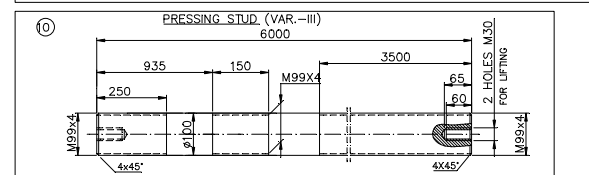
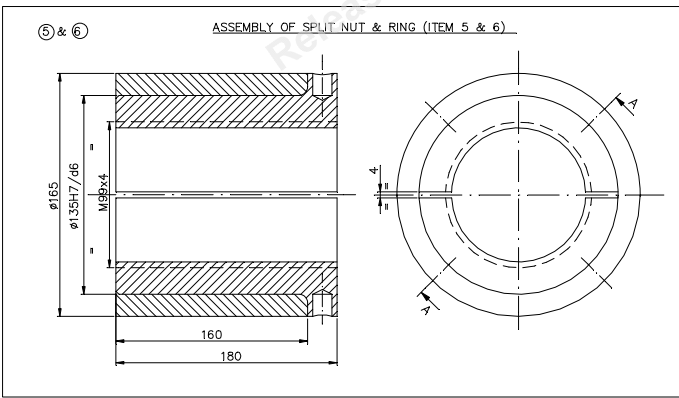
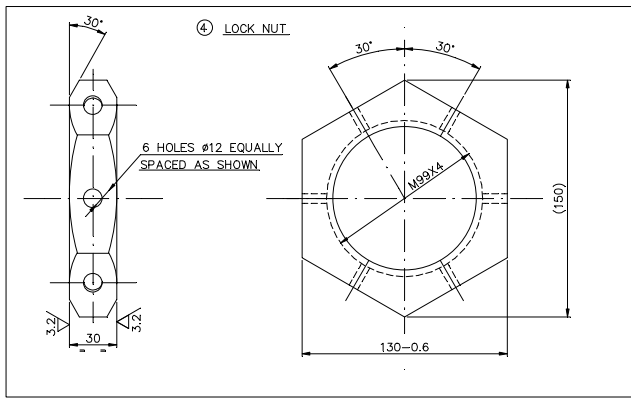
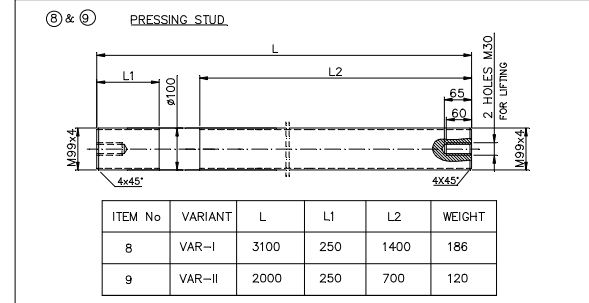
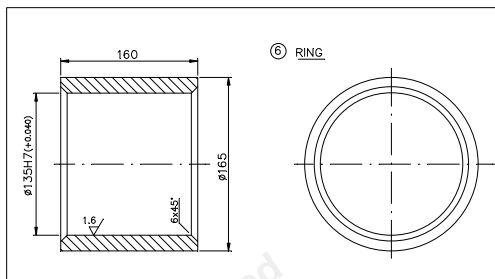
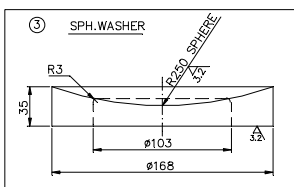
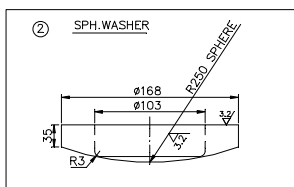
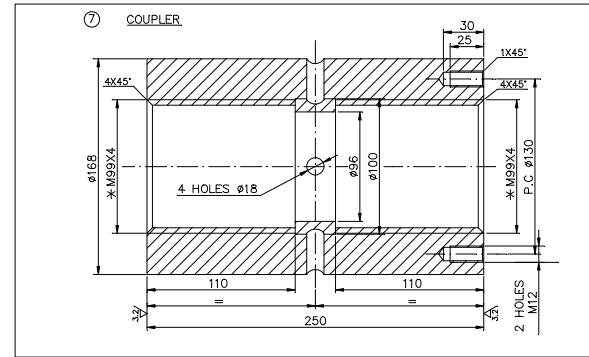
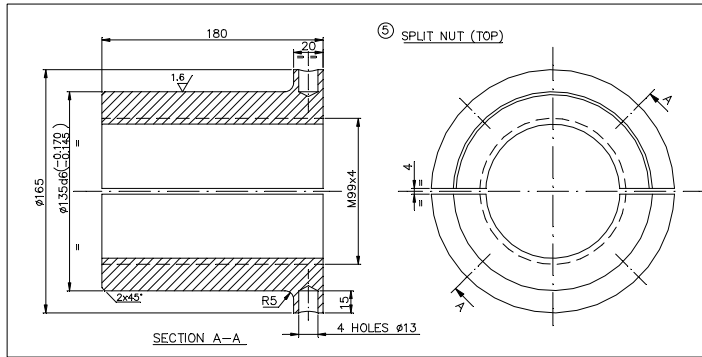
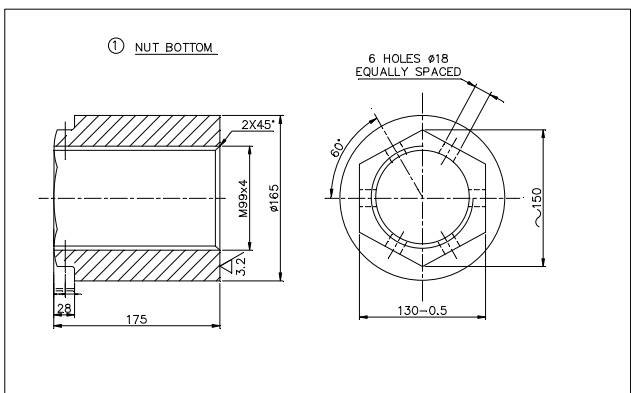


DRWG No. R7002-0118

6.3 / THE REST



MARK ON EACH PART
DRG. NO.
PRODUCT
COMPONENT DRG. NO.

| ITEM No. | DESCRIPTION | UNIT | QTY. | MATERIAL CODE | UNIT WEIGHT | NO. OF SHEETS |
|----------|-------------------------|--------|------|---------------|-------------|---------------|
| 10 | PRESSING STUD (VAR-III) | L=6000 | | 40N6Cr4Mo3 | 362 | |
| | | | | AA10501 | 12+2 EXTRA | |
| 9 | PRESSING STUD (VAR-II) | L=2000 | | 40N6Cr4Mo3 | 120 | |
| | | | | AA10501 | 12+2 EXTRA | |
| 8 | PRESSING STUD (VAR-I) | L=3100 | | 40N6Cr4Mo3 | 186 | |
| | | | | AA10501 | 12+2 EXTRA | |
| 7 | COUPLER | | | 40N6Cr4Mo3 | 28 | |
| | | | | AA10501 | 24+4 EXTRA | |
| 6 | RING (FOR SPLIT NUT) | | | 40N6Cr4Mo3 | 8.7 | |
| | | | | AA10501 | 12+2 EXTRA | |
| 5 | SPLIT NUT (TOP) | | | 40N6Cr4Mo3 | 9.9 | |
| | | | | AA10501 | 12+2 EXTRA | |
| 4 | LOCK NUT | | | 40N6Cr4Mo3 | 1.70 | |
| | | | | AA10501 | 96+10EXTRA | |
| 3 | SPH. WASHER (168x35) | | | 40N6Cr4Mo3 | 3.5 | |
| | | | | AA10501 | 24+4 EXTRA | |
| 2 | SPH. WASHER (168x35) | | | 40N6Cr4Mo3 | 4.1 | |
| | | | | AA10501 | 24+4 EXTRA | |
| 1 | NUT BOTTOM (M99X4) | | | 40N6Cr4Mo3 | 17.8 | |
| | | | | AA10501 | 12+2 EXTRA | |

IN CASE OF MANUFACTURING OUTSIDE FROM BHEL

- COMPLETE SET OF ALL ITEMS OF R7002-0118 SHOULD BE ORDERED TO ONE VENDOR FOR PROPER MATCHING/ASSLY OF THE ITEMS.
- COMPLETE ASSLY OF THE ITEMS ARE AS PER SCHEME R7709-0381, IS TO BE ENSURED BY VENDOR.
- IT MUST BE ENSURED THAT ALL THE ITEMS (LIKE NUT, COUPLER & STUDS) ARE INTERCHANGEABLE TO EACH OTHER.

- NOTES:-
- ALL SHARP EDGES TO BE ROUNDED OFF.
 - TO BE CONSERVED AS PER TL-30007.
 - TO BE ACCEPTED ONLY AFTER TRIAL.
 - ONLY TESTED QUALITY MATERIAL TO BE STRICTLY USED AND NO DEVIATION/CONCESSION IS ALLOWED. TEST CERTIFICATES SHOWING CHEMICAL ANALYSIS, MECHANICAL & ULTRASONIC TEST SHOULD BE SUPPLIED.
 - MATERIAL OF ALL THE ITEMS SHALL BE TESTED ULTRASONICALLY IN ACCORDANCE WITH BHEL STANDARD AA0850118 TO ENSURE FREEDOM FROM INTERNAL DEFECTS & NORMS OF ACCEPTANCE SHALL BE AS PER CATAGORY 2.
 - ALL THE ITEMS SHALL ALSO BE D.P. TESTED IN ACCORDANCE WITH BHEL STANDARD HW0850199 TO ENSURE FREEDOM FROM INTERNAL DEFECTS & NORMS OF ACCEPTANCE SHALL BE AS PER CATAGORY 2.
 - USE LUBRICANT ON SPHERICAL SEATS OF ITEMS 2 & 3.
 - *8. THREADS (M99X4) ARE TO BE MADE SEPARATELY IN EACH SIDE. IN NO CASE BOTH THREADS ARE TO BE MADE FROM ONE END SIDE.
 - SPLIT LOCK NUT (R7002-0127) & SPLIT COUPLER (R7002-0128) MAY BE USED DURING CORE ASSLY. 6

| | | | | | |
|---|--------------------------|------------------------|------------------------------|--------------------|-----------------|
| GMS No./GR.SP.No. | STATUS OF DRG. | TYPE OF PRODUCT | COMP. DRG. No. | M/C TOOL TRANS No. | REF. DRG. No. |
| | | THDF-125/67 (TG 800MW) | 01350401108 | | R7002-0069 |
| DESIGN DEPT. | NAME | SIGN. | DATE | MODEL No. | |
| EMT | AJIT KUMAR | -Sd- | 0.06.12 | | |
| ITEM | NEERAJ KR | -Sd- | 24.05.14 | | |
| GRADE OF UNTOL.DIM. :- | M/CG-2/M/F AA0230208 | | | | |
| WELDING-A/B/C/D-AA0621104 | GAS CUTTING-T3'AA0621101 | | | | |
| REV | DATE | ALTERED CHECKED | REV | DATE | ALTERED CHECKED |
| | | | 1 | 24.05.14 | |
| DRAWING REVISED AS PER C/A NO. JTE-14-F0116 | | | DEPT: JTE | | |
| | | | SCALE: N.T.S | | |
| | | | WEIGHT(Kg): ~11038 | | |
| | | | REF. TO ASSY. DRG. | | |
| | | | ITEM No. OF ITEM | | |
| | | | DRAWING No. R7002-0118 | | |
| | | | SHEET No. 01 No. OF SHEET 01 | | |

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