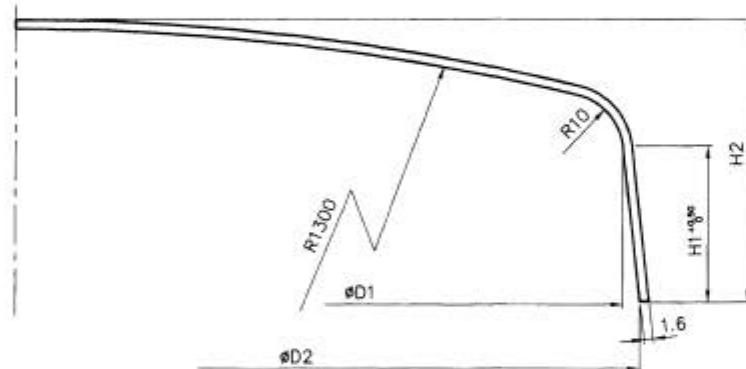
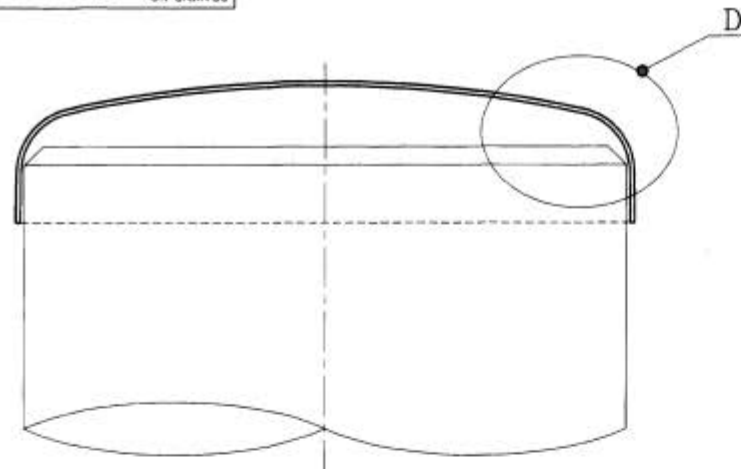


1210-6119

ON SHMVRG

FOR TOLERANCES OF UNTOLERANCED
DIMENSIONS DURING MANUFACTURE
REFER PLANT STD. NO TP 023 0299

DETAIL-D

NOTES: -

IS 1079 Gr.D

01. MATERIAL SPECIFICATION : ~~EN 610 (IS 1079 ST-34)~~
MATERIAL
02. MARK THE ~~BPS CODE AND DIN CODE~~ ON END COVER

NO	OUT SIDE DIA OF PIPE	NOM TOL D1	NOM TOL D2	H1	H2	BLANK DIA	VARIANT NUMBER	ITEM NUMBER	DESCRIPTION	STD	DRAWING NUMBER	ITEM NO	MATERIAL CODE	UNIT WEIGHT	QTY	ZONE
125	141.3	141 ⁺² ₋₁	143 ^{+2.5} ₋₀	35	53	240	18		METALLIC END COVER PIPE OD 141.3		6119 0121 38		94 215 132 0000	0.568		B
150	168.3	168 ⁺² ₋₁	170 ^{+2.5} ₋₀	33	50	240	17		METALLIC END COVER PIPE OD 168.3		6119 0121 37		94 215 057	0.568		B
350	355.6	356 ^{+2.5} ₋₁	359 ^{+2.5} ₋₀	45	71	457	16		METALLIC END COVER PIPE OD 355.6		6119 0121 36		94 215 022	2.060		B
225	244.5	245 ⁺² ₋₁	247 ^{+2.5} ₋₀	40	60	334	15		METALLIC END COVER PIPE OD 244.5		6119 0121 35		94 215 013	1.101		B
175	193.7	194 ⁺² ₋₁	196 ⁺² ₋₀	40	60	279	14		METALLIC END COVER PIPE OD 193.7		6119 0121 34		94 215 004	0.768		B
125	133	133 ^{+1.5} ₋₁	134 ⁺² ₋₀	35	53	205	13		METALLIC END COVER PIPE OD 133		6119 0121 33		94 215 007	0.415		B
100	114.3	114 ⁺¹ ₋₁	115 ⁺² ₋₀	35	53	185	12		METALLIC END COVER PIPE OD 114.3		6119 0121 32		94 215 021	0.338		C
400	406.4	406 ⁺³ ₋₁	409 ⁺³ ₋₀	55	83	526	11		METALLIC END COVER PIPE OD 406.4		6119 0121 31		94 215 011	2.730		C
350	368	368 ^{+2.5} ₋₁	371 ⁺³ ₋₀	45	71	485	10		METALLIC END COVER PIPE OD 368		6119 0121 30		94 215 014	2.321		C
300	323.9	324 ^{+2.5} ₋₁	327 ^{+2.5} ₋₀	45	71	422	09		METALLIC END COVER PIPE OD 323.9		6119 0121 29		94 215 012	1.757		C
250	273	273 ^{+2.5} ₋₁	276 ^{+2.5} ₋₀	40	60	364	08		METALLIC END COVER PIPE OD 273		6119 0121 28		94 215 010	1.307		C
200	219.1	219 ⁺² ₋₁	221 ^{+2.5} ₋₀	40	60	307	07		METALLIC END COVER PIPE OD 219.1		6119 0121 27		94 215 005	0.930		C
150	159	159 ^{+1.5} ₋₁	161 ⁺² ₋₀	35	53	236	06		METALLIC END COVER PIPE OD 159		6119 0121 26		94 215 003	0.550		D
125	127	127 ⁺¹ ₋₁	128 ⁺² ₋₀	35	53	201	05		METALLIC END COVER PIPE OD 127		6119 0121 25		94 215 020	0.400		D
100	108	108 ⁺¹ ₋₁	109 ⁺² ₋₀	35	53	183	04		METALLIC END COVER PIPE OD 108		6119 0121 24		94 215 006	0.331		D
80	88.9	89 ⁺¹ ₋₁	90 ⁺² ₋₀	30	47	151	03		METALLIC END COVER PIPE OD 88.9		6119 0121 23		94 215 008	0.225		D
65	76.1	76 ^{+0.75} ₋₁	77 ^{+1.5} ₋₀	30	47	134	02		METALLIC END COVER PIPE OD 76.1		6119 0121 22		94 215 055	0.177		D
50	57	57 ^{+0.75} ₋₁	57.5 ^{+1.5} ₋₀	30	47	111	01		METALLIC END COVER PIPE OD 57		6119 0121 21		94 215 054	0.122		D
NO	OUT SIDE DIA OF PIPE	NOM TOL D1	NOM TOL D2	H1	H2	BLANK DIA	VARIANT NUMBER	ITEM NUMBER	DESCRIPTION	STD	DRAWING NUMBER	ITEM NO	MATERIAL CODE	UNIT WEIGHT	QTY	ZONE

REV 05	DATE 5-8-2K	ALTERED : <i>MS</i>	CHECKED : <i>MS</i>	REV 04	DATE 22-9-99	ALTERED : <i>MS</i>	CHECKED : <i>MS</i>	REV 03	DATE 1-4-93	ALTERED : <i>MS</i>	CHECKED : <i>MS</i>	REV 02	DATE 9-4-84	ALTERED : <i>MS</i>	CHECKED : <i>MS</i>	REV 01	DATE 26.7.12	ALTERED : R. ASATHAMBI	CHECKED : K. SRIDHAR
ZONE	HEIGHT CORRECTED FOR ALL VARIANTS.				ZONE	ITEM Nos. 10, 11, 13, 14 & 15 ARE REINTRODUCED AND SPEC. CORRECTED.				ZONE	VAR No. 17 INCLUDED.				ZONE	VAR No. 13, 14 & 15 ARE DELETED			
ZONE					ZONE					ZONE					ZONE				

06	DATE 26.7.12	ALTERED : R. ASATHAMBI	CHECKED : K. SRIDHAR
VAR No. 18 INCLUDED			
01	DATE	ALTERED : <i>MS</i>	CHECKED : <i>MS</i>
06	DATE	ALTERED : <i>MS</i>	CHECKED : <i>MS</i>

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT			
Bharat Heavy Electricals Ltd UNIT: HIGH PRESSURE BOILER PLANT TIRUCHIRAPALLI - 620014			
DATE	NAME	SIGNATURE	DATE
1-9-82	R. S.	<i>MS</i>	
DATE	NAME	SIGNATURE	DATE
	M. J. K.	<i>MS</i>	
DATE	NAME	SIGNATURE	DATE
	M. J. K.	<i>MS</i>	
DATE	NAME	SIGNATURE	DATE
	M. J. K.	<i>MS</i>	
BPS 517502		DRAWING NO : 6119-0121	
METALLIC END COVER		06	