

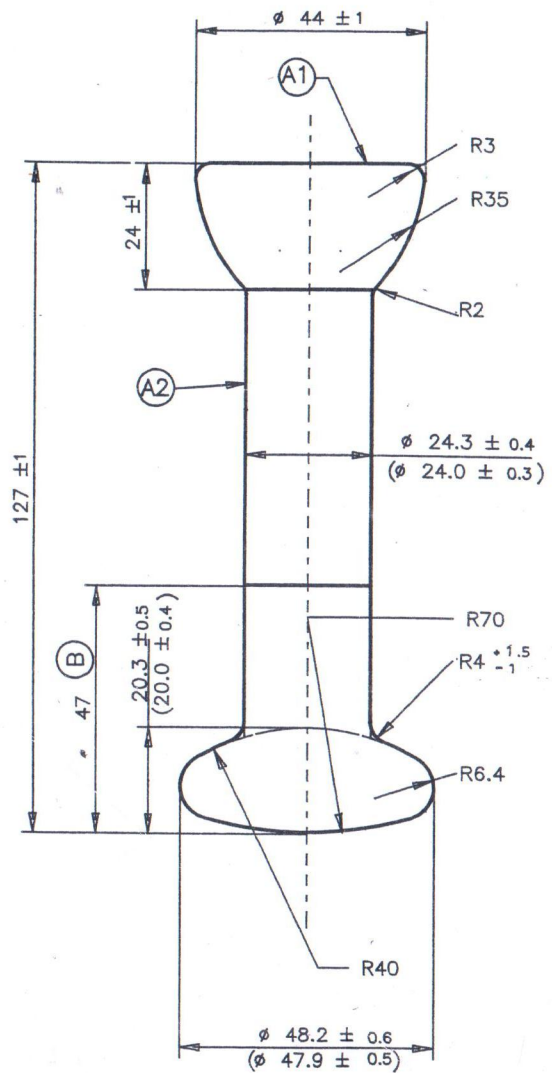
FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm.

REV 0 3 980 08 00222 DRG No.

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SIGN AND DATE REF. DRG. No.



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 PIN PORTION SHOULD ANSWER TO ALL THE RELEVANT 'GO & NOT GO' GAUGES RECOMMENDED BY IEC Pub.120 (LATEST) 24 mm DESIGNATION UP TO PORTION (B)
- SUPPLIER'S IDENTIFICATION MARK TO BE PROVIDED IN DEPRESSED FORM AT (A1) OR (A2)
- SEQUENCE OF OPERATIONS :  
 A) BALL PINS ARE TO BE NORMALISED AFTER FORGING  
 B) MACHINING (IF NECESSARY - SEE NOTE 5)  
 C) SHOTBLASTING  
 D) GALVANISING
- BEFORE GALVANISING THE BALL PIN PORTION SHOULD ANSWER TO 'GO & NOT GO' GAUGES TO DRG. 4 SK 1201, 4 SK 1202 & CLAUSES - B7, B8 & B9 OF IEC Pub.120 OF 24mm DESIGNATION UP TO PORTION (B)
- BALL PINS SHALL WITHSTAND A MINIMUM TENSILE STRENGTH OF 252 kN

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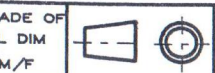
INVENTORY No.	REV	DATE	ALTERED	REV	DATE	ALTERED	REV	DATE	ALTERED	DEPT	GRADE OF TOL DIM	SCALE	WEIGHT (kg)	REF TO ASSY.DRG	ITEM No.	No.OF ITEMS
			CHECKED	02	29/3/00	CHECKED	01	27/4/95	CHECKED			1:1	0.7 (Approx)			
	In Note No.8 Sub No.'C' MODIFIED			Material was "GRADE 080M40 of BS 970:Part 1 was 280 kN.			Ref PH No.3429			TITLE		BALL PIN		DRAWING No.		REV.
	RefPH No.4124			Ref PH No.3429			FOR 24 mm DESIGNATION OF 170 mm SPACING				CARD CODE		3 980 08 00222		02	
														SHEET No.	No.OF SHEETS	

FERROUS PARTS ATRE HOT-DIP GALVANIZED (EXCEPT FEMALE THREADS) AS PER IS: 2629 AND TESTS CONFORM TO IS:2633



**BHARAT HEAVY ELECTRICALS LTD.,**  
ELECTROPORCELAINS DIVISION  
BANGALORE - 560 012

DRN	NAME	SIGN	DATE
CHD	N.K.IDDALAGI	N.K. Idalagi	18.02.1995
APPD	B R K	B Ramakrishna	15.3.95
	N D K		15.3.95



DEPT CODE

DRAWING No. 3 980 08 00222 REV. 02