

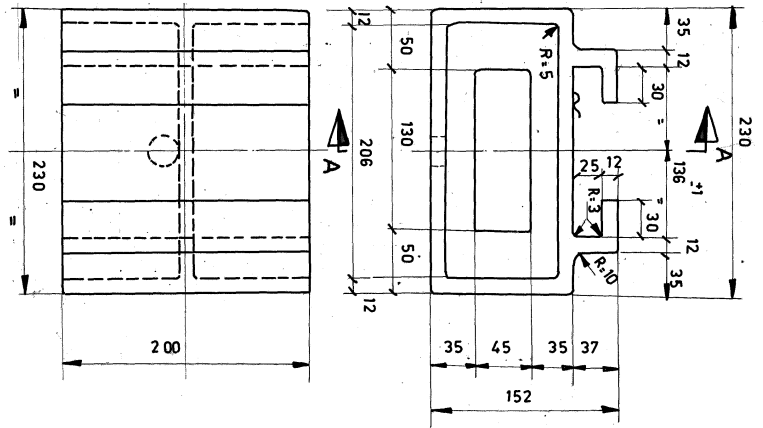
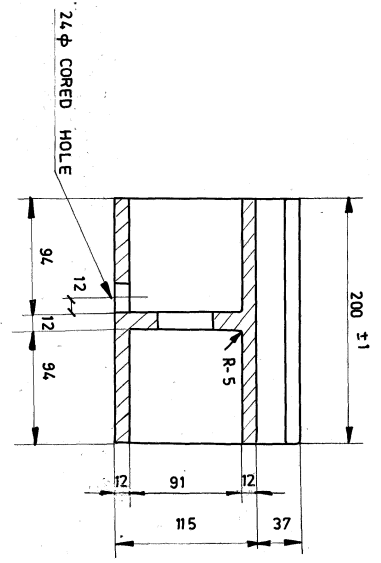






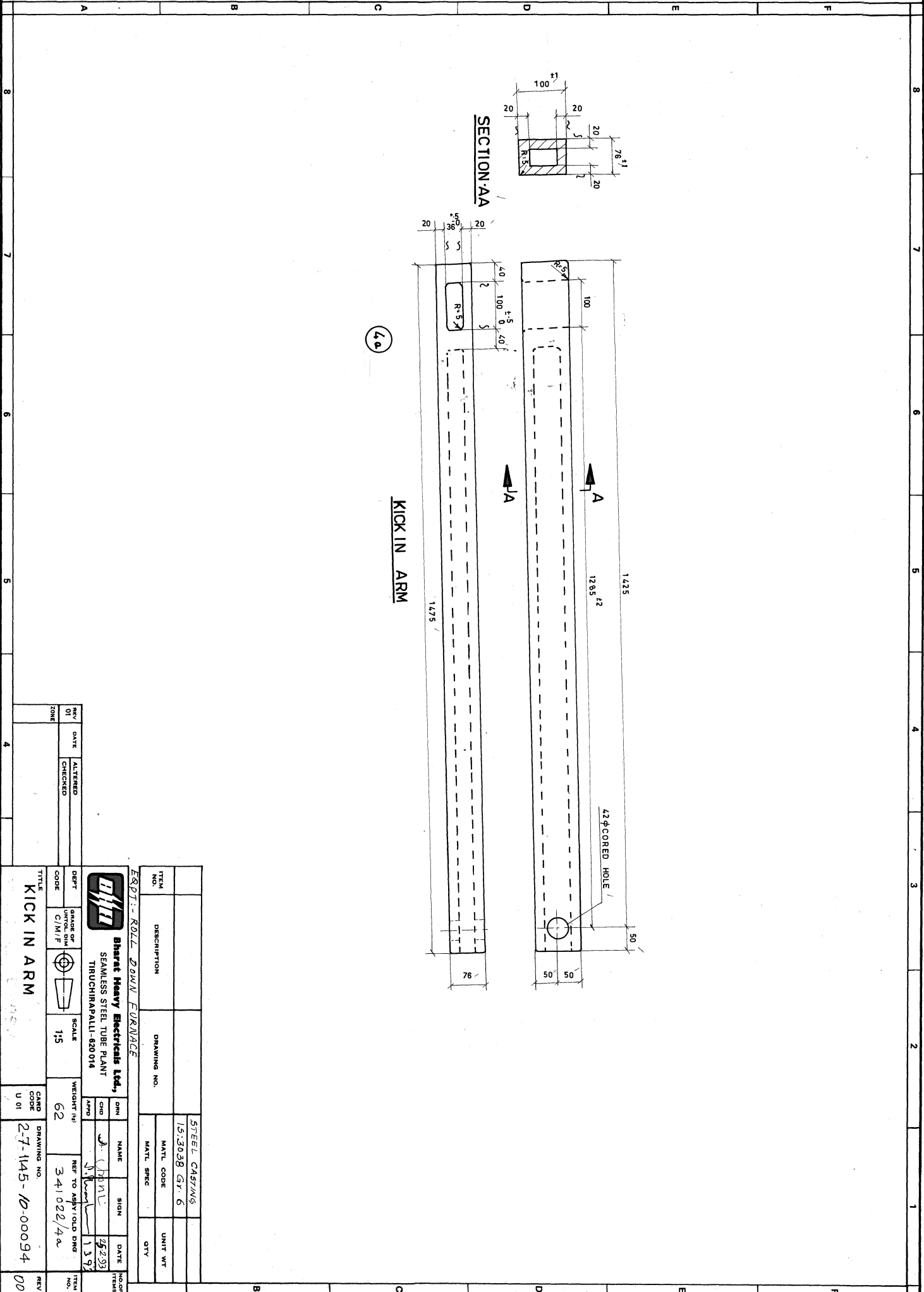
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FIRST ANGLE PROJECTION (ALL DIMENSIONS IN MILLIMETRES)



REV	DATE	ALTERED	ZONE
01		CHECKED	
<b>Bharat Heavy Electricals Ltd.</b> SEAMLESS STEEL TUBE PLANT TRUCHIRAPALLI-620 014			
DEPT	SCALE	WEIGHT (KG)	REF TO HEAVY/DWG NO
01	1:3	114.5	341024/7d
CODE	C/M/F	APPRO	
TITLE	CENTRE SADDLE		
ITEM NO	DESCRIPTION	DRAWING NO	QTY
016	STEEL CASTING	27-1145-03	1
MATL CODE	MATL SPEC	UNIT WT	
DESIGNER	NAME	SIGN	DATE
			08-2-92
CHKD	NAME	SIGN	DATE
			1-3-92
CARD CODE	DRAWING NO		
U 01	27-1145-03		
REV	NO		
00			

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KICK IN ARM

SECTION-AA

L.A.

ITEM NO.	DESCRIPTION	DRAWING NO.	STEEL CASTING
			1513028 GY-6
		MATL. CODE	
		MATL. SPEC	
		UNIT WT.	
		QTY	

REV	DATE	ALTERED
01		CHECKED

DEPT.	GRADE OR C/M/F	SCALE	WEIGHT (kg)	DRAWING NO.	REV
		1:5	62	2-7-1145-10-00094	00

**Bharat Heavy Electricals Ltd.**  
SEAMLESS STEEL TUBE PLANT  
TRUCHIRAPALLI-620 014

DRN	NAME	SIGN	DATE
ENR			28.2.93
APPD			13.93



ESPT:- ROLL DOWN FURNACE

REF TO ASBY/OLD DRG

NO. OF SHEETS

ITEM NO.

REV

DRAWING NO.

SCALE

GRADE OR C/M/F

DEPT.

TITLE

KICK IN ARM

CARD CODE

U 01

WEIGHT (kg)

62

SCALE

1:5

GRADE OR C/M/F

DEPT.

TITLE

KICK IN ARM

CARD CODE

U 01

WEIGHT (kg)

62

SCALE

1:5

GRADE OR C/M/F

DEPT.

TITLE

KICK IN ARM

CARD CODE

U 01

WEIGHT (kg)

62

SCALE

1:5

GRADE OR C/M/F

DEPT.

TITLE

KICK IN ARM

CARD CODE

U 01

WEIGHT (kg)

62

SCALE

1:5

GRADE OR C/M/F

DEPT.

TITLE

KICK IN ARM

CARD CODE

U 01

WEIGHT (kg)

62

SCALE

1:5

GRADE OR C/M/F

DEPT.

TITLE

KICK IN ARM

CARD CODE

U 01

WEIGHT (kg)

62

SCALE

1:5

GRADE OR C/M/F

DEPT.

TITLE

KICK IN ARM

CARD CODE

U 01

WEIGHT (kg)

62

SCALE

1:5

GRADE OR C/M/F

DEPT.

TITLE

KICK IN ARM

CARD CODE

U 01

WEIGHT (kg)

62

SCALE

1:5

GRADE OR C/M/F

DEPT.

TITLE

KICK IN ARM

CARD CODE

U 01

WEIGHT (kg)

62

SCALE

1:5

GRADE OR C/M/F

DEPT.

TITLE

KICK IN ARM

CARD CODE

U 01

WEIGHT (kg)

62

SCALE

1:5

GRADE OR C/M/F

DEPT.

TITLE

KICK IN ARM

CARD CODE

U 01

WEIGHT (kg)

62

SCALE

1:5

GRADE OR C/M/F

DEPT.

TITLE

KICK IN ARM

CARD CODE

U 01

WEIGHT (kg)

62

SCALE

1:5

GRADE OR C/M/F

DEPT.

TITLE

KICK IN ARM

CARD CODE

U 01

WEIGHT (kg)

62

SCALE

1:5

GRADE OR C/M/F

DEPT.

TITLE

KICK IN ARM

CARD CODE

U 01

WEIGHT (kg)

62

SCALE

1:5

GRADE OR C/M/F

DEPT.

TITLE

KICK IN ARM

CARD CODE

U 01

WEIGHT (kg)

62

SCALE

1:5

GRADE OR C/M/F

DEPT.

TITLE

KICK IN ARM

CARD CODE

U 01

WEIGHT (kg)

62

SCALE

1:5

GRADE OR C/M/F

DEPT.

TITLE

KICK IN ARM

CARD CODE

U 01

WEIGHT (kg)

62

SCALE

1:5

GRADE OR C/M/F

DEPT.

TITLE

KICK IN ARM

CARD CODE

U 01

WEIGHT (kg)

62

SCALE

1:5

GRADE OR C/M/F

DEPT.

TITLE

KICK IN ARM

CARD CODE

U 01

WEIGHT (kg)

62

SCALE

1:5

GRADE OR C/M/F

DEPT.

TITLE

KICK IN ARM

CARD CODE

U 01

WEIGHT (kg)

62

SCALE

1:5

GRADE OR C/M/F

DEPT.

TITLE

KICK IN ARM

CARD CODE

U 01

WEIGHT (kg)

62

SCALE

1:5

GRADE OR C/M/F

DEPT.

TITLE

KICK IN ARM

CARD CODE

U 01

WEIGHT (kg)

62

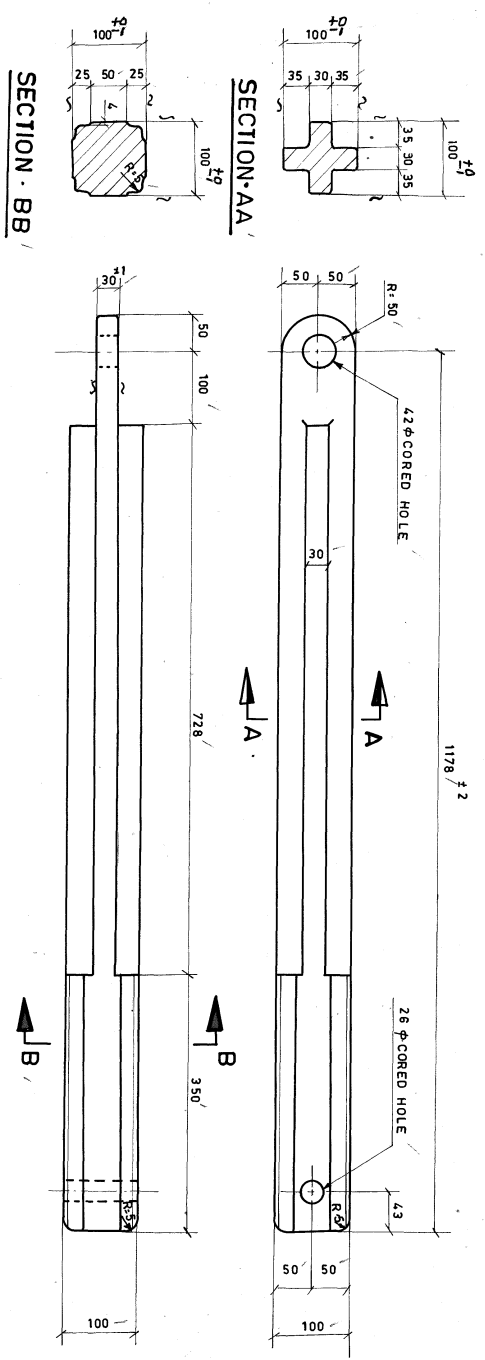
SCALE

1:5

GRADE OR C/M/F

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FIRST ANGLE PROJECTION (ALL DIMENSIONS IN MILLIMETRES)



**NOTE:**  
CASTING SHOULD BE SMOOTH, STRAIGHT AND FREE FROM DEFECTS LIKE BLOW HOLES, WARPAGE ETC.

REV	DATE	ALTERED BY	APPROVED BY
01	4-10-21	S. K. S. S. S.	S. K. S. S. S.
ZONE APPROVED			
DIMENSION 100 <sup>±</sup> WAS			
NOTE ADDED			

ITEM NO.	DESCRIPTION	DRAWING NO.	UNIT WT

GRD	CHKD	APPD	NAME	SIGN	DATE
			S. K. S. S. S.		03-12-21

DEPT	GRADE OF C/M/F	SCALE	WEIGHT (kg)	REF TO ASSY/DWG NO.
		1:5	54.5	341022/3

TITLE	CARD CODE	DRAWING NO.	REV
KICK OUT ARM	U 01	2-3-1145-11-0009201	01

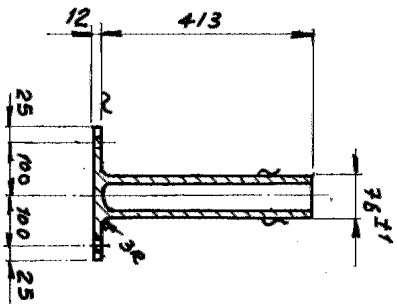
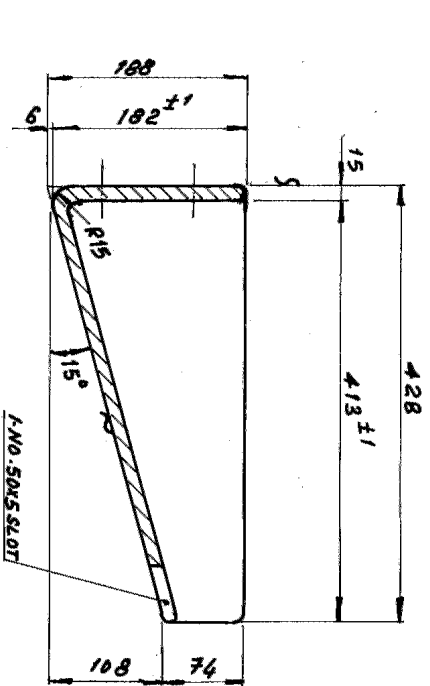
**Bharat Heavy Electricals Ltd.**  
 SEAMLESS STEEL TUBE PLANT  
 TIRUCHIRAPALLI-620 014

**ESPT: ROLL DOWN FURNACE**

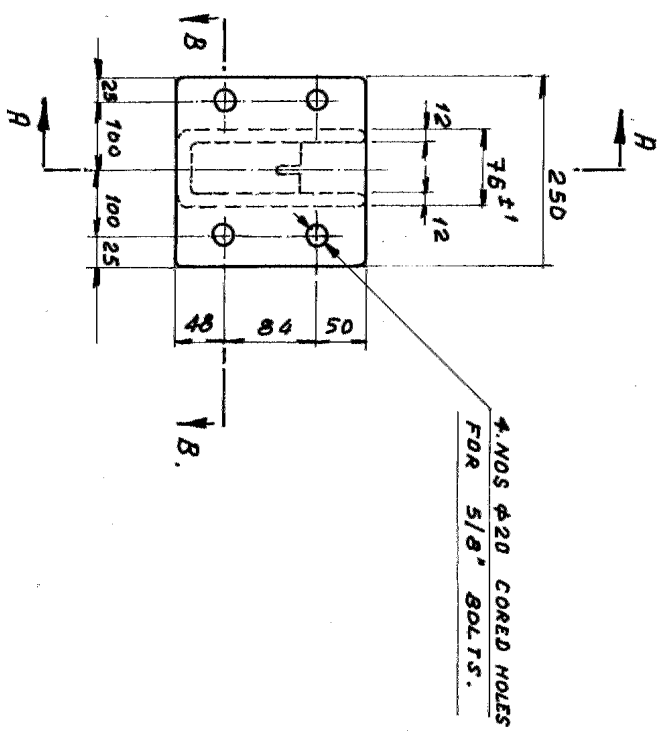
Gr 6 J.S. 3038  
 STEEL CASTING

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FIRST ANGLE PROJECTION (ALL DIMENSIONS IN MILLIMETRES)



SECTION - BB.  
SCALE: 1:10



MATERIAL SPECIFICATION

HRCJ GRADE 3 TYPE 'E' OF IS:3355

CHEMICAL COMPOSITION

C = 0.28 TO 0.32 %  
S = 0.15 % MAX.  
P = 0.04 % MAX.  
CV = 1.21 TO 1.4 %

ITEM NO.	DESCRIPTION	DRAWING NO.	MATL. CODE	UNIT WT.
<b>EPT: ROLL DOWN FURNACE</b>				

**Bharat Heavy Electricals Ltd.,**  
SEAMLESS STEEL TUBE PLANT  
TIRUCHIRAPPALLI-620 014

DRN. NAME: S. Anand  
CHD. NAME: J. Jeyaraj  
APPD. NAME: J. Jeyaraj

DATE: 9/12/98

REV.	DATE	ALTERED	BY	REASON
01	12/12/98	CHECKED	J. Jeyaraj	

MATL. SPEC: HRCJ GR. 3 TYPE 'E' OF IS: 3355 WAS STEEL CASTING FC: 3138 GR. 4

DEPT.	GRADE OF UNTOOL DIM	SCALE	WEIGHT (KG)	REF TO OLD DRG
	C/M/F	1:5 (1:10)	18.5	341021

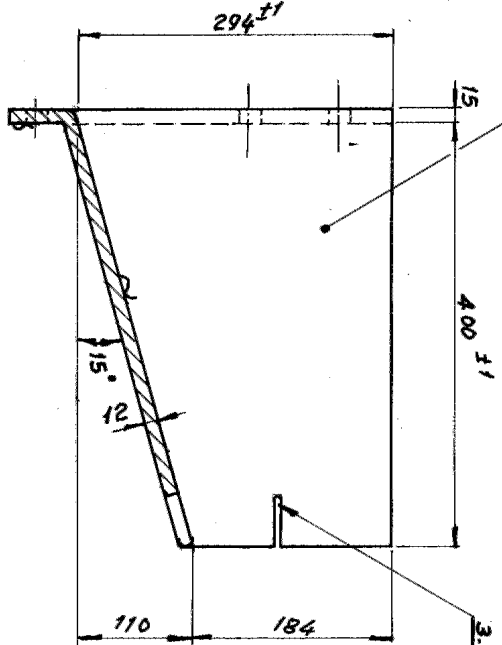
**STOPPER BEAM GUIDE.**  
ROLL DOWN FURNACE.

CARD CODE: U 01  
DRAWING NO.: 3-7-1145-07-00144.  
REV: 01

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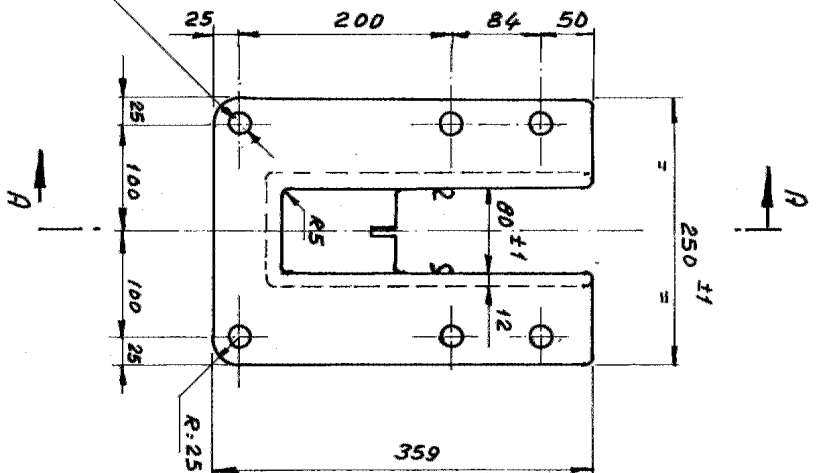
FIRST ANGLE PROJECTION (ALL DIMENSIONS IN MILLIMETRES)

STOPPER BEAM AND STOPPER BEAM GUIDE  
MUST FIT FAEELY IN TO THIS PART.



SECTION-RR.

6-NOS Ø20 CORED HOLES FOR 5/8" BOLTS.



**MATERIAL SPECIFICATION:-**  
H.R.C.I GRADES TYPE 'E' OF IS: 3355

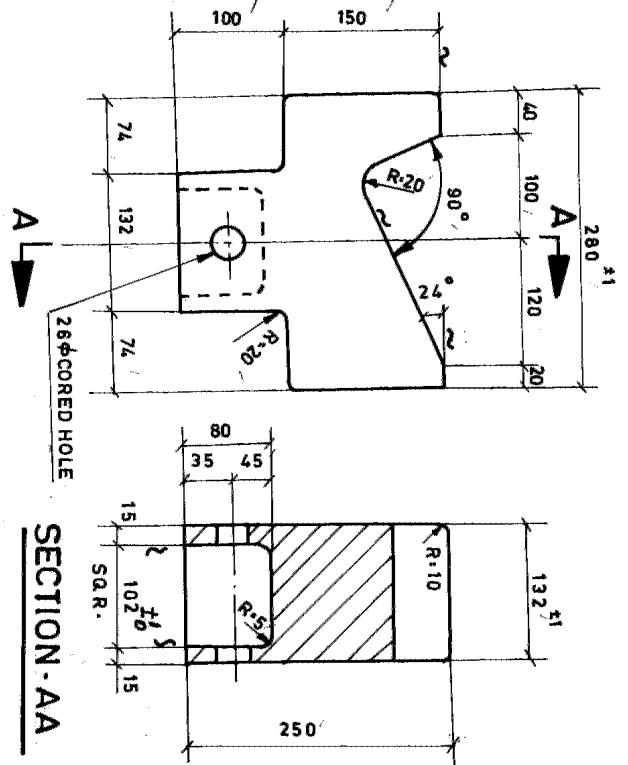
**CHEMICAL COMPOSITION:-**  
C = 2.8 TO 3.2 %  
S = 0.15 % MAX  
P = 0.4 % MAX  
C<sub>v</sub> = 1.21 TO 1.4 %

REV.	DATE	ALTERED	BY	CHKD.
01	10.12.98		J. Shankar	
M.T.L. SPECN H.R.C.I GRAD 3 TYPE 'E' OF IS: 3355 WAS STEEL CASTING 15.3088 GR 4.				

DEPT.	GRADE OF UNTOOL/DIM	SCALE	WEIGHT (KG)	REF. TO NEW/OLD DRW
	C/M/F	1:5	27.5	341021
Bharat Heavy Electricals Ltd., SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI-620014				
DRN.	NAME	SIGN.	DATE	NO. OF
CHD.	S. Ramesh	[Signature]	9.9.98	ITEMS
APPR.	J. Shankar	[Signature]	3.2.95	
APPR.	[Signature]	[Signature]	3/2/98	

TITLE	CARD CODE	DRAWING NO.	REV.
STOPPER BEAM HOUSING ROLL DOWN FURNACE.	U 01	3-7-1145-07-00145.	01

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3C

**KICK OUT ARM HEAD**

**SECTION-AA**

**NOTE:**

**CASTING SHOULD BE SMOOTH, STRAIGHT AND FREE FROM DEFECTS LIKE BLOW HOLES, WARPAGE ETC.**

ITEM NO.	DESCRIPTION	DRAWING NO.	MATL. CODE	UNIT WT.	QTY.
	STEEL CASTING		IS:3038 GY 6		

EQUIP:- ROLL DOWN FURNACE	
Bharat Heavy Electricals Ltd., SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI-620014	
DRN.	NAME
CHG.	DATE
APPR.	REF TO ASSV/OLD DRG.

REV.	DATE	ALTERED	BY	CHKD.	DATE
01	4-10-24	4-10-24	S. N. S.	S. N. S.	10/10/24
* DIMENSION 102 ±1 SQ.R. * NOTE ADDED					

DEPT.	GRADE OF UNTO. DIM	SCALE	WEIGHT (KG)	CARD CODE	DRAWING NO.	REV.
	C/M/F	1,5	38	U 01	341022/3C	01
<b>KICK OUT ARM HEAD</b>						