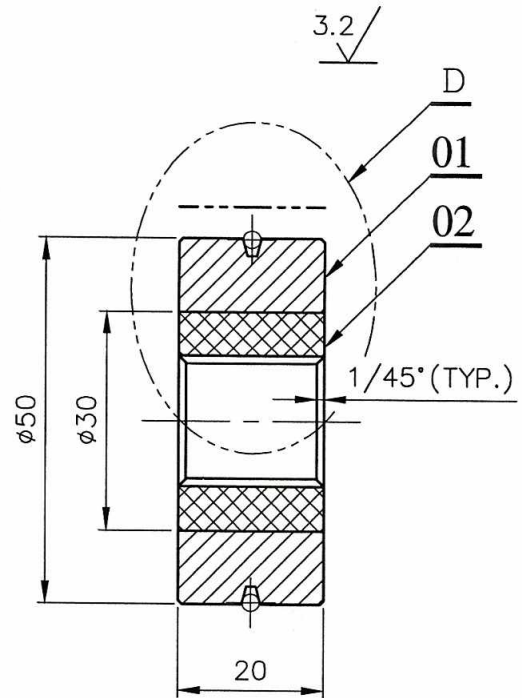
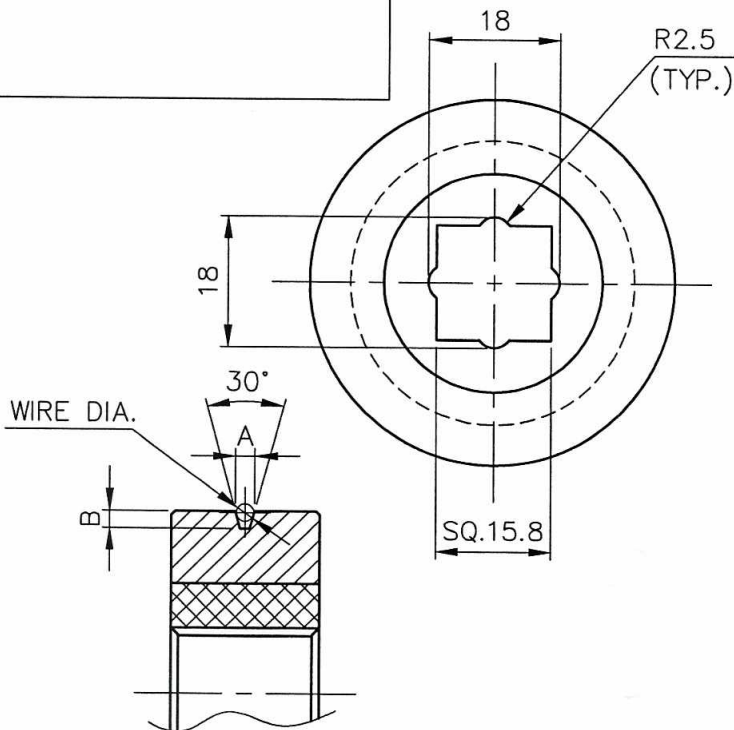


REV	DATE	ALTERED
		CHECKED
		APPROVED
ZONE		



DETAIL-D

1. ITEM NO.01 HARDENED TO HRC 60^{±2}
2. CASE DEPTH 0.8mm
3. ITEM NO.01&02 INTEGRALLY MOULDED
4. SHARP CORNERS TO BE REMOVED

SL. NO.	WIRE DIA.	A	B
01	2.4	2.6	2.4
02	3.2	3.5	3.0
03	4.0	4.4	3.5
04	4.8	5.4	4.3

02	ø30x20L		—	—
			BAKLITE	—
01	ROLLER ø50X20L		IS: 3748	0.19
			XT215Cr12	—
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT
			MATL SPEC	QTY

EQPT: PIPE TO PIPE AND PIPE FITTING & WELDING / FINE ARC



Bharat Heavy Electricals Ltd
HIGH PRESSURE BOILER PLANT
TIRUCHIRAPALLI - 620014

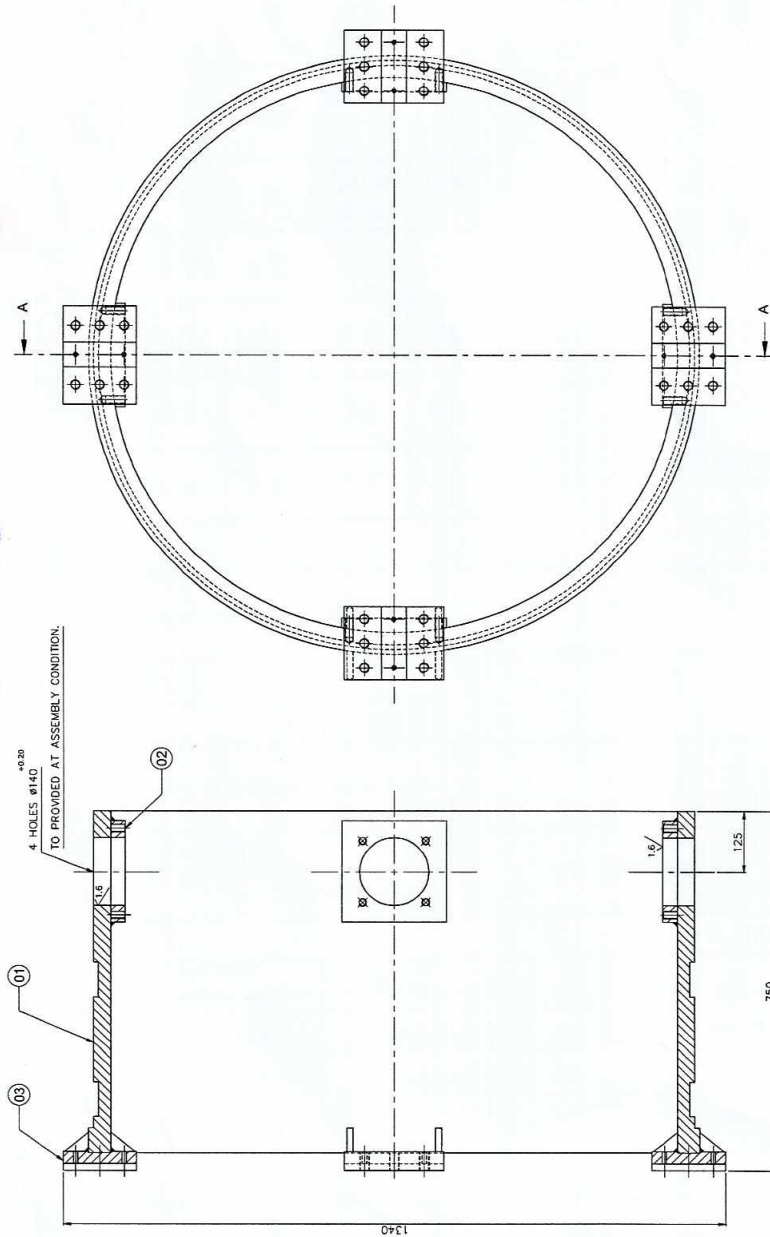
DRN	NAME	SIGNATURE	DATE
	S.SELVAMANICKAM	<i>S.Selvamanickam</i>	19.02.18
CHD	G.GOVINDARAJ	<i>G.Govindaraj</i>	20.02.18
APPD	S.MUTHURAJ	<i>S.Muthuraj</i>	20.02.18

DEPT M&S	GRADE OF UNTOL. DIM		SCALE 1:1	WEIGHT (Kg) —	REF TO ASSY DWG NO	ITEM
CODE 2597	✓ C/M/AF IS: 2102				REF TO OLD DWG NO	
TITLE WIRE FEED ROLLER Ø50x20L (FEED ASSY.)				CARD CODE U 01	DRAWING NO : 4-M-10A63-29956	REV 00

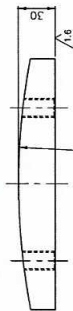
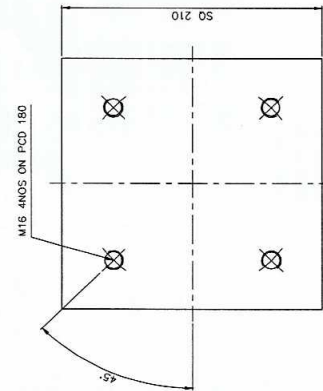
A4-SIZE

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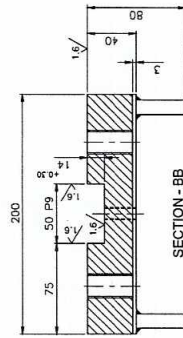
ALL DIMENSIONS ARE IN MILLIMETERS



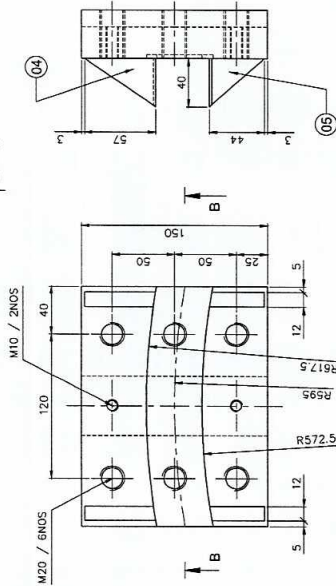
SECTION - AA



SECTION - BB



400 / 6000



IS 9595 FILLET SIZE

THICKNESS OF THICKER PART		MINIMUM SIZE OF FILLET WELD mm
OVER mm	UP TO AND INCLUDING mm	
-	6	3
6	12	4
12	18	6
18	36	8

NOTE

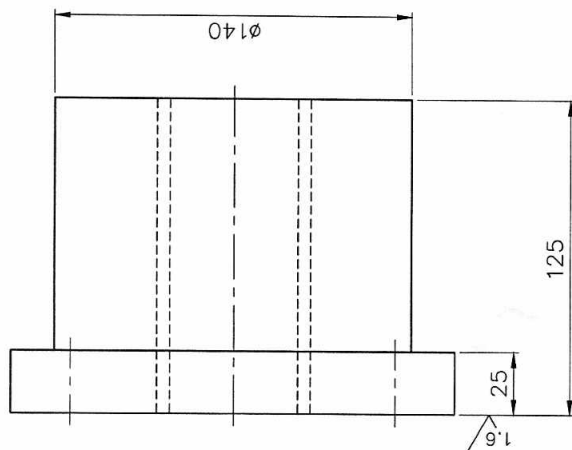
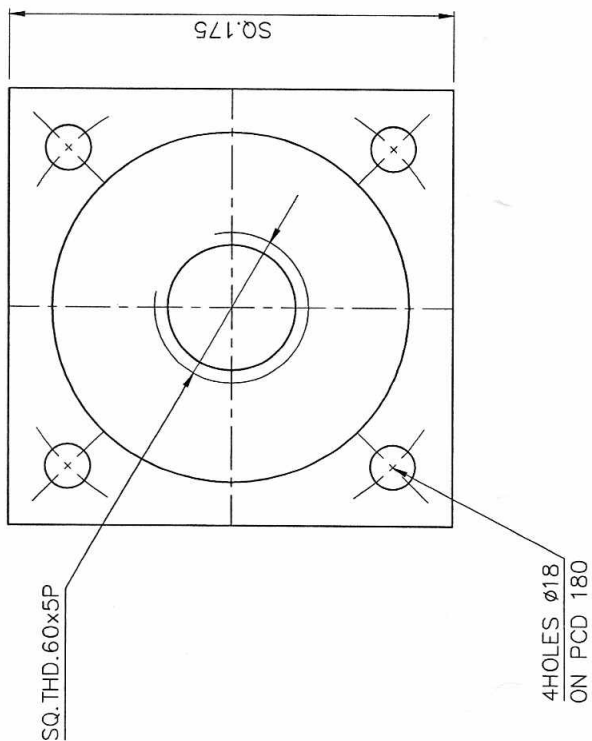
01. ALL JOINTS ARE WELDED
02. SIZE OF FILLET WELD SHALL BE AS PER IS 9595
03. SHARP EDGES TO BE REMOVED.

ITEM NO - 01

SCALE - 1:5

05	PL 121 x 40 x 44	—	45 GB	IS 2004	0.17
04	PL 121 x 40 x 57	—	45 GB	IS 2004	0.21
03	PL 401 x 150 x 200	—	45 GB	IS 2004	9.42
02	PL 301 x 210 x 210	—	45 GB	IS 2004	10.39
01	PL 451 x 713 x 3739	—	45 GB	IS 2004	941.73
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT	QTY
			MATL SPEC		

COPY TO: PIPING TO PIPING & WELDING / AUTO / PIANO		 Bharat Heavy Engineering Ltd HIGH PRESSURE BOILER PLANT TRICHURAPPALLY - 620014		DATE: 27/02/18 DESK: 27/02/18 CHECKED: 27/02/18 APPROVED: 27/02/18 PROJECT NO: 1-M-10A65-02890	
1. TITLE: ROTATOR Ø1235 x 713L (PIPE CLAMPING UNIT)	2. DRAWING NO: 1-M-10A65-02890	3. SCALE: 1:2	4. HEIGHT (mm): 1024.01	5. WEIGHT (kg): 1024.01	6. REV: 00

$\frac{3.2}{\sqrt{1.6}}$ 

MATING SCREW ROD DRG.No: 4-M-10A65-28986

ITEM NO	DESCRIPTION	DRAWING NO	125 x 125 x 125L	IS 2004	12.38
			45C8		
ITEM NO	DESCRIPTION	DRAWING NO		MATL SPEC	UNIT WT
					QTY

EQUIPMENT: AUTO WELDING M/C. / PRIMO	
	
Bharat Heavy Electricals Ltd HIGH PRESSURE BOILER PLANT TIRUCHIRAPALLI - 620014	
DEPT	GRADE OF UNTOOL DIM
M&S	ϕ M / f
CODE	2557 / S-2102
DRN	SCALE
CHD	1:1
APPD	WEIGHT (Kg)
NAME	12.38
SIGNATURE	
DATE	REF TO ASSY DWG NO
16.03.18	REF TO OLD DWG NO
16.03.18	ITEM
16.03.18	

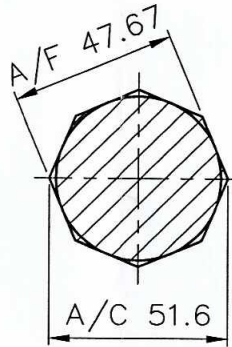
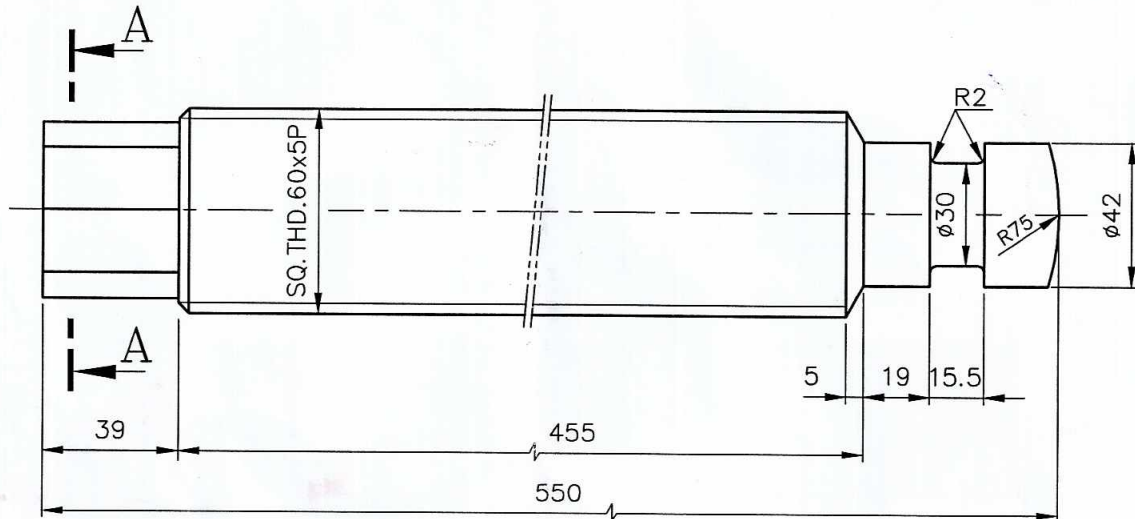
CAUTION: THIS PROPERTY MUST NOT BE DESTROYED OR DETRIMENTED	TITLE	BOX NUT SQ.TH.D.60x5P	CARD CODE	DRAWING NO :	REV
			U 01	3-M-10A65-15891	00

A3-SIZE

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ALL DIMENSIONS ARE IN MM

3.2/
✓



SECTION-AA

NOTE:

SHARP CORNERS TO BE REMOVED

MATING BOX NUT DRG.No.: 3-M-10A65-15891 ①

X		ø60x550L		45C8	IS: 2004	8.40		
No. of Pieces	DESCRIPTION		MATERIAL	STANDARD	NET.WT.IN KGS.	DRAWING No.		ITEM No.
	REFERENCE:			ALTERATIONS:	DCN REF	DATE	SIGN.	INDEX
				MATING DRG.NO.ADDED		16.03.18	GGR	①
SCALE 1:2	DRAWN	S.Selvamanickam						
	CHECKED	R.RAMAMOORTHY						
	APPROVED	C.S.JAYASHEELAN						
	DATE	15.06.11'						
	MACHINE: AUTO WELDING				TYPE: PRIMO AUTO			
	TITLE: SCREW ROD SQ.60x5P (ROTATING POSITIONER)				DRAWING No:			
					4M10A6528986 01			
					Sheet No: No. of Sheets:			
								REV.
								01