

MATERIAL THICKNESS(mm)	WELD THICKNESS(mm)
OVER 60 TO 12	3
OVER 12 TO 15	4
OVER 15 TO 20	5
OVER 20 TO 30	6
OVER 30 TO 40	7
OVER 40 TO 50	8
OVER 50 TO 60	10
OVER 60 TO 80	12

ITEM NO.	DESCRIPTION	QTY	UNIT
1	PL. 788 x 310 x 6	20.00	EA
2	PL. 200 x 142 x 30	0.44	EA
3	PL. 245 x 160 x 10	3.08	EA
4	PL. 160 x 150 x 20	3.77	EA
5	PL. 160 x 150 x 20	1.96	EA
6	PL. 160 x 150 x 20	1.96	EA
7	PL. 160 x 150 x 20	1.96	EA
8	PL. 160 x 150 x 20	1.96	EA
9	PL. 160 x 150 x 20	1.96	EA
10	PL. 160 x 150 x 20	1.96	EA
11	PL. 160 x 150 x 20	1.96	EA
12	PL. 160 x 150 x 20	1.96	EA

NOTES:
 1. UNSPECIFIED DIMENSIONS ARE IN MILLIMETERS.
 2. REBURR SHARP CORNERS.
 3. USE 2018 ELECTRIC WELDING ROD.
 4. STRESS TO BE RELEASED AFTER COMPLETE FABRICATION.

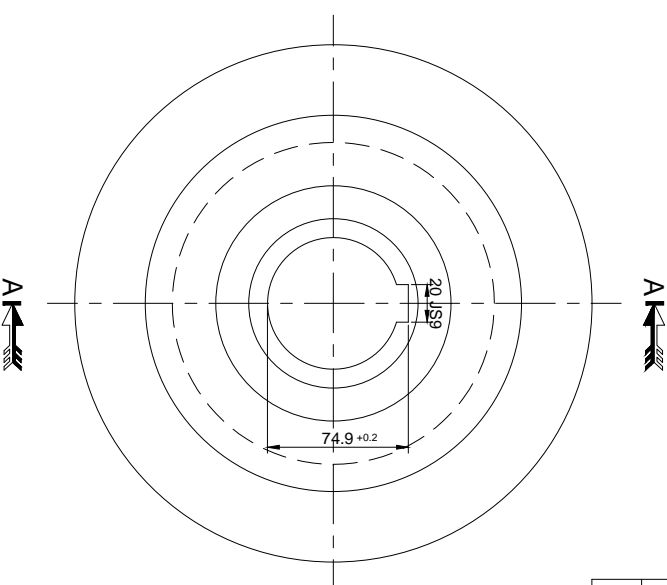
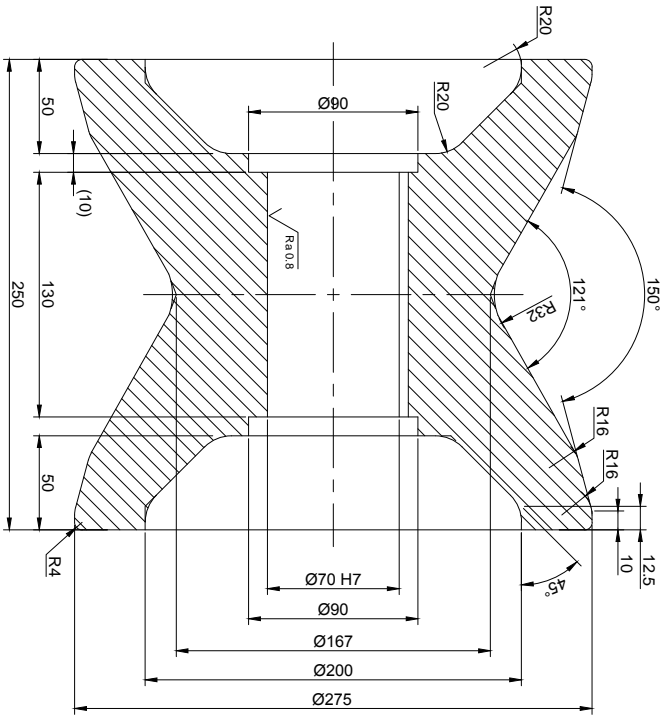
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REV.	DATE	BY	CHKD.	DESCRIPTION
01	12/25/2014			ISSUED FOR FABRICATION

CONVEYOR ROLLER

CONVEYOR ROLLER
 1-7-1123-46-10219

√ Ra 1.6 (√ Ra 0.8)



Nominal size	Tolerance field	Deviations
Ø70	H7	+0.03 0
20	JS9	+0.026 -0.026

SEC-AA

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REV	DATE	ALTERED
01		CHECKED APPROVED

DEPT	CODE	GRADE or UNITS, DIM	SCALE	WEIGHT (Kgs)
456	IS:2102	φ M/F	1:2	61.7

CPE - ROLL
(TRANSPORT ROLL ASSY.)

DRAWING NO: 2-7-1123-46-10109

REV: 00

ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT	QTY
	EGPT. CROSS PIERING AND ELONGATION- MAN EQUIPMENT INCL. INLET PUSHER SIDE, OUTLET SIDE AND AIR THRUST BLOCK		SG 7002/IS:1985-1974	61.7	

DNM	R. RACHIVIER	R. RACHIVIER	14.03.14
SHD	G. LOGANATHAN	G. Logannathan	15.03.14
APPD	M. CHANDRAKUMAR	M. Chandrakumar	15.03.14

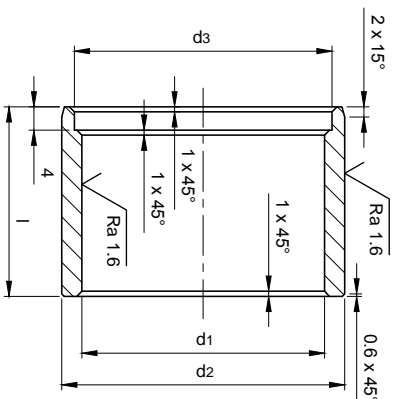
REF TO ASSY DWG NO: 0101095-46.000

REF TO OLD DWG NO: 0101095-46.000

1 2 3 4 5 6 7 8 A2-SIZE

EXAMPLE : DESIGNATION OF A BUSH FOR PIN NOMINAL SIZE 50
*BUSH NOMINAL SIZE 50

Nominal Size	d1 H7	d2 h6	d3 -0.5	l	Weight ≈ kg	ASSY DWG NO/ ITEM NO
25	23	30	26	19.5	0.04	
30	28	35	31	23.5	0.07	
35	33	42	36	27	0.11	
40	38	46	41	30.5	0.13	
50*	48	56	51	37	0.19	0-7-1123-46-11219/19
60	58	68	61	42.5	0.33	
70	68	78	71	50	0.45	
80	78	88	81	52	0.53	
90	88	98	91	59.5	0.68	
100	98	108	101	64.5	0.82	
110	108	120	111	84.5	1.08	
120	118	140	121	92	2.81	



d1 H7	DEVIATION	d2 h6	DEVIATION
23	+0.021 0.000	30	0.000 -0.016
28	+0.021 0.000	35	0.000 -0.016
33	+0.025 0.000	42	0.000 -0.016
38	+0.025 0.000	46	0.000 -0.016
48	+0.025 0.000	56	0.000 -0.016
58	+0.030 0.000	68	0.000 -0.019
68	+0.030 0.000	78	0.000 -0.019
78	+0.030 0.000	88	0.000 -0.019
88	+0.035 0.000	98	0.000 -0.022
98	+0.035 0.000	108	0.000 -0.022
108	+0.035 0.000	120	0.000 -0.022
118	+0.035 0.000	140	0.000 -0.022

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REV	DATE	ALTERED
01		CHECKED APPROVED

DEPT	SSIP	GRADE OF UNITOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM
456	456	φ _N /φ _F IS:2102	1:1			

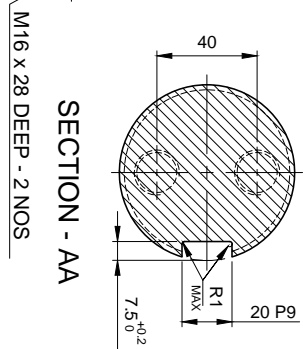
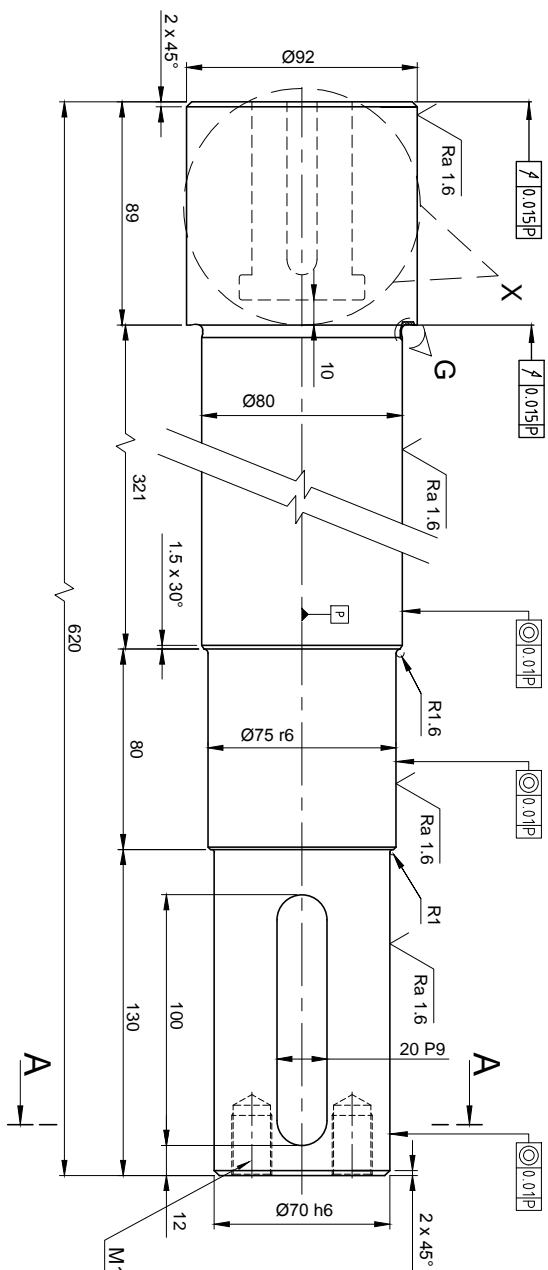


Bharat Heavy Electricals Ltd
SEAMLESS STEEL TUBE PLANT
TIRUCHIRAPALLI - 620014

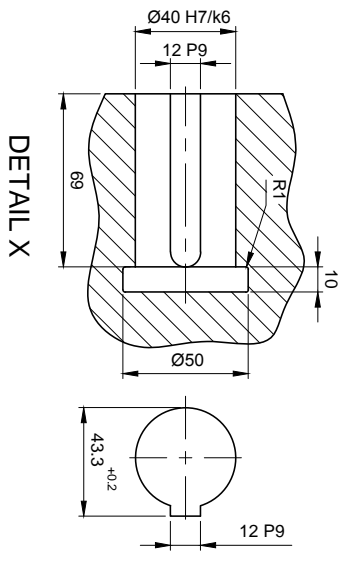
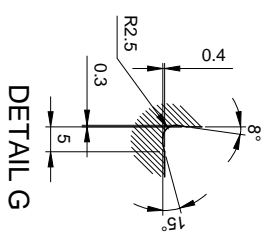
DRN	NAME	SIGNATURE	DATE
CHD	S.S.N.KUMAR/ A.S	<i>S.S.N. Kumar</i>	22.08.14
APPD	R.K.SINGH	<i>R.K. Singh</i>	22.08.14
	G.LOGANATHAN	<i>G. Loganathan</i>	22.08.14

ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT
			C45	
			MATL SPEC	QTY

TITLE	CARD CODE	DRAWING NO :	REV
STD - BUSH FOR CYLINDER	U 01	3-7-0000-00-10228	00
MMWN 344.01-2			



SIZE	DEVIATION
Ø75 r6	+0.062 +0.043
Ø70 h6	0.000 -0.019
20 P9	-0.022 -0.074
12 P9	-0.018 -0.016
Ø40 H7	+0.025 0.000

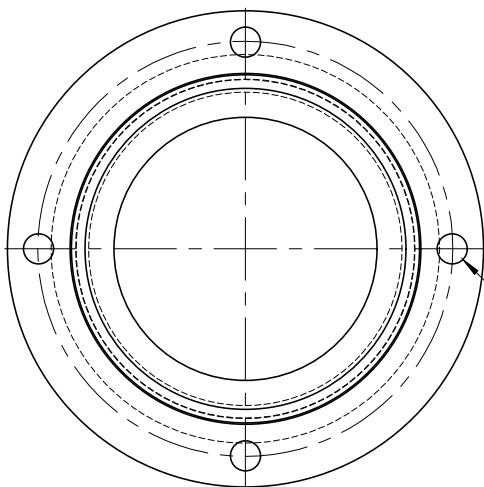


- NOTES:
1. UNSPECIFIED CHAMFERS 1 x 45°
 2. DEBURR SHARP CORNERS
 3. HARDEN AND TEMPERED TO 30-34RC
 4. DETAIL 'G' RELIEF GROOVE TYPE 'F' TO IS:3428

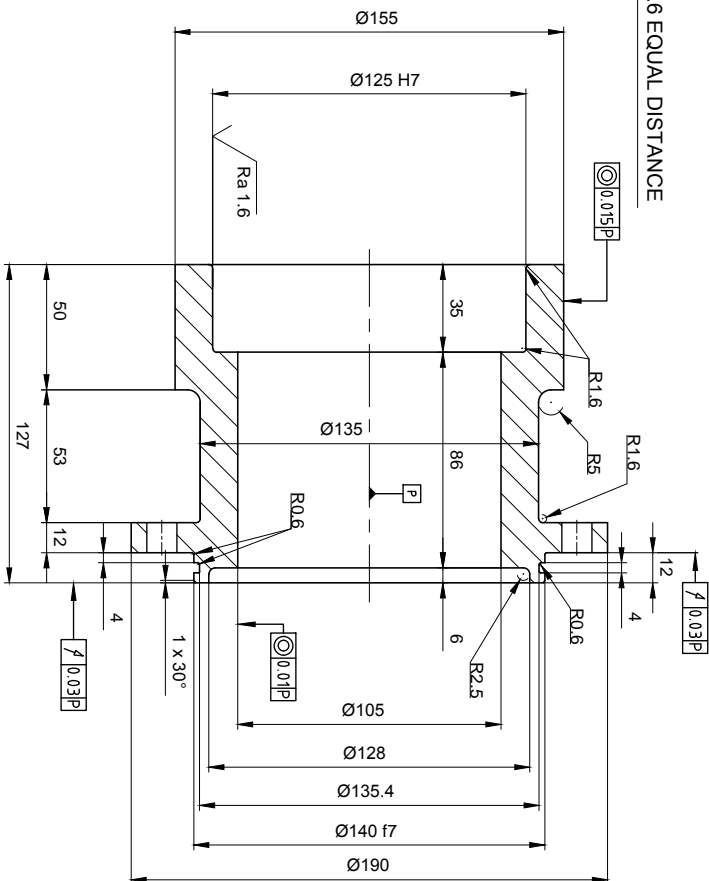
REV	DATE	ALTERED
01		CHECKED APPROVED

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DEPT	RO 100 x 620	ITEM NO	IS:1732	DESCRIPTION	DRAWING NO	NAME	S.S.N.KUMAR / AS	SIGNATURE	DATE
SSTP	IS:1732	DESCRIPTION				DRN	R.K.SINGH	<i>R.K. Singh</i>	22.08.14
GRADE OF UNTOOL DIM	φ / M / F	SCALE	1:2	WEIGHT (Kg)	23.2	CHD	G.LOKANATHAN	<i>G. Lokanathan</i>	22.08.14
CODE	456	IS:2102				APPD			
TITLE	CPE - SHAFT CONVEYOR ROLLER			CARD CODE	U 01	REF TO ASSY DWG NO	0-7-1123-46-11219	REF TO OLD DWG NO	0101056-46.000
EQUIP: CROSS PIERCING AND ELONGATION - CONVEYOR ROLLER				DRAWING NO	42C4M02 IS:5517	MATL CODE		UNIT WT	1
Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TRUCHIRAPALLI - 620014				MATL SPEC		QTY			



Ø125 - 4 HOLES ON PCD 165.6 EQUAL DISTANCE



SIZE	DEVIATION
Ø140 F7	-0.043 -0.083
Ø125 H7	+0.040 0.000

- NOTES:
1. UNSPECIFIED CHAMFERS 1 x 45°
 2. DEBURR SHARP CORNERS.
 3. NORMALIZING TEMPERATURE - 840 - 880°C/AIR

REV	DATE	ALTERED
01		CHECKED APPROVED

DEPT	GRADE OF UNROL. DIM	SCALE	WEIGHT (KG)
SSTP	φ M / φ	1:2	1.25
456	IS:2102		

ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT
IS-1732	RO 190 X 127		C45	01

BRN	NAME	SIGNATURE	DATE
R.K.SINGH	S.S.N.KUMAR / AS	<i>S.S.N. Kumar / AS</i>	22.08.14
G.LOCHANATHAN		<i>G. Lochanathan</i>	22.08.14

REF TO ASSY DWG NO	REF TO OLD DWG NO
0-7-1123-46-11219	0101056-46.000

TITLE	CARD CODE	DRAWING NO :	REV
CPE-ADAPTER FOR HYDRO MOTOR CONVEYOR ROLLER	U 01	3-7-1123-46-10225	00

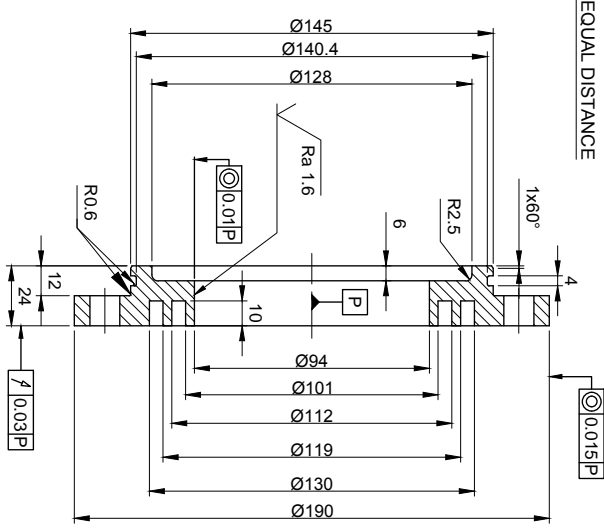
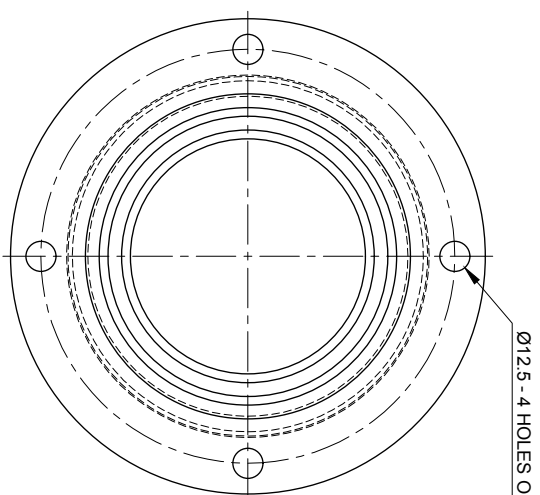
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Bharat Heavy Electricals Ltd
SEAMLESS STEEL TUBE PLANT
THRUCHIRAPALLI - 620014

EQUI: CROSS PIERCING AND ELONGATION - CONVEYOR ROLLER ASSY

√ Ra 3.2 (√ Ra 1.6)



- NOTES:
1. UNSPECIFIED CHAMFERS 1 x 45°
 2. DEBURR SHARP CORNERS.
 3. NORMALIZING TEMPERATURE - 840 - 880°C/AIR

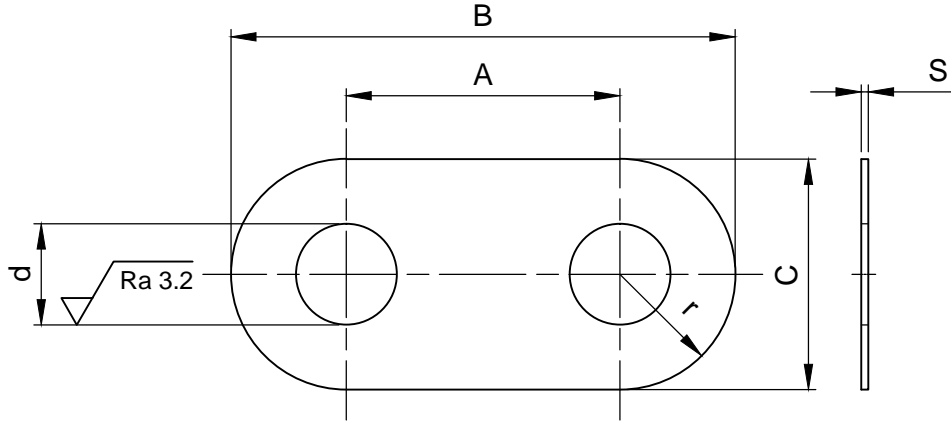
REV	DATE	ALTERED	DEPT	GRADE OF UNTOOL. DIM	SCALE	WEIGHT (Kg)	DRN	NAME	SIGNATURE	DATE
01		CHECKED APPROVED	456	IS:2102	1:2	2.9	R.K.SINGH	R.K.Singh	22.08.14	
			SSTP	IS:2102			G.LOGANATHAN	G. Loganathan	22.08.14	
			456	15:2102						
CAUTION: THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.										
TITLE CPE - LABYRINTH CAP CONVEYOR ROLLER			DEPT SS:TP 456			WEIGHT (Kg) 2.9			DRAWING NO : 3-7-1123-46-10226	
CARD CODE U 01			SCALE 1:2			DRAWING NO C45			UNIT WT 1	
APPD G.LOGANATHAN			GRADE OF UNTOOL. DIM IS:2102			DRAWING NO C45			MATL SPEC QTY	
BHARAT HEAVY ELECTRICALS LTD SEAMLESS STEEL TUBE PLANT TRUCHIRAPALLI - 620014			EOP: CROSS PIERCING AND ELONGATION - CONVEYOR ROLLER			NAME S.S.N.KUMAR / A.S			SIGNATURE S.S.N.Kumar / A.S	
DRN R.K.SINGH			CHD R.K.SINGH			NAME R.K.SINGH			SIGNATURE R.K.Singh	
REF TO ASSY DWG NO 0-7-1123-46-11219			REF TO OLD DWG NO 0101056-46.000			NAME G.LOGANATHAN			SIGNATURE G. Loganathan	
REF TO ASSY DWG NO 0-7-1123-46-11219			REF TO OLD DWG NO 0101056-46.000			NAME R.K.SINGH			SIGNATURE R.K.Singh	
REF TO OLD DWG NO 0101056-46.000			REF TO OLD DWG NO 0101056-46.000			NAME G.LOGANATHAN			SIGNATURE G. Loganathan	
REF TO OLD DWG NO 0101056-46.000			REF TO OLD DWG NO 0101056-46.000			NAME R.K.SINGH			SIGNATURE R.K.Singh	
REF TO OLD DWG NO 0101056-46.000			REF TO OLD DWG NO 0101056-46.000			NAME G.LOGANATHAN			SIGNATURE G. Loganathan	

ALL DIMENSIONS ARE IN MM

REV	DATE	ALTERED	<i>S.P.N.Kumar / A.S</i>
01	22.08.14	CHECKED	<i>R.K.Singh</i>
		APPROVED	<i>S.Loganathan</i>

√ Ra 3.2 (√ Ra 3.2)


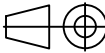
Assy column added



* LOCK WASHER 70 MMN 343.03

A	Nominal size B	C	d	r	s	weight kg / piece	Stock number	ASSY NO/ ITEM NO
22	48	26	11.5	13	1	7.45	451 360	
28	60	32	14	16	1	11.55	451 361	
38	70 *	32	14	16	1	14.07	451 362	
40	80	40	18	20	1	21.40	451 363	0-7-1123-46-11219/20
42	87	45	23	22.5	1	22.60	451 364	
52	97	45	23	22.5	1	29.40	451 365	
55	105	50	27	25	1	34.50	451 366	
75	125	50	27	25	1	38.50	451 367	
95	145	50	27	25	1	42.50	451 368	

MATL :
WUSt 1203 (Old designation)
Sheet DIN EN 10130 - DC03 - A-m (New designation)

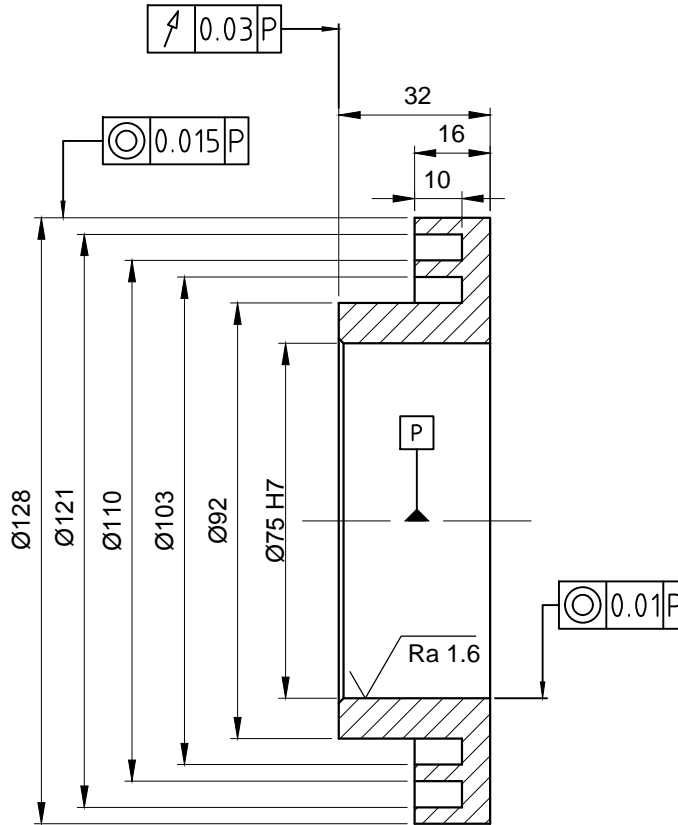
CAUTION: THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.	LOCK WASHER		Gr. CR3 IS 513 / ISO 3574			
	ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT	
				MATL SPEC	QTY	
	EQPT: -					
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME	SIGNATURE	DATE	
		CHD	G.LOGANATHAN	<i>S.Loganathan</i>	05.03.13	
		APPD	S.MOHAN	<i>S.Mohan</i>	05.03.13	
DEPT	GRADE OF UNTOL. DIM		SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM
SSTP	$\phi / M / \#$ IS: 2102		1:1	-	-	
CODE					REF TO OLD DWG NO	
456					-	
TITLE			CARD CODE	DRAWING NO :		REV
STD - LOCK WASHER - MMN 343.03			U 01	4-7-0000-00-10083		01

ALL DIMENSIONS ARE IN MM

REV 01	DATE	ALTERED
		CHECKED
		APPROVED

$\sqrt{Ra\ 3.2}$ ($\sqrt{Ra\ 1.6}$)


SIZE	DEVIATION
Ø75 H7	0.00 +0.03



NOTES:

- 1.UNSPECIFIED CHAMFERS 1 x 45°
- 2.DEBURR SHARP CORNERS.
- 3.NORMALIZING TEMPERATURE - 840 - 880°C/AIR

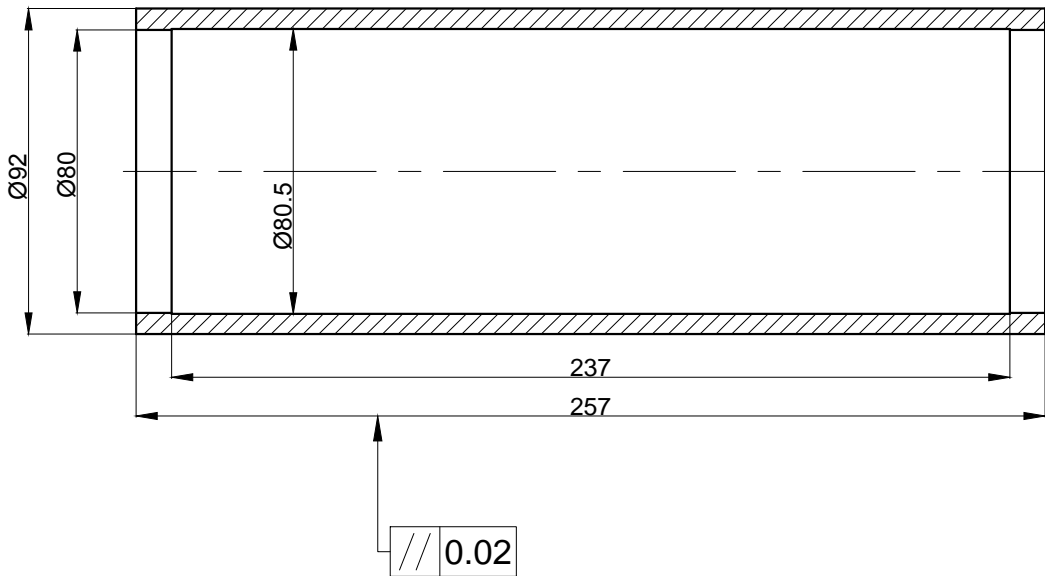
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	Ro 128 x 32 IS:1732		C45	01	
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT	
			MATL SPEC	QTY	
EQPT: CROSS PIERCING AND ELONGATION - CONVEYOR ROLLER					
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME S.S.N.KUMAR/ A.S	SIGNATURE <i>S.S.N.Kumar/ A.S</i>	DATE 22.08.14
		CHD	R.K.SINGH	<i>R.K.Singh</i>	22.08.14
		APPD	G.LOGANATHAN	<i>G.Loganathan</i>	22.08.14
DEPT SSTP	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO 0-7-1123-46-11219	ITEM 08
CODE 456	$\phi/M/\#$ IS: 2102	1:1.5	1.55	REF TO OLD DWG NO 0101056-46.000	08
TITLE CPE - LABYRINTH RING CONVEYOR ROLLER			CARD CODE U 01	DRAWING NO : 4-7-1123-46-10320	REV 00


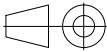
ALL DIMENSIONS ARE IN MM

REV 01	DATE	ALTERED
		CHECKED
		APPROVED

✓ Ra 3.2



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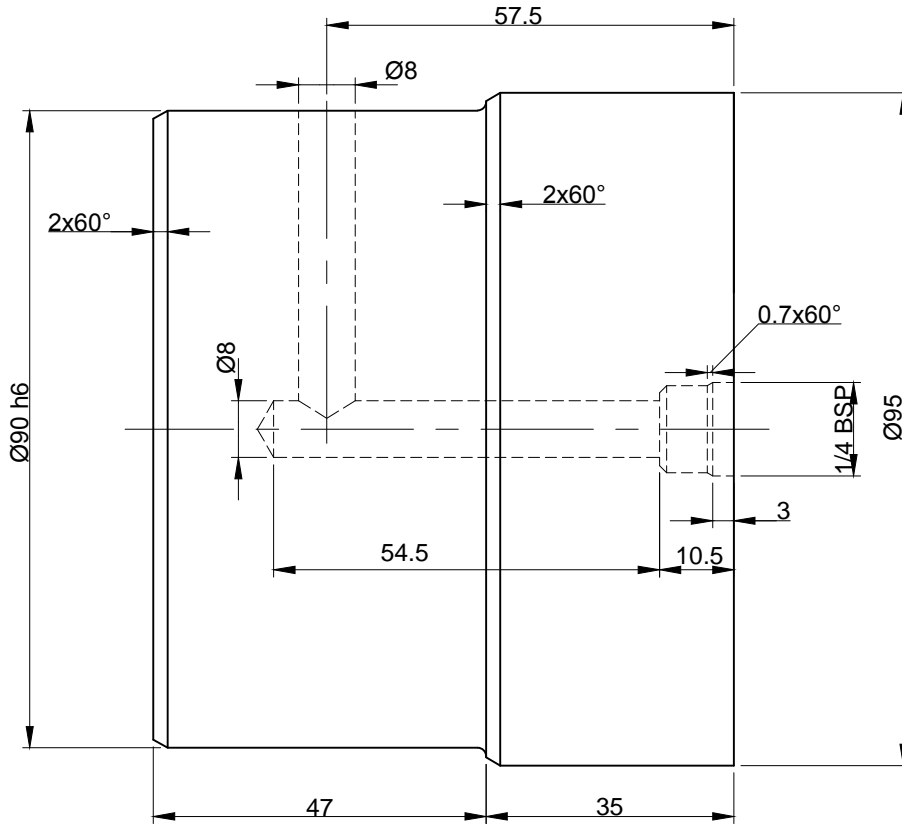
Ro 100 x 257 IS:1732		45C8 IS:1875		01	
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT	
			MATL SPEC	QTY	
EQPT: CROSS PIERCING AND ELONGATION-CONVEYOR ROLLER					
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME S.S.N.KUMAR/ A.S	SIGNATURE <i>S.S.N.Kumar/ A.S</i>	DATE 22.08.14
		CHD	R.K.SINGH	<i>R.K. Singh</i>	22.08.14
		APPD	G.LOGANATHAN	<i>G. Loganathan</i>	22.08.14
DEPT SSTP CODE 456	GRADE OF UNTOL. DIM Ø/M/√ IS: 2102		SCALE 1:2	WEIGHT (Kg) 3.270	REF TO ASSY DWG NO 0-7-1123-46-11219
TITLE CPE - DISTANCE SLEEVE CONVEYOR ROLLER			CARD CODE U 01	REF TO OLD DWG NO 0101056-46.000	ITEM 09
			DRAWING NO : 4-7-1123-46-10321	REV 00	

ALL DIMENSIONS ARE IN MM


REV 01	DATE	ALTERED
		CHECKED
		APPROVED

✓ Ra 3.2

SIZE	DEVIATION
Ø90 h6	0.000 -0.022



NOTE:
HARDEN AND TEMPERED TO 30 - 34RC

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	ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT
				MATL SPEC	QTY
	EQPT: CROSS PIERCING AND ELONGATION-CONVEYOR ROLLER				
		Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME S.S.N.KUMAR/ A.S
				CHD	R.K.SINGH
				APPD	G.LOGANATHAN
				SIGNATURE <i>S.S.N.Kumar/ A.S</i>	DATE 22.08.14
				SIGNATURE <i>R.K. Singh</i>	DATE 22.08.14
				SIGNATURE <i>S. Loganathan</i>	DATE 22.08.14
DEPT SSTP	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM
CODE 456	$\phi/M/\#$ IS: 2102	1:1	5.60	0-7-1123-46-11219	11
				REF TO OLD DWG NO	11
				0101056-46.000	
TITLE			CARD CODE	DRAWING NO :	REV
CPE - PIN CONVEYOR ROLLER			U 01	4-7-1123-46-10323	00

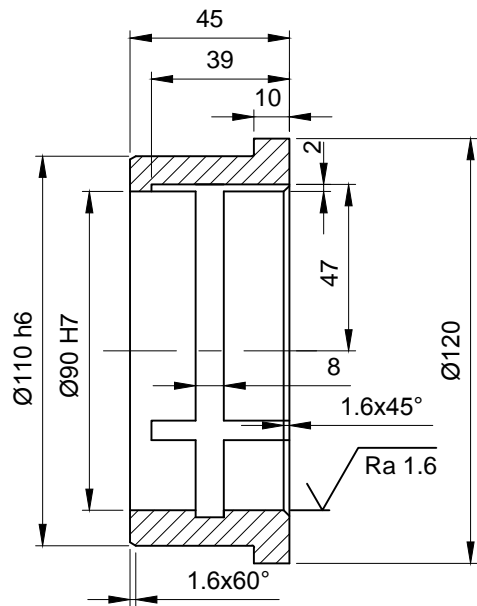
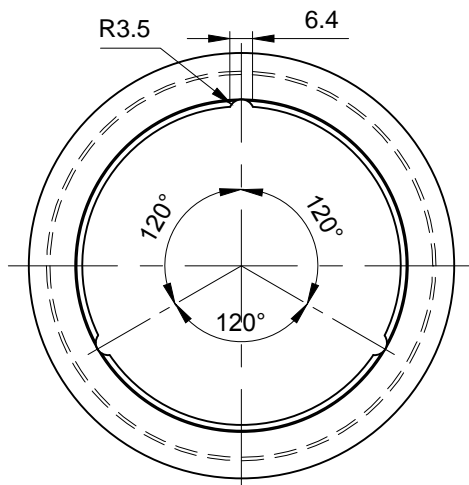
A4-SIZE

ALL DIMENSIONS ARE IN MM


REV 01	DATE	ALTERED
		CHECKED
		APPROVED

$\sqrt{Ra\ 3.2}$ ($\sqrt{Ra\ 1.6}$)

SIZE	DEVIATION
Ø90 H7	+0.035 0.000
Ø110 h6	0.000 -0.022



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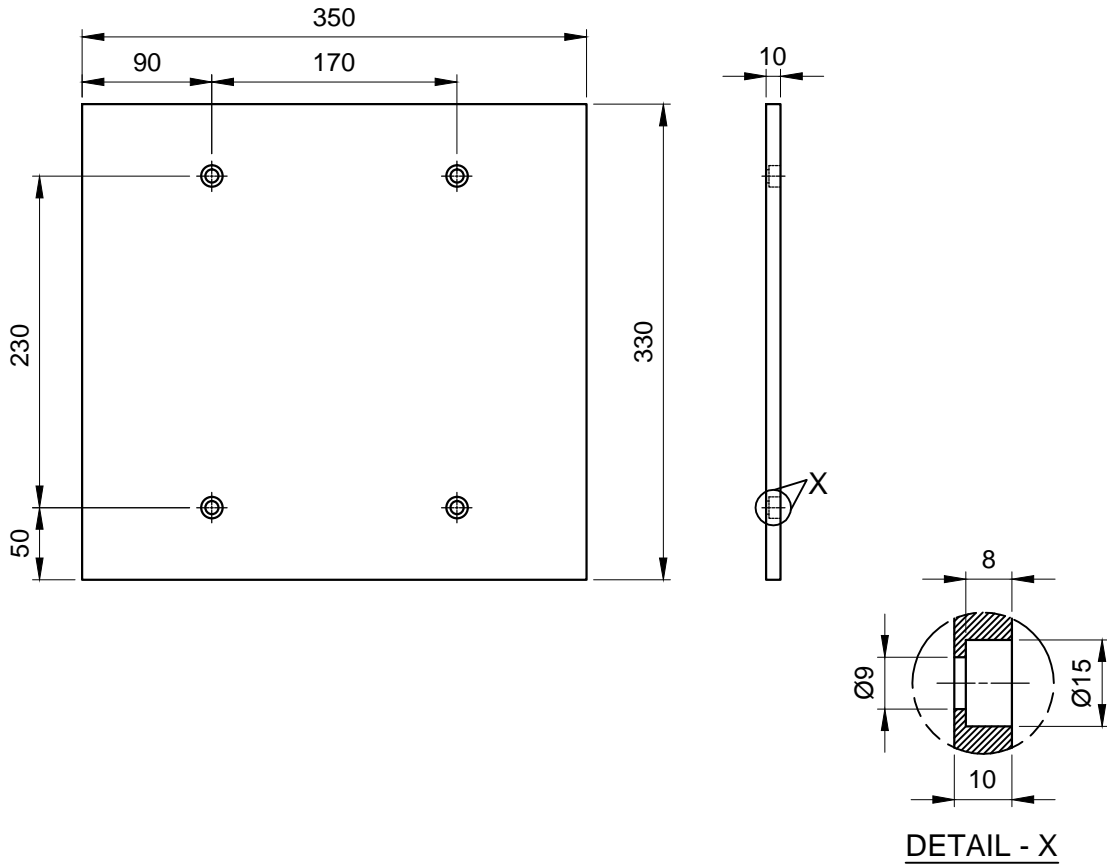
Ro 110 x 45		CuSn12-C DIN EN 1982		02	
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT	
			MATL SPEC	QTY	
EQPT: CROSS PIERCING AND ELONGATION-CONVEYOR ROLLER					
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME S.S.N.KUMAR/ A.S	SIGNATURE <i>S.S.N.Kumar/ A.S</i>	DATE 22.08.14
		CHD	R.K.SINGH	<i>R.K.Singh</i>	22.08.14
		APPD	G.LOGANATHAN	<i>G.Loganathan</i>	22.08.14
DEPT SSTP	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM
456	$\phi/M/f$ IS: 2102	1:2	1.50	0-7-1123-46-11219	13
TITLE		CARD CODE	REF TO OLD DWG NO	0101056-46.000	13
CPE - BUSH CONVEYOR ROLLER		U 01	DRAWING NO :	4-7-1123-46-10324	REV
					00

A4-SIZE

ALL DIMENSIONS ARE IN MM

REV 01	DATE	ALTERED
		CHECKED
		APPROVED

√ Ra 3.2



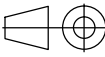
NOTE:
HARDOX 500 IS AN ABRASION RESISTANT STEEL
WITH A NOMINAL HARDNESS OF 500 HBW

CAUTION: THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

ITEM NO	DESCRIPTION	DRAWING NO	PL 350 x 330 x 10	HARDOX 500	02
				MATL CODE	UNIT WT
				MATL SPEC	QTY

EQPT: CROSS PIERCING AND ELONGATION - CONVEYOR ROLLER

	Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME	SIGNATURE	DATE
			CHD	S.S.N.KUMAR/ A.S	<i>S.S.N.Kumar/ A.S</i>	22.08.14
			APPD	R.K.SINGH	<i>R.K. Singh</i>	22.08.14
				G.LOGANATHAN	<i>G. Loganathan</i>	22.08.14

DEPT	GRADE OF UNTOL. DIM		SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM
SSTP					0-7-1123-46-11219	14
CODE	$\phi/M/f$ IS: 2102		1:5	9.00	REF TO OLD DWG NO	14
456					0101056-46.000	

TITLE	CPE - WEAR PLATE CONVEYOR ROLLER	CARD CODE	DRAWING NO :	REV
		U 01	4-7-1123-46-10325	00