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2-V-0000-15043/6

ON ENIMYRD

ALL DIMENSIONS ARE IN MILLIMETRES. FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP / QP

SL No.	DRAWING No.	MATL SPCEN.	SUGGESTED SIZE	MATL. CODE	GROSS WT(Kg.)	SCRAP SORT	TOA DRAWING No.	DIMENSIONS																								FINISHED WT (KG)		
				COMP. CODE				ØD	ØD1 b9 (DIMENSION PRIOR TO PLATING)	ØD2	ØD3 b9 (DIMENSION PRIOR TO PLATING)	ØD4	ØD5	TW-N 7e	MD	Sq.S h8	L	L1	L2	(L3)	L4	L5	L6	L7	L8	R	ØD6							
01	2-V-G001-15043/3	OHATRON	Ø60x625	93 111 246 0000	13.8	40	T-E65559(0210)	55	46	-0.180 -0.242	-0.210 -0.272	44	42	-0.180 -0.242	-0.210 -0.272	41	+0.2 -0.1	36	TW 42-3.5	M24	29	0 -0.033	610	21	74	(453)	36	26	3	191	6	150	34	6.62
02	2-V-G003-15043/3	OHATRON	Ø60x660	93 111 247 0000	14.65		T-E65567(0323)	55	46	-0.180 -0.242	-0.210 -0.272	44	42	-0.180 -0.242	-0.210 -0.272	41	+0.2 -0.1	36	TW 42-3.5	M24	29	0 -0.033	642	21	74	(485)	36	26	3	186	6	150	34	6.96
03	2-V-G004-15043/3	OHATRON	Ø50x590	93 111 248 0000	9.09		4-E09429(0007)	46	38	-0.170 -0.232	-0.200 -0.262	36	34	-0.170 -0.232	-0.200 -0.262	33	+0.2 -0.1	30	TW 34-4	M20	23	0 -0.033	575	17	62	(444)	30	22	2.5	160	4	120	27	4.11
04	2-V-G033-15043/3	OHATRON	Ø50x560	93 111 249 0000	8.71		T-E65563(0526)	46	38	-0.170 -0.232	-0.200 -0.262	36	34	-0.170 -0.232	-0.200 -0.262	33	+0.2 -0.1	30	TW 34-4	M20	23	0 -0.033	543	17	62	(412)	30	22	2.5	160	4	120	27	3.73
05	2-V-G041-15043/3	OHATRON	Ø50x505	93 111 250 0000	7.78		T-E65560(0865)	44	36	-0.170 -0.232	-0.200 -0.262	34	32	-0.170 -0.232	-0.200 -0.262	31	+0.2 -0.1	30	TW 32-4	M20	23	0 -0.033	488	16	58	(362)	30	22	2.5	160	4	120	25	2.97
06	2-V-G045-15043/3	OHATRON	Ø50x530	93 111 251 0000	8.17		T-E65558(0883)	46	38	-0.170 -0.232	-0.200 -0.262	36	34	-0.170 -0.232	-0.200 -0.262	33	+0.2 -0.1	30	TW 34-4	M20	23	0 -0.033	516	17	62	(385)	30	22	2.5	165	4	120	27	3.70
07	2-V-G145-15043/3	OHATRON	Ø55x615	93 113 610 0000	11.48		T-E65565(2177)	50	42	-0.180 -0.242	-0.210 -0.272	40	38	-0.170 -0.232	-0.200 -0.262	37	+0.2 -0.1	34	TW 38-3.5	M22	26	0 -0.033	600	19	68	(455)	34	24	2.5	170	6	150	30	5.40
08	2-V-G146-15043/1	OHATRON	Ø55x665	93 119 198 0000	12.41		-	50	42	-0.180 -0.242	-0.210 -0.272	40	38	-0.170 -0.232	-0.200 -0.262	37	+0.2 -0.1	34	TW 38-3.5	M22	26	0 -0.033	650	19	68	(505)	34	24	2.5	220	6	150	30	5.85
09	2-V-G046-15043/1	OHATRON	Ø50x585	9 119 199 0000	9.02		-	46	38	-0.170 -0.232	-0.200 -0.262	36	34	-0.170 -0.232	-0.200 -0.262	33	+0.2 -0.1	30	TW 34-4	M20	23	0 -0.033	571	17	62	(440)	30	22	2.5	220	4	120	27	4.09
10	2-V-G005-15043/1	OHATRON	Ø60x700	93 119 267 0000	15.5		-	55	46	-0.180 -0.242	-0.210 -0.272	44	42	-0.180 -0.242	-0.210 -0.272	41	+0.2 -0.1	36	TW 42-3.5	M24	29	0 -0.033	685	21	74	(528)	36	26	3	266	6	150	34	7.44
11	2-V-G011-15043/1	OHATRON	Ø60x725	93 119 268 0000	16.1		-	55	46	-0.180 -0.242	-0.210 -0.272	44	42	-0.180 -0.242	-0.210 -0.272	41	+0.2 -0.1	36	TW 42-3.5	M24	29	0 -0.033	707	21	74	(550)	36	26	3	251	6	150	34	7.67
12	2-V-G014-15043/1	OHATRON	Ø50x645	93 119 269 0000	9.95		-	46	38	-0.170 -0.232	-0.200 -0.262	36	34	-0.170 -0.232	-0.200 -0.262	33	+0.2 -0.1	30	TW 34-4	M20	23	0 -0.033	630	17	62	(499)	30	22	2.5	215	4	120	27	4.50
13	2-V-G034-15043/1	OHATRON	Ø50x610	93 119 270 0000	9.41		-	46	38	-0.170 -0.232	-0.200 -0.262	36	34	-0.170 -0.232	-0.200 -0.262	33	+0.2 -0.1	30	TW 34-4	M20	23	0 -0.033	593	17	62	(462)	30	22	2.5	210	4	120	27	4.09
14	2-V-G042-15043/1	OHATRON	Ø50x565	93 119 271 0000	8.72		-	44	36	-0.170 -0.232	-0.200 -0.262	34	32	-0.170 -0.232	-0.200 -0.262	31	+0.2 -0.1	30	TW 32-4	M20	23	0 -0.033	548	16	58	(422)	30	22	2.5	220	4	120	25	3.35

ØD6

R2

8

L7

ALTERNATE TO
DETAIL - F

R0.5

R0.5

DETAIL - E

ØD

R

ØD1

ØD2

ØD3

ØD4

ØD5

TW-N

MD-6g

L1

L2

1

L3

L4

L5

L6

L

SECTION - AA

ØD5

Sq.S

3.2

R1.5

R0.5

3.2

L8

45°

LAPPING 0.8

DETAIL - D

THE ABOVE UNDERCUT SHALL BE SMOOTHLY FINISHED.
SO THAT THE CUT SHOULD NOT BE NOTCH EFFECTED.

NOTES:
1. HARDNESS FOR OHATRON MATERIAL - 241 TO 321 BHN.
2. MATL. SHALL BE AS PER LATEST APPLICABLE QUALITY WORK INSTRUCTION

REV 6
DATE 24.12.03
ZONE

ALTERED VB
CHD & APPD MRK

SURFACE FINISH 0.4/ WAS 0.8/

DCP.No.800270

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.

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT

TA

RETRACED WITH REV.6 ON 24.12.03

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

DRN V.BAIRAVAN
CHD K.RAJASEKRAN
APPD M.RAJAKUMAR

DEPT VL
CODE 320

SCALE N T S

WEIGHT (KG).

REFERENCE INFORMATION

CARD CODE U 01

DRAWING NO. 2-V-0000-15043

REV 6

STEM

NO. OF ITEMS

365-120

DEPT VL

CODE 320

TITLE

NO. OF

ITEMS

365-120

DEPT VL

CODE 320

TITLE

NO. OF

ITEMS

1

2

3

4

5

6

7

8

Size A2