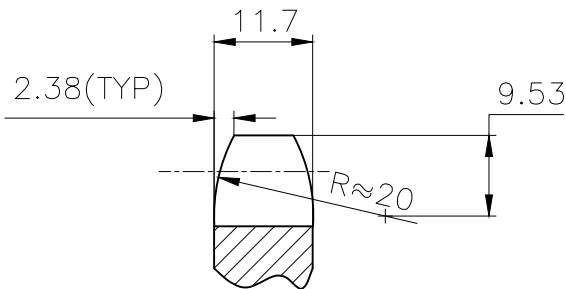
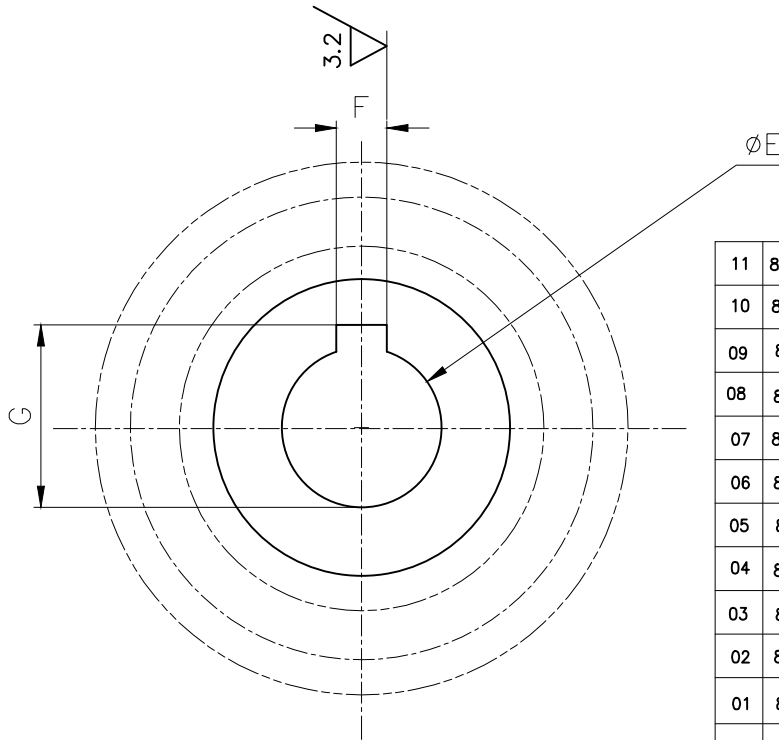
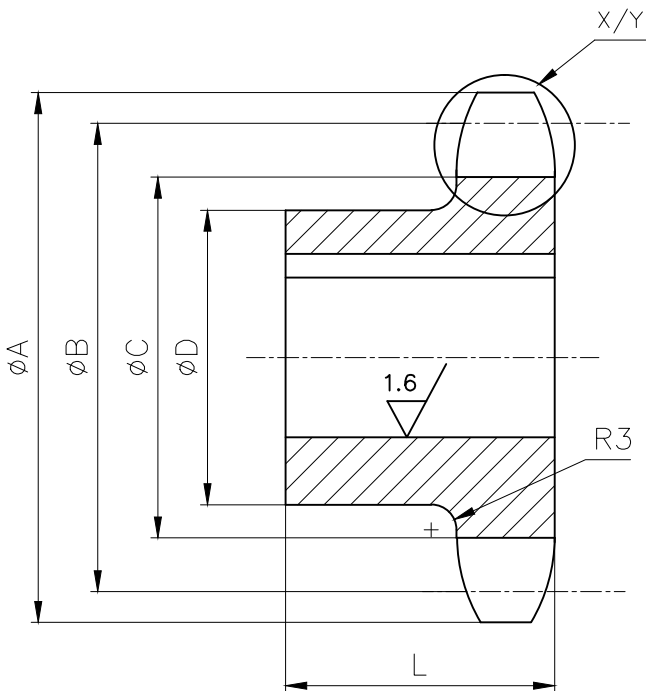
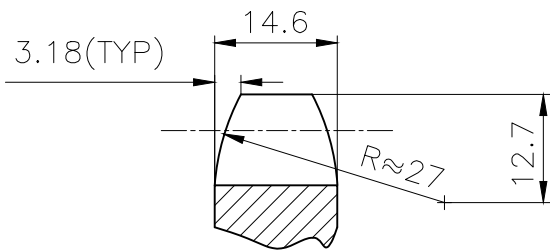


10710-100-07-3
DRAWING NO.

6.3 / 3.2 / 1.6



DETAIL-X
(FOR 3/4")



DETAIL-Y
(FOR 1")

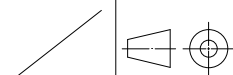
11	842083175000	9	3/4" SP	X	63.75	55.68	43.79	35	19 ^{+0.03} _{0.0}	6 ^{+0.0} _{-0.03}	21.8 ^{+0.10} _{0.0}	32 ^{0.0} _{-0.25}	0.200	--	
10	842083175100	9	3/4" SP	X	63.75	55.68	43.79	35	25.4 ^{+0.01} _{-0.01}	--	--	32 ^{0.0} _{-0.25}	0.190	963534490000	
09	842005153000	18	1" EP	Y	159	148.53	132.65	110	50 ^{+0.03} _{0.0}	14 ^{+0.05} _{+0.12}	53.8 ^{+0.10} _{0.0}	40 ^{0.0} _{-0.25}	3.500	963534480000	
08	842005153500	26	3/4" SP	X	168	158.04	146.13	80	30 ^{+0.02} _{0.00}	8 ^{+0.04} _{+0.10}	33.3 ^{+0.10} _{0.0}	32 ^{0.0} _{-0.25}	2.460	963534470000	
07	842005153400	18	3/4" SP	X	119	109.71	97.8	80	30 ^{+0.02} _{0.00}	8 ^{+0.04} _{+0.10}	33.3 ^{+0.10} _{0.0}	32 ^{0.0} _{-0.25}	1.500	963534460000	
06	842000143900	20	3/4" SP	X	131.72	121.77	109.88	80	40 ^{+0.04} _{0.0}	--	--	32 ^{0.0} _{-0.25}	1.900	963534450000	
05	842000102000	20	3/4" SP	X	131.72	121.77	109.88	80	40 ^{+0.04} _{0.0}	12 ^{+0.0} _{-0.04}	43.3 ^{+0.1} _{0.0}	32 ^{0.0} _{-0.25}	1.900	963534440000	
04	842000103700	14	3/4" SP	X	94.92	85.62	73.71	62	22 ^{+0.03} _{0.0}	6 ^{+0.0} _{-0.03}	24.8 ^{+0.1} _{0.0}	32 ^{0.0} _{-0.25}	1.050	963534430000	
03	842000130900	21	3/4" EP	X	138	129.26	116.99	98	40 ^{+0.04} _{0.0}	--	--	32 ^{0.0} _{-0.25}	2.210	963534420000	
02	842000168700	21	3/4" EP	X	138	129.26	116.99	98	40 ^{+0.04} _{0.0}	12 ^{+0.0} _{-0.04}	43.3 ^{+0.1} _{0.0}	32 ^{0.0} _{-0.25}	2.200	963534410000	
01	842000168600	15	3/4" EP	X	101	93.67	81.25	60	40 ^{+0.04} _{0.0}	12 ^{+0.0} _{-0.04}	43.43 ^{+0.1} _{0.0}	32 ^{0.0} _{-0.25}	0.730	963534400000	
VAR. No.	PART CODE	NO.OF TEETH	PITCH	DETAIL	A	B	C	D	E	F	G	L	WEIGHT IN KG / UNIT	SUB DELIVERY CODE	REMARKS
TOOTH PROFILE									DIMENSIONS						

NOTES:-

1. SP- STANDARD PITCH AS PER ANSI B29.1 (LATEST VERSION)
2. E.P- DOUBLE PITCH AS PER ANSI B29.3 (LATEST VERSION)
3. MATERIAL - EN 8 / AISI 1045 / IS1875 CL IV
4. TOLERANCE ON TOOTH DIMENSION AS PER ANSI
5. TOLERANCE ON OTHER DIMENSION-IS 2102 (LATEST VERSION)
6. SPROCKET TEETH TO BE HARDNED 50 - 55 RC
7. CHAIN ROLLER Ø11.91mm FOR 3/4" PITCH & Ø15.88mm FOR 1' PITCH
8. SPROCKET TO BE PHOSPATED.
9. DO NOT HARDEN BORE / HUB

REV	DATE	ALTERED	J.S
02	15.05.14	CHD & APPD	S.K.G & H.R
ØE POSITION CORRECTED.			
DCN : SB : 801745/5018204			

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	SPROCKET	—	IS1875 CL IV	REFER NOTE 6 & 9	—	—	—	—	—
NO OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT									
 365-126 BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI-620014.				DRN	NAME J.SANKAR	SIGN J.S	DATE 31.05.13	NO.OF VAR.	
				CHD	S.K.GUPTA	S.K.G	31.05.13		
				APPD	HIRENDRA RAUT	H.R	31.05.13		
DEPT SB			SCALE NTS	WEIGHT (KG). —	REFERENCE INFORMATIONS				NO. OF ITEMS
CODE 330									
TITLE SPROCKET TYPE 'B'				CARD CODE U 01	DRAWING NO. 3-20-001-0120102				REV

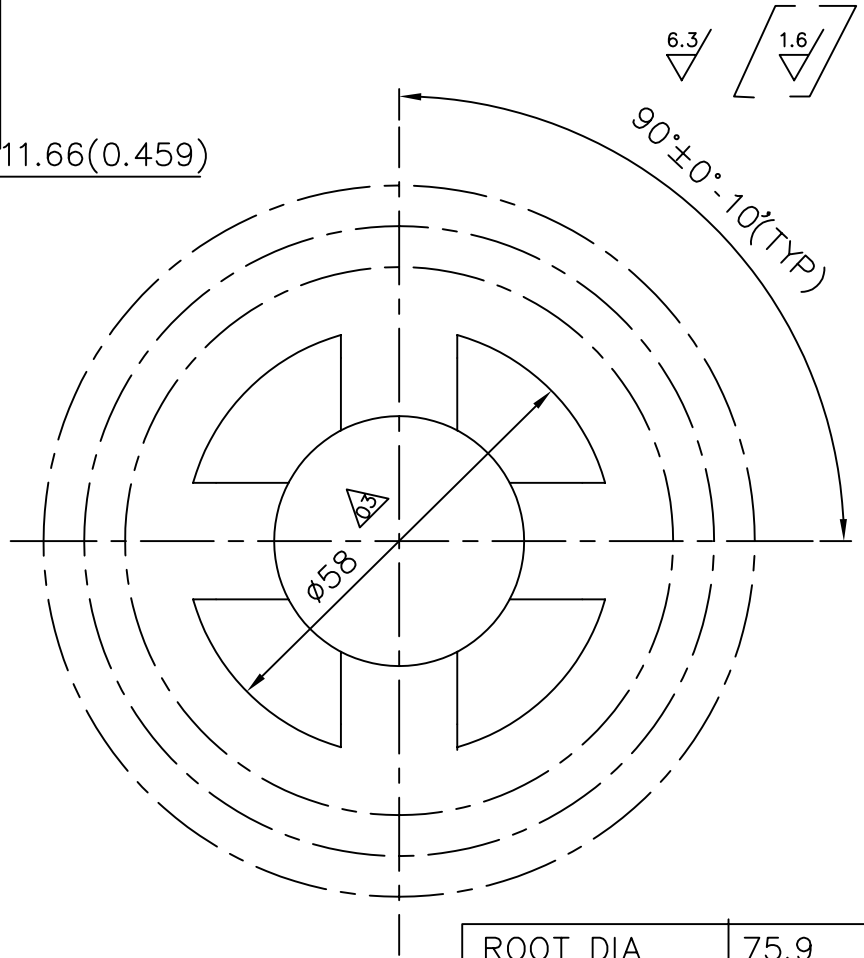
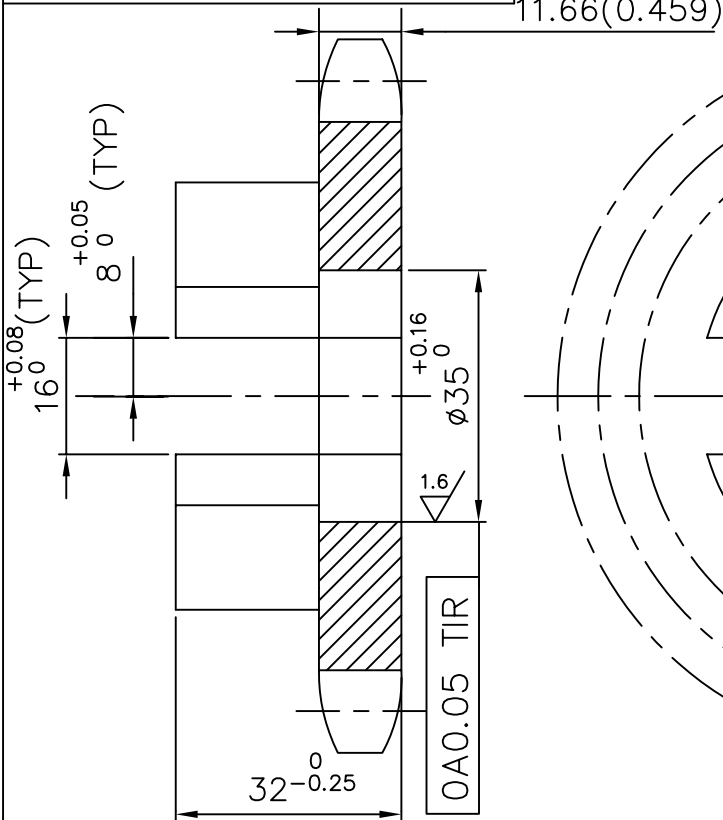
ALL DIMENSIONS ARE IN MILLIMETRES.

FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP/QP

REV	DATE	ALTERED	J.S.
03	17.09.08	CHD & APPD	K.S.

DIM.Ø58 WAS Ø61.

DCN:SB:800863 DT:17.09.08



ROOT DIA	75.9
PITCH	1 1/2"
NO OF TEETH	14
OUT SIDE DIA	95
PITCH DIA	87.81

NOTES: -

1. SPROCKET TEETH SHOULD BE CUT WITH HOBGING CUTTER.
2. THE HOB SHOULD BE AS PER ASAB 29a
ROLLER DIA OF CHAIN Ø 11.91 REF A IS OD OF SPROCKETØ95
3. FOR QUALITY REQUIREMENTS REFER APPLICABLE LATEST QUALITY PROCEDURE.

PART CODE : 842095242000

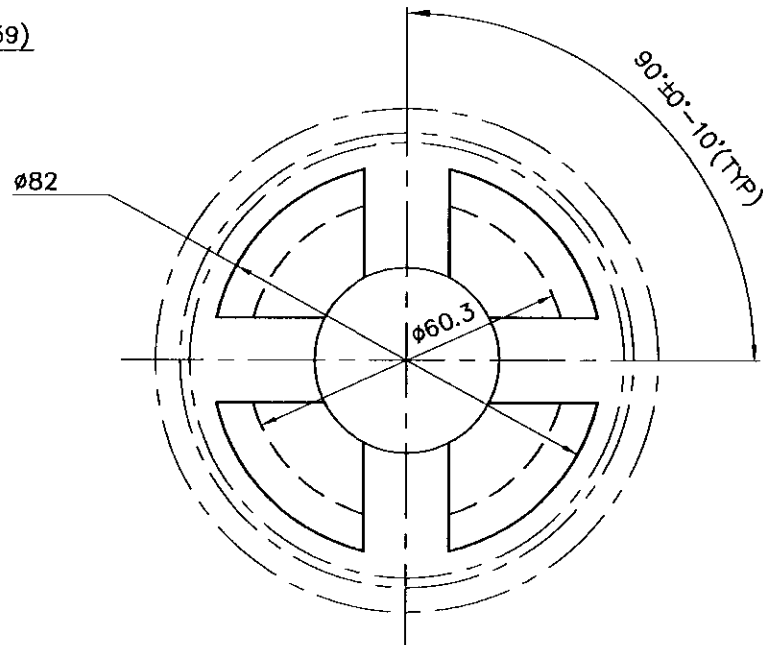
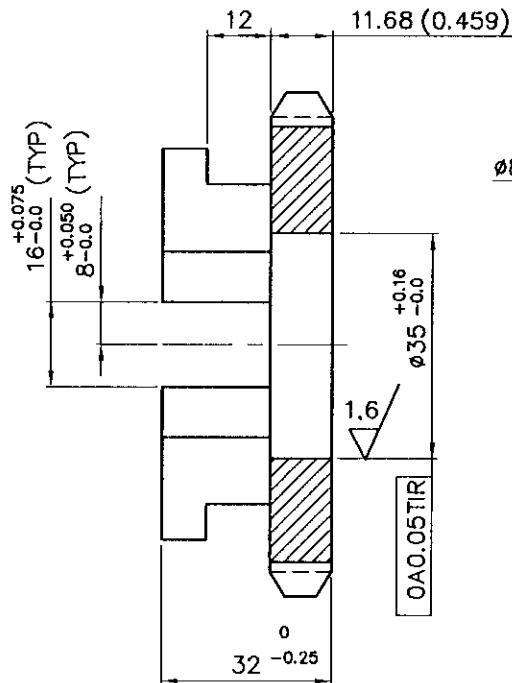
01	4-20-001-00812	92-037-048	IS:1875 CL4			1.200			01
NO OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
 BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI 620014.				DRN	NAME J.SANKAR		SIGN J.S	DATE 17.09.08	NO.OF VAR
				CHD	K.SRIDHARAN		K.S	17.09.08	
				APPD	S.NATARAJAN		S.N	17.09.08	
DEPT SB			SCALE	WEIGHT (KG).	REFERENCE INFORMATION				NO. OF ITEMS
CODE 330			NTS	1.20	S-73125				
TITLE				CARD CODE	DRAWING NO.				REV
SPROCKET-14T (EP)				U 01	4-20-952-01571				03

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ALL DIMENSIONS ARE IN MILLIMETRES.

FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP/QP

REV	DATE	ALTERED
03	11.06.01	CHD & APPD
DRG.UPDATED AND REDRAWN.		
DCN: SB: 1298		

6.3 $\sqrt{\quad}$ (1.6 $\sqrt{\quad}$)

ROOT DIA	73.71
PITCH	19.05
NO.OF TEETH	14
OUT SIDE DIA	94.92
PITCH DIA	85.62

NOTE: -

FOR QUALITY REQUIREMENTS REFER APPLICABLE
LATEST QUALITY PROCEDURES.SPROCKET TEETH SHOULD BE CUT WITH A HOBGING
CUTTER. THE HOB SHOULD BE AS PER ASAB29A
ROLLER DIA OF CHAIN 0.468/0.464 REF [A] IS OD OF
SPROCKET 94.92

PART CODE : 842083179400

01	DIA 100	15-026-363	IS 1875 CL4			1.200			01
NO OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
 BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI 620014.				NAME DRN V.ARUMUGAM CHD K.SRIDHARAN APPD S.NATARAJAN		SIGN DATE		NO.OF VAR	
DEPT SB		SCALE		WEIGHT (KG).		REFERENCE INFORMATION			
CODE 330		NTS		1.200					
TITLE				CARD CODE	DRAWING NO.				REV
SPROCKET-14T				U 01	4-20-831-02026				03

Size A4

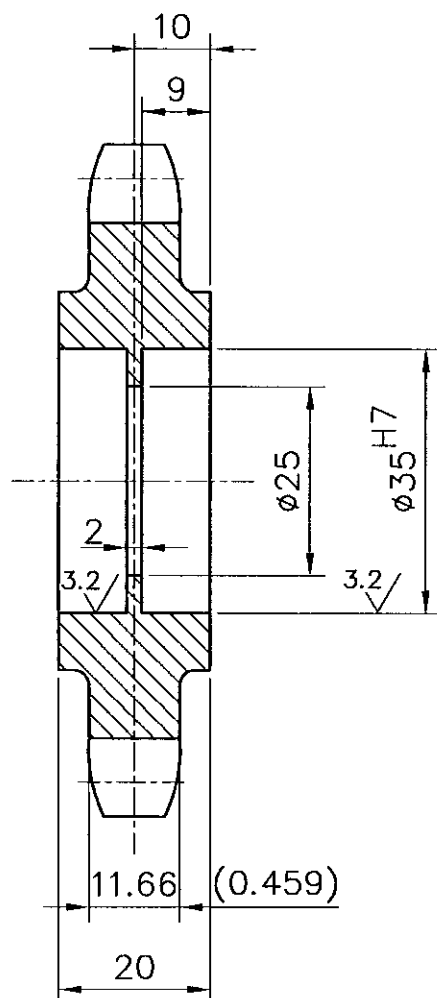
CAUTION: The information on this document is the property of BHARAT HEAVY ELECTRICALS LTD. It must not be used directly or indirectly in any way detrimental to the interest of the company.

REV	DATE	ALTERED
01	11.06.01	CHD & APPD

DRG.UPDATED AND REDRAWN.

DCN: SB:1298

6.3 3.2

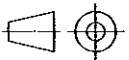


DIMENSION	TOLERANCE
$\phi 35^{H7}$	+0.025
	0.000

	INCH	MM
OUTSIDE DIA	3.492	88.7
PITCH CIRCLE DIA	3.133	79.58
ROOT DIA	2.675	67.95
HUB DIA	2.262	57.45
PITCH	3/4	19.05
No.OF TEETH – 13 Nos		

1. FOR QUALITY REQUIREMENTS REFER APPLICABLE LATEST QUALITY PROCEDURE.

PART CODE : 842083176400

01	ROD DIA 100 L=20	15 026 363	IS 1875 CI 4			0.470			01
NO OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
 BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI 620014.					DRN	NAME V.ARUMUGAM	SIGN	DATE	NO.OF VAR
					CHD	K.SRIDHARAN			
					APPD	S.NATARAJAN			
DEPT SB			SCALE	WEIGHT (KG).	REFERENCE INFORMATIONS				NO. OF ITEMS
CODE 330			NTS						
TITLE					CARD CODE	DRAWING NO.			REV
SPROCKET 13T.					U 01	4-20-831-01022			01

ALL DIMENSIONS ARE IN MILLIMETRES.

FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP/QP

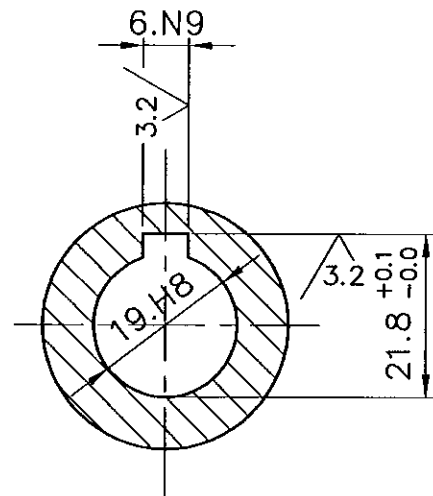
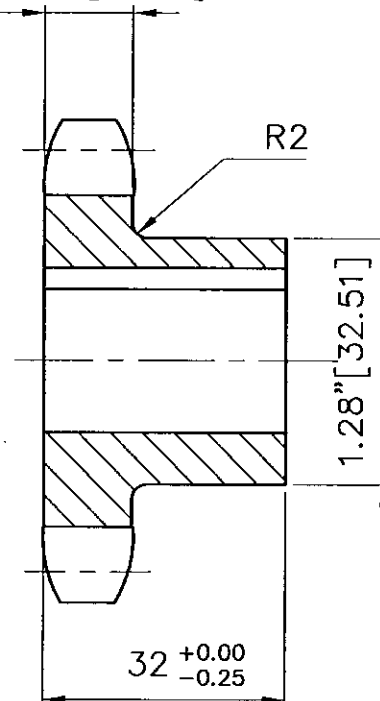
REV	DATE	ALTERED
01	11.06.01	CHD & APPD
DRG.UPDATAED AND REDRAWN.		
DCN: SB: 1298		

6.3 $\sqrt{\quad}$ (3.2 $\sqrt{\quad}$)

DIMENSION	TOLERANCE
Ø19 H8	+0.033
	0.000
6 N9	0.000
	-0.030

	INCH	MM
PITCH	3/4	19.05
PITCH CIRCLE DIA	2.192	55.68
ROOT DIA	1.724	43.79
OUTSIDE DIA	2.51	63.75
HUB DIA	1.28	32.51
No. OF TEETH	9 Nos.	—

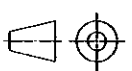
0.459" [11.66]



NOTES: -

1. FOR QUALITY REQUIREMENTS REFER APPLICABLE LATEST QUALITY PROCEDURE.

PART CODE : 842083175000

01	ROD DIA80; L-32	15 004 116	IS1875CI4			0.200			01
NO OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
 BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI 620014.				DRN	NAME V.ARUMUGAM		SIGN	DATE	NO.OF VAR
				CHD	K.SRIDHARAN				
				APPD	S.NATARAJAN				
DEPT SB			SCALE	WEIGHT (KG).	REFERENCE INFORMATION				NO. OF ITEMS
CODE 330			NTS	0.200					
TITLE				CARD CODE	DRAWING NO.				REV
SPROCKET [9T]				U 01	4-20-831-00867				01

Size A4

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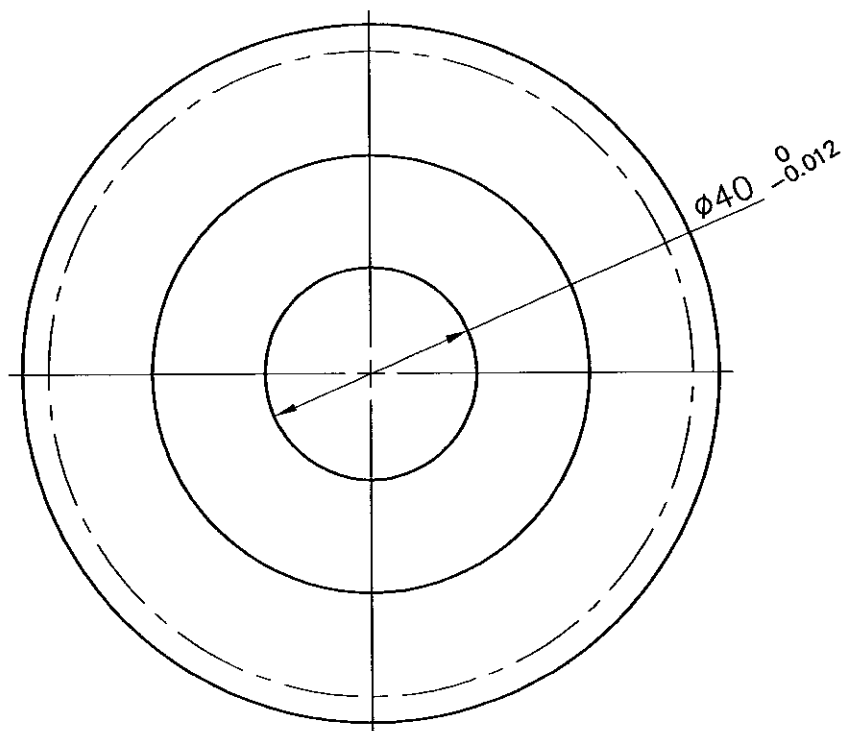
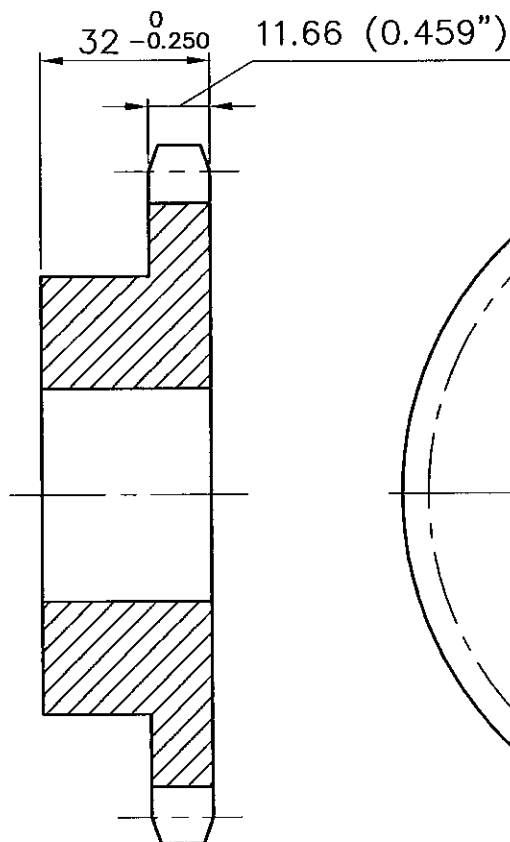
ALL DIMENSIONS ARE IN MILLIMETRES.

FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP/QP

REV	DATE	ALTERED
03	11.06.01	CHD & APPD
DRG.UPDATED AND REDRAWN.		
DCN: SB: 1298		

6.3/
▽

NO. OF TEETH	20	
PITCH	3/4"	19.05mm
PITCH DIA	4.794"	121.77mm
ROOT DIA	4.326"	109.88mm
OUT SIDE DIA	5.186"	131.72mm
HUB DIA	3.25"	82.55mm

**NOTE:**

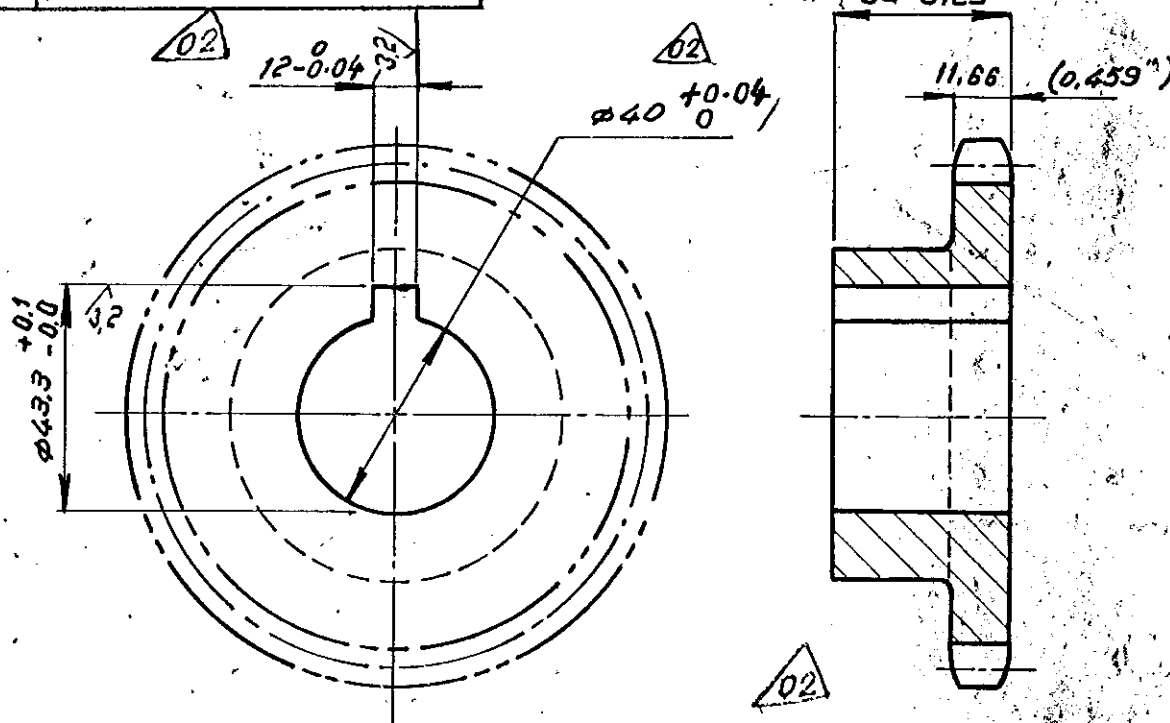
1.SPROCKET TO BE PHOSPHATED. SPROCKET TEETH SHOULD BE CUT WITH HOBGING CUTTER. THE HOB SHOULD BE AS PER ASA B29A ROLLER DIA OF THE CHAIN 0.468"/0.464".

2.FOR QUALITY REQUIREMENTS REFER APPLICABLE LATEST QUALITY PROCEDURE.

PART CODE : 842000143900

01	FORGING	92-037-046	IS1875C14			0.190			01
NO OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
 BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI 620014.				DRN	NAME V.ARUMUGAM		SIGN	DATE	NO.OF VAR
				CHD	K.SRIDHARAN				
				APPD	S.NATARAJAN				
DEPT SB		SCALE NTS		WEIGHT (KG). 0.190		REFERENCE INFORMATION			NO. OF ITEMS
CODE 330						3-20-001-00087			
TITLE SPROCKET-20T				CARD CODE U 01	DRAWING NO. 4-20-001-01714				REV 03

FILED 01 4-1-79	ALTERED 77 Ganeyan CHECKED [Signature]
ZONE 254	NOTES ADDED.



PART CODE: 842000117400

PITCH :	3/4"	19.05)
NO. OF TEETH :	36	
PITCH DIA :	8.805	218.57
ROOT DIA :	8.137	206.66
OUTSIDE DIA :	8.82	229
HUB DIA :	3.37	95

TEETH TO BE FLAME HARDENED TO
A DEPTH OF 2.5mm TO 5mm & TO A
HARDNESS OF 66-30 RC.

SPROCKET TO BE PHOSPHATED.

SPROCKET TEETH SHOULD BE CUT WITH A HOBBIING CUTTER
THE HOB SHOULD BE AS PER A.S.A B294
ROLLER DIA. OF CHAIN : 0.468" / 0.468" 11-91 02

15	17	20	21	REF. DRG./BPS No.	RVN	34	MATERIAL CODE	56	57	63	UNIT wt. (kg.)	68	75	76	20	DESCRIPTION/ REMARKS
ITEM No.	BPS				32	44	MATERIAL SPECN.	A	COMP. GROUP	70	No. OFF	8MI	DI			

CARD TYPE 1

CARD TYPE 2

BILL OF MATERIAL No.

FIRST ANGLE	SCALE	DRAWN	V. LAKSHMI HANTHAN	TOTAL wt. (kg)	
		CHECKED		TYPE	
		APPROVED			
ALL DIMENSIONS IN MILLIMETRES		DATE		NEW/OLD DRG. No.	S-162286

CAUTION



THE INFORMATION CONTAINED IN THIS
DRAWING IS THE PROPERTY OF
BHARAT HEAVY ELECTRICALS LIMITED.
BOILER PLANT UNIT, TIRUCHY-620 074.
AND SHALL NOT BE USED WITHOUT THEIR
EXPRESS WRITTEN PERMISSION IN ANY FORM
OR PART THEREOF FOR ANY OTHER PURPOSE
THAN FOR WHICH IT IS SENT TO YOU.

TITLE FOR: T30 MARK I

SPROCKET- 36T
(FOR 3.75 RPM)

DRAWING No.

CARD

4-204001-00291

REVISION

02

05-249

REV	DATE	ALTO	11/17/2000
02	14-11-95	CHINSKAPD	219
DYN. 218.57, 206.56, 229.895 WERE 218.87, 206.98, 229.41, 9525 PART CODE GIVEN DYN.NO: 581192			

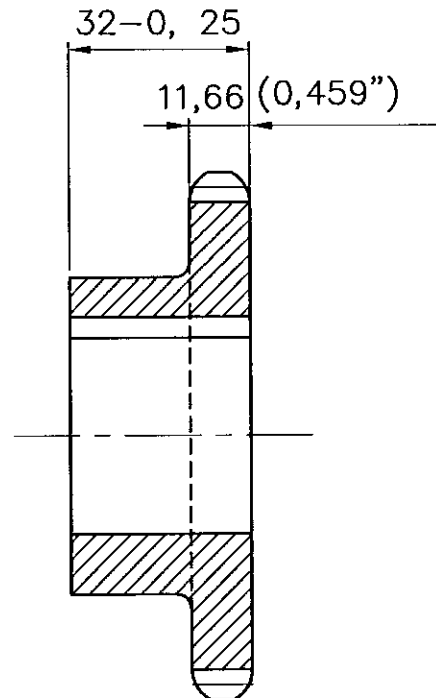
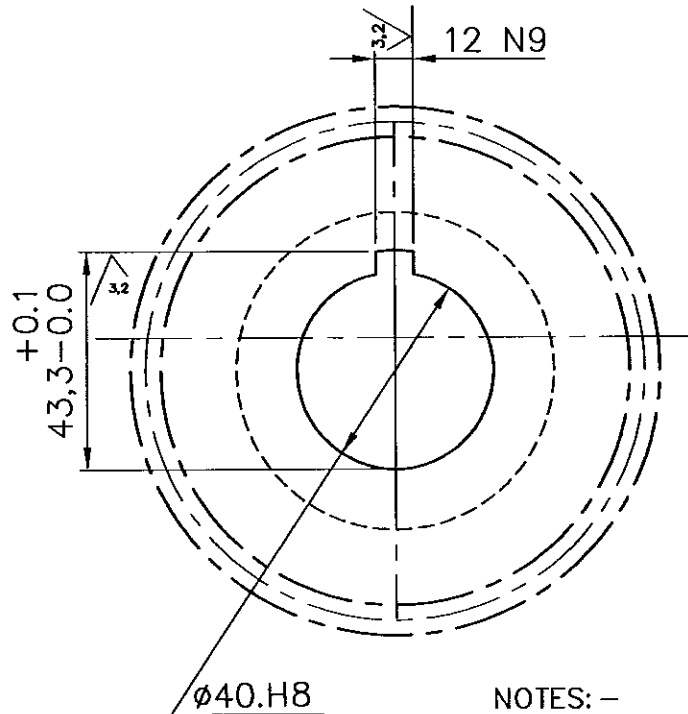
067809

ALL DIMENSIONS ARE IN MILLIMETRES.

FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP/QP

6,3 // 3,2 //

REV	DATE	ALTERED
04	11.06.01	CHD & APPD
DRG.UPDATED AND REDRAWN.		
DCN: SB: 1298		



NOTES: -

1. SPROCKET TEETH SHOULD BE CUT WITH A HOBGING CUTTER.
2. THE HOB SHOULD AS PER ASA B 29a
3. ROLLER DIA.OF CHAIN: 0.468"/0.464"
4. FOR QUALITY REQUIREMENTS REFER APPLICABLE LATEST QUALITY PROCEDURE.

PITCH : $3/4"$ (19,05)
 NO OF TEETH : 16
 PITCH DIA : 3,844" (97,64)
 ROOT DIA : 3,376", (85,75)
 OUTSIDE DIA : 4,22" (107,11)
 HUB DIA : 2,5" (63,5)

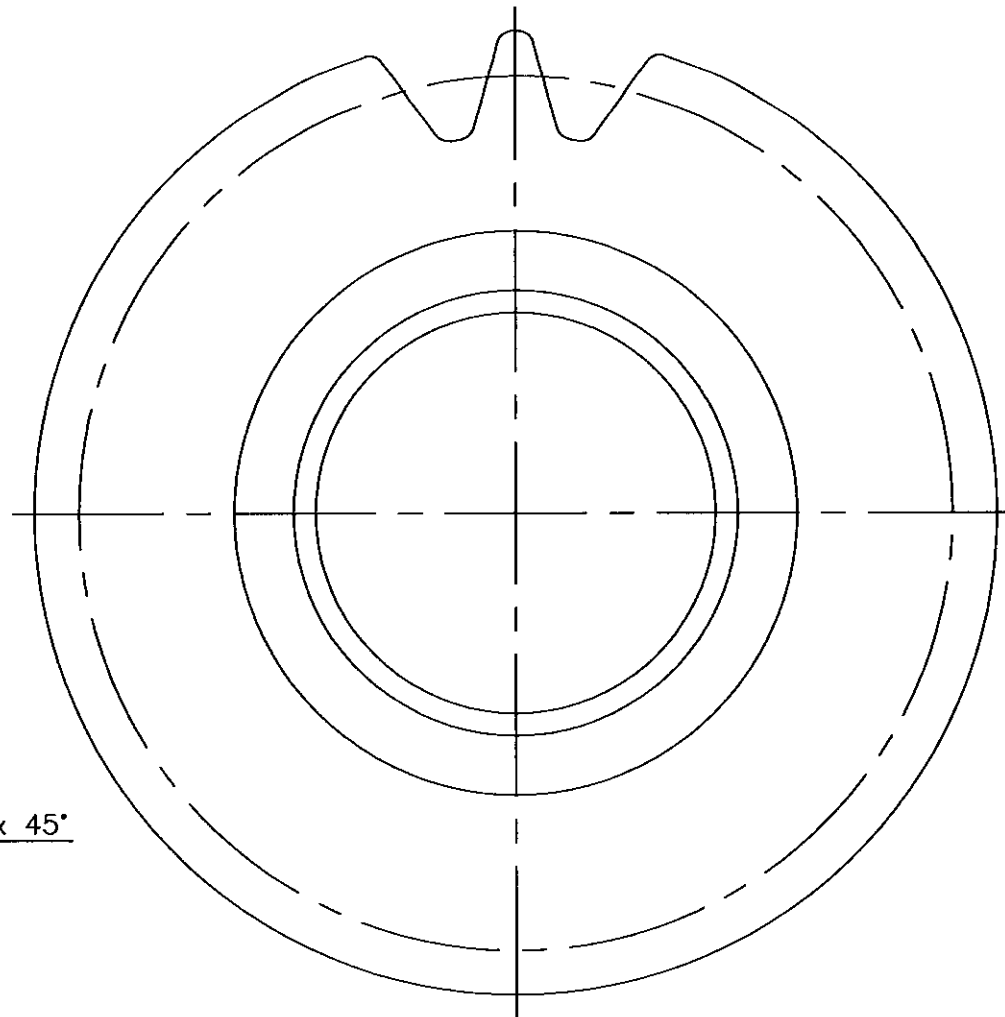
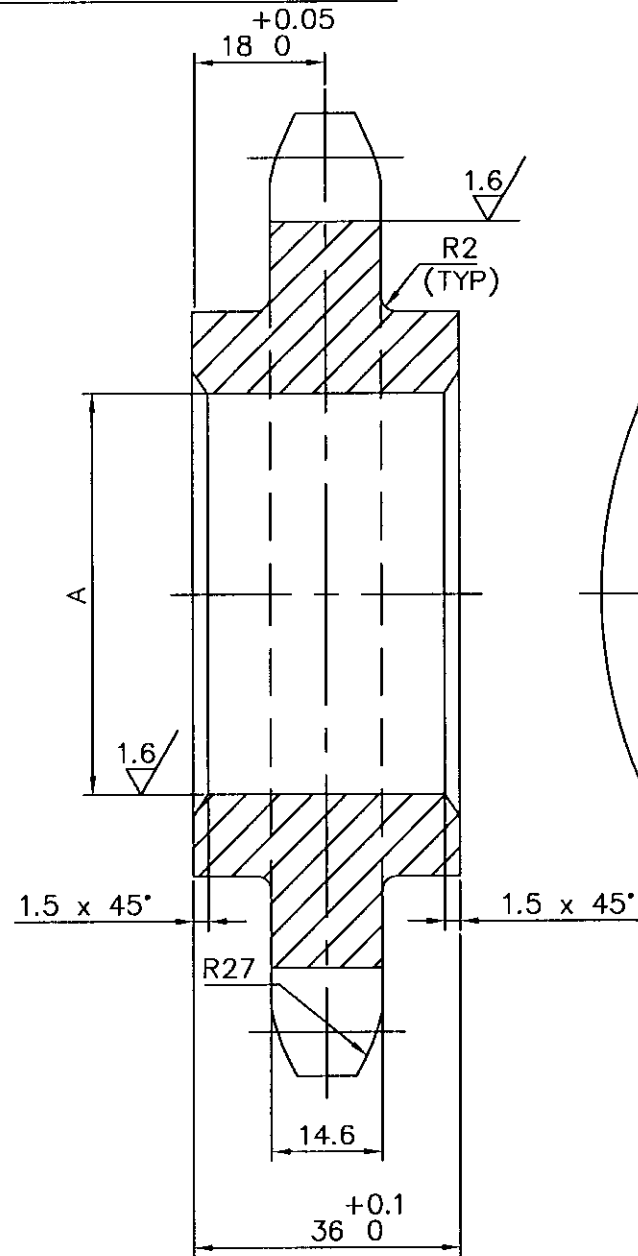
SPROCKET TO BE PHOSPHATED

PART CODE : 842000106800

02				92 037 768			1.00			FORMING
				IS 1875 CI4			1			
01				15 026 128			1.00			ROUND
				IS 1875 CI4			1			D 125; L32
No	ITEM No	BPS	REF.DRG./BPS No	MATERIAL CODE	BPS	COM.	UNIT WT.(Kg.)	BMI	DI	DESCRIPTION/REMARKS
				MATERIAL SPECN.			NO. OFF			
NO OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No	
				BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI 620014.		DRN	V.ARUMUGAM	SIGN	DATE	NO.OF VAR
				CHD	K.SRIDHARAN					
				APPD	S.NATARAJAN					
DEPT SB			SCALE	WEIGHT (KG).	REFERENCE INFORMATION				NO. OF ITEMS	
CODE 330			NTS	1.100.						
TITLE FOR: T-30MARK I					CARD CODE	DRAWING NO.				REV
SPROCKET-16 T					U 01	4-20-001-00098				04
(FOR -3,2MPN & 3,19 PRM)										

DRAWING NO. 3-20-051-00842

6.3 (1.6)



DATA	
DATA	2" *
HUB DIA	4.331" (110mm)
OUT SIDE DIA	6.366" (161.70mm)
ROOT DIA	5.217" (132.51mm)
PITCH DIA	5.848" (148.54)
No. OF TEEYH	18
CHAIN ROLLER DIA	15.88

NOTES: —

1. SPROCKET TO BE PHOSPHATED.
2. * PITCH GIVEN IS DOUBLE PITCH. ACTUAL MEASURED PITCH IS EQUAL TO 1.015" (25.792mm) BETWEEN ADJACENT TEETH.
3. SPROCKETS ARE TO BE AS PER SPECIFICATION ANSI : 29-3-R 1974.
4. FOR QUALITY REQUIREMENTS REFER APPLICABLE LATEST QUALITY PROCEDURE.

02	ø62 -0.02 -0.04	84 20 051 521 01
01	ø65 -0.075 -0.050	84 20 051 521 00
VAR	DIM A	PART CODE

REV	DATE	ALTERED
02	1.06.01	CHD & APPD
DRG.UPDATED AND REDRAWN.		

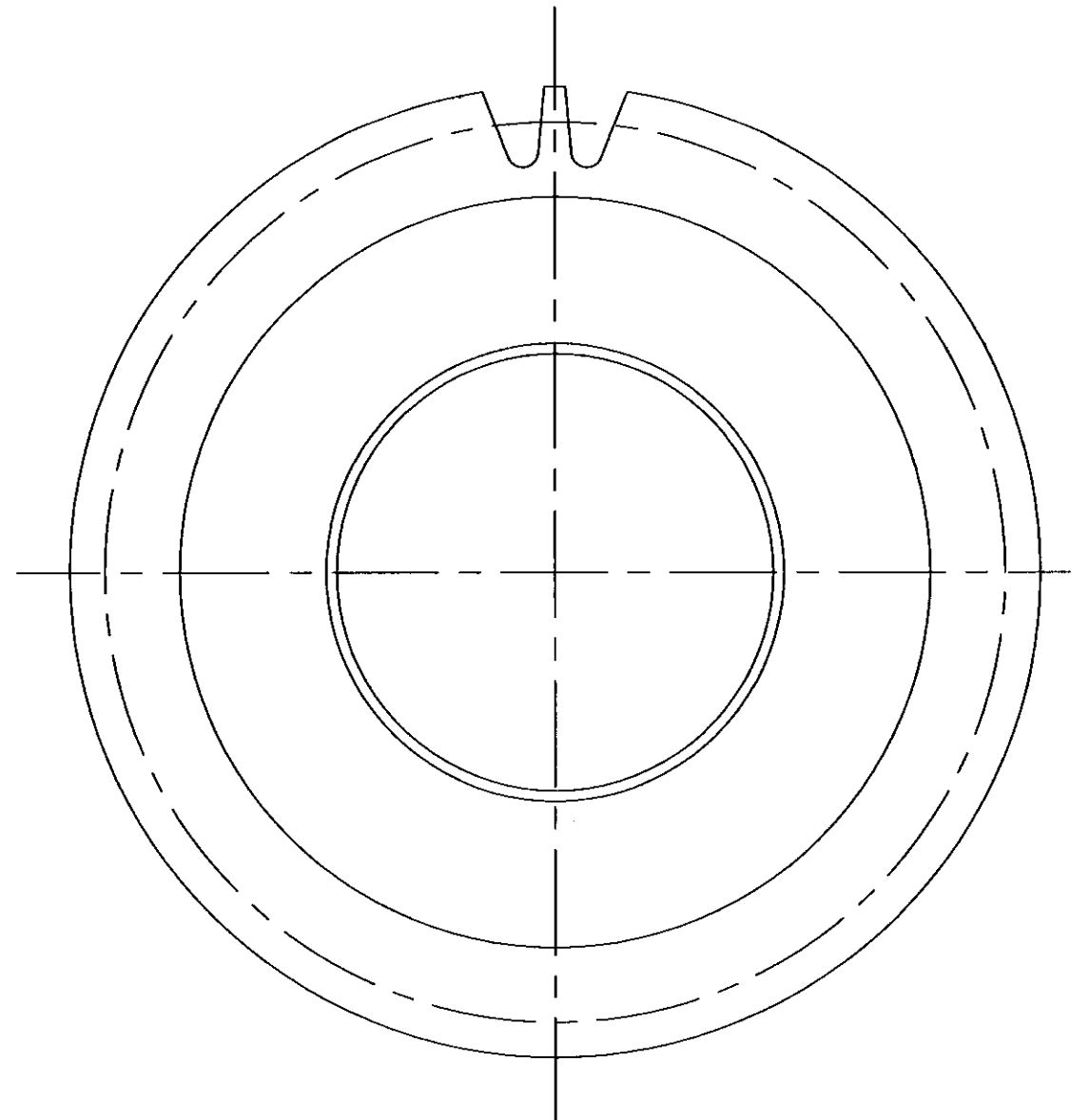
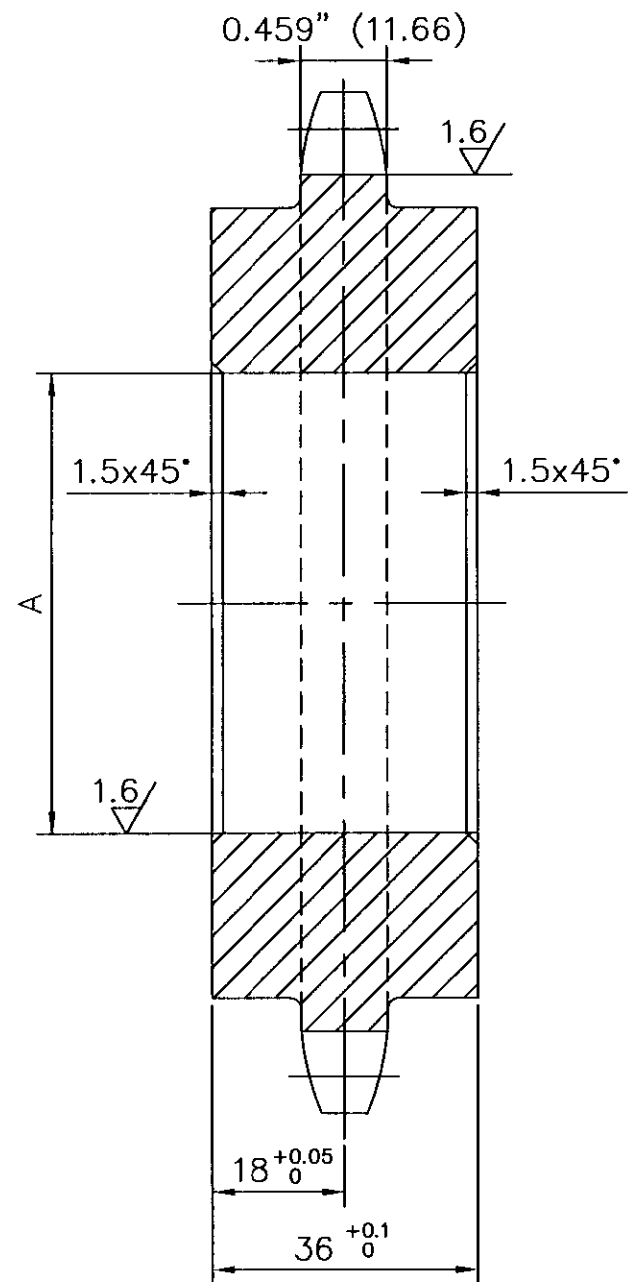
DCN:SB:1298

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1.	SPROCKET 18T FORGING	92 037 047	IS1875C14			3.83			1
NO OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT									
BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI-620014.						DRN	NAME V.ARUMUGAM	SIGN	DATE
365-121						CHD	K.SRIDHARAN		
						APPD	S.NATARAJAN		
DEPT SB		SCALE	WEIGHT (KG).	REFERENCE INFORMATION			NO. OF ITEMS		
CODE 330		NTS	3.83	3-20-051-00453					
TITLE CHAIN TIGHTENER SPROCKET (TRAVERSE SIDE)						CARD CODE	DRAWING NO.	REV	
						U 01	3-20-051-00842	02	

DRAWING NO. 3-20-051-00454

6.3/1.6/



PITCH DIA	5.032"
HUB DIA	4.195"
OUTSIDE DIA	5.425"
ROOT DIA	4.548"
NO. OF TEETH	21
PITCH	3/4"
CHAIN ROLLER DIA	11.91MM

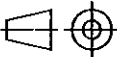
02	Ø62 $\begin{smallmatrix} -0.02 \\ -0.04 \end{smallmatrix}$	84 20 051 522 01
01	Ø65 $\begin{smallmatrix} +0.075 \\ +0.050 \end{smallmatrix}$	84 20 051 522 00
VAR	DIM 'A'	PART CODE

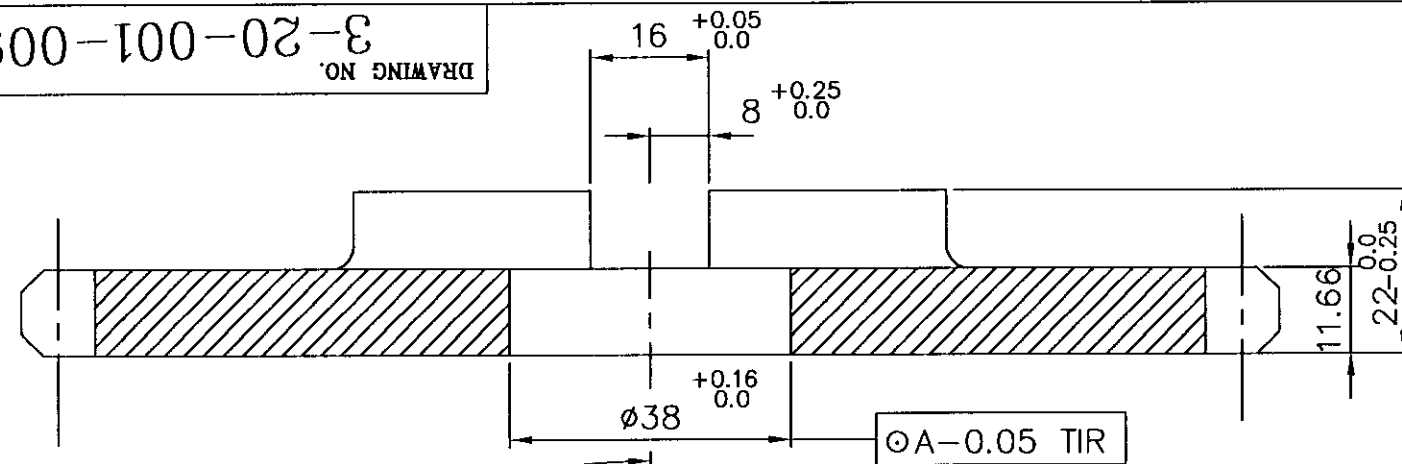
NOTE: —

1. SPROCKET TO BE PHOSPHATED.
2. SPROCKETS ARE TO BE AS PER SPECIFICATION ANSI 29-1-R1972
3. FOR QUALITY REQUIREMENTS REFER LATEST APPLICABLE QUALITY PROCEDURES.

REV	DATE	ALTERED
04	11.06.01	CHD & APPD
DRG.UPDATED AND REDRAWN.		
DCN: SB: 1298		

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01	FORGING	92 037 046	IS 1875 CI 4			2.10			1
NO OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT									
 365-121				DRN	NAME V.ARUMUGAM	SIGN	DATE	NO.OF VAR.	
BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI-620014.				CHD	K.SRIDHARAN				
				APPD	S.NATARAJAN				
DEPT VL			SCALE NTS	WEIGHT (KG). 2.10	REFERENCE INFORMATION 3-20-051-00451				NO. OF ITEMS
CODE 330									
TITLE CHAIN TIGHTENER SPROCKET (ROTARY SIDE)				CARD CODE U 01	DRAWING NO. 3-20-051-00454				REV 04

60600-100-02-3
DRAWING NO.

DATE	DIMENSION
PITCH	3/4"(19.05) mm
NO OF TEETH	23(11 1/2 EFFECTIVE)
PITCH DIA	141.22MM
ROOT DIA	128.98MM
OUT SIDE DIA (A)	150MM
HUB DIA	82.55MM

NOTES: —

1. SPROCKET TO BE PHOSPHATED
2. SPROCKET TEETH SHOULD BE CUT WITH A HOBGING CUTTER
3. THE HOB SHOULD BE AS PER ANSI B29.3(1974) ROLLER DIA OF CHAIN; 0.468/0.464(11.9MM)
4. FOR QUALITY REQUIREMENTS REFER LATEST APPLICABLE QUALITY PROCEDURES.

PART CODE : 842000168800

	FORGING		92 037047	IS1875CI4		1.950		02
	ROUND D 200; L22		15 004216	IS1875CI4		1.950		01
NO OF PIECES	DESCRIPTION	SEMPROSEQ	EMPROSEQ	MATLSPECN	SCRAP SORT	UNIT WTCKG	DRG NO	VAR NO

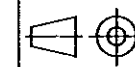
NO OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
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TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT



BHARAT HEAVY ELECTRICALS LTD.,
UNIT: HIGH PRESSURE BOILER PLANT.
TIRUCHIRAPALLI-620014.

DEPT
SB
CODE 330



SCALE
NTS

WEIGHT (KG).

DRN	NAME	SIGN	DATE	NO. OF VAR.
CHD	V. ARUMUGAM			
APPD	K. SRIDHARAN			
	S. NATARAJAN			

REFERENCE INFORMATION

NO. OF
ITEMS

TITLE

SPROCKET 23T
(FOR 1.62 & 2.1 PM)
(FOR LR DIE)

CARD
CODE
U 01

DRAWING NO.

3-20-001-00909

REV

02

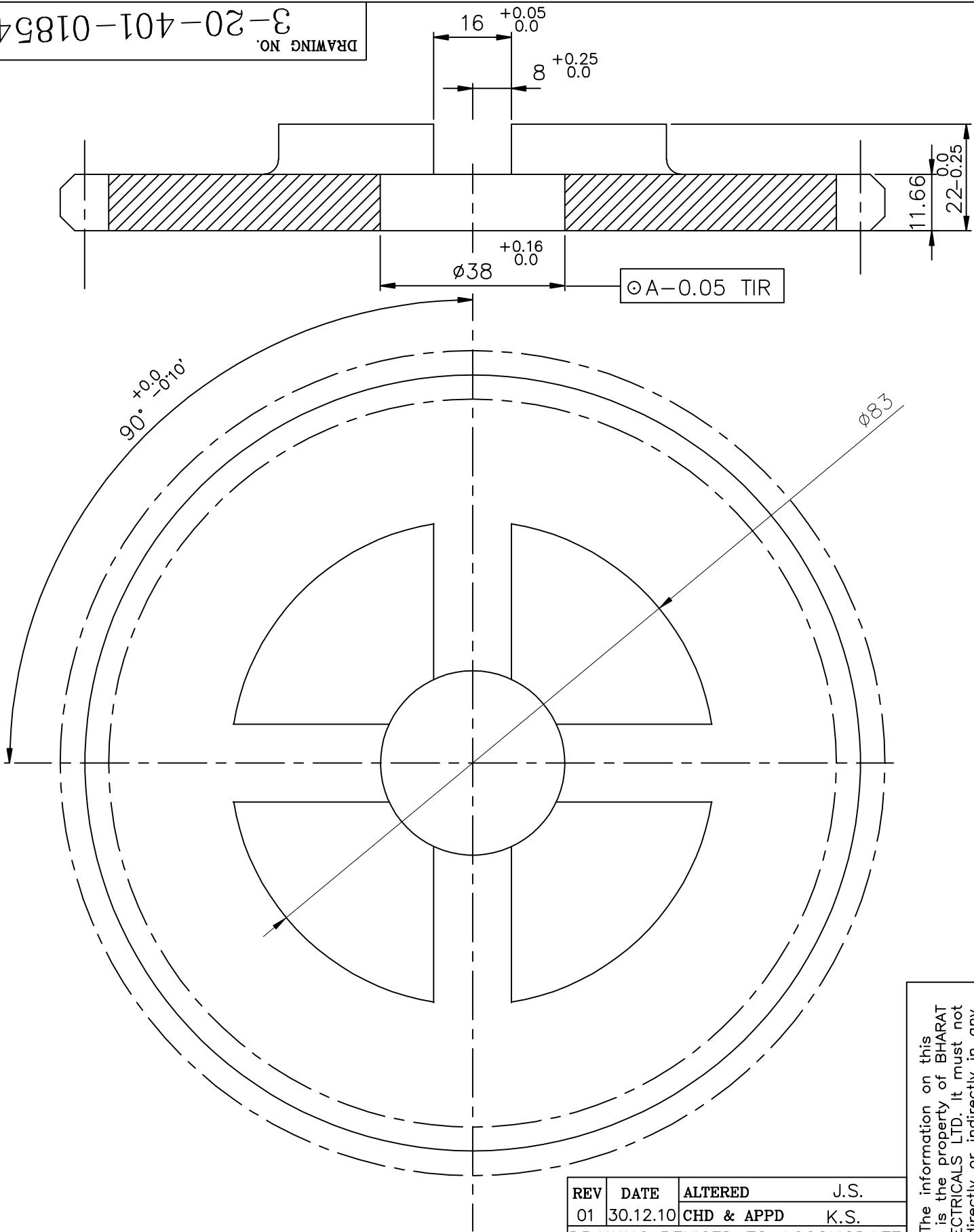
REV	DATE	ALTERED
02	11.06.01	CHD & APPD

DRG. UPDATED AND REDRAWN.

DCN: SB: 1298

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3-20-401-01854
DRAWING NO.



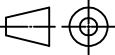
PITCH	3/4"	19.05MM
NO. OF TEETH	46	46
PITCH CIRCLE	10.990"	279.16MM
ROOT DIA	10.521"	267.25MM
OUTER DIA	11.459"	291.07MM
HUB DIA	2.5"	63.5 MM

NOTES: —

1. SPROCKET TO BE PHOSPHATED
2. SPROCKET TEETH SHOULD BE CUT WITH A HOBGING CUTTER
3. THE HOB SHOULD BE AS PER ANSI B29.3(1974) ROLLER DIA OF CHAIN; 0.468/0.464(11.9MM)
4. FOR QUALITY REQUIREMENTS REFER LATEST APPLICABLE QUALITY PROCEDURES.

PART CODE : 842040103800

02	FORGING		IS 1875 CI 4	1
01	ROUND D 300; L 32		IS 1875 CI 4	11
VAR NO	DESCRIPTION		MATL.CODE	UINT WT
			MATERIAL SPEC	QTY

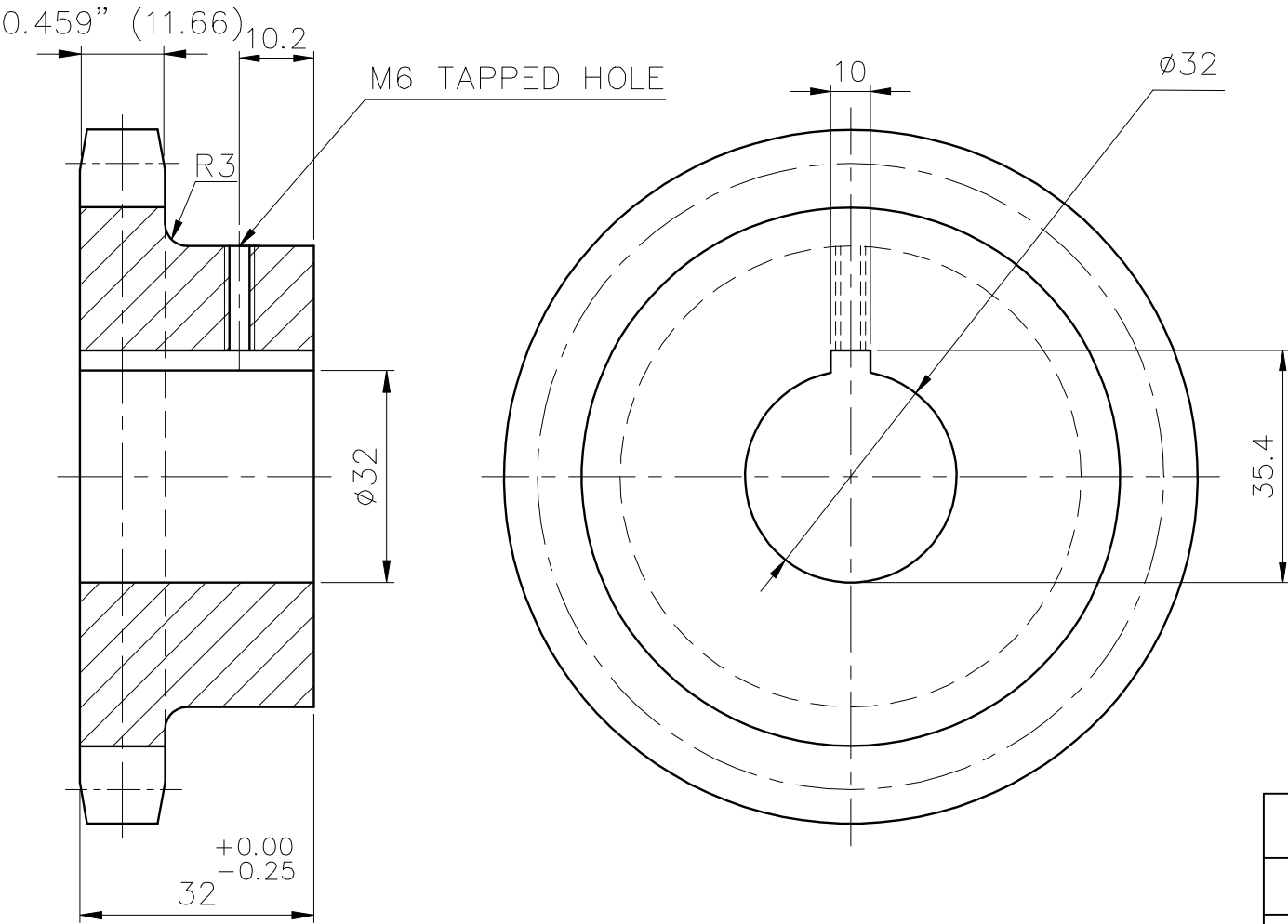
NO OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT									
 365-121 BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI-620014.					DRN	NAME J.SANKAR	SIGN J.S.	DATE 20.09.10	NO.OF VAR.
					CHD	K.SRIDHARAN	K.S.	20.09.10	
					APPD	K.SRIDHARAN	K.S.	20.09.10	
DEPT SB			SCALE	WEIGHT (KG).	REFERENCE INFORMATIONS				NO. OF ITEMS
CODE 330			NTS						
TITLE REAR END PLATE SPROCKET (46 TEETH)					CARD CODE U 01	DRAWING NO. 3-20-401-01854			REV 01

REV	DATE	ALTERED	J.S.
01	30.12.10	CHD & APPD	K.S.
DRAWING REVISED TO ACCOMODATE EMERGENCY CRANK.			
DCN : SB : 801023 / 5011214			

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3-20-401-01853
DRAWING NO.

6.3/1.6



PITCH	3/4"	19.05MM
NO. OF TEETH	14	14
PITCH CIRCLE	3.371"	85.62MM
ROOT DIA	2.902"	73.71MM
OUTER DIA	3.737"	94.92MM
HUB DIA	2.5"	63.5 MM

02	FORGING		92 037 048	0.800
			IS 1875 CI 4	1
01	ROUND D 100; L 32		15 026 363	6.840
			IS 1875 CI 4	11
VAR NO	DESCRIPTION		MATL.CODE	UINT WT
			MATRIAL SPEC	QTY

NOTE:

- 1.SPROCKET TO BE PHOSPHATED.
- 2.SPROCKET TEETH SHOULD BE CUT WITH A HOBGING CUTTER.
- 3.THE HOB SHOULD BE AS PER A.S.A. B 29a.
- 4.ROLLER DIA.OF CHAIN:0.468"/0.464".
- 5.FOR QUALITY REQUIREMENTS REFER LATEST APPLICABLE QUALITY PROCEDURES.

PART CODE :842040103700

REV	DATE	ALTERED	J.S
01	08.01.11	CHD & APPD	K.S
M6 TAPPED HOLE INTRODUCED.			
DCN: SB: 801133/5012916			

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NO OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT									
BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI-620014.					DRN	NAME J.SANKAR	SIGN J.S	DATE 20.09.10	NO.OF VAR.
					CHD	K.SRIDHARAN	K.S	20.09.10	
					APPD	K.SRIDHARAN	K.S	20.09.10	
DEPT SB		SCALE NTS	WEIGHT (KG).	REFERENCE INFORMATION				NO. OF ITEMS	
CODE 330				PPA SIDE					
TITLE IDLER SHAFT SPROCKET 14 T (LRNR)						CARD CODE U 01	DRAWING NO. 3-20-401-01853		REV 01