

NOTE:  
FOR TRANSFER CHAIN ASSY REFER DRG. NO: 2-7-1125-21-10104

ITEM NO	DESCRIPTION	DRAWING NO	MATL SPEC	UNIT	WT	QTY
8	CONICAL GREASE NIPPLE A M10x1		SI.GI.4.8 IS.1387	64	0.008	
7	CIRCLIP 25 X 1.5 N		70 CB IS.2807	64	0.002	
6	SUPPORT ROLLER WITH FLANGE RINGS (TRACK ROLLERS) PWTR 2562 ZRS		SIK / INA	64	0.238	
5	PLAIN WASHER 25		STEEL	64	0.004	
4	BUSH FOR INNER / OUTER LINKS	4-7-1125-21-10244		96	0.018	
3	LINKS CONNECTING SHAFT	3-7-1125-21-10114		32	0.771	
2	V - BLOCK - INNER LINK	3-7-1125-21-10115		16	6.247	
1	OUTER LINK	4-7-1125-21-10243		32	0.758	

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DEPT	466	GRADE OR VTRNO.	DWI	SCALE	1:2	WEIGHT (KGS)	166.768
SRP		φ	M/F	IS:2102			

REV	01	DATE	ALTERED
			CHECKED
			APPROVED

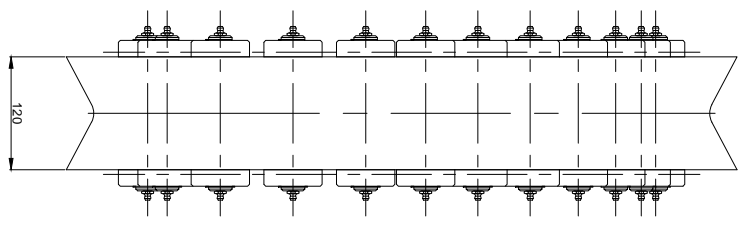
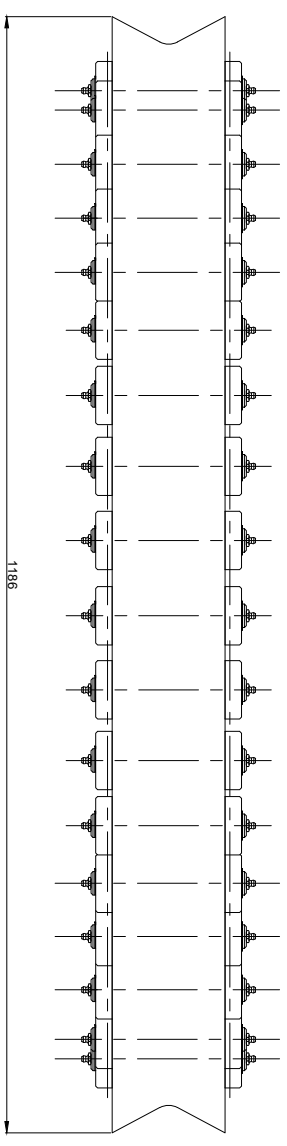
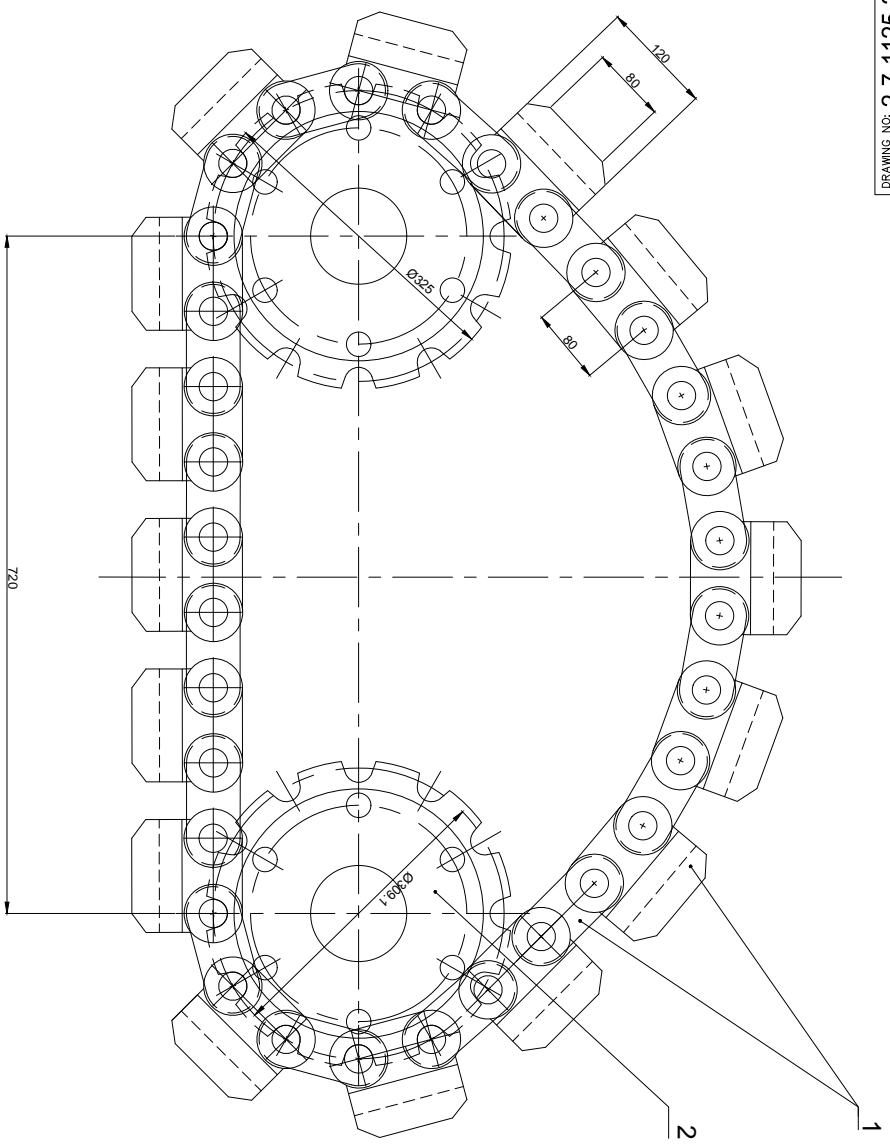
TITLE	CRP - TRANSFER CHAIN - PARTS	DRAWING NO :	2-7-1125-21-10103
CHD CODE	U 01	REV	00



**Bharat Heavy Electricals Ltd**  
SEAMLESS STEEL TUBE PLANT  
TIRUCHIRAPPALLI - 620014

DESIGNED BY: S.S.NAKHWA/C.R  
CHECKED BY: G.LOONATHAN  
APPROVED BY: M.CHANDRASEKHAR

DATE: 26/11/13  
SCALE: 1:2  
WEIGHT (KGS): 166.768



NOTE:  
FOR TRANSFER CHAIN - PARTS REFER DRG. NO. : 2-7-1125-21-10103

ITEM NO	DESCRIPTION	DRAWING NO	MATL SPEC	QTY
2	CHAIN SPROCKET		45C8 IS 1875	2
1	TRANSFER CHAIN - PARTS	2-7-1125-21-10103		1668.84

**Bharat Heavy Electricals Ltd**  
 SEAMLESS STEEL TUBE PLANT  
 TIRUCHIRAPPALLI - 620014  
 S.No: 23111.13  
 DATE: 23.11.13  
 REF TO ASSY DWG NO: 0201511-21.000 - 02  
 REF TO OLD DWG NO:

DEPT: SSTE  
 CODE: 456  
 GRADE OR UNTO: DM  
 IS: 2102  
 SCALE: 1:4  
 WEIGHT (KG): 195.44  
 REF TO OLD DWG NO:

**CRP - TRANSFER CHAIN ASSY**  
 DRAWING NO: 2-7-1125-21-10104  
 REV: 00

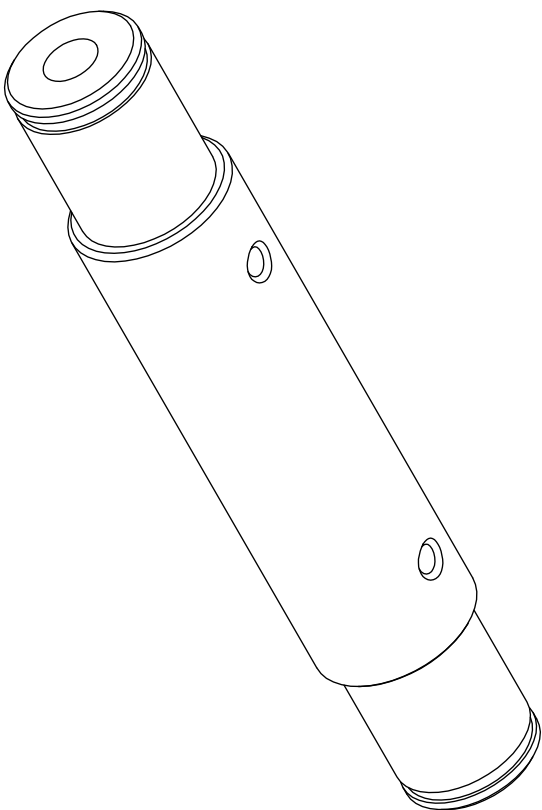
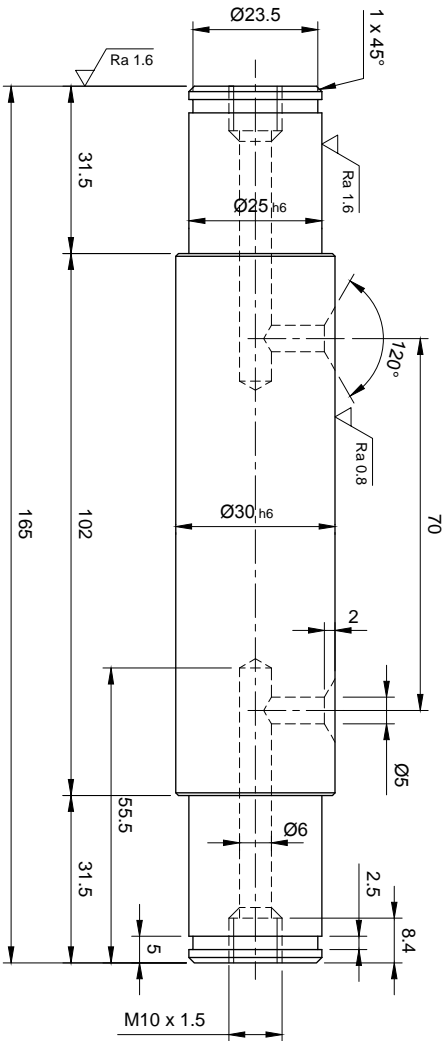
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REV	DATE	ALTERED
01		APPROVED

F 1 2 3 4 5 6 7 8 A2-SIZE



Nominal size	Tolerance field	Deviation
Ø25	h6	0 -0.013
Ø30	h6	0 -0.016



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EQUIPMENT: POSITIONING ROLLER CONVEYOR, CRAMPING LINE AND CRAMPING PRESS WITH FACILITIES		ITEM NO.		DESCRIPTION		DRAWING NO.		MATERIAL CODE		UNIT WT	
								42CrMo4			
								MATERIAL SPEC		QTY	

DEPT	GRADE OF UNTOOL DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	DATE
SSTP	φ / M / f	1:1	0.771	2-7-1125-21-10103	28.11.13
456	IS:2102				

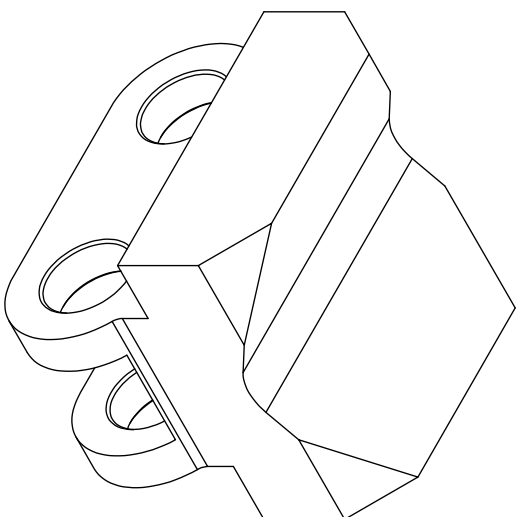
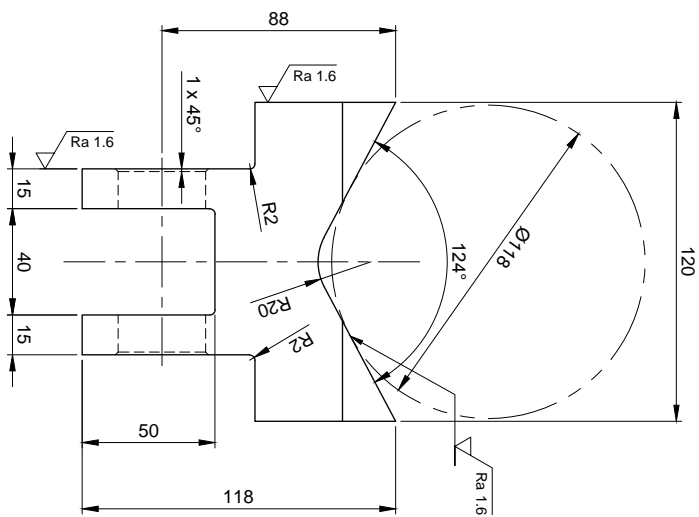
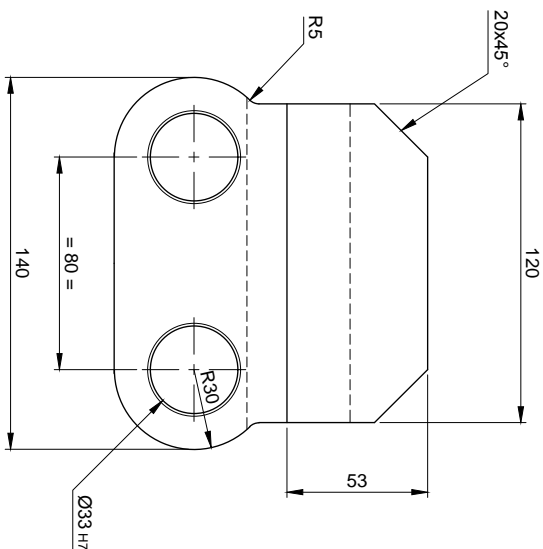
DRN	NAME	SIGNATURE	DATE
S.S.N.KUMAR / R.V	S.S.N.KUMAR	<i>S.S.N.KUMAR</i>	28.11.13
G.D		<i>G. Loganathan</i>	28.11.13
APPD		<i>M. Chandrakumar</i>	28.11.13

REV	DATE	ALTERED	REV
01		CHECKED APPROVED	00

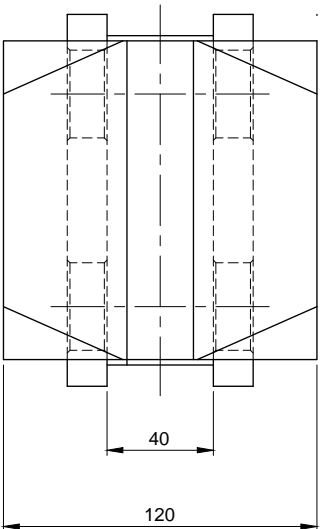
  

TITLE	CARD CODE	DRAWING NO :	REV
CRP - LINKS CONNECTING SHAFT	U 01	3-7-1125-21-10114	00



Nominal size	Tolerance field	Deviation
Ø33	H7	+0.021 0

√ (Ra 1.6)



REV	DATE	ALTERED
01		CHECKED APPROVED

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**Bharat Heavy Electricals Ltd**  
SEAMLESS STEEL TUBE PLANT  
TIRUCHIRAPALLI - 620014

DEPT	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	REF TO OLD DWG NO
SSTP	φ / M / f	1:2	6.247	2-7-1125-21-10103	-
456	IS:2102				

ITEM NO	DESCRIPTION	DRAWING NO	E 410C IS 2062	UNIT WT

DRN	NAME	SIGNATURE	DATE
S.S.N.KUMAR / R.V	S.S.N.Kumar / R.V	<i>S.S.N.Kumar</i>	28.11.13
GLOGANATHAN	GLOGANATHAN	<i>G. Loganathan</i>	28.11.13
M.CHANDRAKUMAR	M.CHANDRAKUMAR	<i>M. Chandrakumar</i>	28.11.13

**CRP - V - BLOCK - INNER LINK**

**3-7-1125-21-10115**

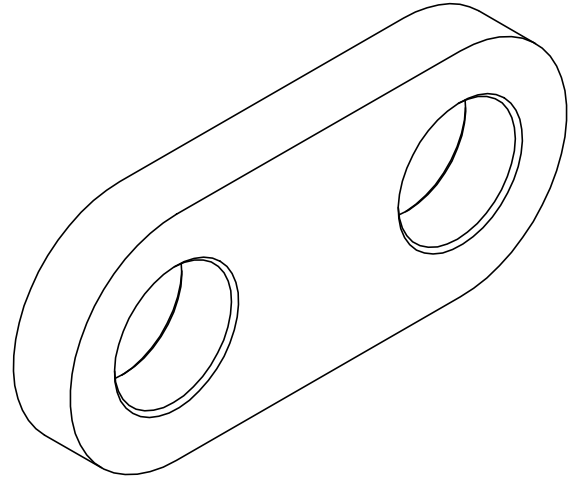
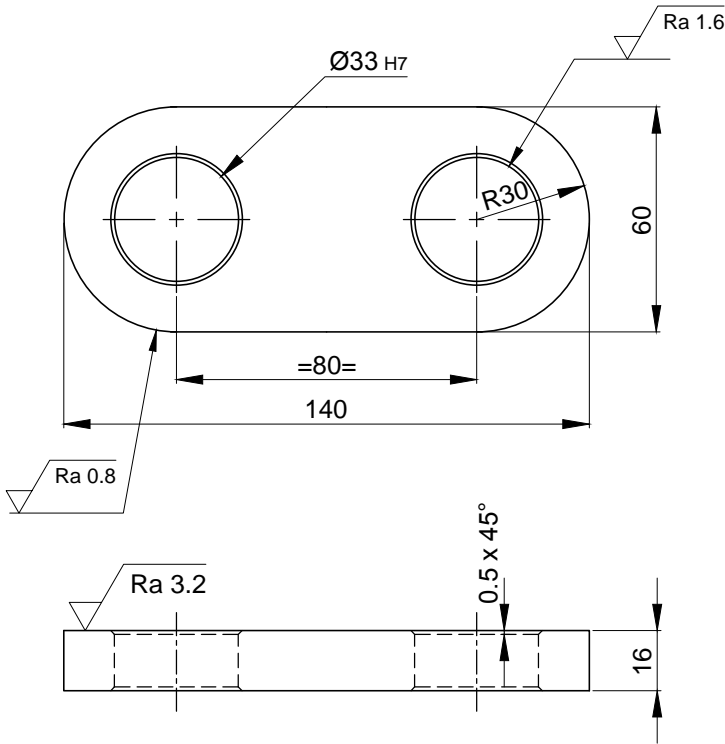
REV	DRAWING NO :
01	3-7-1125-21-10115


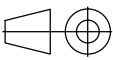
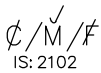
ALL DIMENSIONS ARE IN MM

REV 01	DATE	ALTERED
		CHECKED
		APPROVED

✓ ( ✓ Ra 0.8    ✓ Ra 3.2    ✓ Ra 1.6 )

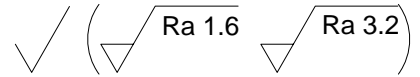
Nominal size	Tolerance field	Deviation
Ø33	H7	+0.021 0



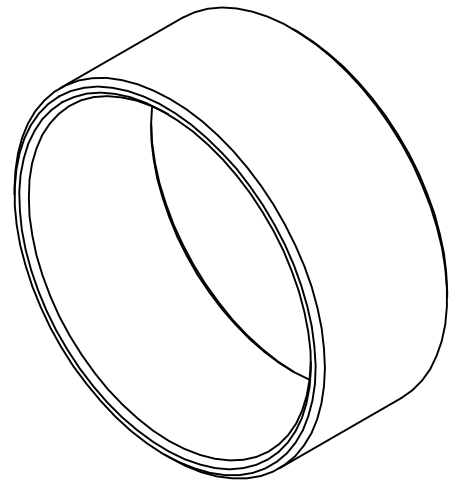
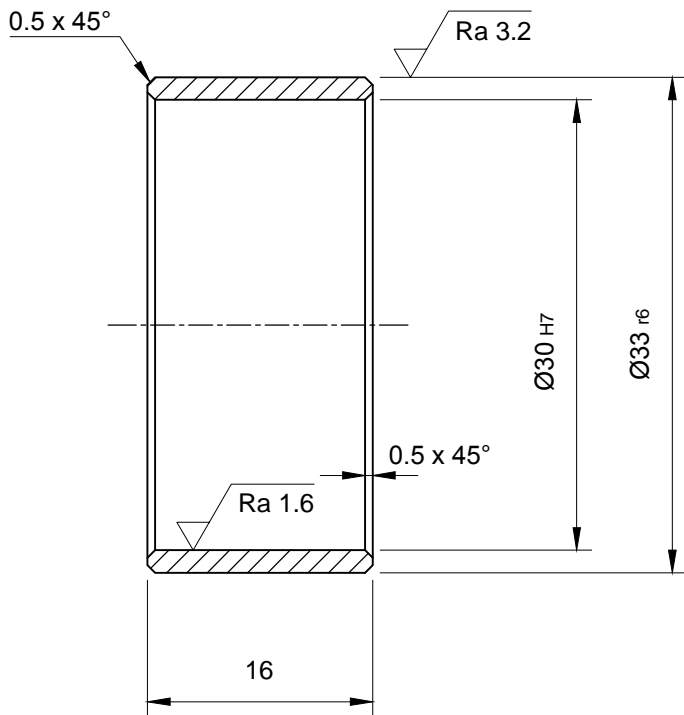
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	ITEM NO	DESCRIPTION	DRAWING NO		MATL CODE	UNIT WT
					MATL SPEC	QTY
	EQPT: POSITIONING ROLLER CONVEYOR, CRIMPING LINE AND CRIMPING PRESS WITH FACILITIES					
	Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME S.S.N.KUMAR / R.V	SIGNATURE <i>S.S.N. Kumar / R.V</i>	DATE 28.11.13
			CHD	G.LOGANATHAN	<i>G. Loganathan</i>	28.11.13
			APPD	M.CHANDRAKUMAR	<i>M. Chandrakumar</i>	28.11.13
DEPT SSTP	GRADE OF UNTOL. DIM		SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO 2-7-1125-21-10103	ITEM 1
CODE 456	 IS: 2102		1:2	0.759	REF TO OLD DWG NO -	
TITLE <b>CRP - OUTER LINK</b>				CARD CODE U 01	DRAWING NO : <b>4-7-1125-21-10243</b>	REV 00


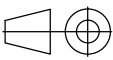
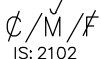
ALL DIMENSIONS ARE IN MM

REV 01	DATE	ALTERED
		CHECKED
		APPROVED



Nominal size	Tolerance field	Deviation
Ø30	H7	+0.025 0
Ø33	r6	+0.05 +0.034



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	ITEM NO	DESCRIPTION	DRAWING NO		MATL CODE		UNIT WT
					MATL SPEC		QTY
	EQPT: POSITIONING ROLLER CONVEYOR , CRIMPING LINE AND CRIMPING PRESS WITH FACILITIES						
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME S.S.N.KUMAR / R.V		SIGNATURE <i>S.S.N.kumar/R.V</i>		DATE 28.11.13
		CHD	G.LOGANATHAN		<i>G.Loganathan</i>		28.11.13
		APPD	M.CHANDRAKUMAR		<i>M.Chandrakumar</i>		28.11.13
DEPT SSTP	GRADE OF UNTOL. DIM		SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO 2-7-1125-21-10103		ITEM 4
CODE 456	 IS: 2102		2:1	0.018	REF TO OLD DWG NO -		
TITLE <b>CRP - BUSH FOR INNER / OUTER LINKS</b>				CARD CODE U 01	DRAWING NO : <b>4-7-1125-21-10244</b>		REV 00