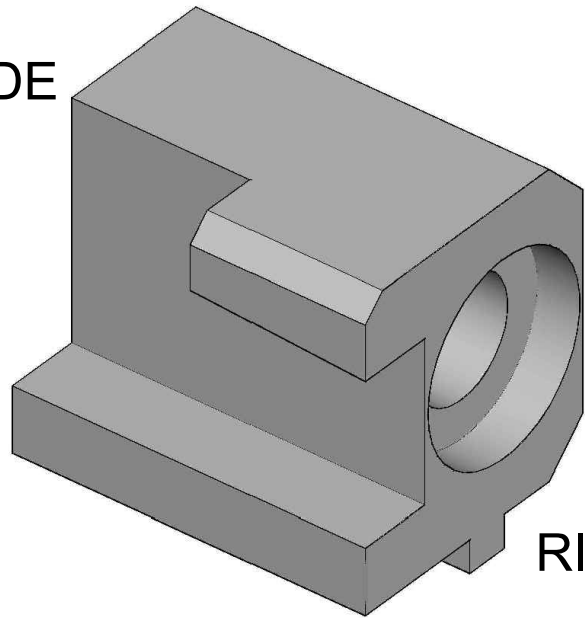
ALL DIMENSIONS ARE IN MILLIMETERS

$\sqrt{Ra\ 3.2}$ ($\sqrt{Ra\ 0.8}$)

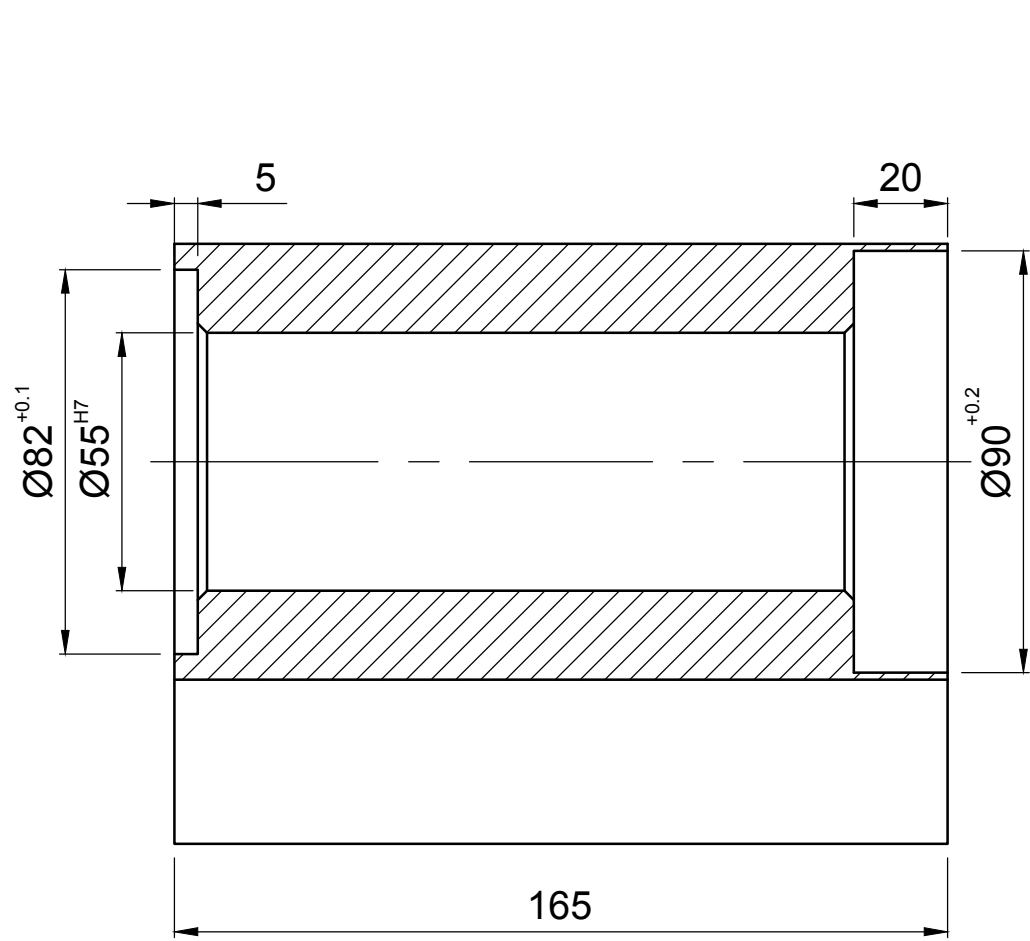
$\varnothing 55^{H7}$ $\begin{matrix} +0.030 \\ 0 \end{matrix}$



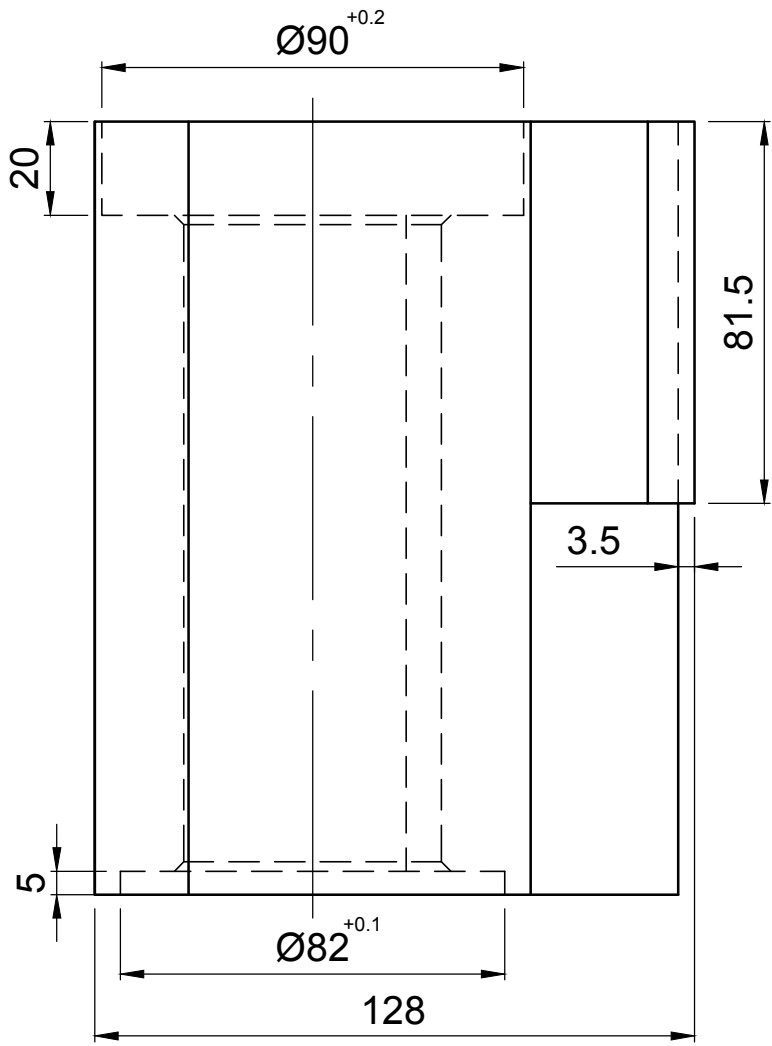
LEFT SIDE



RIGHT SIDE



SECTION A-A



VIEW A

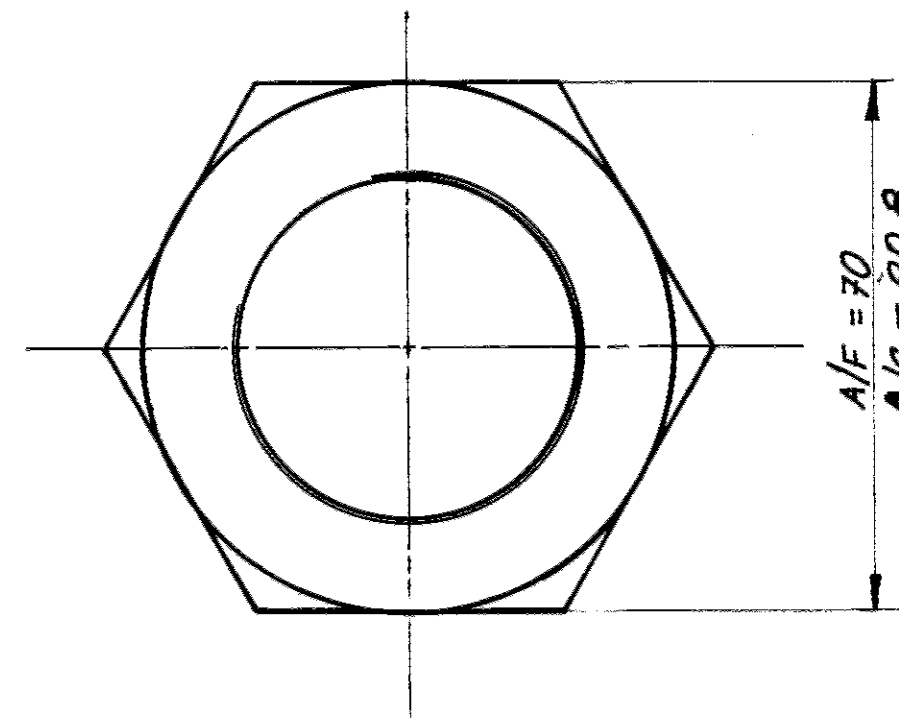
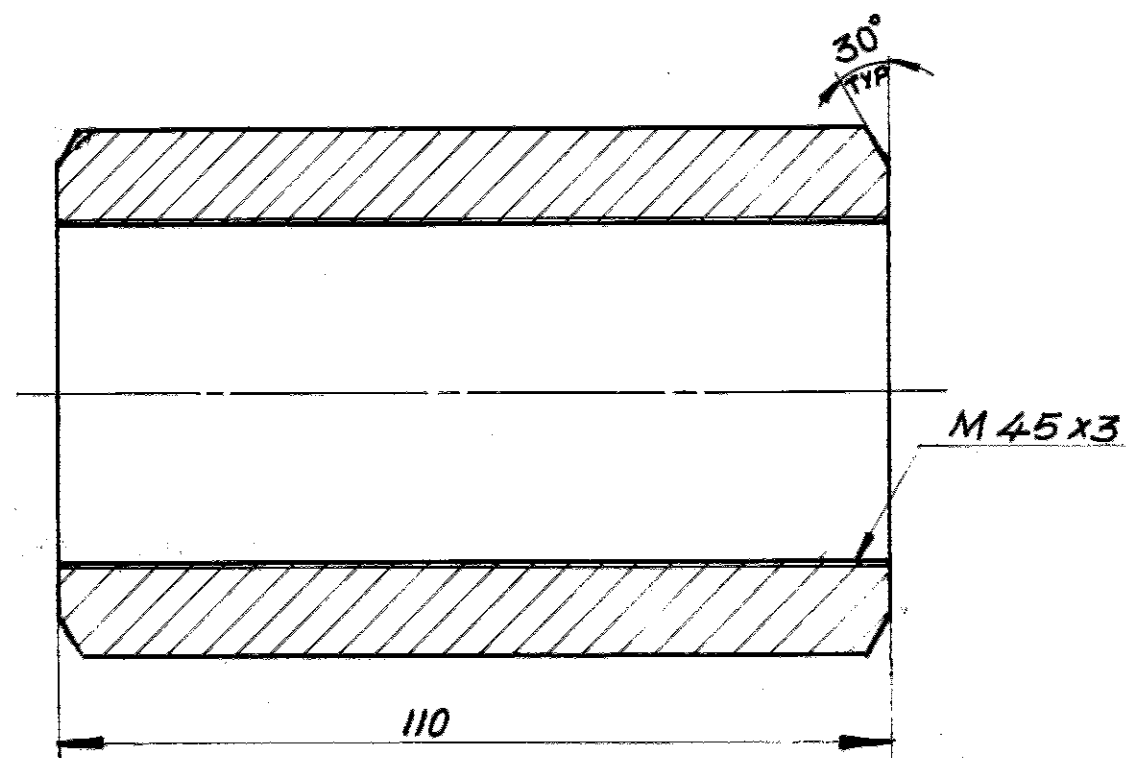
REV	DATE	ALTERED	CHECKED	APPROVED
01				

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			45C8 IS:1875				
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE		UNIT WT		
			MATL SPEC		QTY		
EQPT: PUSH BENCH							
	Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI – 620014		DRN	NAME SSN.KUMAR/B.N	SIGNATURE <i>SSN.Kumar/B.N</i>	DATE 10.11.18	
			CHD	SSN.KUMAR	<i>SSN.Kumar</i>	10.11.18	
			APPD	D.ABHIGNNA	<i>D.Abhignna</i>	10.11.18	
DEPT SSTP	GRADE OF UNTOL. DIM		SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO 0-7-1127-06-00215		ITEM 44
CODE 456	ϕ /M/F IS: 2102		NTS	10	REF TO OLD DWG NO RW-27751/6, 3-7-1127-06-02733/Rev 05		
TITLE			CARD CODE U 01	DRAWING NO : 2-7-1127-06-10162			REV 00
PHB-SLIDE BLOCK COVER INTERLOCKING ASSY.							

A2-SIZE

6.3



ITEM NO.	DESCRIPTION	DRAWING NO.	MATL. CODE	UNIT WT
			MATL. SPEC	QTY
EQUIP: PUSH BENCH				
 Bharat Heavy Electricals Ltd., SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI-620 014		DRN	NAME	SIGN
		CHD	V.S. MANIAN	V. Subramanyam
		APPD	A. ARICKIAM	J. ANNIL
REV	DATE	ALTERED	CHECKED	APPROVED
01	23/03/82		J. ANNIL	
ZONE	MATERIAL SPECIFICATION			
	45CB IS: 1875 WAS			
	C45 IS: 2073			
DEPT	GRADE OF UNTOOL DIM	SCALE	WEIGHT (kg)	REF TO ASSY OLD DRG
CODE	C/M/F	1:1	2.3	0-7-1127-06-00215
TITLE			CARD CODE	DRAWING NO
CONNECTING NUT (COVER LOCKING SYSTEM)			U 01	3-7-1127-06-02748
ITEM NO.				REV
41				01

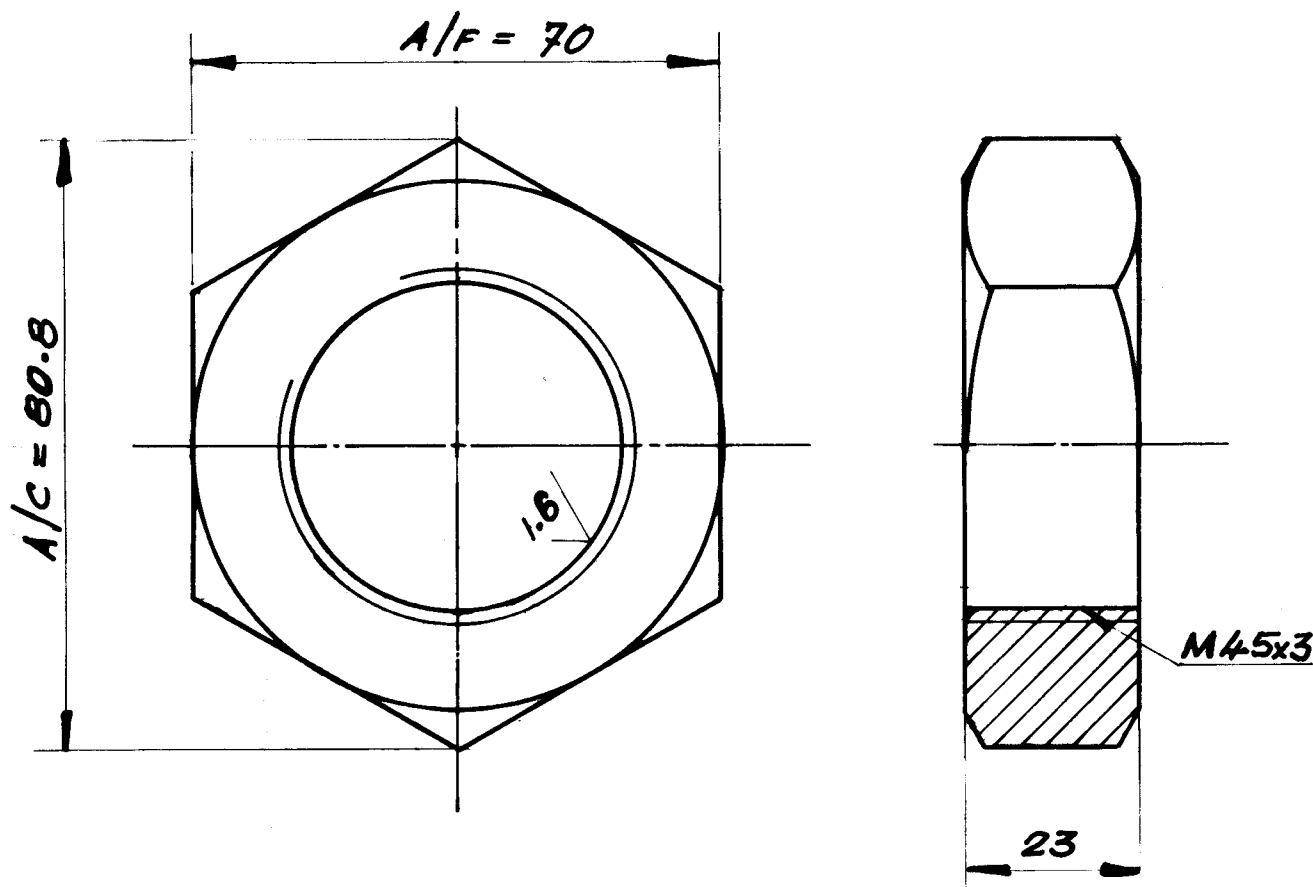
FIRST ANGLE PROJECTION (ALL DIMENSIONS IN MILLIMETERS)

S 27-009

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REV	DATE	ALTERED
01		CHECKED
ZONE		

3.2 / 1.6



		C 45	
		IS: 2073	
ITEM NO.	DESCRIPTION	MATL CODE	UNIT WT.
		MATL SPEC	QTY

EQPT: **PUSH BENCH**

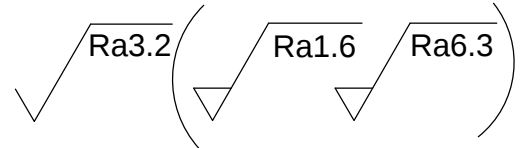
Bharat Heavy Electricals Ltd.,
SEAMLESS STEEL TUBE PLANT
TIRUCHIRAPALLI-620 014

DRN	NAME	SIGN	DATE
CHD	V.S. MANI	V. Subramanian	14-10-87
APPD	A. AROCKIAM	J. J. J.	15-10-87
			18-10-87

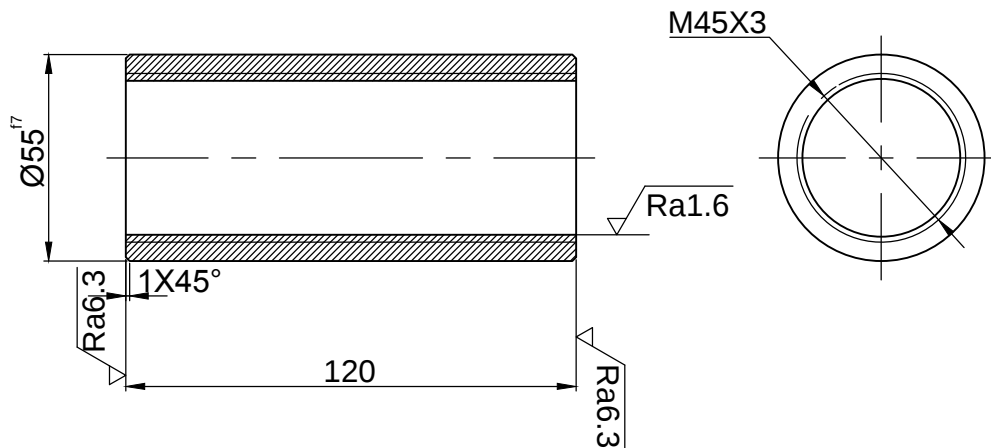
DEPT	Grade of Untol Dim		SCALE	WEIGHT (Kg)	REF TO ASSY/OLD DRG	Item NO.
CODE	C/M/F		1:1	0.476	0-7-1127-06-00215	74
TITLE			CARD CODE	DRAWING NO.		REV
LOCK NUT (COVER LOCKING SYSTEM)			U 01	4-7-1127-06-03593		00

Size A 4

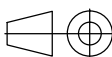
REV 01	DATE 23.03.96	ALTERED <i>L.Kandasamy</i>
		CHECKED <i>A.Arockiam</i>
		APPROVED <i>S.S.Sundaram</i>
MATERIAL SPECIFICATION 45C8 IS:1875 WAS C45 IS:2073		
REV 02	DATE 28.03.14	ALTERED <i>M.Munieshkumar</i>
		CHECKED <i>R.Raghuveer</i>
		APPROVED <i>S.Loganathan</i>
CONVERTED TO AUTOCAD DRG.		



Ø55 ^{f7}	-0.030
	-0.060

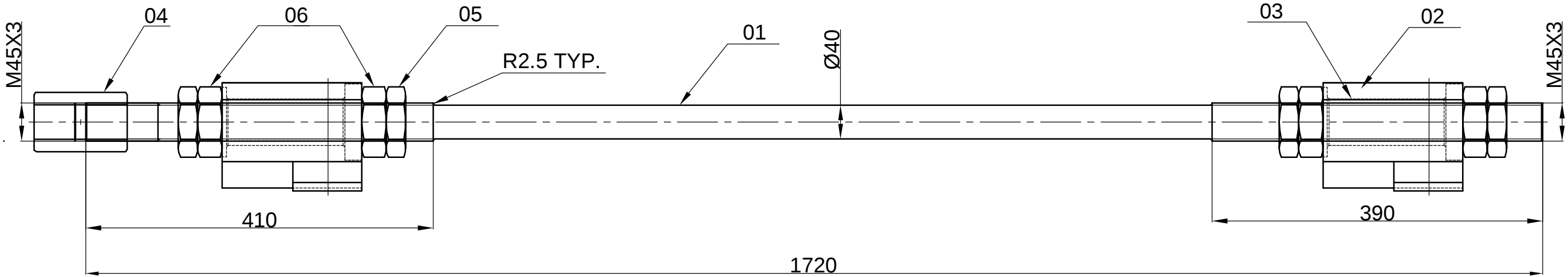


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					45C8	IS: 1875	
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE		UNIT WT		
			MATL SPEC		QTY		
EQPT: PUSH BENCH							
		Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI – 620014		DRN	NAME V.S.MANIAN	SIGNATURE V.S.Manian	DATE 14.10.87
				CHD	A.AROCKIAM	A.Arockiam	15.10.87
				APPD	S.S.SUNDARAM	S.S.Sundaram	15.10.87
DEPT SSTP	GRADE OF UNTOL. DIM Ø/M/¢ IS: 2102		SCALE 1:2	WEIGHT (Kg) 0.185	REF TO ASSY DWG NO 0-7-1127-06-00215		ITEM 40
CODE 456					REF TO OLD DWG NO		
TITLE PHB - THREADED SLEEVE (SLIDE BLOCK OF COVER INTER LOCKING ASSY)				CARD CODE U 01	DRAWING NO : 4-7-1127-06-03594		REV 02

ALL DIMENSIONS ARE IN MILLIMETRES

DRAWING NO: 3-7-1127-06-10384



- NOTES:
- 1. ALL SHARP CORNERS ARE CHAMFERED TO 1X45°
 - 2. SUPPLY SHOULD BE IN ASSEMBLED CONDITION.

06	HEX. NUT		IS:1364 P8	4
			C45 IS:2073	0.476
05	LOCK NUT	4-7-1127-06-03593	45C8 IS:1875	2.3
			45C8 IS:1875	1
04	CONNECTING NUT	3-7-1127-06-02748	45C8 IS:1875	0.185
			45C8 IS:1875	2
03	SLEEVE	4-7-1127-06-03594	45C8 IS:1875	10
			45C8 IS:1875	2
02	SLIDE BLOCK	2-7-1127-06-10162	45C8 IS:1875	19.95
			45C8 IS:1875	1
01	TIE ROD	4-7-1127-06-03788	MATL CODE	UNIT WT
			MATL SPEC	QTY

EQPT: PUSH BENCH

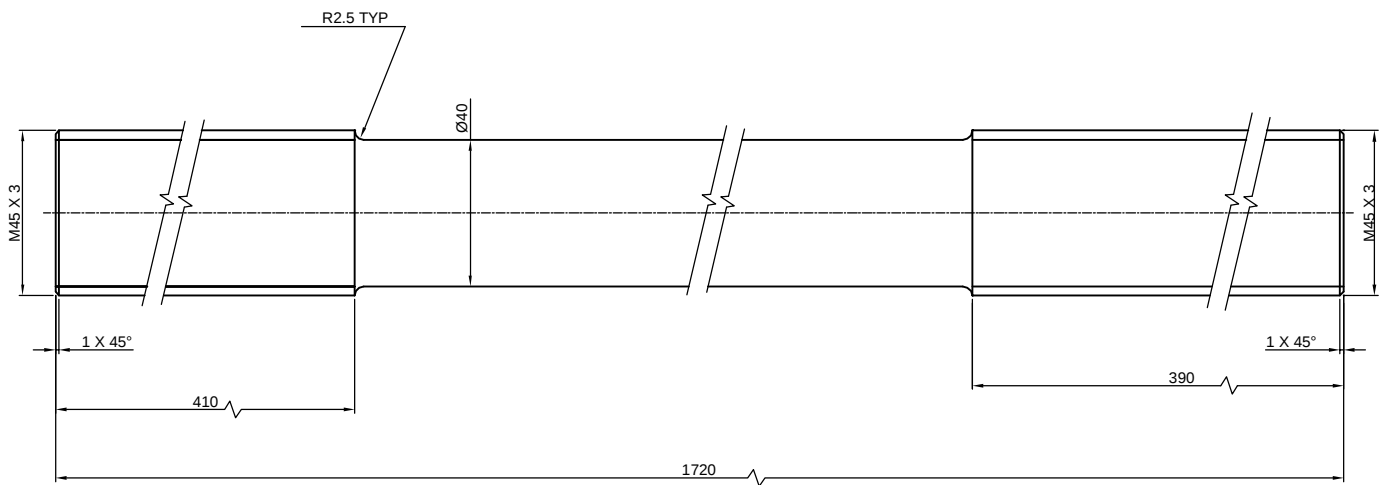
	Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI – 620014		NAME	S.S.N.KUMAR/M.D	SIGNATURE	<i>S.P.N. Kumar/M.D</i>	DATE	18.03.19
			DRN	S.S.N.KUMAR	SIGNATURE	<i>S.P.N. Kumar</i>	DATE	18.03.19
			CHD	D.ABHIGNA	SIGNATURE	<i>D. Abhigna</i>	DATE	18.03.19
DEPT	SSTP	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO		ITEM	
CODE	456	$\phi/M/\#$ IS: 2102	1:2	44.524	REF TO OLD DWG NO			
TITLE				CARD CODE	DRAWING NO :		REV	
PHB-TIE ROD ASSY. - I COVER LOCKING SYSTEMS				U 01	3-7-1127-06-10384		00	

REV	DATE	ALTERED
01		CHECKED
		APPROVED

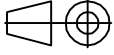
CAUTION: THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

ALL DIMENSIONS ARE IN MM

REV 01	DATE 21.08.92	ALTERED	S.Mohanraj	REV 02	DATE 16.08.96	ALTERED	S.Mohanraj	1.6 ✓
		CHECKED	A.Arockiam			CHECKED	A.Arockiam	
		APPROVED				APPROVED	SS.Sundarm	
DIMENSION 1720 WAS 1810				MATL. SPCN 45C8 IS:1875 WAS C45 IS: 2073				
REV 03	DATE 03.08.11	ALTERED	R.SUNDAR.					
		CHECKED	SSN.KUMAR					
		APPROVED	G.LOGANATHAN					
CONVERT TO AUTOCAD DWG								



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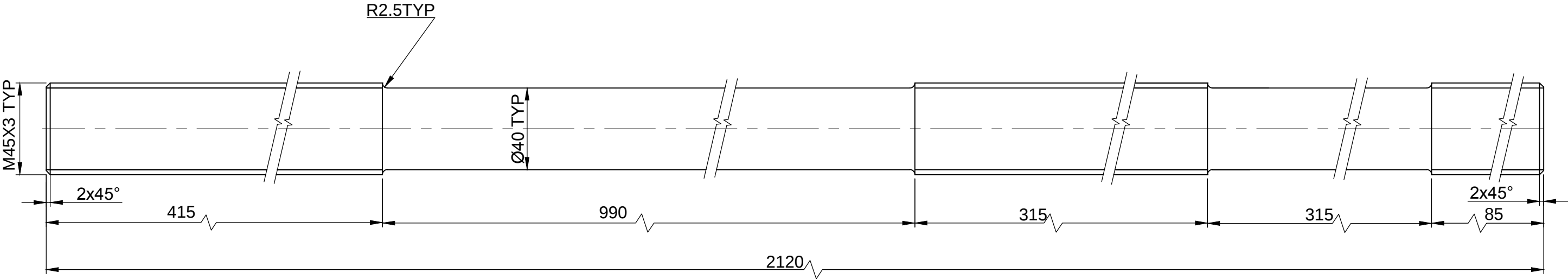
						45C8 IS:1875	
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE		UNIT WT		
			MATL SPEC		QTY		
EQPT: PUSH BENCH							
		Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI – 620014		DRN	NAME S.MOHANRAJ	SIGNATURE <i>S.Mohanraj</i>	DATE 28.06.89
				CHD	A.AROCKIAM	<i>A.Arockiam</i>	28.06.89
				APPD	SS.SUNDARM	<i>SS.Sundarm</i>	29.06.89
DEPT SSTP	GRADE OF UNTOL. DIM $\phi/M/f$ IS: 2102		SCALE 1:2	WEIGHT (Kg) 19.95	REF TO ASSY DWG NO 0-7-1127-06-00215		ITEM —
CODE 456					REF TO OLD DWG NO —		
TITLE TIE ROD TYPE I & VIII (COVER LOCKING SYSTEM)				CARD CODE U 01	DRAWING NO : 4-7-1127-06-03788		REV 03

A4—SIZE

ALL DIMENSIONS ARE IN MILLIMETRES

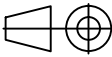
DRAWING NO: 3-7-1127-06-02747

Ra 3.2



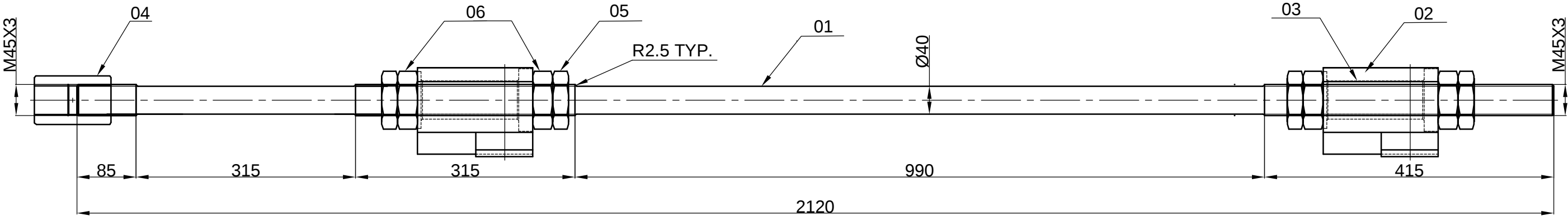
REV 03	DATE 28.03.14	ALTERED CHECKED APPROVED	M. Munieshkumar R. Raghuvier S. Loganathan	REV 02	DATE 18.08.98	ALTERED CHECKED APPROVED	S. Mohanraj A. Arockiam S. P. Sundaram	REV 01	DATE 17.08.96	ALTERED CHECKED APPROVED	S. Mohanraj A. Arockiam S. P. Sundaram
CONVERT TO AUTOCAD DWG			DRAWING MODIFIED			MATL. SPCN. 45C8 IS:1875 WAS C45 IS: 2073					

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.

					45C8 IS:1875		
ITEM NO	DESCRIPTION	DRAWING NO			MATL CODE	UNIT WT	
					MATL SPEC	QTY	
EQPT: PUSH BENCH							
	Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI – 620014		DRN	NAME V.S.MANIAN	SIGNATURE <i>V.S.Manian</i>	DATE 08.10.87	
			CHD	A.AROCKIAM	<i>A.Arockiam</i>	15.10.87	
			APPD	SS.SUNDARAM	<i>SS.Sundaram</i>	15.10.87	
DEPT SSTP	GRADE OF UNTOL. DIM $\phi/M/F$ IS: 2102		SCALE 1:2	WEIGHT (Kg) 23.05	REF TO ASSY DWG NO 0-7-1127-06-00215		ITEM 38
CODE 456					REF TO OLD DWG NO —		
TITLE PHB - TIE ROD TYPE IV & VII COVER INTER LOCKING SYSTEM				CARD CODE U 01	DRAWING NO : 3-7-1127-06-02747		REV 03

ALL DIMENSIONS ARE IN MILLIMETRES

3-7-1127-06-10385
DRAWING NO.:



NOTES:

1. ALL SHARP CORNERS ARE CHAMFERED TO 1X45°
2. SUPPLY SHOULD BE IN ASSEMBLED CONDITION.

06	HEX. NUT		IS:1364 P8	4
				0.476
05	LOCK NUT	4-7-1127-06-03593	C45 IS:2073	4
				2.3
04	CONNECTING NUT	3-7-1127-06-02748	45C8 IS:1875	1
				0.185
03	SLEEVE	4-7-1127-06-03594	45C8 IS:1875	2
				10
02	SLIDE BLOCK	2-7-1127-06-10162	45C8 IS:1875	2
				23.05
01	TIE ROD	3-7-1127-06-02747	45C8 IS:1875	1
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT
			MATL SPEC	QTY

EQPT: PUSH BENCH

	Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI – 620014		NAME	S.S.N.KUMAR/M.D	SIGNATURE	<i>S.P.N. Kumar/M.D</i>	DATE	18.03.19
			DRN	S.S.N.KUMAR		<i>S.P.N. Kumar</i>		18.03.19
			CHD	D.ABHIGNA		<i>D. Abhigna</i>		18.03.19
DEPT	SSTP	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO		ITEM	
CODE	456	φ/∅/∅ IS: 2102	1:2	47.624	REF TO OLD DWG NO			
TITLE				CARD CODE	DRAWING NO :		REV	
PHB-TIE ROD ASSY. - II COVER LOCKING SYSTEMS				U 01	3-7-1127-06-10385		00	

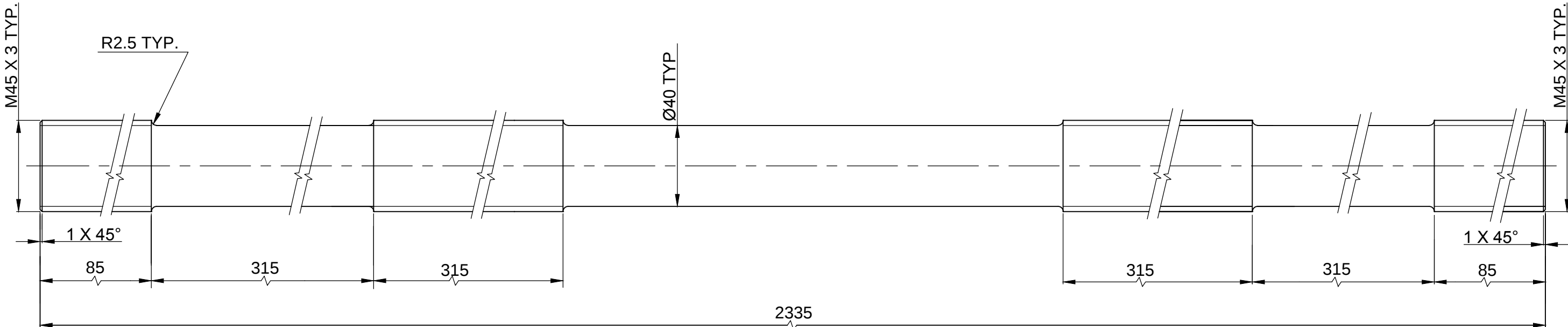
REV	DATE	ALTERED
01		CHECKED
		APPROVED

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ALL DIMENSIONS ARE IN MILLIMETRES

3-7-1127-06-02875
DRAWING NO:

Ra 3.2



REV	DATE	ALTERED
02	28.03.14	<i>M. Munieshkumar</i>
		CHECKED <i>R. Raghuvier</i>
		APPROVED <i>S. Loganathan</i>

REV	DATE	ALTERED
01	24.01.97.	<i>J. Kumar</i>
		CHECKED <i>A. Arockiam</i>
		APPROVED <i>P. P. Sundaram</i>

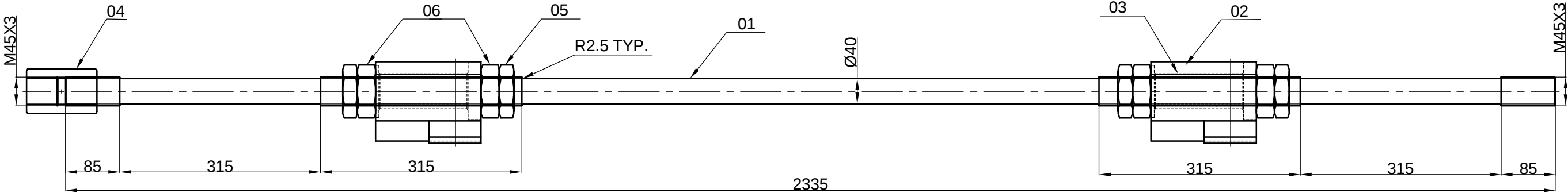
MTL SPCN. 45C8 IS:1875
WAS C45 IS: 2073

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WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

							45C8 IS:1875		
ITEM NO	DESCRIPTION	DRAWING NO				MATL CODE		UNIT WT	
						MATL SPEC		QTY	
EQPT: PUSH BENCH									
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI – 620014			DRN	NAME S.MOHANRAJ	SIGNATURE <i>S.Mohanraj</i>	DATE 29.06.89			
			CHD	A.AROCKIAM	<i>A.Arockiam</i>	29.06.89			
			APPD	S.S.SUNDARM	<i>S.S.Sundarm</i>	29.06.89			
DEPT SSTP	GRADE OF UNTOL. DIM  IS: 2102		SCALE 1:2	WEIGHT (Kg) 25.12	REF TO ASSY DWG NO 0-7-1127-06-00215		ITEM —		
CODE 456					REF TO OLD DWG NO —				
TITLE PHB - TIE ROD TYPE III & VI COVER INTER LOCKING SYSTEM				CARD CODE U 01	DRAWING NO : 3-7-1127-06-02875		REV 02		

ALL DIMENSIONS ARE IN MILLIMETRES

98301-90-7211-7-3
DRAWING NO. : 3-7-1127-06-10386

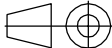


NOTES:

1. ALL SHARP CORNERS ARE CHAMFERED TO 1X45°
2. SUPPLY SHOULD BE IN ASSEMBLED CONDITION.

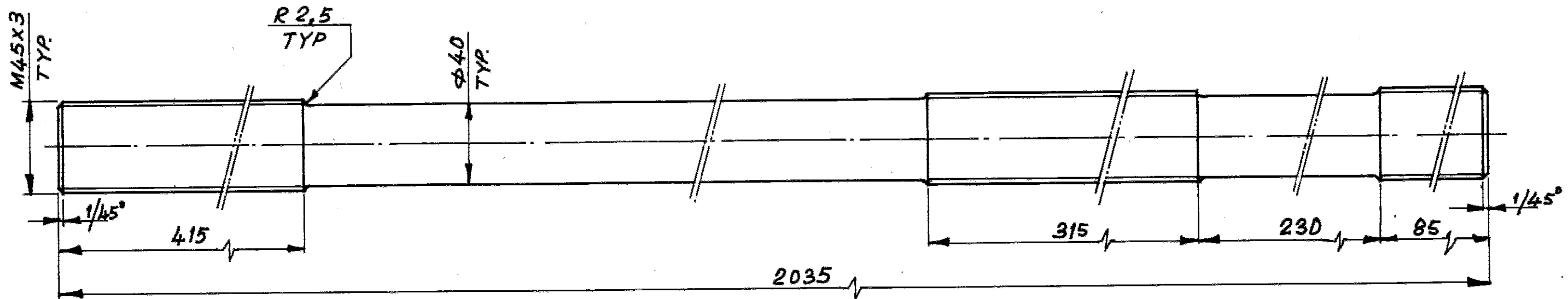
06	HEX. NUT		IS:1364 P8	4
				0.476
05	LOCK NUT	4-7-1127-06-03593	C45 IS:2073	4
				2.3
04	CONNECTING NUT	3-7-1127-06-02748	45C8 IS:1875	1
				0.185
03	SLEEVE	4-7-1127-06-03594	45C8 IS:1875	2
				10
02	SLIDE BLOCK	2-7-1127-06-10162	45C8 IS:1875	2
				25.12
01	TIE ROD	3-7-1127-06-02875	45C8 IS:1875	1
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT
			MATL SPEC	QTY

EQPT: PUSH BENCH

		Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI – 620014		NAME		SIGNATURE		DATE		
				DRN	S.S.N.KUMAR/M.D		<i>S.S.N.Kumar/M.D</i>		18.03.19	
				CHD	S.S.N.KUMAR		<i>S.S.N.Kumar</i>		18.03.19	
APPD		D.ABHIGHNA		<i>D.Abhighna</i>		18.03.19				
DEPT SSTP	GRADE OF UNTOL. DIM		SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO					ITEM
CODE	$\phi/M/\#$ IS: 2102		1:2	49.694	REF TO OLD DWG NO					
456										
TITLE				CARD CODE U 01	DRAWING NO :					REV
PHB-TIE ROD ASSY. - III COVER LOCKING SYSTEMS					3-7-1127-06-10386					00

REV 01	DATE	ALTERED
		CHECKED
		APPROVED

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ITEM NO.	DESCRIPTION	DRAWING NO.	45 CB 15:1875	
			MATL CODE	UNIT WT
			MATL SPEC	QTY

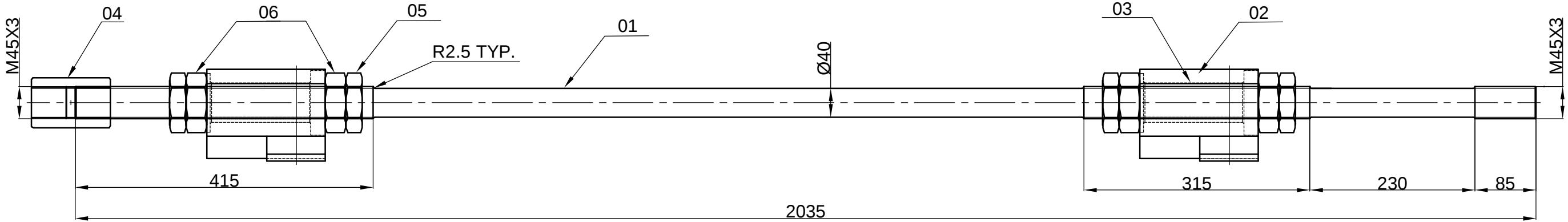
ERPT: PUSH BENCH

BHE	Bharat Heavy Electricals Ltd.,		ORN	NAME	SIGN	DATE	NO. OF ITEMS
	SEAMLESS STEEL TUBE PLANT		CHD	A. ARDEKIAM	J. J. J. J.	28.6.87	
	TIRUCHIRAPALLI - 620 014		APPD			29.06.87	

REV 01	DATE 24-1-97	ALTERED T. J. J. J.	DEPT	GRADE OF UNTOOL DIM	SCALE	WEIGHT (kg)	REF TO ASSY OLD DRG	ITEM NO.
ZONE	APPD: J. J. J. J.	CHECKED: J. J. J. J.	CODE	φ M F	1:2	22,21	0-7-1127-06-00215	
MTL SPCN. 45 CB 15:1875 WAS C-45, 15:2073.			TITLE			CARD CODE	DRAWING NO	REV
			TIE ROD (COVER LOCKING SYSTEM)			U 01	3-7-1127-06-02874	01

ALL DIMENSIONS ARE IN MILLIMETRES

DRAWING NO: 3-7-1127-06-10387



NOTES:

1. ALL SHARP CORNERS ARE CHAMFERED TO 1X45°
2. SUPPLY SHOULD BE IN ASSEMBLED CONDITION.

06	HEX. NUT		IS:1364 P8	4
			0.476	
05	LOCK NUT	4-7-1127-06-03593	C45 IS:2073	4
			2.3	
04	CONNECTING NUT	3-7-1127-06-02748	45C8 IS:1875	1
			0.185	
03	SLEEVE	4-7-1127-06-03594	45C8 IS:1875	2
			10	
02	SLIDE BLOCK	2-7-1127-06-10162	45C8 IS:1875	2
			22.21	
01	TIE ROD	3-7-1127-06-02874	45C8 IS:1875	1
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT
			MATL SPEC	QTY

EQPT: PUSH BENCH

		Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI – 620014		DRN	NAME S.S.N.KUMAR/M.D	SIGNATURE <i>S.P.N.Kumar/M.D</i>	DATE 18.03.19
				CHD	S.S.N.KUMAR	<i>S.P.N.Kumar</i>	18.03.19
				APPD	D.ABHIGHNA	<i>D.Abhighna</i>	18.03.19
DEPT SSTP	GRADE OF UNTOL. DIM  IS: 2102	SCALE 1:2	WEIGHT (Kg) 46.784	REF TO ASSY DWG NO			ITEM
CODE 456				REF TO OLD DWG NO			
TITLE PHB-TIE ROD ASSY. - IV COVER LOCKING SYSTEMS			CARD CODE U 01	DRAWING NO : 3-7-1127-06-10387			REV 00

REV	DATE	ALTERED
01		CHECKED
		APPROVED

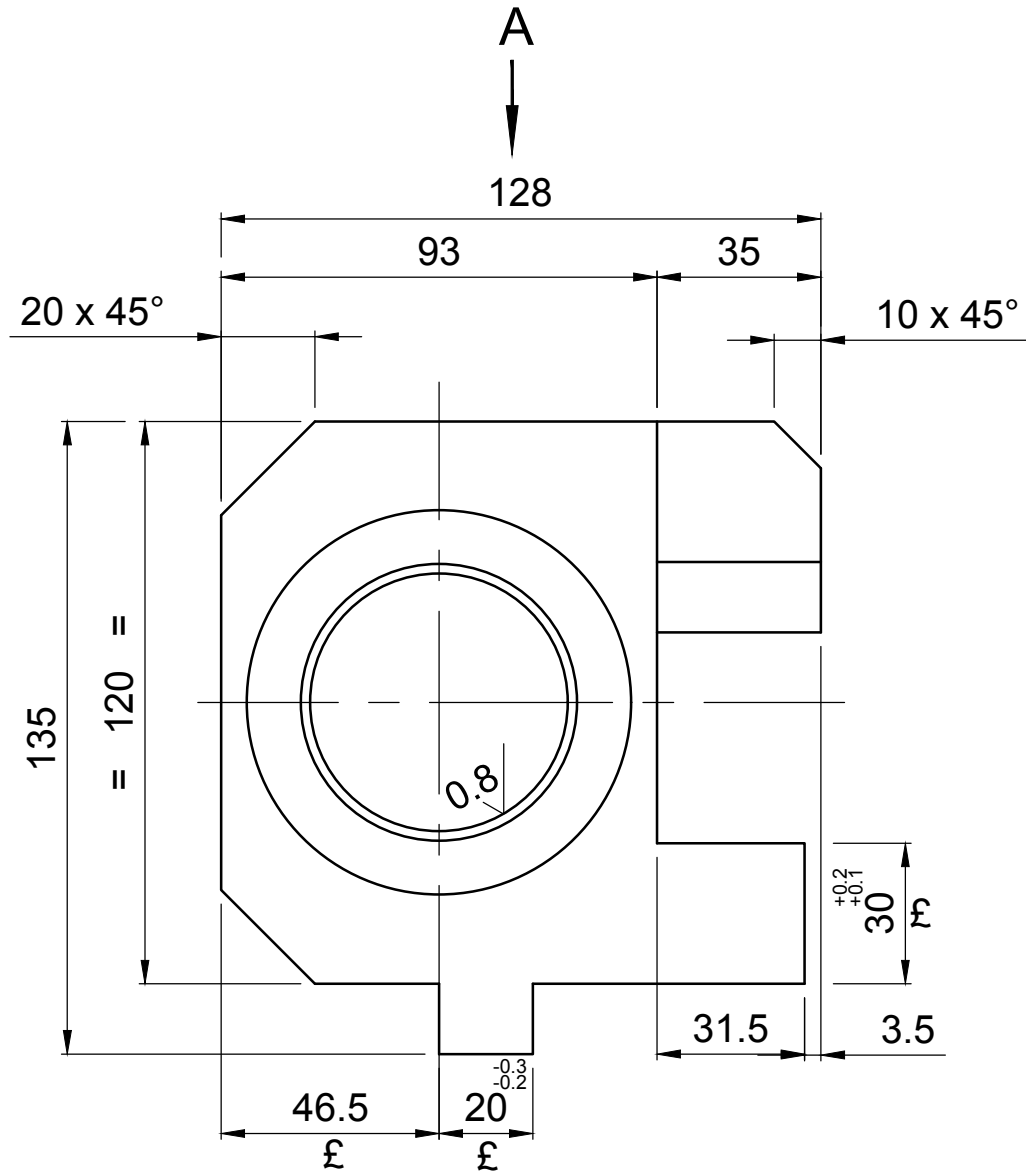
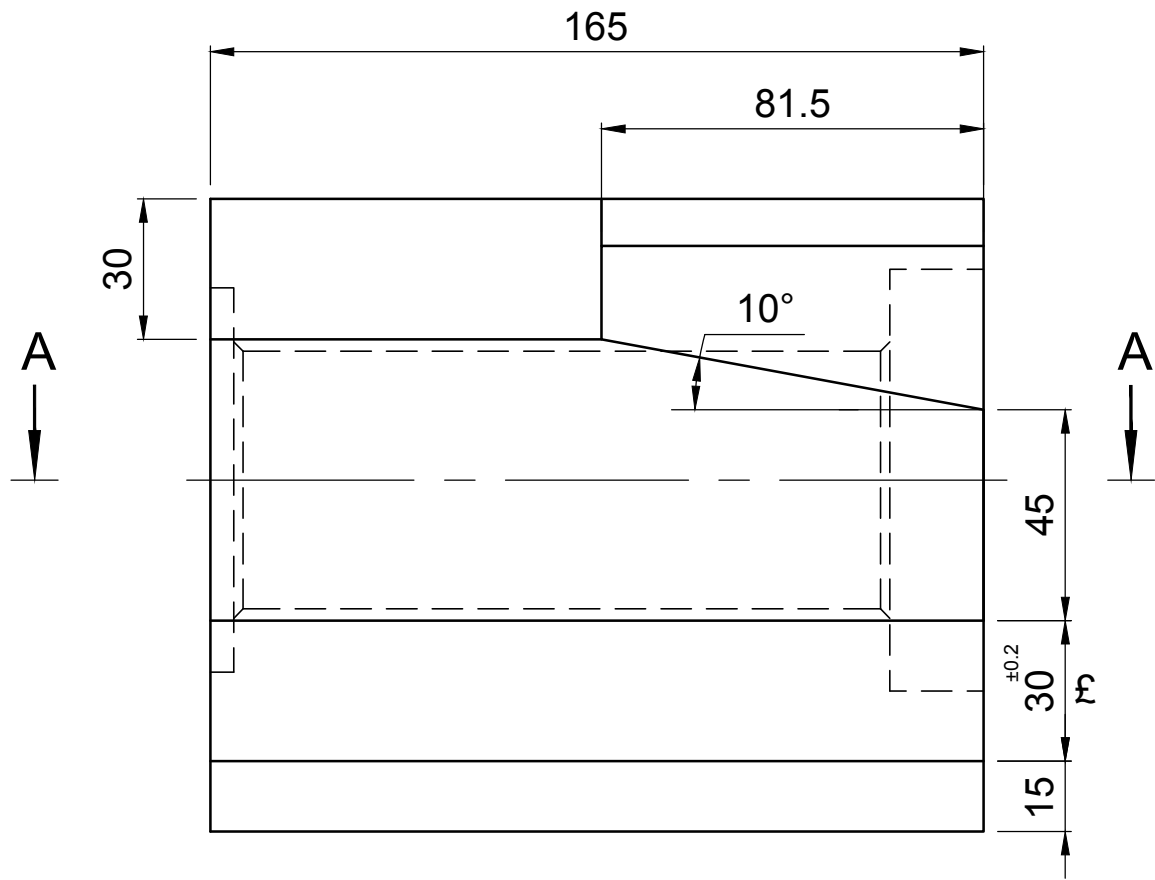
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2-7-1127-06-10162

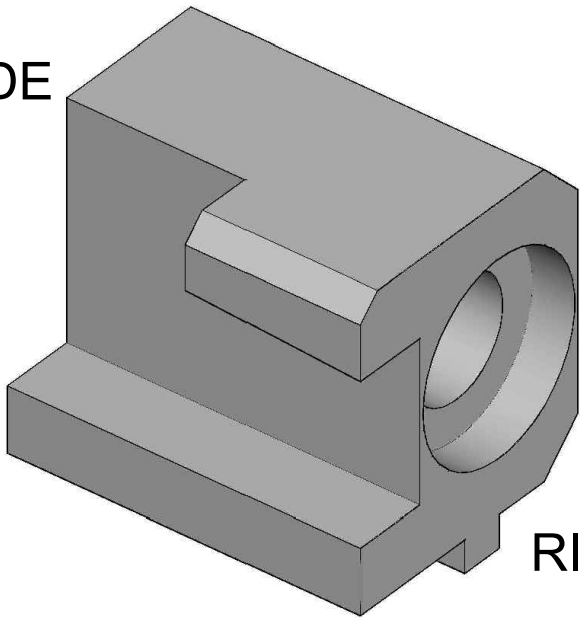
ALL DIMENSIONS ARE IN MILLIMETERS

$\sqrt{Ra\ 3.2}$ ($\sqrt{Ra\ 0.8}$)

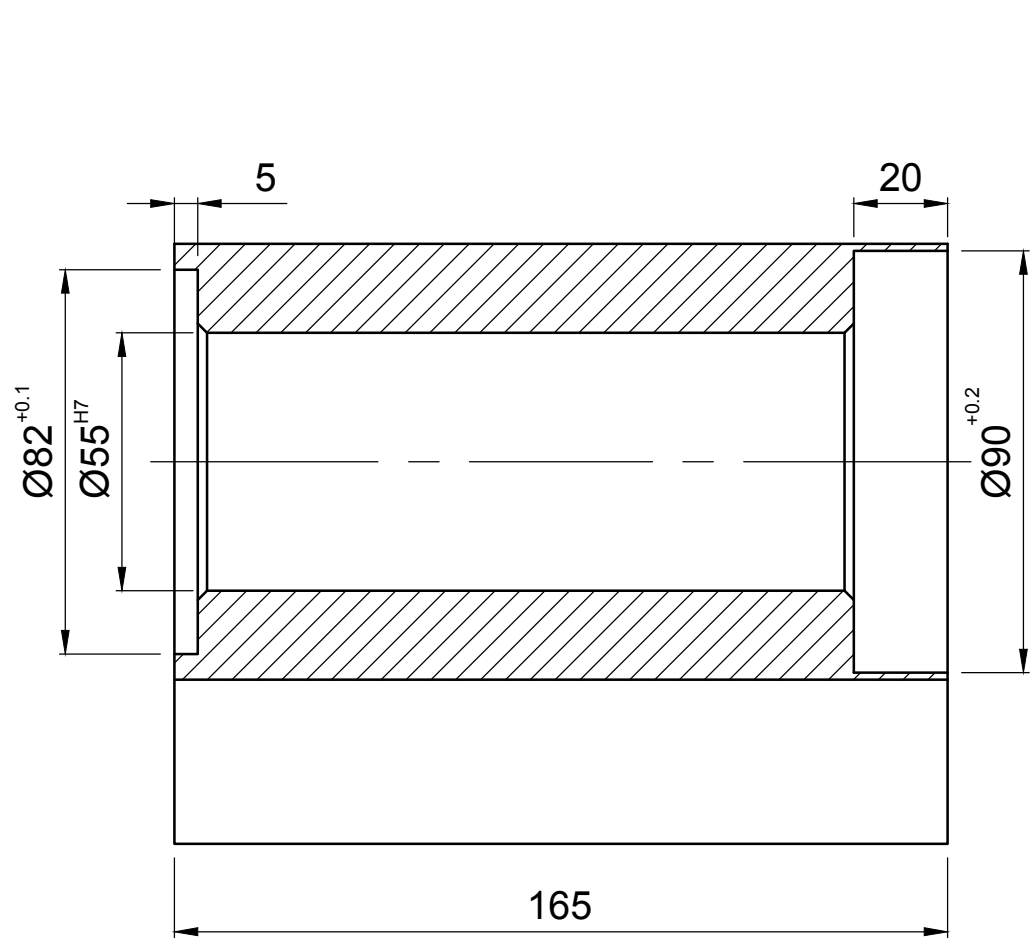
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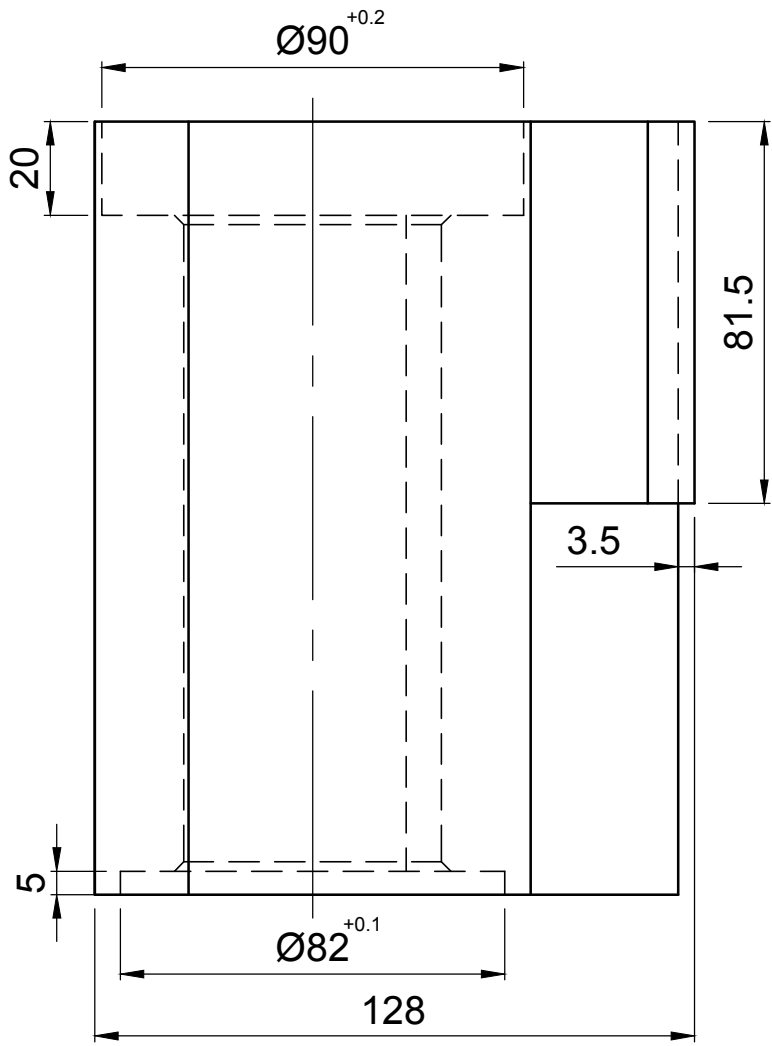
LEFT SIDE



RIGHT SIDE



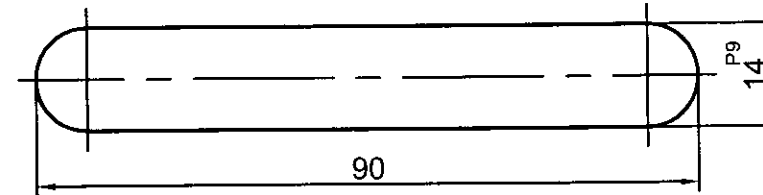
SECTION A-A



VIEW A

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.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
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Ø50 ^{h6}	0.0
	-0.016
Ø50 ^{j6}	+0.011
	-0.004
Ø45 ^{h6}	0.0
	-0.016
Ø35 ^{j6}	+0.011
	-0.004
Ø33 ^{h12}	0.0
	-0.250
14 ^{P9}	-0.018
	-0.061
1.6 ^{H13}	+0.140
	0.0



REV 01	DATE	ALTERED :
		CHECKED :
		APPROVED
ZONE		

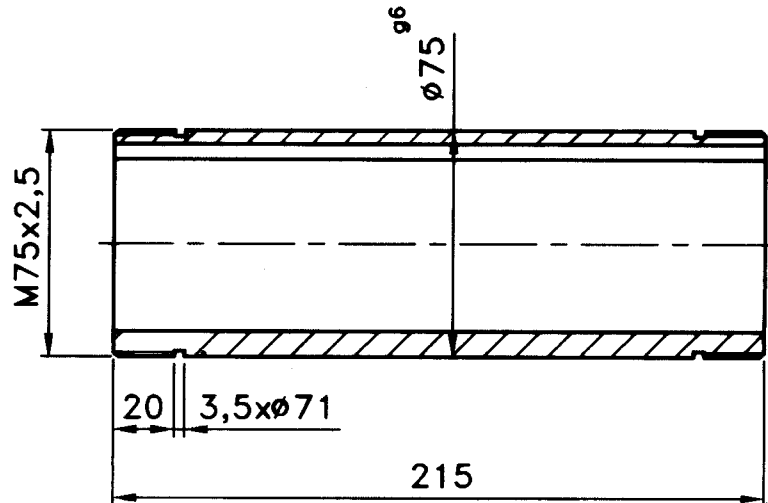
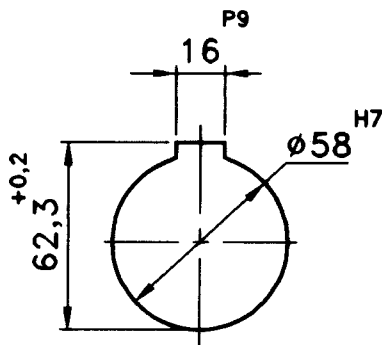
ALL DIMENSIONS ARE IN MM

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IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANYWAY DETERMINAL TO INTEREST OF THE COMPANY

REV	DATE	ALTERED
01		CHECKED
		APPROVED

1.6/
✓

ø75 g6	-0,010
	-0,075
ø58 H7	+0,030
	0
16 P9	-0,018
	-0,061



ALL CORNERS CHAMFERED TO 1x45°

				AISI410			
ITEM NO	DESCRIPTION	DRAWING NO		MATL CODE		UNIT WT	
				MATL SPEC		QTY	
EQPT: SCALE PIT & PUMP HOUSE							
		Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME SSN.KUMAR	SIGNATURE <i>SSN.Kumar</i>	DATE 2.12.96
				CHD	AROCKIAM A	<i>A. Arockiam</i>	7.12.96
				APPD	SHANMUGASUNDARAM S	<i>Shanmugasundaram</i>	7.12.96
DEPT MPG	GRADE OF UNTOL DIM C/M/F		SCALE 1:2,5	WEIGHT (Kg) 3,0	REF TO ASSY DRG 820-05/2667		ITEM NO 19
CODE					REF TO OLD DRG		
TITLE COUPLING SLEEVE SHAFT ASSY-SAM PUMP VO150/500+AR				CARD CODE U 01	DRAWING NO : 4-7-3412-00-05424		REV 00

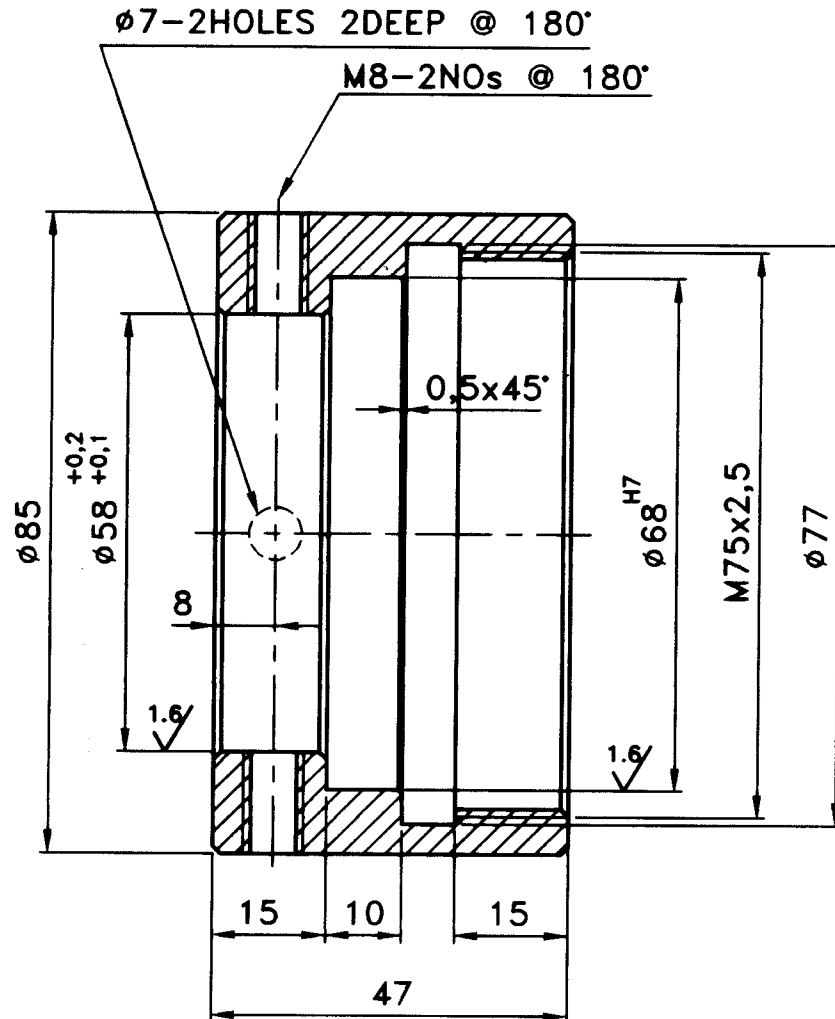
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ALL DIMENSIONS ARE IN MM

REV	DATE	ALTERED
		CHECKED
		APPROVED

3.2/ 1.6/

ø68 H7	+0,030
	0



UNSPECIFIED CHAMFERS TAKEN AS 1x45°

				AISI410			
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE		UNIT WT		
			MATL SPEC		QTY		
EQPT: SCALE PIT & PUMP HOUSE							
		Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		NAME	SIGNATURE	DATE	
				DRN	SSN.KUMAR	2.12.96	
				CHD	AROCKIAM A	7.12.96	
				APPD	SHANMUGASUNDARAM	7.12.96	
DEPT	MPG	GRADE OF UNTOOL DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DRG	ITEM NO	
CODE		C/M/F	1:1	0,75	320-05/667	22	
TITLE				CARD CODE	DRAWING NO :	REV	
COUPLING NUT				U 01	4-7-3412-00-05425	00	
SHAFT ASSY-SAM PUMP VO150/500+AR							

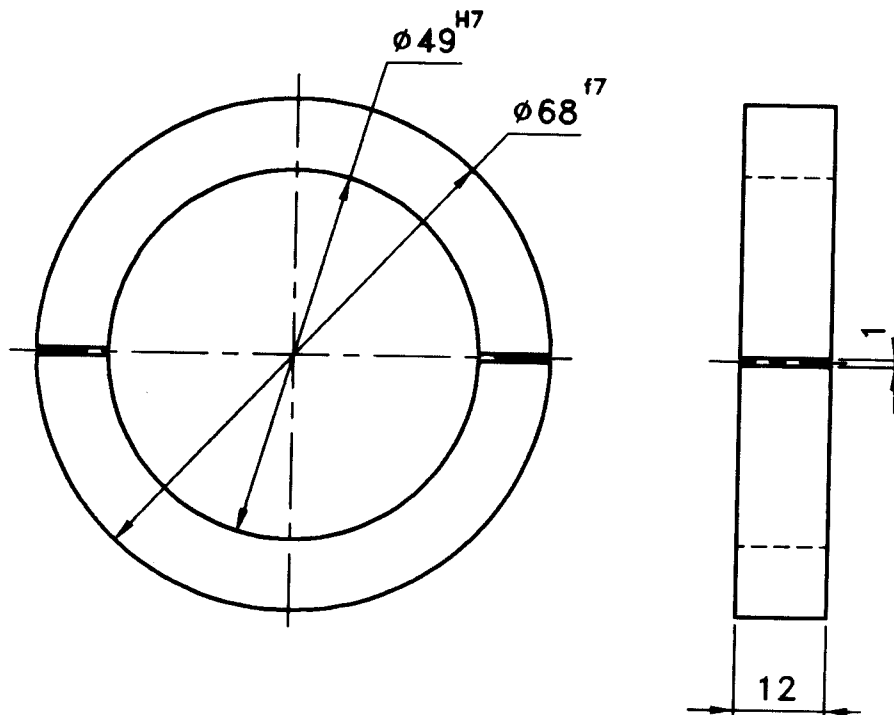
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ALL DIMENSIONS ARE IN MM

REV 01	DATE	ALTERED
		CHECKED
		APPROVED

1.6/

ø68 f7	-0,030
	-0,060
ø49 H7	+0,025
	0



ALL CORNERS CHAMFERED TO 1x45°

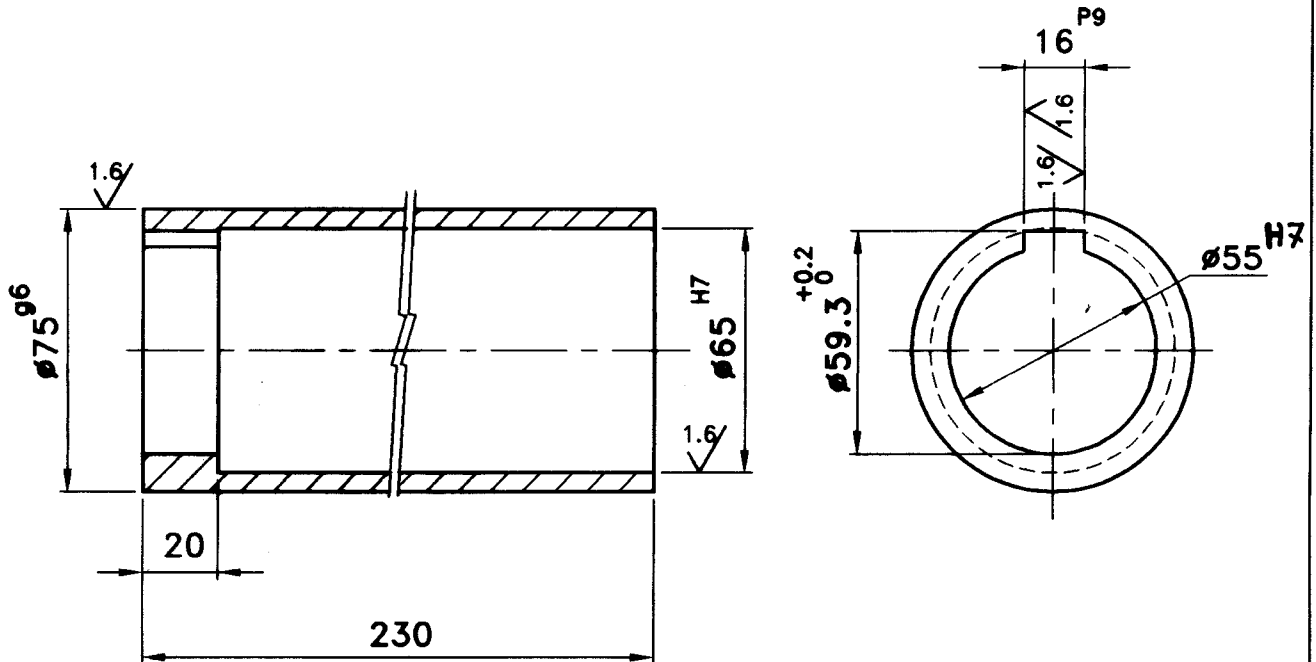
				AISI410			
ITEM NO	DESCRIPTION		DRAWING NO		MATL CODE	UNIT WT	
EQPT: SCALE PIT & PUMP HOUSE				MATL SPEC		QTY	
		Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME SSN.KUMAR	SIGNATURE <i>SSN.Kumar</i>	DATE 2.12.96
				CHD	AROCKIAM A	<i>A. Arockiam</i>	7-12-96
				APPD	SHANMUGASUNDARAM S	<i>S. Shanmugasundaram</i>	7-12-96
DEPT MPG	GRADE OF UNTOL DIM C/M/F		SCALE 1:1	WEIGHT (Kg) 0,16	REF TO ASSY DRG 820-05/2667		ITEM NO 18
CODE					REF TO OLD DRG		
TITLE COUPLING SPLIT RING				CARD CODE U 01	DRAWING NO : 4-7-3412-00-05426		REV 00
SHAFT ASSY-SAM PUMP VO150/500+AR							

ALL DIMENSIONS ARE IN MM

REV	DATE	ALTERED
01		CHECKED
		APPROVED

3.2/1.6/

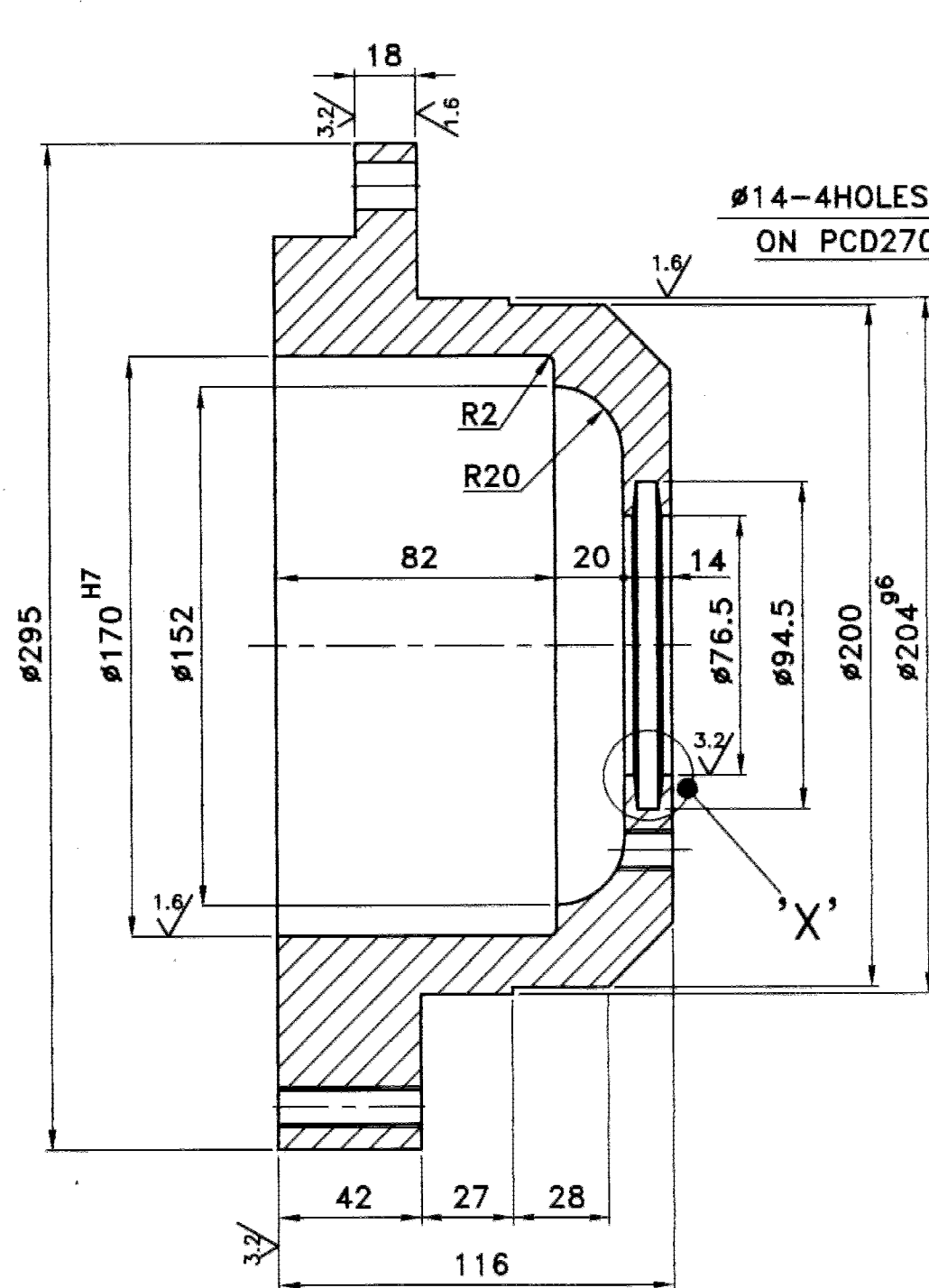
$\phi 55 H7$	$+0.030$	$\phi 75 g6$	-0.010
	0		-0.029
16 P9	-0.018	$\phi 65 H7$	$+0.030$
	-0.061		0



SHARP EDGES REMOVED BY 0.5x45°

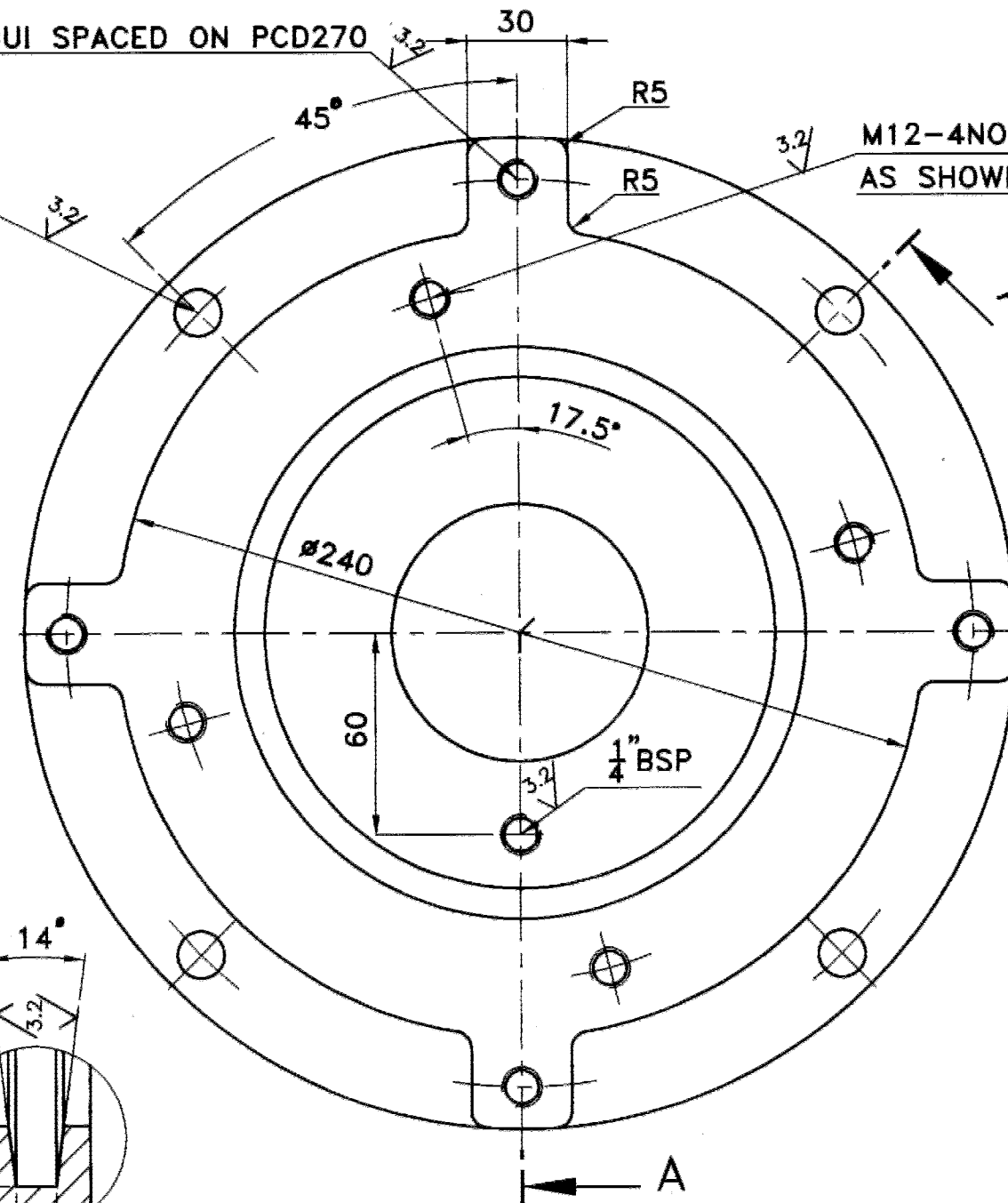
				AISI-410			
ITEM NO	DESCRIPTION	DRAWING NO		MATL CODE		UNIT WT	
				MATL SPEC		QTY	
EQPT: SCALE PIT PUMP HOUSE							
		Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME S. MOHAN RAJ	SIGNATURE <i>S. Mohan Raj</i>	DATE 05.12.97
				CHD	A. AROCKIAM	<i>A. Arockiam</i>	10.12.97
				APPD	S. SHANMUGASUNDARAM	<i>S. Shanmugasundaram</i>	10.12.97
DEPT MPG	GRADE OF UNTOL. DIM C/M/F		SCALE 1:1	WEIGHT (Kg) 2.130	REF TO ASSY DRG		ITEM NO
CODE					REF TO OLD DRG 820-06/2667		31
TITLE SHAFT SLEEVE (SAM PUMP VO150/500+AR)				CARD CODE U 01	DRAWING NO : 4-7-3412-00-05553		REV 00

ALL DIMENSIONS ARE IN MILLIMETERS



SECTION-AA

M12-4NOS.EQUI SPACED ON PCD270
 14-4HOLES EQUI SPACED ON PCD270
 M12-4NOS.SPACED AS SHOWN ON PCD206



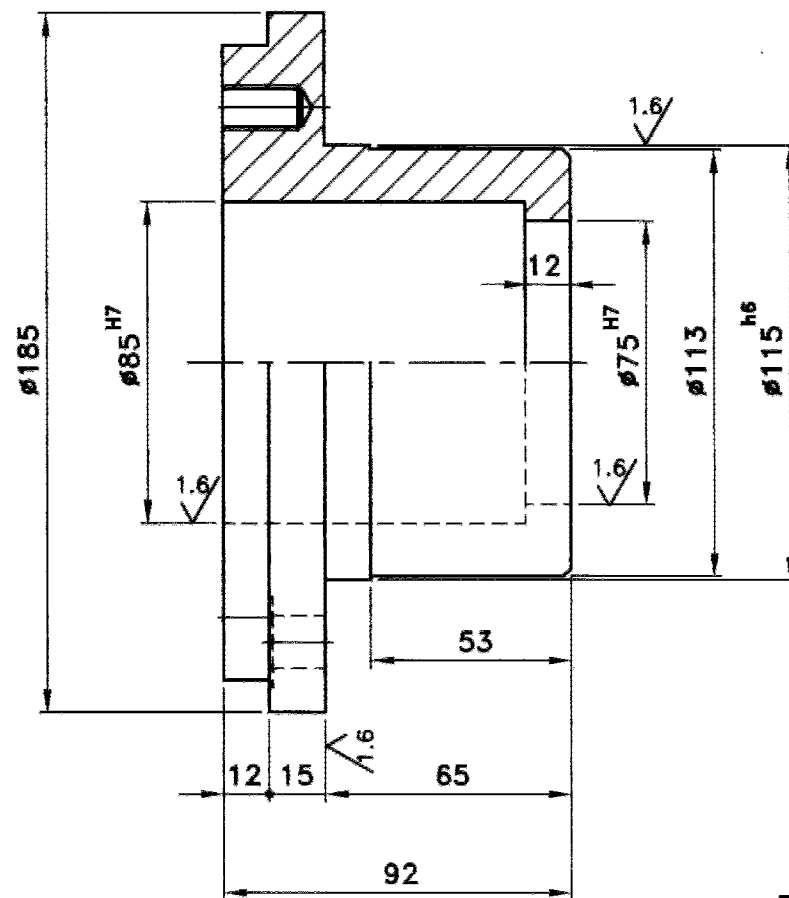
DETAIL-X
SCALE 1:1

ø170	H7	+0.040
		0
ø204	g6	-0.015
		-0.044

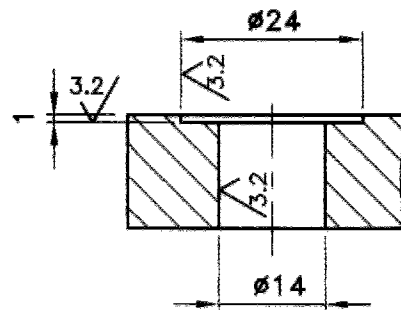
ITEM NO		DESCRIPTION		DRAWING NO		CI Gr FG200 IS:210		MATL CODE		UNIT WT	
								MATL SPEC		QTY	
EQPT: SCALE PIT & PUMP HOUSE											
Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014				DRN	NAME S.MOHAN RAJ		SIGNATURE <i>S. Mohan Raj</i>	DATE 12.11.97			
				CHD	A.AROCKIAM		SIGNATURE <i>A. Arockiam</i>	DATE 30.12.97			
				APPD	S.SHANMUGASUNDARAM		SIGNATURE <i>S. Shanmugasundaram</i>	DATE 01.01.98			
REV	DATE	ALTERED :		DEPT	GRADE OF UNTOOL. DIM		SCALE		WEIGHT(kg)		REF TO ASSY DWG NO
01		CHECKED :		MPG	C/M/F		1:2, 1:1		18.500		REF TO OLD DWG NO
ZONE		APPROVED		CODE							820-06/2667
				TITLE				CARD CODE		DRAWING NO :	
				BEARING HOUSING (SAM PUMP VO150/500+AR)				U 01		3-7-3412-00-04116	
										REV	
										00	

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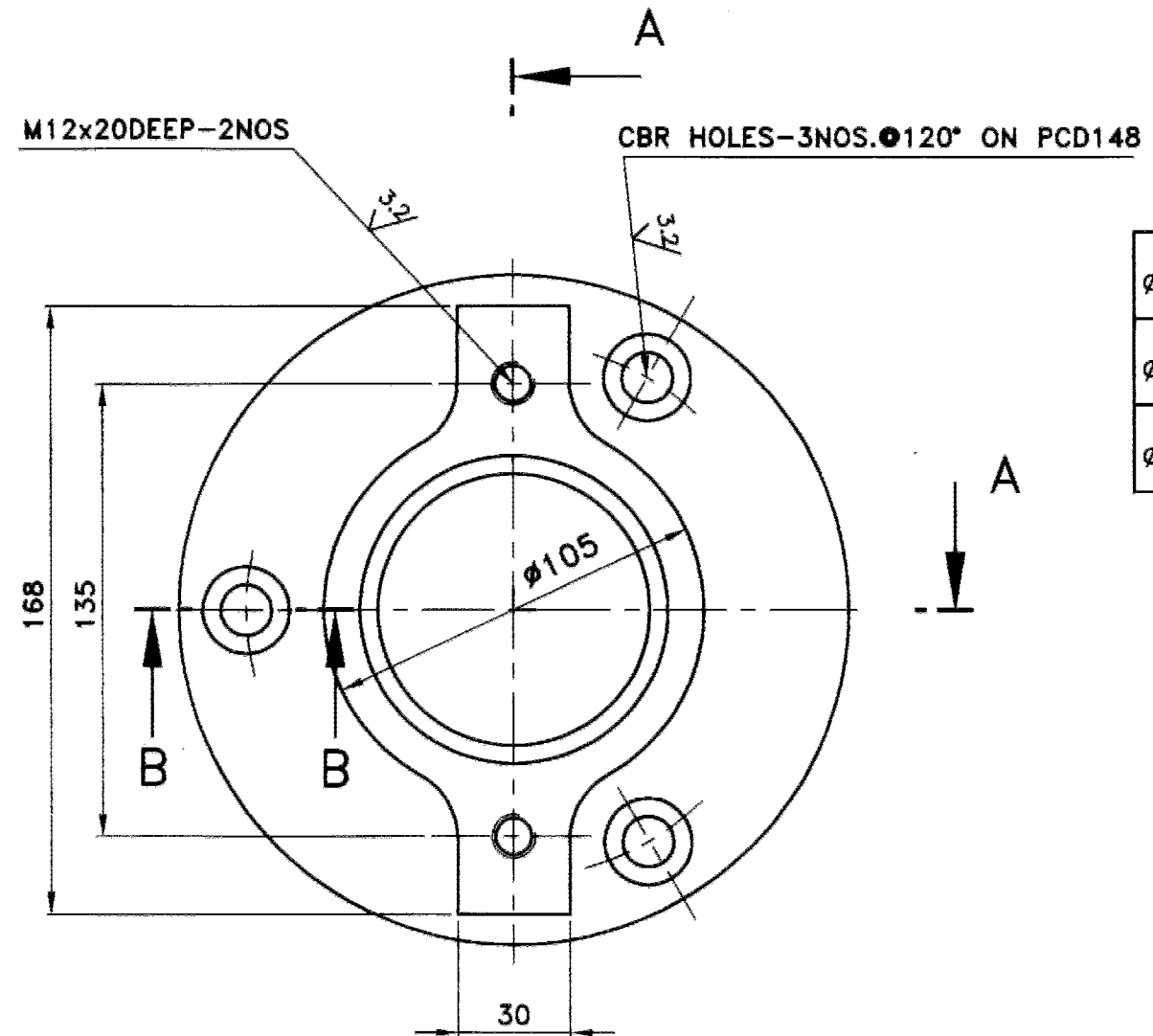


SECTION-AA



SECTION-BB

SCALE 1:1



ø75 H7	+0.030
	0
ø115h6	0
	-0.022
ø85 H7	+0.035
	0

REV 01	DATE	ALTERED :
		CHECKED :
		APPROVED
ZONE		

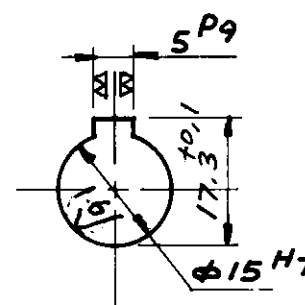
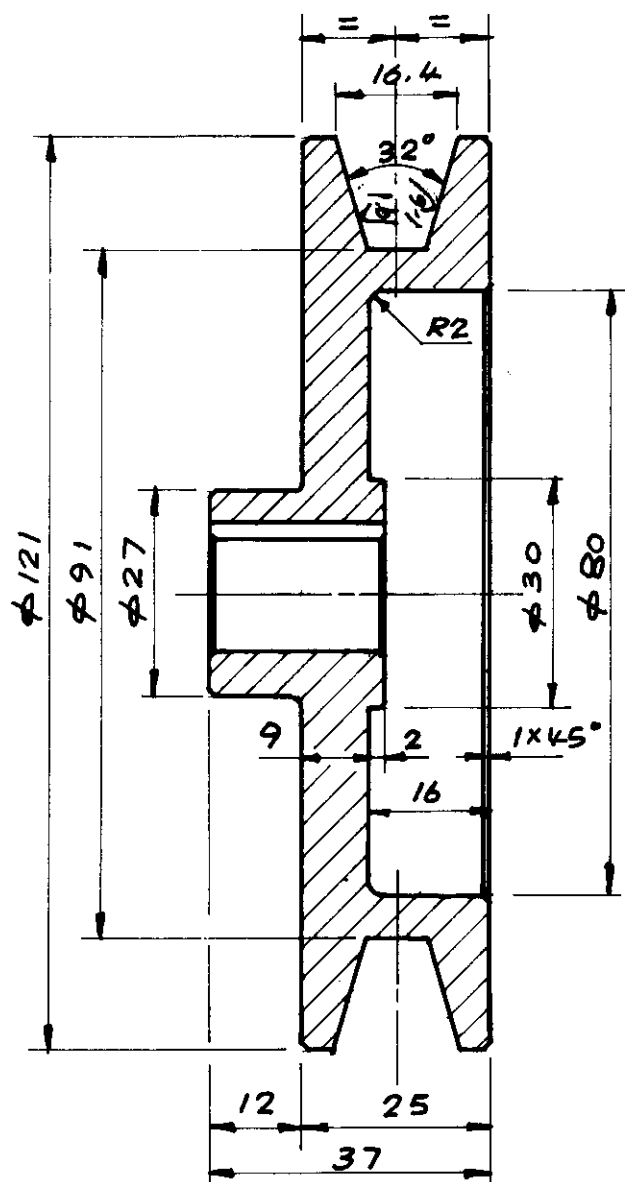
				CAST IRON			
				GrFG200		IS:210	
ITEM NO	DESCRIPTION			DRAWING NO		MATL CODE	UNIT WT
						MATL SPEC	QTY
EQPT: SCALE PIT & PUMP HOUSE							
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014				DRN	NAME S.MOHAN RAJ	SIGNATURE <i>S. Mohan Raj</i>	DATE 02.12.97
				CHD	A.AROCKIAM	<i>A. Arockiam</i>	19.12.97
				APPD	S.SHANMUGASUNDARAM	<i>S. Shanmugasundaram</i>	19.12.97
DEPT MPG	GRADE OF UNTOL. DIM		SCALE	WEIGHT(kg)	REF TO ASSY DWG NO		ITEM NO
CODE	C/MYF		1:2 , 1:1	5.250	REF TO OLD DWG NO 820-06/2667		11
TITLE				CARD CODE	DRAWING NO :		REV
GLAND HOUSING (SAM PUMP VO150/500+AR)				U 01	3-7-3412-00-04118		00

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REV 01	DATE	ALTERED
		CHECKED
ZONE		

3.2 ✓ / 1.6 ✓ /

$\phi 15 \text{ H7}$	+0.018
	0
5 P9	-0.012
	-0.042



		3008 15/1875	
ITEM NO.	DESCRIPTION	MATL CODE	UNIT WT
		MATL SPEC	QTY

EQPT: HEAVY DUTY LATHE NH26



Bharat Heavy Electricals Ltd.,

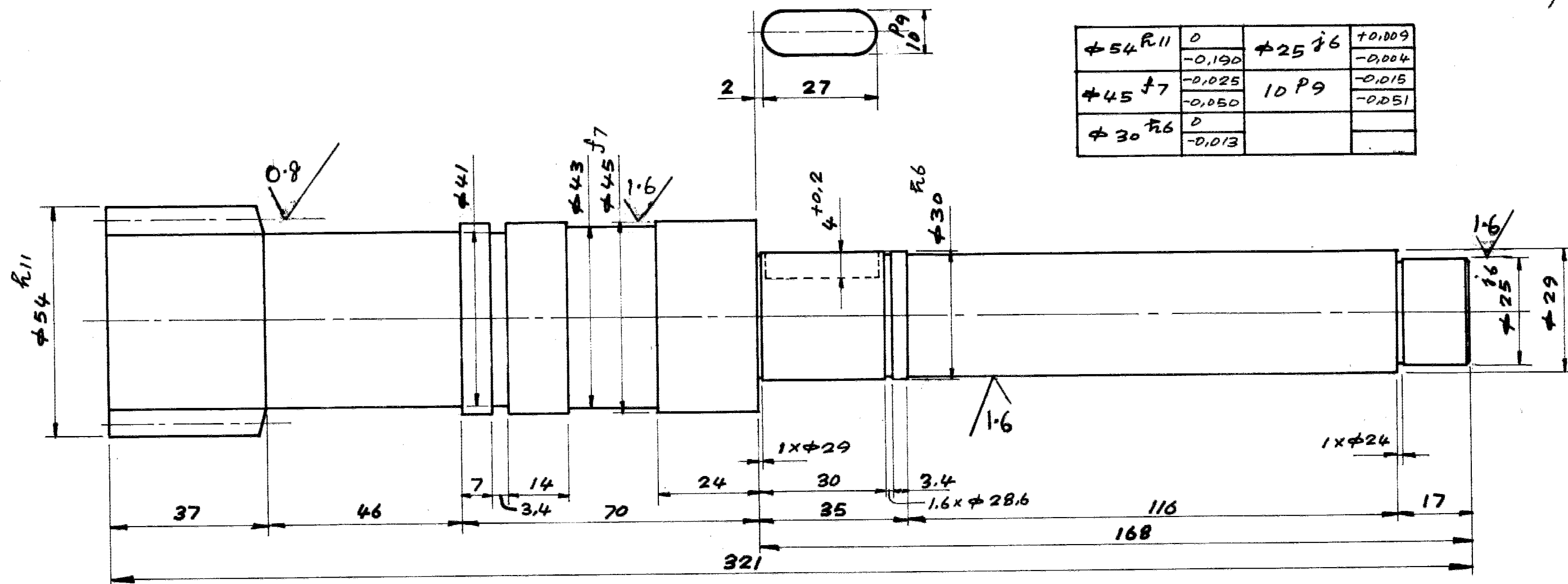
SEAMLESS STEEL TUBE PLANT
TIRUCHIRAPALLI-620 014

DRN	NAME SSN KUMAR	SIGN <i>[Signature]</i>	DATE 12.12.85
CHD			
APPD		<i>[Signature]</i>	8.12.85

DEPT	GRADE OF UNTOL. DIM		SCALE	WEIGHT (kg)	REF TO ASSY / OLD DRG	ITEM NO.
CODE	C/M/F		1:1	1.06		
TITLE V-PULLEY HYDRAULIC PUMP DRIVE			CARD CODE U 01	DRAWING NO. 4-7-3901-00-03151		REV. 00

FIRST ANGLE PROJECTION (ALL DIMENSIONS IN MILLIMETRES)

3.2 / 0.8 / 1.6



SHARP CORNERS CHAMFER TO 0.5X45°

NO OF TEETH	:	16
MODULE	:	3
PRESSURE ANGLE	:	20°
CORRECTION FACTOR	:	0.00
WIDTH ACROSS 3 TEETH:		22.8132 ^{+0.127} _{-0.169}
QUALITY & TOL. ZONE	:	9CDIN3967
MATING GEAR DRG-NO :		
MATING GEAR NO OF TEETH :		∞ (RACK)
CENTRE DISTANCE	:	-

		25.5517			
		C55 M475			
ITEM NO.	DESCRIPTION	DRAWING NO.	MATL CODE	UNIT WT	
			MATL SPEC	QTY	
EXPT:- BECO HEAVY DUTY LATHE TYPE: HD 50C/3000					
 Bharat Heavy Electricals Ltd., SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620 014		DRN	NAME	SIGN	DATE
		CHD	S.S.N. KUMAR	[Signature]	19.1.85
		APPD		[Signature]	21.1.85
DEPT	GRADE OF UNTO. DIM	SCALE	WEIGHT (kg)	REF TO ASSY / OLD DRG	ITEM NO.
CODE	C/M/F	1:1		SL M2 3003 c/a	
TITLE	PINION SHAFT (APRON GEAR BOX ASSY.)		CARD CODE	DRAWING NO	REV
			U 01	3-7-3902-00-02367	00