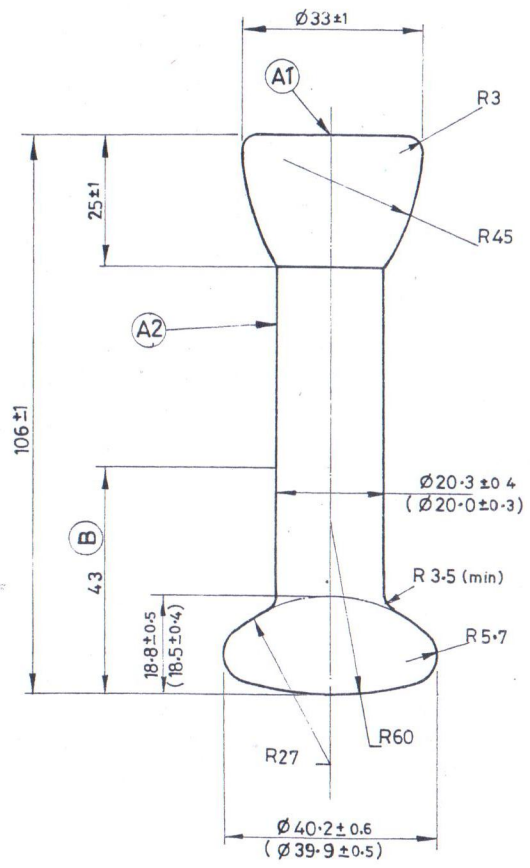


FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm

DRG. NO. 3 980 02 00322


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.



NOTES

- ALL DIMENSIONS ARE AFTER HOT DIP GALVANISING. A THICKNESS OF 0.15mm MAY BE ASSUMED FOR GALVANISING.
- DIMENSIONS INDICATED IN BRACKETS REFER TO BEFORE GALVANISING STAGE.
- BALL PINS ARE TO BE MADE BY FORGING PROCESS ONLY.
- MATERIAL TO CONFORM TO PURCHASING SPECIFICATION EL:PS:36:00103. (LATEST REVISION)
- IF THE FORGED SURFACE IS NOT SMOOTH AT PORTION (B) BALL PINS ARE TO BE MACHINED AT THAT PLACE WITH THE HELP OF A 'FORM TOOL' TO GET A SMOOTH SURFACE.
- AFTER GALVANISING THE BALL PORTION SHOULD ANSWER TO ALL THE RELEVANT GO AND NOT GO GAUGES RECOMMENDED BY IEC PUB 120-1984 OR LATEST (20mm DESIGNATION) UPTO PORTION (B)
- SUPPLIER'S IDENTIFICATION MARK TO BE PROVIDED IN DEPRESSED FORM AT (A1) OR (A2)
- SEQUENCE OF OPERATIONS :
 - BALL PINS ARE TO BE NORMALISED AFTER FORGING.
 - MACHINING (IF NECESSARY-SEE NOTE 5)
 - SHOT BLASTING
 - GALVANISING
- BEFORE GALVANISING THE BALL PORTION SHOULD ANSWER TO 'GO AND NOT GO' GAUGES TO DRG.NO.4 SK 0260-01, 4 SK 0261-01 & CLAUSES B7, B8 & B9 OF IEC-PUB.120 OF 1984 (20mm DESIGNATION) UPTO PORTION (B)

CONTROLLED COPY

NAME OF CUSTOMER/PROJECT				 BHARAT HEAVY ELECTRICALS LTD., ELECTROPORCELAINS DIVISION BANGALORE-560012		DRN.	RS J	SIGN.	18 9 87	DATE	18 9 87	No. OF VAR
						CHD.	BRK	19.9.87				
						APPD.	NDK	24.9.87				
DEPT.	GRADE OF TOL. DIM.	SCALE	WEIGHT (kg)	REF. TO ASSY. DRG.		ITEM No.		No. OF ITEMS				
CODE	C/M/F	1:1	0.45 (APPROX)									
TITLE				DRAWING No.		REV.						
BALL PIN FOR 120 KN DISC INSULATOR (20mm DESIGNATION)				3 980 02 00322		04						
				SHEET No.		NO. OF SHEETS						

REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED
		CHECKED	04	17.5.95	CHECKED	03	21 9 87	CHECKED
Note No.4 modified			1. MATERIAL SPECIFICATION WAS EL:PS:25:00203.			2. DRG No REGULARISED REF. PH-2157		
Ref PH No.3437								