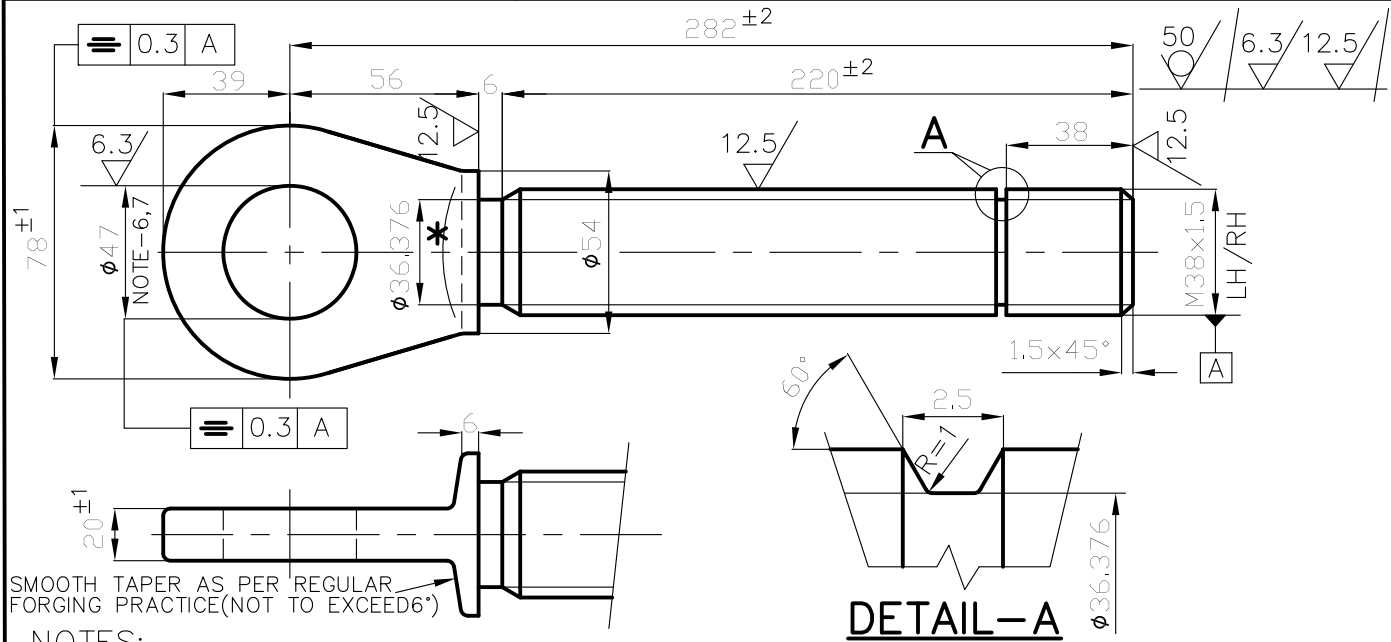


CAUTION: The information on this document is the property of BHARAT HEAVY ELECTRICALS LTD. It must not be used directly or indirectly in any way detrimental to the interest of the company.

ALL DIMENSIONS ARE IN MILLIMETRES

REV	DATE	ALTERED	P SURESH
01	17.06.17	APPROVED	R SESHAGIRI
NOTE NO.07 AND REMARKS IN ITEM NO.02 MODIFIED			
REVISIONS MARKED AS			



SMOOTH TAPER AS PER REGULAR FORGING PRACTICE (NOT TO EXCEED 6°)

- NOTES:
- 01) MATERIAL FOR ITEM.01/03- SA105 / IS1875CL3-30C8 / IS8500FE540; ITEM 01 HAS TO BE FORGED.
 - 02) ITEM 01&03 ARE TO BE ELECTROGALVANISED & YELLOW CHROMOTISED TO A DEPTH OF 15 MICRONS.
 - 03) THREADS SHALL CONFORM TO IS4218.
 - 04) UNSPECIFIED RADIUS FOR ITEM 01 SHALL BE AS PER REGULAR FORGING PRACTICE.
 - 05) DETAILS OF NUT -ITEM 03 (LH/RH): THREAD SIZE M38x1.5; HEIGHT 30; DIM ACROSS FLATS 60+0-1; DIM ACROSS CORNERS 69.3mm.
 - 06) ITEM 02 MAINTENANCE FREE RADIAL SPHERICAL BEARING WITH SLIDING CONTACT SURFACE COMBINATION. STEEL OUTER RING WITH INTERNAL SLIDING LAYER OF SINTER BRONZE INTO WHICH PTFE WITH MOLYBDENUM DISULPHIDE MoS2 IS ROLLED. THE OUTER RING IS PRESSED AROUND THE INNER RING. CARBON CHROMIUM STEEL INNER RING IS HARDENED, GROUND AND THE SLIDING CONTACT SURFACE IS HARD CHROMIUM PLATED.
 - 07) ITEM 02 HAS TO BE SUITABLY FIT INTO ITEM 01 AS PER SKF OR EQUIVALENT OF INA/ELGES/NSK/MAYFIELD'S BEARING PRACTICE WITH SUITABLE TOLERANCES ON MATING SURFACES OF ITEM 01,02.
 - 08) MARK ON ITEM 01 AT LOCATION * 2 ALPHA LETTERS REPRESENTING SUPPLIER'S CODE; 63KN; (LH FOR LH ONLY) MARK LH ON 03 FOR LH NUT.
 - 09) TO BE SUPPLIED IN ASSEMBLED CONDITION WITH SUITABLE PACKING.
 - 10) STOCK CODE FOR RH ASSY-94 821 574 0000; FOR LH ASSY 94 821 584 0000.

ITEM No.	DESCRIPTION	QTY	WEIGHT kg	REMARKS
01	FORGED ROD END (WITHOUT BEARING)	1	2.600	
02	MAINTENANCE FREE SPHERICAL BEARING STEEL/SINTER BRONZE COMPOSITE-NOTE6,7	1	0.160	SKF GE30C OR EQUIVALENT OF INA/ELGES/NSK/MAYFIELD
03	HEX. NUT M38x1.5 LH/RH	1	0.430	

STANDARD

		BHARAT HEAVY ELECTRICALS LIMITED		DRN	NAME	SIGN	DATE	NO.OF VAR
		PIPING CENTRE		CHD	R.ANANTH		06.10.08	
		CHENNAI 600 017		APPD	M.N.VASUDEVAN		06.10.08	
DEPT	GRADE OF UNTOL.DIM		SCALE	WEIGHT (KG).	REF. TO ASSY./OLD DRG.		ITEM NO	NO. OF ITEMS
CODE	C / M / F		N.T.S	3.190	3-80-999-97163			
TITLE				CARD CODE	DRAWING NO.			REV
ROD END WITH NUT -63KN				U 01	4-80-999-93164			01