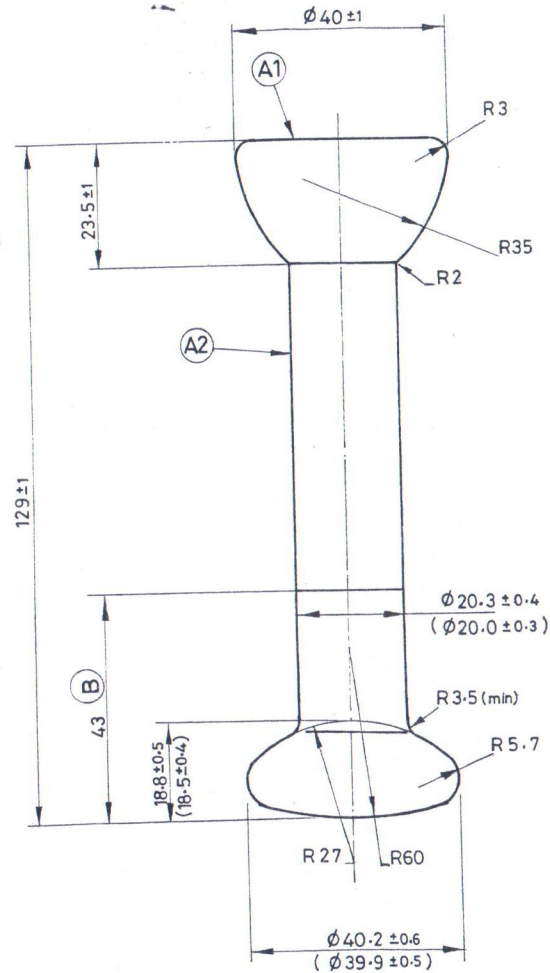


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DRG. NO. 3 980 01 00122



NOTES

- ALL DIMENSIONS ARE AFTER HOT-DIP GALVANISING. A THICKNESS OF 0.15 mm 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)
 - HARDENING & TEMPERING AND SHOTBLASTING
 - GALVANISING
- BEFORE GALVANISING THE BALL PORTION SHOULD ANSWER TO 'GO' AND 'NOT GO' GAUGES TO DRG.NO.4 SK 0260-01, 4SK 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		NAME	SIGN.	DATE	No. OF VAR
		DRN.	RSJ	18.9.87	
		CHD.	BRK	19.9.87	
APPD.	N DK	24.7.77			
DEPT.	GRADE OF TOL. DIM.	SCALE	WEIGHT (kg)	REF. TO ASSY. DRG.	
	C/M/F	1:1	0.55 (APPROX)	ITEM No.	No. OF ITEMS
TITLE			CARD CODE	DRAWING No.	REV.
BALL PIN FOR 160 kN DISC INSULATOR (20mm DESIGNATION)				3 980 01 00122	05
				SHEET No.	NO. OF SHEETS

REV.	DATE	ALTERED	REV.	DATE	ALTERED
05	17.5.95	Y. Bahadur	04	21.9.87	PRY
CHECKED			CHECKED		
Note No.4 modified Ref PH No.3437			1. MATERIAL SPECIFICATION WAS EL: PS:36:00103. 2. DRG. No. REGULARISED. REF. PH-2157		