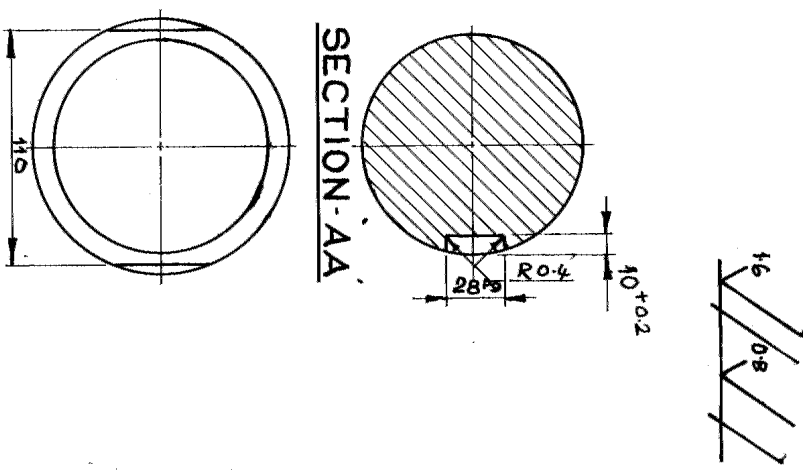
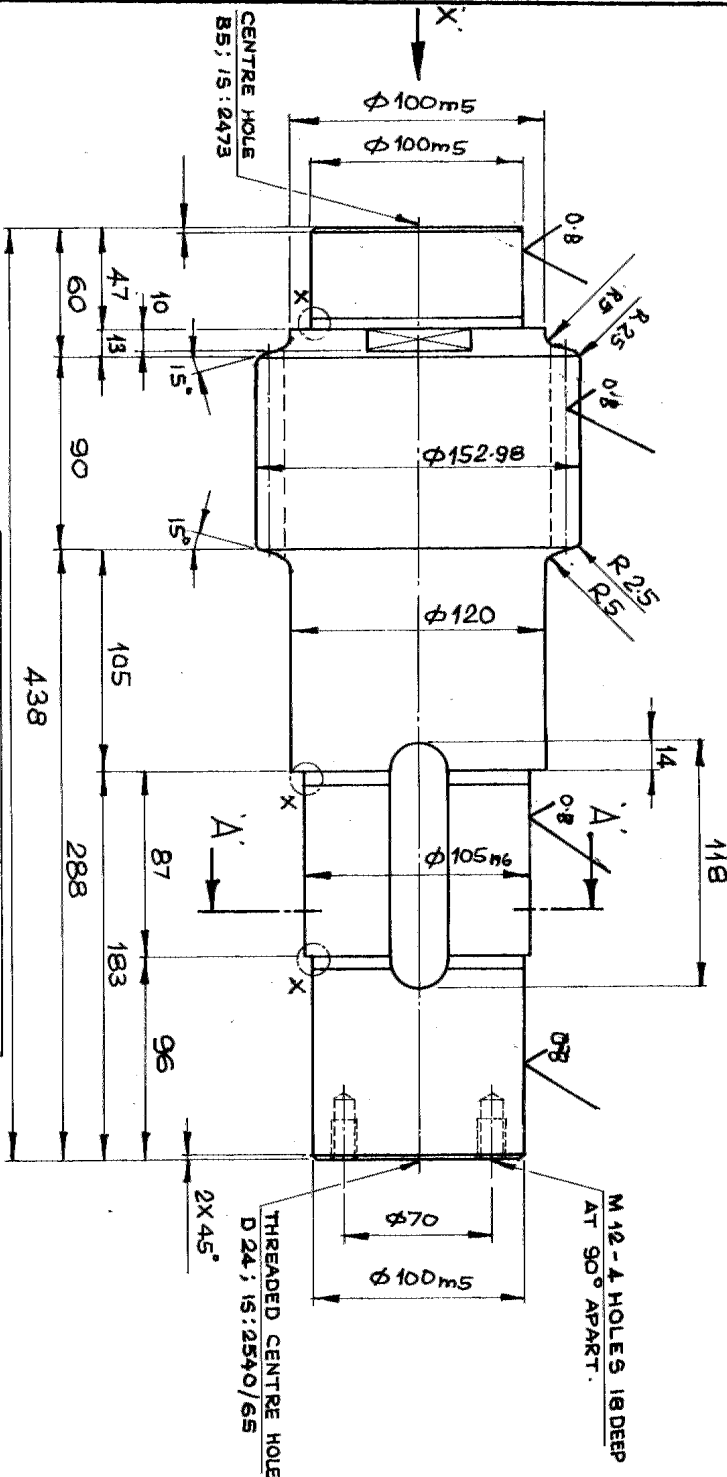
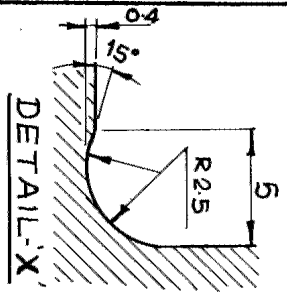


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TOPPING EFFECTED
CASE HARDEN TO HRC 5S-2
CASE DEPTH = 1.1MM.



NO. OF TEETH	21
NORMAL MODULE	6.5
AXIAL MODULE	6.6
PRESSURE ANGLE	20°
HELIX ANGLE	10°
HAND OF HELIX	R-H
CORRECTION FACTOR	+0.107
WIDTH ACROSS 3 TEETH	-0.045 -0.095 50.445
GEAR RATIO	2.381
MATING GEAR NO. OF TEETH	50
MATING GEAR DRG. NO.	3-7-1155-15-00432
CENTRE DISTANCE	235 ± 0.05

100m5	+0.028
105m6	+0.043
28P9	+0.045
	+0.023
	-0.022
	-0.074

REV	DATE	ALTERED BY	CHECKED BY	APPROVED BY
01	26-2-82			

MAT. SPEC. ICMIN BCT 4
 IS:14432 WAS ICMIN BCT 9S
 IS:1870/61

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

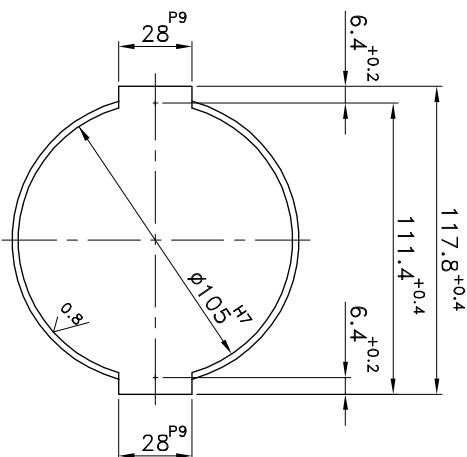
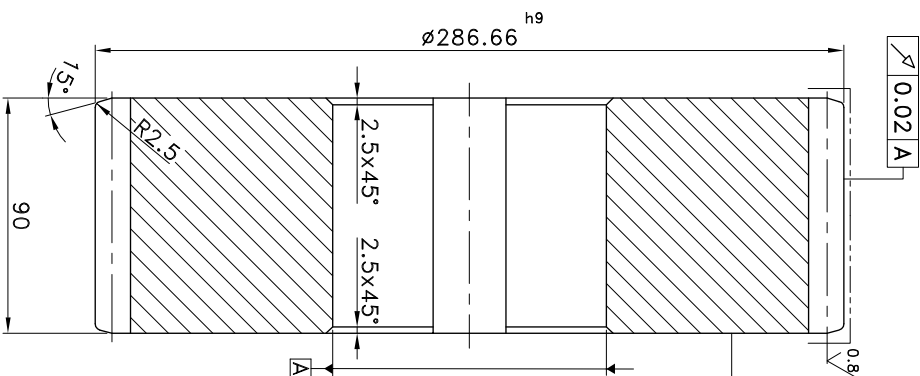
ITEM NO.	DESCRIPTION	DRAWING NO.	QTY

PINION SHAFT 2.21
(GEAR BOX ASSY) MS 6.5

Scale: 1:2.5

DRN: S. Ramesh
 CHD: S. Ramesh
 APPD: S. Ramesh

REF TO ASSY/OLD DRG: 99094
 3-7-1155-15-00609/01



$\phi 286.66$ h9	0
	-0.130
$\phi 105$ H7	+0.035
	0
28 P9	-0.022
	-0.074

NO OF TEETH (Z4)	49
MODULE	5.5
PRESSURE ANGLE	20°
HELIX ANGLE	10°
HAND OF HELIX	R.H
CORRECTION FACTOR	0.2104
WIDTH ACROSS 7 TEETH	110.2734 -0.085 -0.169
QUALITY & TOLERANCE ZONE	7e DIN 3967
MATING GEAR NO OF TEETH (Z3)	34
MATING GEAR DRG NO	3-7-1155-15-10084
CENTRE DISTANCE	235 ±0.05

----- CASE HARDEN TO HRC 59⁺²
CASE DEPTH 1.1mm

REV	DATE	ALTERED
01		CHECKED APPROVED

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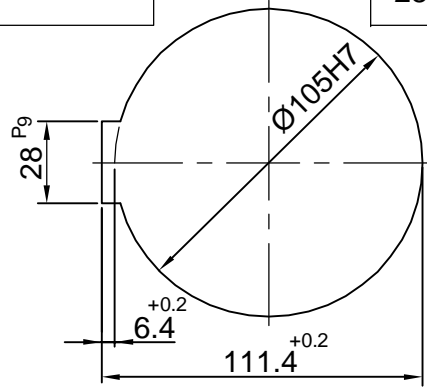
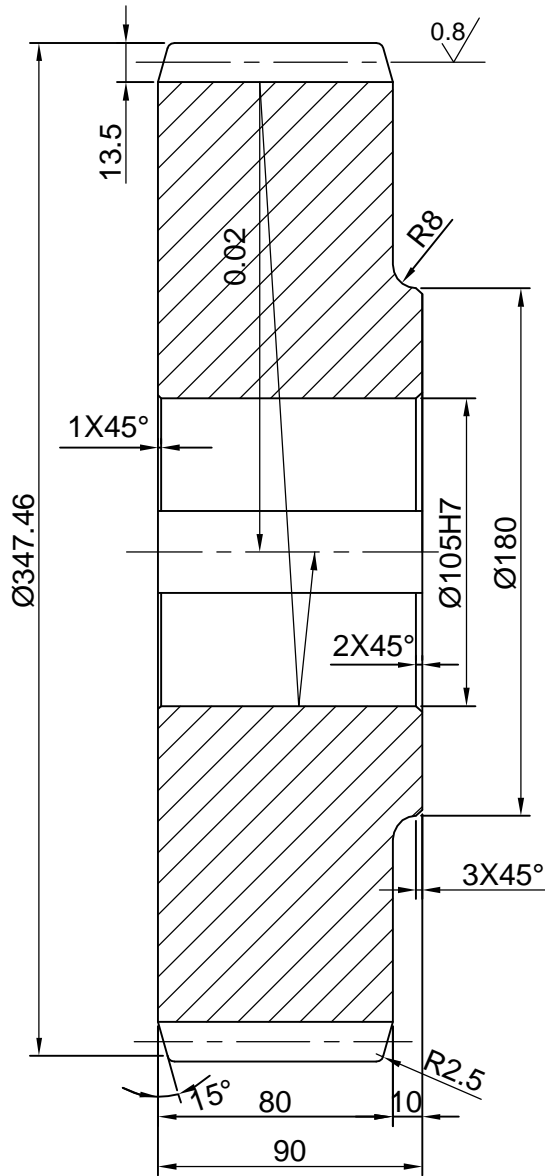
EQUIPMENT: STRETCH REDUCING MILL		ITEM NO		DESCRIPTION		DRAWING NO		UNIT WT	
Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		16Mn5Cr4 IS:4432							
DEPT	SSIP	GRADE OF UNTOOL. DIM	$\phi / M / \#$	SCALE	WEIGHT (Kg)	DRN	NAME	SIGNATURE	DATE
456	456	IS:2102		1:2	38	SSM.KUMAR	S.S.M. Kumar		22.08.12
CHD	G.LLOGANATHAN	APPD	S.MOHAN	REF TO ASSY DWG NO	0-7-1155-15-11046	CHD	G.LLOGANATHAN	S. Sivanandhan	22.08.12
REF TO OLD DWG NO		REF TO OLD DWG NO		REF TO OLD DWG NO		APPD	S.MOHAN	S. Mahan	22.08.12
TITLE		SRM - HELICAL GEAR		CARD CODE		DRAWING NO :		REV	
Z = 49 Mn = 5.5 GEAR BOX ASSY		U 01		38		3-7-1155-15-10083		00	

ALL DIMENSIONS ARE IN MM

REV 01	DATE 20.02.83	ALTERED CHECKED APPROVED	PALANISAMY SSN.KUMAR S.S.SUNDARAM	REV 02	DATE 25-03-2011	ALTERED CHECKED APPROVED	<i>D. Anand</i> <i>SSN. Kumar</i> <i>G. Loganathan</i>
MATL. SPEC. 16Mn5Cr4 IS : 4432 WAS 17MnCr95 IS:1570/61				CONVERTED TO AUTO CAD DRAWING			

1.6 // 0.8 //


Ø105	H7	+0.035
		0
28	P9	-0.022
		-0.074



NO OF TEETH	54
NORMAL MODULE	6
AXIAL MODULE	6.093
PRESSURE ANGLE	20°
HELIX ANGLE	10°
HAND OF HELIX	R.H
CORRECTION FACTOR	+0.6423
WIDTH ACROSS 8 TEETH	-0.052 -0.082 140.222
GEAR RATIO	2.571
MATING GEAR N _O OF TEETH	21
MATING GEAR DRG N _O :3-7-1155-15-00601	
CENTRE DISTANCE	235 ^{+0.05}

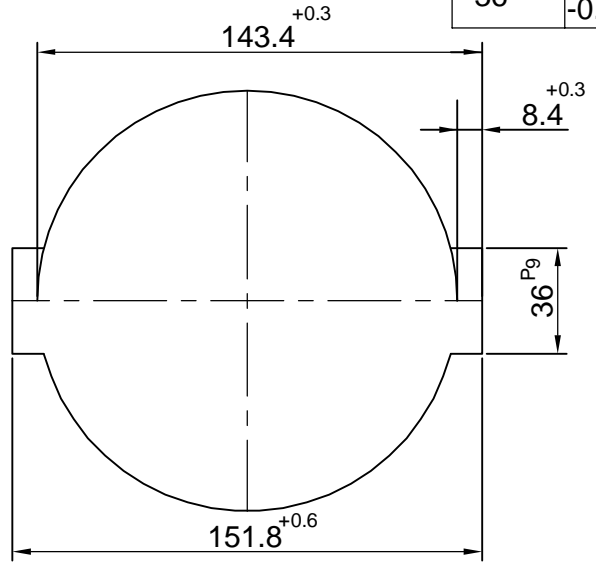
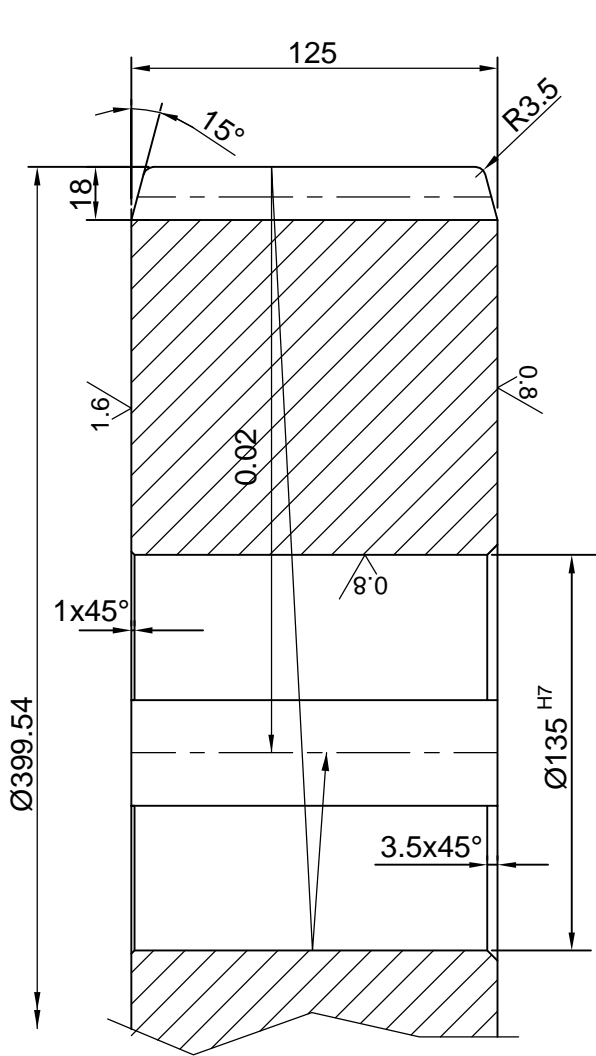
TOPPING EFFECTED
CASE HARDEN TO HRC 59⁻²
CASE DEPTH = 1.1mm

CAUTION: 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.

				16Mn5Cr4 IS:4432			
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE		UNIT WT		
			MATL SPEC		QTY		
EQPT: STRETCH REDUCING MILL							
		Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME	SIGNATURE	DATE
				CHD	D.ANAND	<i>D. Anand</i>	17-03-11
				APPD	SSN.KUMAR	<i>SSN. KUMAR</i>	17-03-11
					G.LOGANATHAN	<i>G. Loganathan</i>	17-03-11
DEPT	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO		ITEM	
SSTP	Ø/M/F	1:2.5	54	0-7-1155-15-11046		76	
CODE	IS: 2102			REF TO OLD DWG NO			
456				29011			
TITLE				CARD CODE	DRAWING NO :		REV
SRM - HELICAL GEAR (GEAR BOX DRIVE)				U 01	4-7-1155-15-00624		02

ALL DIMENSIONS ARE IN MM


REV 01	DATE 19-2-83	ALTERED	SSN . KUMAR	REV 02	DATE 25-03-2011	ALTERED	D. Anand	3.2 // 1.6 // 0.8 //									
		CHECKED	A . AROCKIAM			CHECKED	SSM. Kumar										
		APPROVED	S.S.SUNDARAM			APPROVED	J. Loganathan										
MATL SPEC. 20Mn5Cr5 IS:4432 WAS 20MnCr1 IS:1570/61				CONVERTED TO AUTO CAD DRAWING				<table border="1"> <tr> <td>Ø135^{H7}</td> <td>+0.040</td> </tr> <tr> <td></td> <td>0</td> </tr> <tr> <td>36^{P9}</td> <td>-0.026</td> </tr> <tr> <td></td> <td>-0.088</td> </tr> </table>		Ø135 ^{H7}	+0.040		0	36 ^{P9}	-0.026		-0.088
Ø135 ^{H7}	+0.040																
	0																
36 ^{P9}	-0.026																
	-0.088																



TOPPING EFFECTED
CASE HARDEN TO HRC 59⁻²
CASE DEPTH = 1.3mm

NO OF TEETH	39
NORMAL MODULE	8
AXIAL MODULE	8.078
PRESSURE ANGLE	20°
HELIX ANGLE	8°
HAND OF HELIX	R.H
CORRECTION FACTOR	+0.67056
WIDTH ACROSS 8 TEETH	-0.128 -0.158 138.128
GEAR RATIO	2.294
MATING GEAR No.OF TEETH	17
MATING GEAR DRG No:3-7-1155-15-00602	
CENTRE DISTANCE	235 ^{+0.05}

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ITEM NO		DESCRIPTION	DRAWING NO	20Mn5Cr5 IS:4432		UNIT WT	
				MATL CODE		QTY	
				MATL SPEC			
EQPT: STRETCH REDUCING MILL							
		Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME	SIGNATURE	DATE
				CHD	SSN.KUMAR	SSM. KUMAR	17-03-11
				APPD	G.LOGANATHAN	J. Loganathan	17-03-11
DEPT SSTP	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO		ITEM	
CODE	456	1:2.5	74	0-7-1155-15-11046		78	
				REF TO OLD DWG NO			
				29014/4 1155 42 178			
TITLE				CARD CODE	DRAWING NO :		REV
SRM - HELICAL GEAR (GEAR BOX DRIVE)				U 01	4-7-1155-15-00625		02

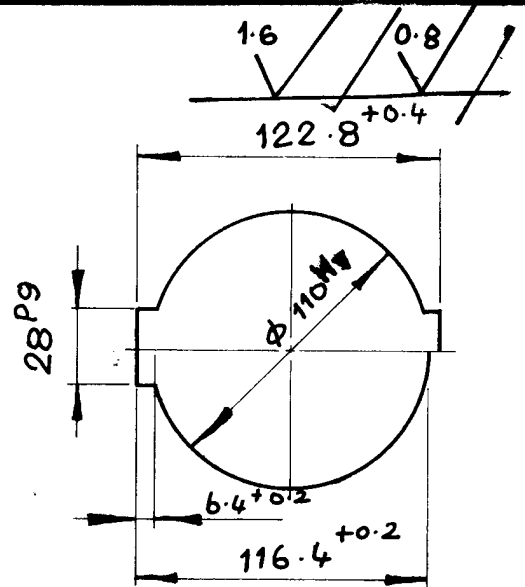
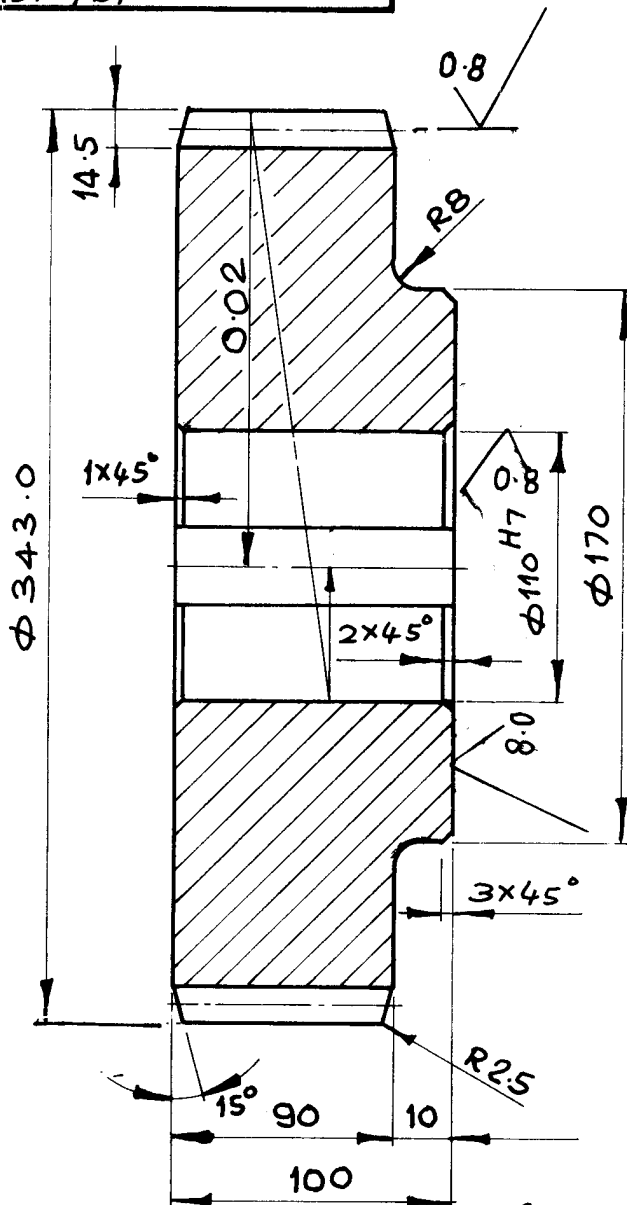
FIRST ANGLE PROJECTION (ALL DIMENSIONS IN MILLIMETRES)

05-249/B

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REV 01	DATE 26.02.85	ALTERED <i>[Signature]</i>
		CHECKED <i>[Signature]</i>
		APPROVED <i>[Signature]</i>

MATL. SPEC. 16Mn5Cr4
IS: 4432 WAS 17MnCr95
IS: 1570/6



NO OF TEETH	50
NORMAL MODULE	6.5
AXIAL MODULE	6.6
PRESSURE ANGLE	20°
HELIX ANGLE	10°
HAND OF HELIX	Lo Ho
CORRECTION FACTOR	+0.0034
WIDTH ACROSS 6 TEETH	-0.055 -0.085 110, 295
GEAR RATIO	2,381
MATING GEAR NO. OF TEETH	21
MATING GEAR DRG. NO.	3-7-1155-15-00609
CENTRE DISTANCE	235 ±0.050

CASE HARDEN TO HRC 59⁻²
CASE DEPTH = 1.2 mm

110H7	+0.035 0
28P9	-0.022 -0.074

TOPPING EFFECTED

ITEM NO.	DESCRIPTION	MATL CODE	UNIT WT
		MATL SPEC	QTY

EQPT: STRETCH REDUCING MILL.



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

DRN	NAME	SIGN	DATE
	RAJENDRA KUMAR G. RAJENDRAN	<i>[Signature]</i>	14.12.84
CHD		<i>[Signature]</i>	12.01.82
APPD		<i>[Signature]</i>	13.06.85

DEPT	GRADE OF UNTO. DIM	SCALE	WEIGHT (kg)	REF TO ASSY / OLD DRG	ITEM NO.
CODE	C/M/F			29095/4115542223	

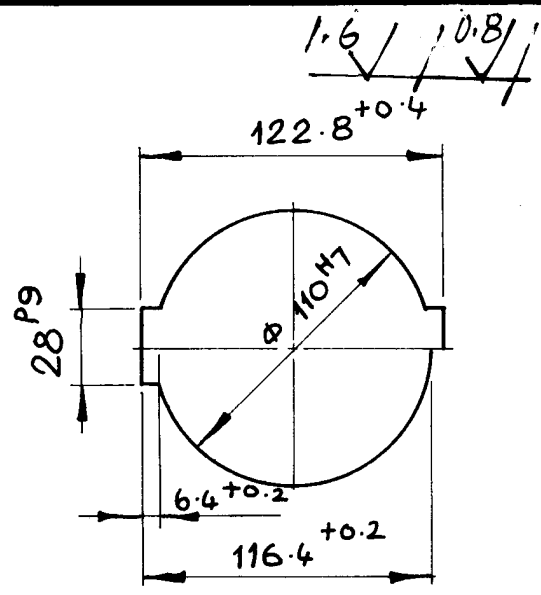
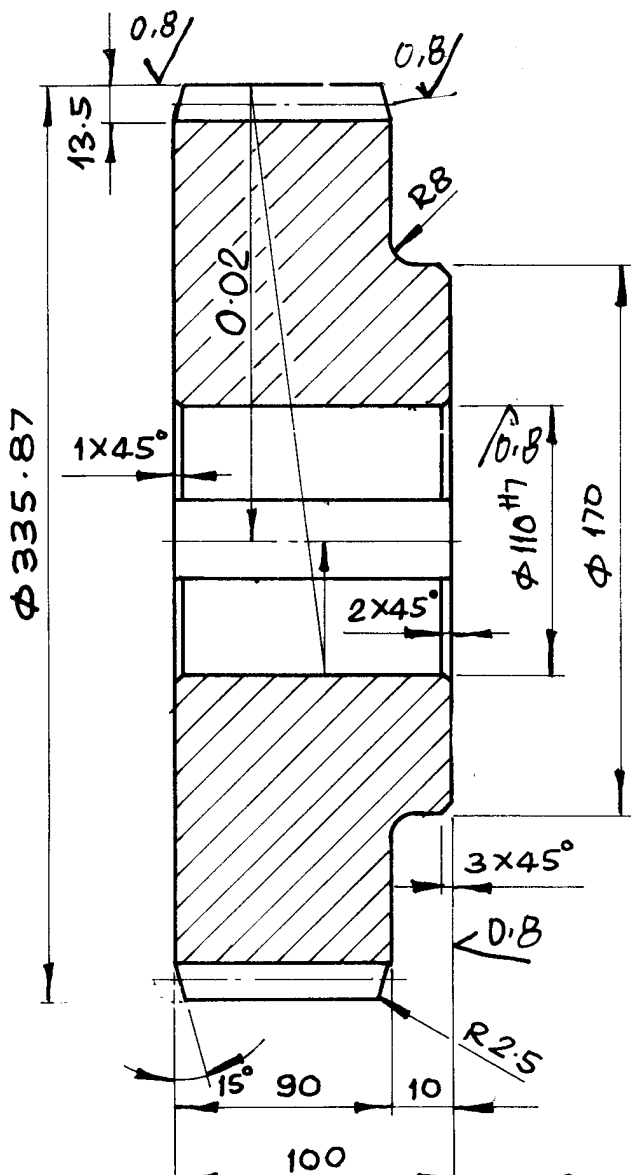
TITLE	CARD CODE	DRAWING NO.	REV.
HELICAL GEAR (GEAR BOX ASSY.)	U 01	4-7-1155-15-00632.	01

FIRST ANGLE PROJECTION (ALL DIMENSIONS IN MILLIMETRES)

05-249/B

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REV 01	DATE 12.3.2000	ALTERED S. Prasad
		CHECKED J. Prasad
ZONE	APPD: J. Prasad	
MATL-SPEC-16Mn5Cr4 IS: 4432 WAS 17MnCr95 IS: 1570		



NO OF TEETH	52
NORMAL MODULE	6
AXIAL MODULE	6.093
PRESSURE ANGLE	20°
HELIX ANGLE	10°
HAND OF-HELIX	L.H
CORRECTION FACTOR	0.69233
WIDTH ACROSS 8 TEETH	-0.051 -0.081 140.25
GEAR RATIO	2.261
MATING GEAR NO. OF TEETH	23
MATING GEAR DRG. NO.	3-7-1155-15-00610
CENTRE DISTANCE	235

CASE HARDEN TO HRC 59⁻²
CASE DEPTH = 1.1 mm

110H7	+0.035
	0
28P9	-0.022
	-0.074

TOPPING EFFECTED.

ITEM NO.	DESCRIPTION	MATL CODE	UNIT WT
		MATL SPEC	QTY

EQPT: STRETCH REDUCING MILL.

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

DRN	NAME	SIGN	DATE
CHD	GRAJENDRA KUMAR	G. Rajendrakumar	15.12.81
APPD	S. Prasad	S. Prasad	12.01.82
			13.06.86

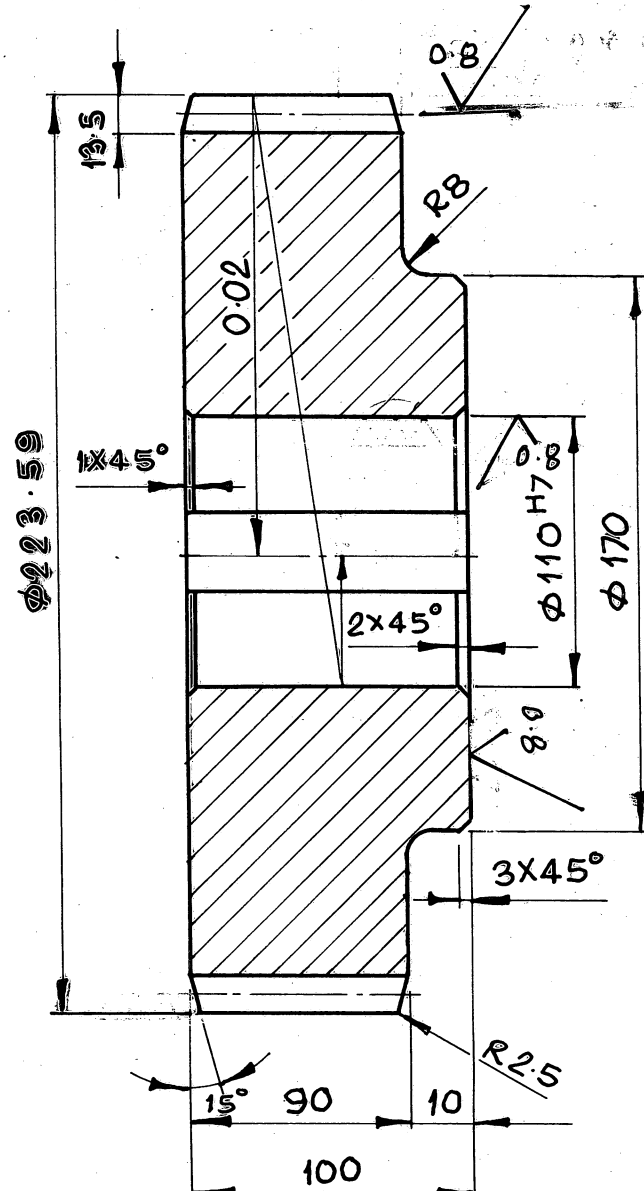
DEPT	GRADE OF UNTOL. DIM	SCALE	WEIGHT (kg)	REF TO ASSY OLD DRG	ITEM NO.
CODE	C/M/F		52.25	29097/4 1155 42 225	

TITLE	CARD CODE	DRAWING NO.	REV.
HELICAL GEAR ^{Z=52} _{N₂=6} (GEAR BOX ASSY.)	U 01	4-7-1155-15-00633 01	

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REV 01	DATE 26-02-88	ALTERED
		CHECKED
		APPROVED

MATL. SPEC. 16MN5CY4
IS:4432 WAS 17MN C 95
IS:1570/6



NO. OF TEETH	34
NORMAL MODULE	6
AXIAL MODULE	6.093
PRESSURE ANGLE	20°
HELIX ANGLE	10°
HAND OF HELIX	L.H.
CORRECTION FACTOR	*0.4009
WIDTH ACROSS 5 TEETH	84.337 -0.048 -0.088
GEAR RATIO	0.810
MATING GEAR NO. OF TEETH	42
MATING GEAR DRG. NO.	4.7.1155.15.0065
CENTRE DISTANCE	235 ^{+0.050}

CASE HARDEN TO HRC 59⁻²
CASE DEPTH = 1.1mm.

TOPPING EFFECTED.

110H7	+0.035
	0
28P9	-0.022
	-0.074

ITEM NO.	DESCRIPTION	MATL CODE	UNIT WT
		MATL SPEC	QTY

EQPT : STRETCH REDUCING MILL



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

DRN	NAME	SIGN	DATE
GHD			
APPD			

DEPT	GRADE OF UNTOL. DIM	SCALE	WEIGHT (kg)	REF TO ASSY/OLD DRG	ITEM NO.
CODE	C/M/F			29121/4-1155-42253	

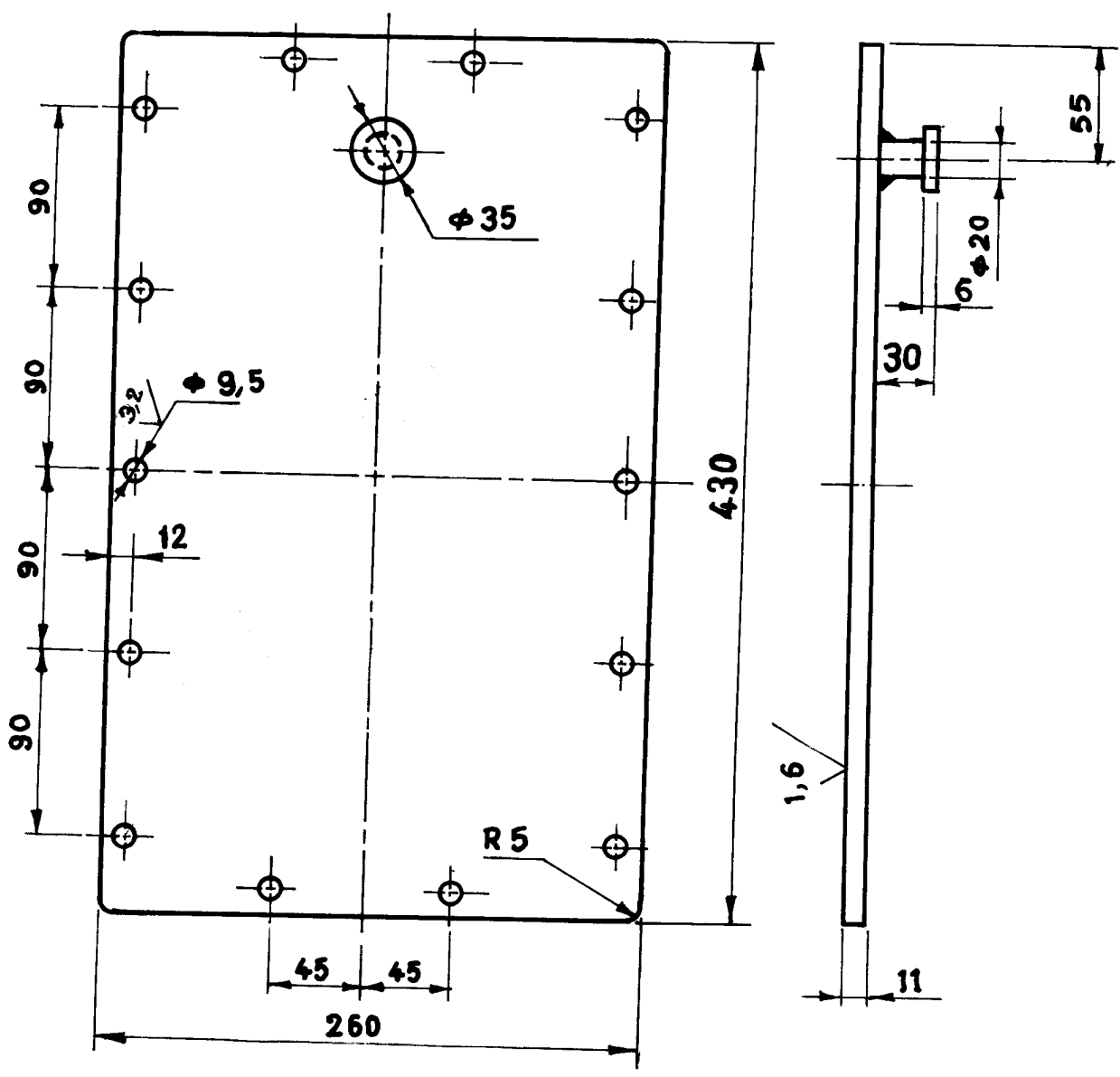
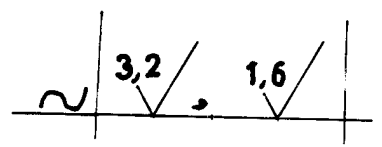
TITLE	Z=34 MN=6	CARD CODE	DRAWING NO.	REV
HELICAL GEAR (GEAR BOX ASSY)		U 01	4-7-1155-15-00657	01

FIRST ANGLE PROJECTION (ALL DIMENSIONS IN MILLIMETERS)

S 27-009

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REV 01	DATE	ALTERED
		CHECKED
ZONE		



ITEM NO.	DESCRIPTION	St:- 34	
		IS :- 1079	11x1
		MATL CODE	UNIT WT.
		MATL SPEC	QTY

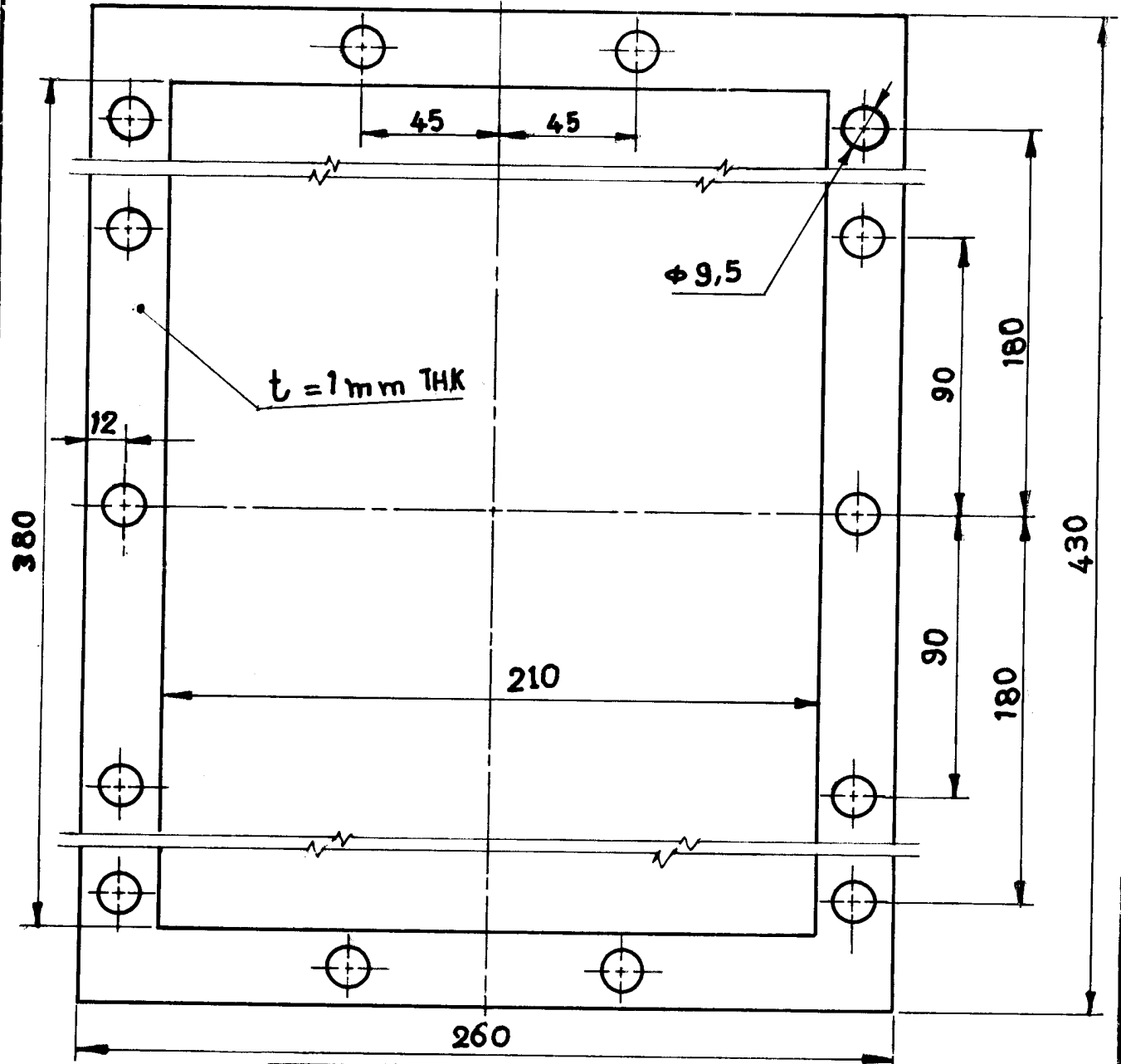
EQPT: SRM

		Bharat Heavy Electricals Ltd. SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI-620 014		DRN	NAME	SIGN	DATE
DEPT	Grade of Untol Dim		SCALE	CHD	<i>M. Dharmalingam</i> <i>M. S. Subramanian</i>		18/12/89
CODE	C/M/F			APPD	<i>S. Ramani</i>	23/12/89	
			1:3 1/3	WEIGHT (Kg)	REF TO ASSY/PLD DRG	9-7-1155-15-00216 28988	
TITLE				CARD CODE	DRAWING NO.	Item NO.	
COVER OF LOOKING HOLE (GEAR BOX ASSEMBLY)				U 01	4-7-1155-15-03858	45	
						REV	
						00	

5 27-009

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REV 01	DATE	ALTERED
		CHECKED
ZONE		



		ASBESTOS	
		SHEET: - 1mm THICK	11 X 1
ITEM NO.	DESCRIPTION	MATL CODE	UNIT WT.
		MATL SPEC	QTY

EQPT: SRM

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

DRN	NAME	SIGN	DATE
CHD			19/12/89
APPD			23-12-89
			23-12-89

DEPT	Grade of Untol Dim	SCALE	WEIGHT (Kg)	REF TO ASSY/OLD DRG	Item NO.
CODE	C/M/F	1:2		9-7-1155-15-00216	46
				28990	

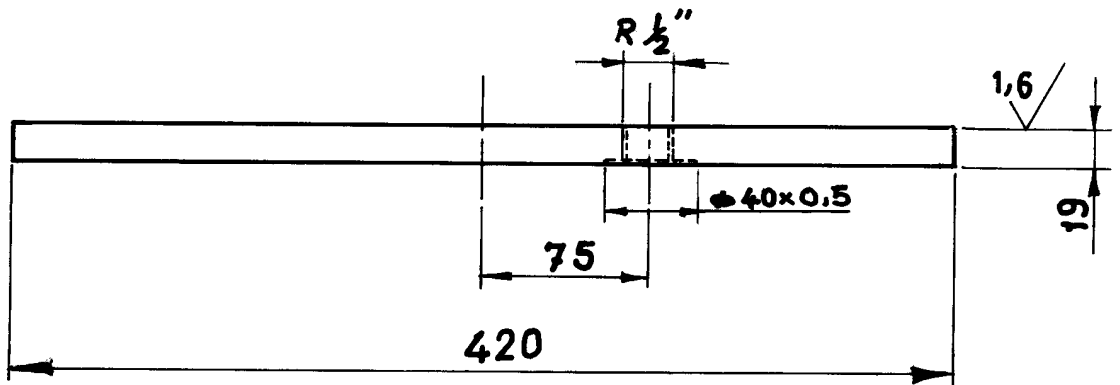
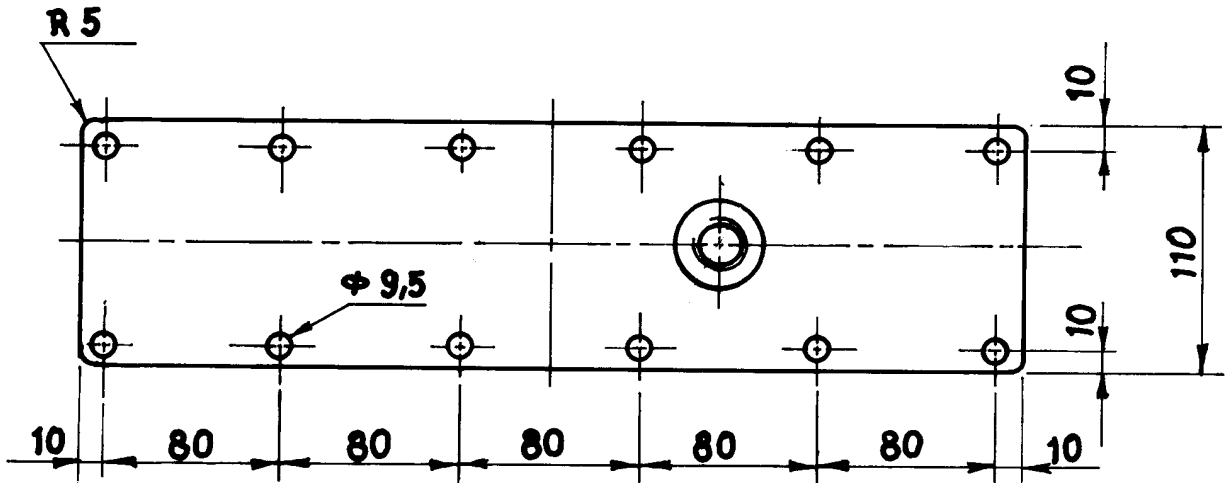
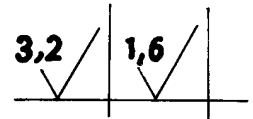
TITLE	CARD CODE	DRAWING NO.	REV
PACKING RING (GEAR BOX ASSEMBLY)	U 01	4-7-1155-15-03859	00

FIRST ANGLE PROJECTION (ALL DIMENSIONS IN MILLIMETERS)

S 27-009

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REV 01	DATE	ALTERED
		CHECKED
ZONE		



		St:- 34	
		IS:- 1079	11x1
ITEM NO.	DESCRIPTION	MATL CODE	UNIT WT.
		MATL SPEC	QTY

EQPT: SRM



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

DRN	NAME	SIGN	DATE
CHD			18/12/89
APPD			23-12-89
			23-12-89

DEPT	Grade of Tolerance Dim		SCALE	WEIGHT (Kg)	REF TO ASSY/OLD DRG	Item NO.
CODE	C/M/F		1:3 1/3		9-7-1155-15-00216	47

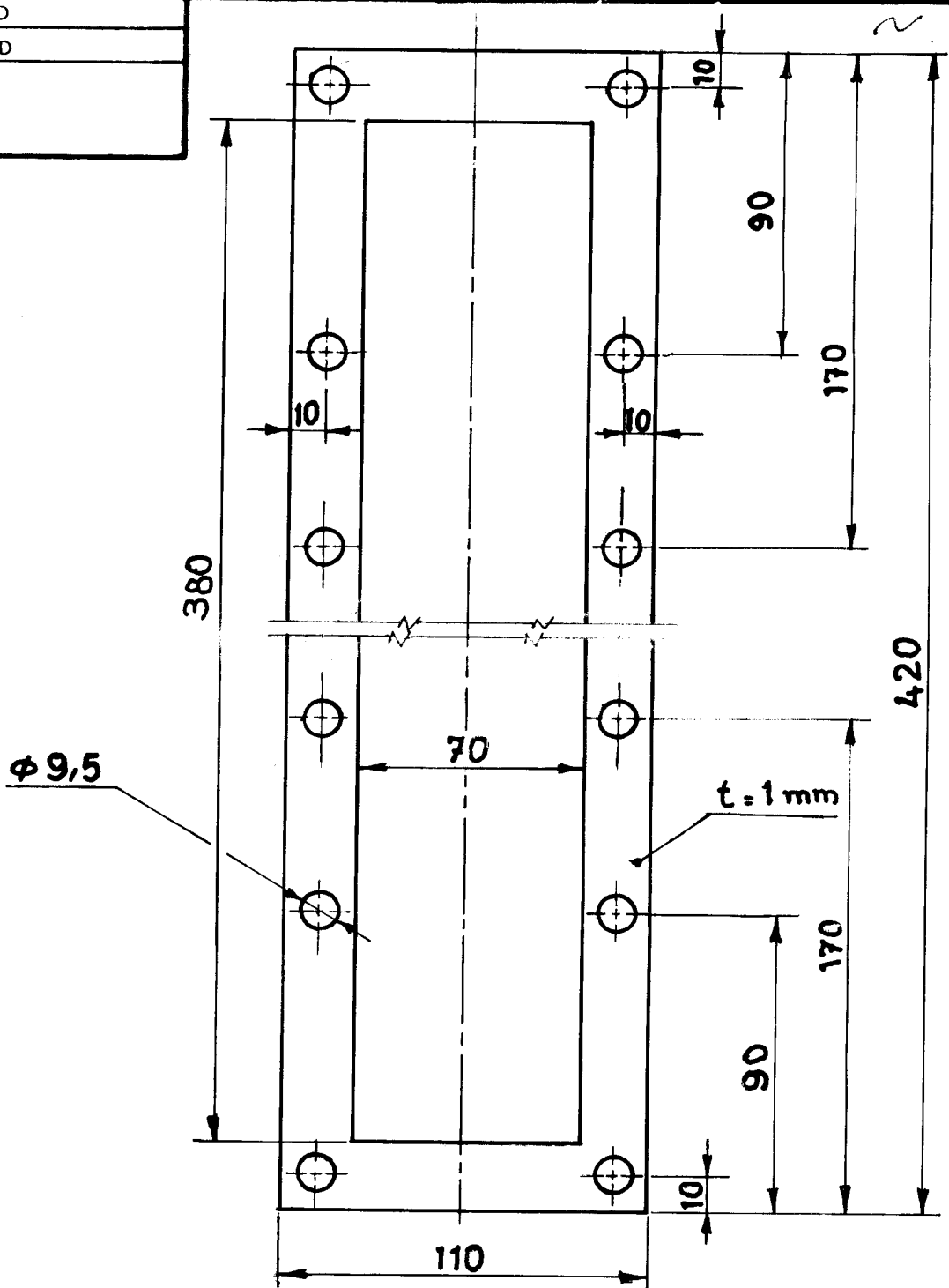
TITLE	CARD CODE	DRAWING NO.	REV
COVER OF DISTRIBUTOR (GEAR BOX ASSEMBLY)	U 01	4-7-1155-15-03860	00

FIRST ANGLE PROJECTION (ALL DIMENSIONS IN MILLIMETERS)

S 27-009

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REV 01	DATE	ALTERED
		CHECKED
ZONE		



		ASBESTOS	
		SHEET THK 1 mm	11x1
ITEM NO.	DESCRIPTION	MATL CODE	UNIT WT.
		MATL SPEC	QTY

EQPT: SRM



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

DRN	NAME	SIGN	DATE
CHD			19/12/89
APPD			23/12/89

DEPT	Grade of Untol Dim		SCALE	WEIGHT (Kg)	REF TO ASSY/OLD DRG	Item NO.
CODE	C/M/F		1:2		9-7-1155-15-00216 28991	48

TITLE	CARD CODE	DRAWING NO.	REV
PACKING RING OF DISTRIBUTOR (GEAR BOX ASSEMBLY)	U 01	4-7-1155-15-03861	00

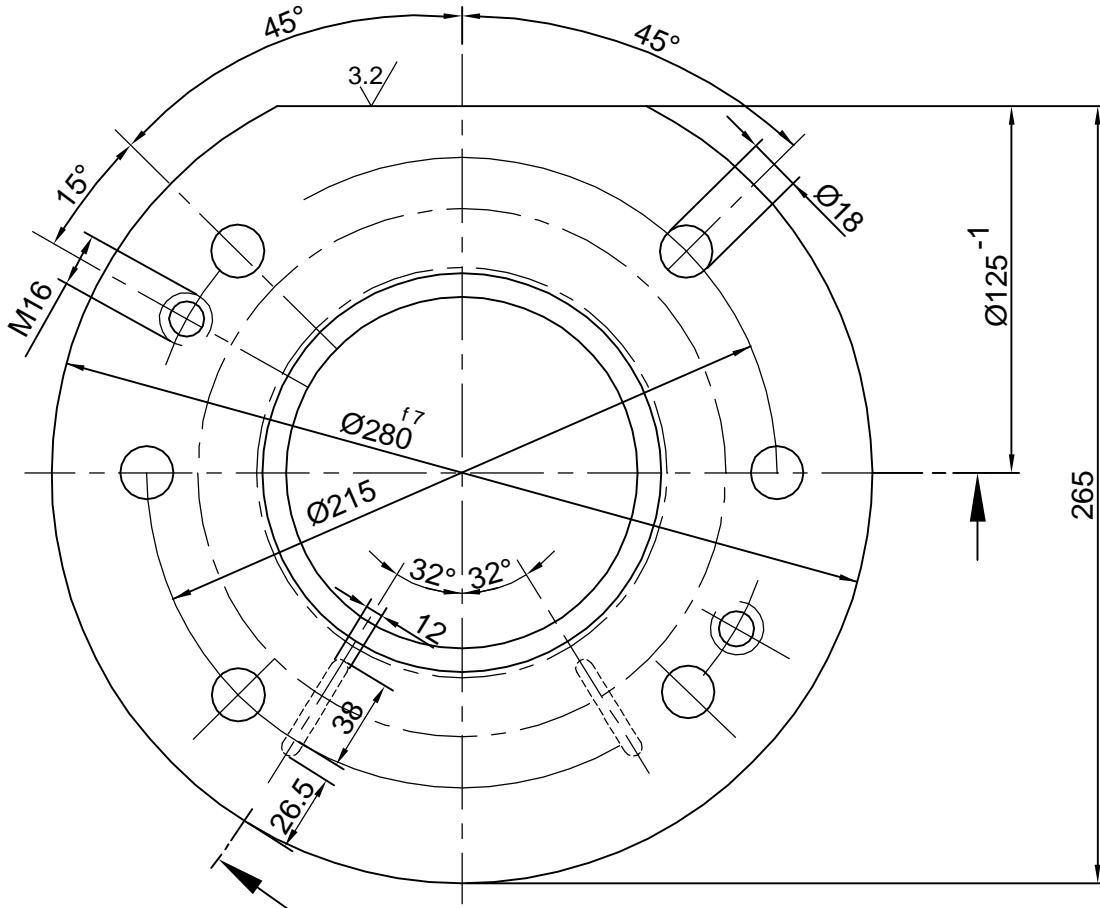
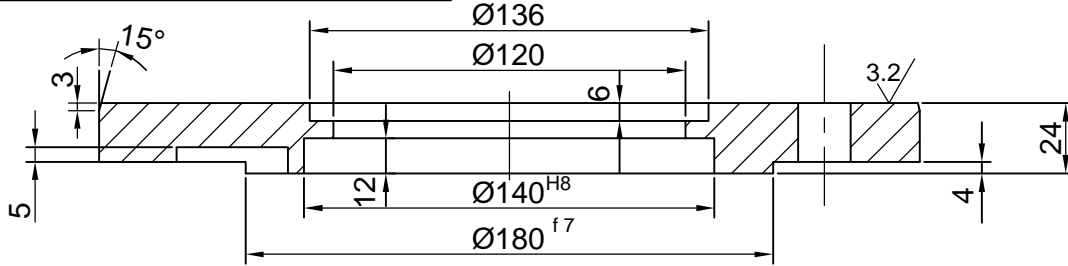
ALL DIMENSIONS ARE IN MM

REV 01	DATE 25.03.11	ALTERED <i>D. Anand</i>
		CHECKED <i>SSM. Kumar</i>
		APPROVED <i>J. Loganathan</i>

CONVERTED TO AUTO CAD
DRAWING

1.6 // 3.2 //

Ø280 ^{f7}	-0.056
	-0.108
Ø140 ^{H8}	+0.063
	0
Ø180 ^{f7}	+0.043
	-0.083




ALL SHARP CORNERS CHAMFERED TO 0.5x45°

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ITEM NO	DESCRIPTION	DRAWING NO	St: 52 IS:1079	UNIT WT
			MATL CODE	QTY
			MATL SPEC	

EQPT: STRETCH REDUCING MILL

 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014	DRN	NAME D.ANAND	SIGNATURE <i>D. Anand</i>	DATE 17-03-11
	CHD	SSN.KUMAR	<i>SSM. KUMAR</i>	17-03-11
	APPD	G.LOGANATHAN	<i>J. Loganathan</i>	17-03-11
DEPT SSTP	GRADE OF UNTOL. DIM ϕ/M/f	SCALE 1:2.5	WEIGHT (Kg) 9.4	REF TO ASSY DWG NO 0-7-1155-15-11046
CODE 456	IS: 2102			REF TO OLD DWG NO 28996
TITLE SRM - PLUMMER BLOCK COVER (GEAR BOX DRIVE)			CARD CODE U 01	DRAWING NO : 4-7-1155-15-03862
				ITEM 49
				REV 01

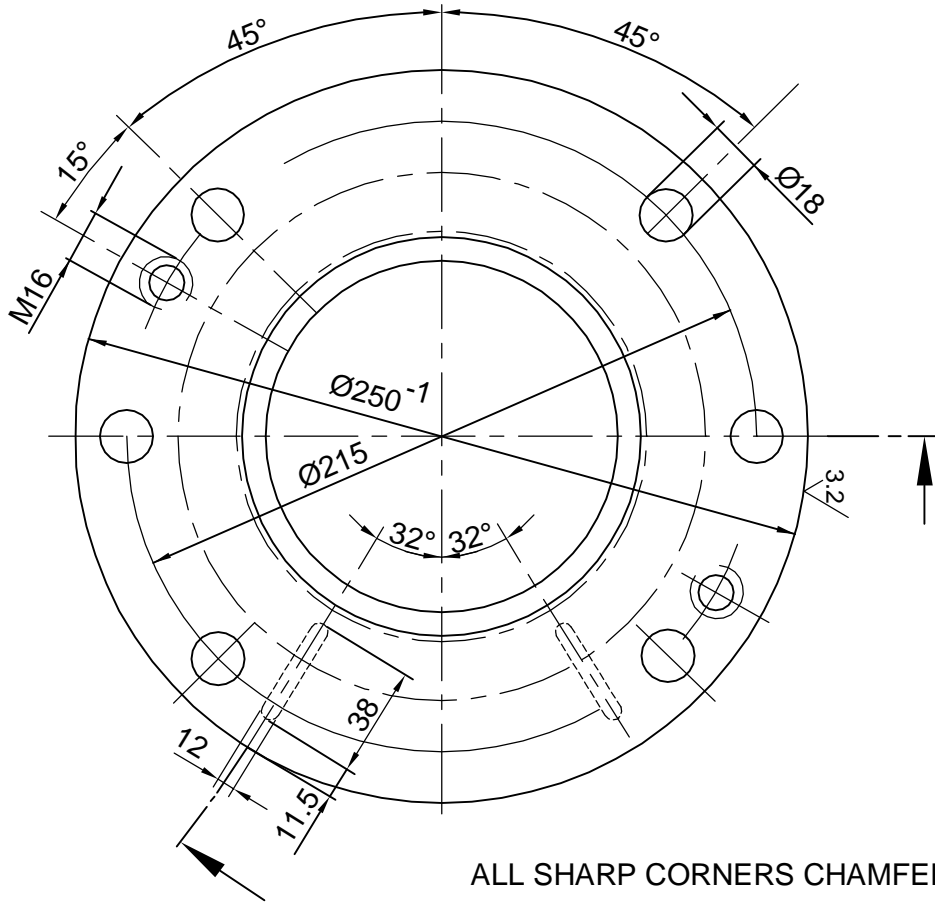
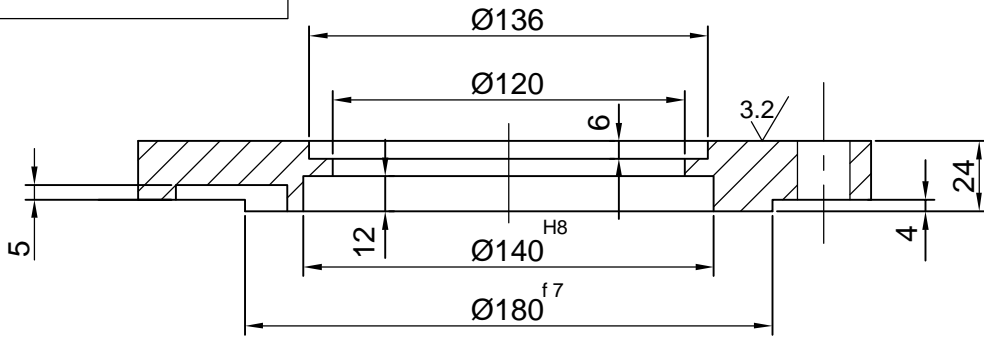
ALL DIMENSIONS ARE IN MM

REV	DATE	ALTERED	<i>D. Anand</i>
01	25.03.11	CHECKED	<i>SSM. Kumar</i>
		APPROVED	<i>J. Loganathan</i>

CONVERTED TO AUTO CAD DRAWING

1.6 // 3.2 //


H^8	+0.063
h^7	-0.043
f^7	-0.083



ALL SHARP CORNERS CHAMFERED TO 0.5x45°

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ITEM NO	DESCRIPTION	DRAWING NO	St: 52 IS:1079	UNIT WT
			MATL CODE	QTY
			MATL SPEC	

EQPT: STRETCH REDUCING MILL						
	Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME D.ANAND	SIGNATURE <i>D. Anand</i>	DATE 17-03-11
			CHD	SSN.KUMAR	<i>SSM. KUMAR</i>	17-03-11
			APPD	G.LOGANATHAN	<i>J. Loganathan</i>	17-03-11
DEPT SSTP	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM	
CODE 456	$\phi/M/F$ IS: 2102	1:2.5	7.1	0-7-1155-15-11046	50	
TITLE SRM - PLUMMER BLOCK COVER (GEAR BOX DRIVE)				REF TO OLD DWG NO	REV	
				28997	01	
			CARD CODE U 01	DRAWING NO :		
				4-7-1155-15-03863		

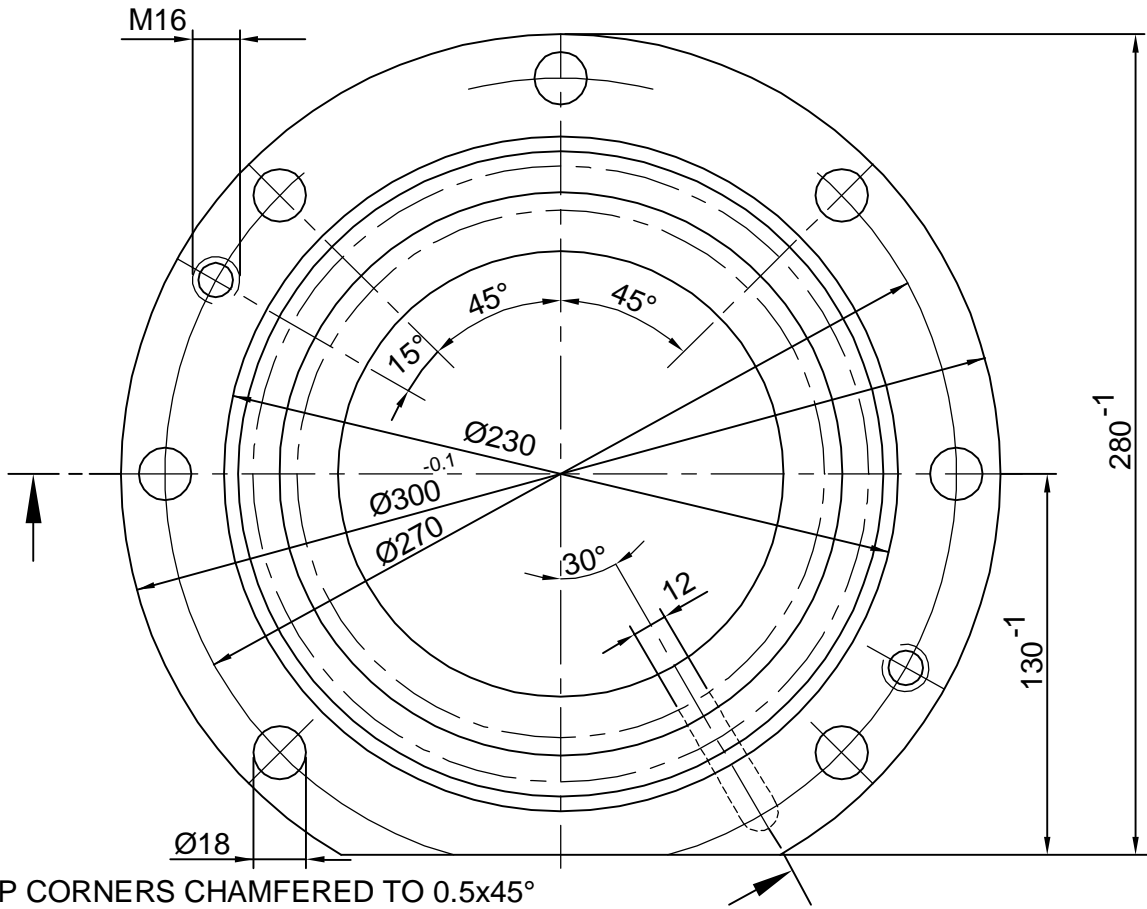
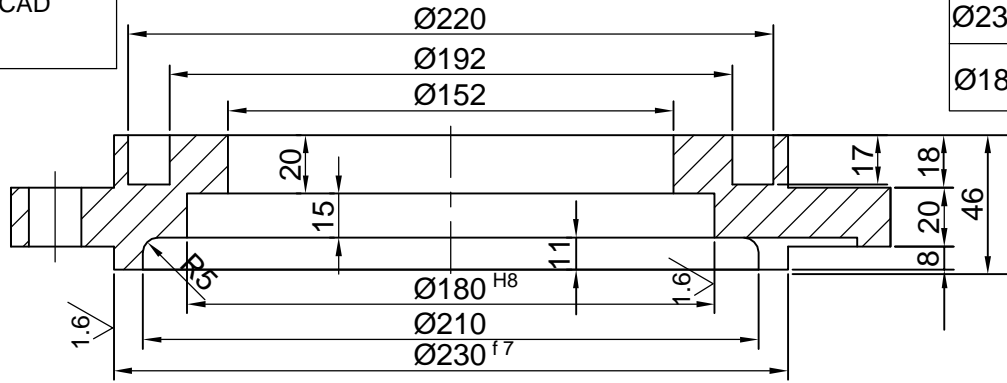
ALL DIMENSIONS ARE IN MM

REV	DATE	ALTERED	<i>D. Anand</i>
01	25.03.11	CHECKED	<i>SSM. Kumar</i>
		APPROVED	<i>J. Loganathan</i>

CONVERTED TO AUTO CAD DRAWING

3.2//1.6//


Ø230 ^{f7}	-0.050
	-0.096
Ø180 ^{H8}	+0.063
	0



ALL SHARP CORNERS CHAMFERED TO 0.5x45°

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ITEM NO	DESCRIPTION	DRAWING NO	St: 52 IS:1079	UNIT WT
			MATL CODE	QTY
			MATL SPEC	

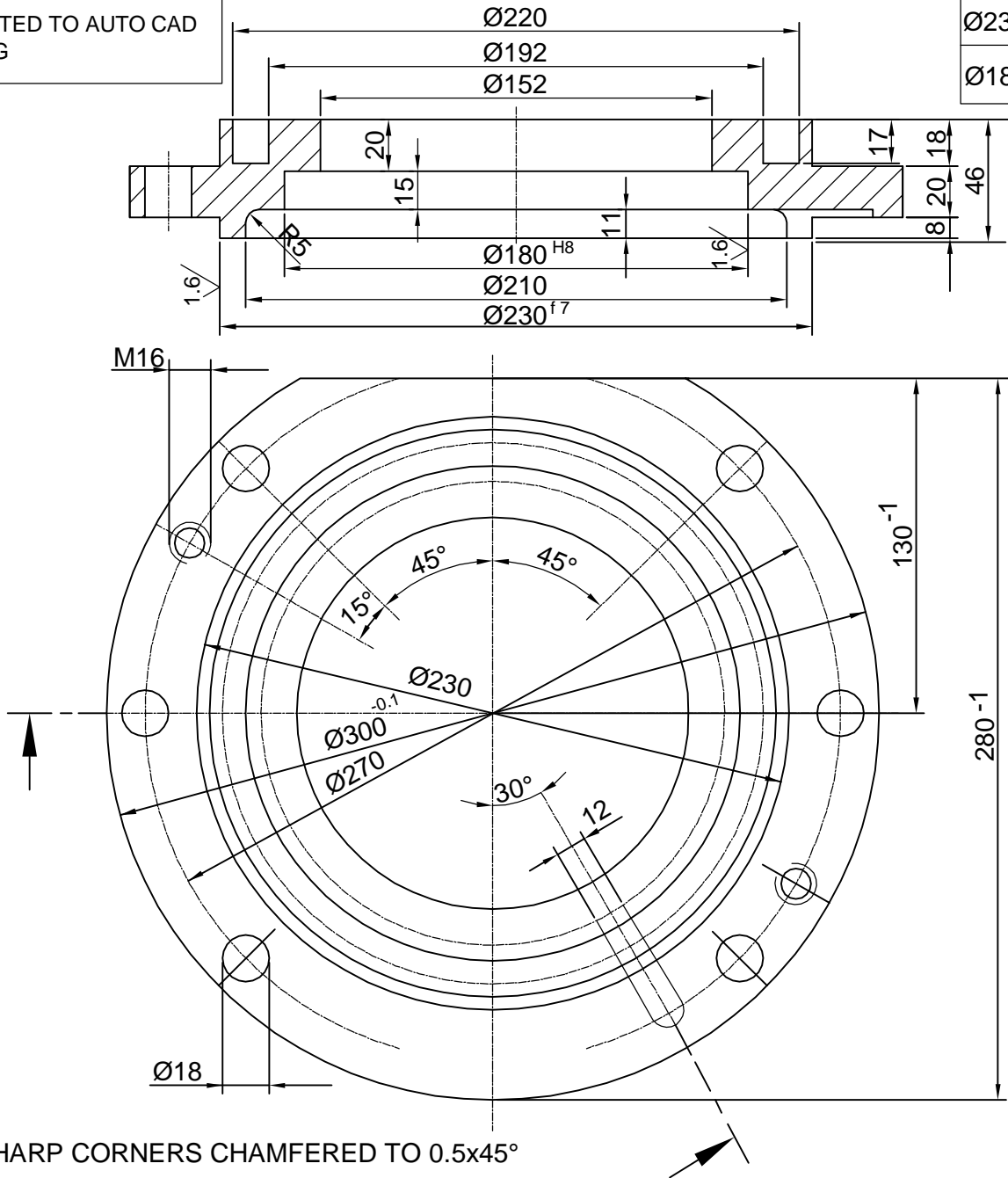
EQPT: STRETCH REDUCING MILL		NAME: D.ANAND		SIGNATURE: <i>D. Anand</i>		DATE: 17-03-11	
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	D.ANAND		<i>D. Anand</i>		17-03-11
		CHD	SSN.KUMAR		<i>SSM. KUMAR</i>		17-03-11
		APPD	G.LOGANATHAN		<i>J. Loganathan</i>		17-03-11
DEPT SSTP	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM		
456	Ø/M/F IS: 2102	1:2.5	18.9	0-7-1155-15-11046	51		
TITLE: SRM - PLUMMER BLOCK COVER (GEAR BOX DRIVE)				REF TO OLD DWG NO	29000		
CARD CODE: U 01				DRAWING NO :	4-7-1155-15-03864		REV: 01

ALL DIMENSIONS ARE IN MM


REV 01	DATE 25-03-11	ALTERED D. Anand
		CHECKED SSM. Kumar
		APPROVED G. Loganathan

CONVERTED TO AUTO CAD
DRAWING

Ø230 ^{f7}	-0.050
	-0.096
Ø180 ^{H8}	+0.063
	0



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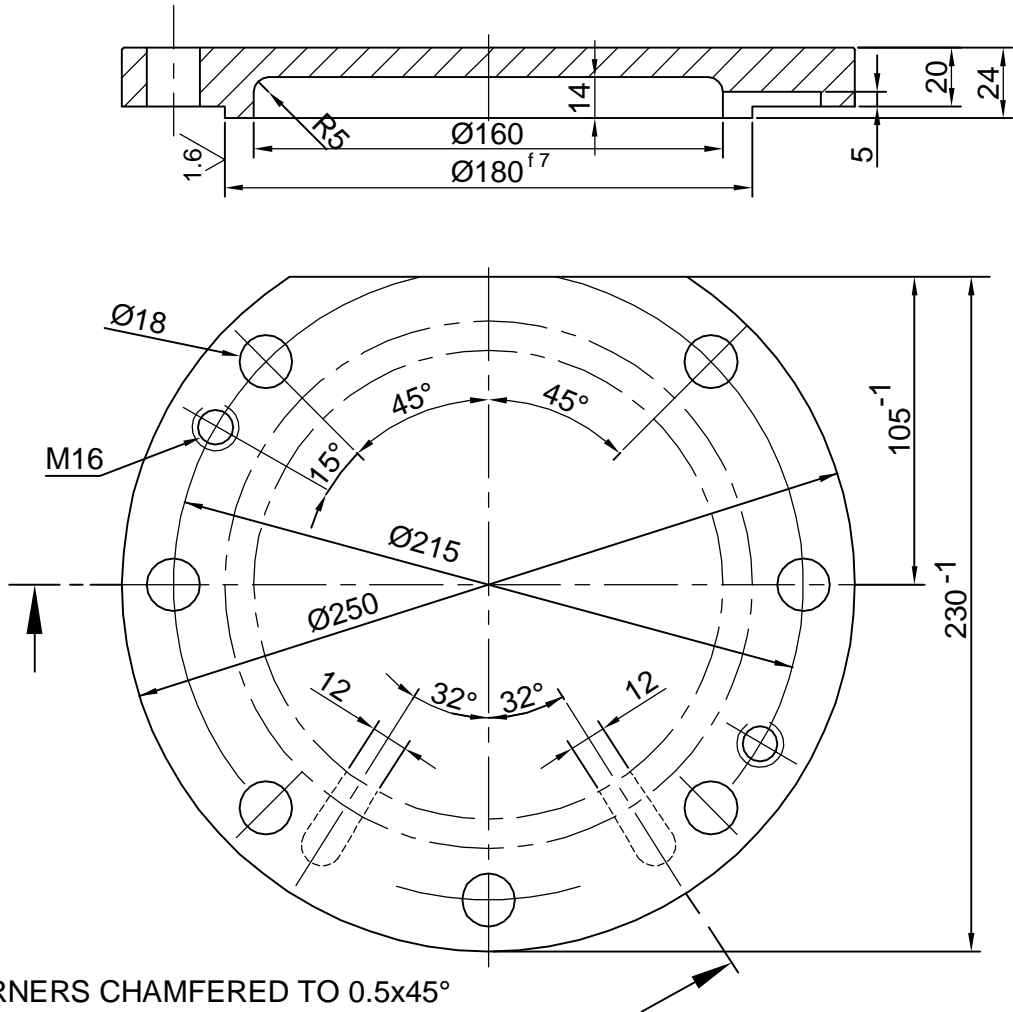
				St: 52 IS:1079	
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT	
			MATL SPEC	QTY	
EQPT: STRETCH REDUCING MILL					
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME D.ANAND	SIGNATURE <i>D. Anand</i>	DATE 17-03-11
		CHD	SSN.KUMAR	<i>SSM. KUMAR</i>	17-03-11
		APPD	G.LOGANATHAN	<i>G. Loganathan</i>	17-03-11
DEPT SSTP	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM
CODE 456	ϕ / M / F IS: 2102	1:2.5	18.9	0-7-1155-15-11046	52
TITLE SRM - PLUMMER BLOCK COVER (GEAR BOX DRIVE)			CARD CODE U 01	REF TO OLD DWG NO 29001	DRAWING NO : 4-7-1155-15-03865
				REV	01

ALL DIMENSIONS ARE IN MM

REV 01	DATE	ALTERED	REV 02	DATE	ALTERED
	16.08.96	CHECKED		26.03.2011	CHECKED
		SSN . KUMAR			<i>D. Anand</i>
APPROVED			APPROVED		
SANTHA KUMAR			<i>S.M. Kumar</i>		
GREASING SLOT ADDED IN LEFT SIDE			CONVERTED TO AUTO CAD DRAWING		


3.2 / 1.6

Ø180 ^{f7}	-0.043
	-0.083



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				St: 52 IS:1079	
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT	QTY
EQPT: STRETCH REDUCING MILL					
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME	SIGNATURE	DATE
		CHD	D.ANAND	<i>D. Anand</i>	17-03-11
		APPD	SSN.KUMAR	<i>S.M. KUMAR</i>	17-03-11
			G.LOGANATHAN	<i>G. Loganathan</i>	17-03-11
DEPT	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM
SSTP	Ø/M/F	1:2.5	5.4	0-7-1155-15-11046	53
CODE	IS: 2102			REF TO OLD DWG NO	
456				29002	
TITLE			CARD CODE	DRAWING NO :	REV
SRM - SEALING COVER (GEAR BOX DRIVE)			U 01	4-7-1155-15-03866	02

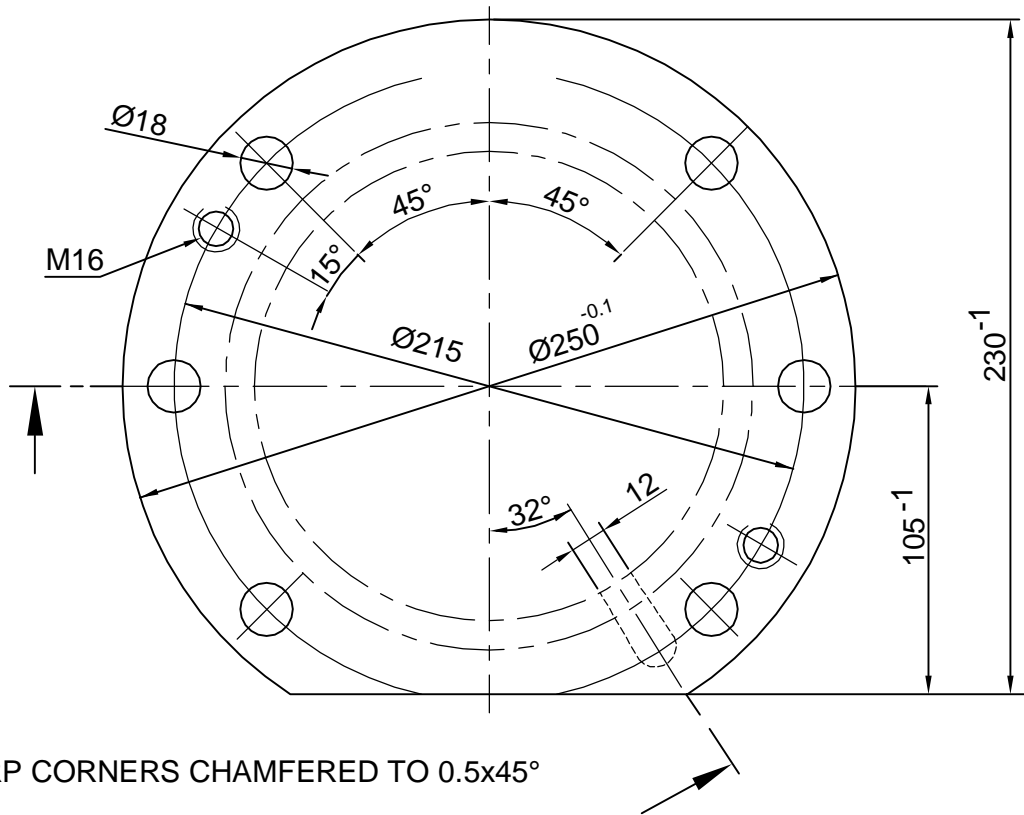
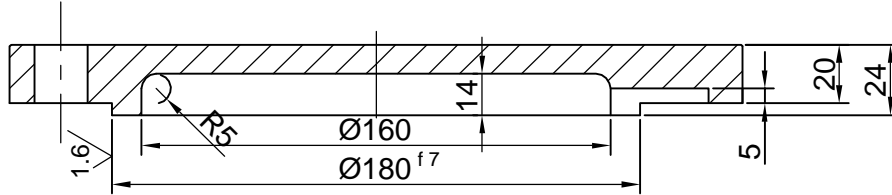
ALL DIMENSIONS ARE IN MM

REV 01	DATE 25.03.11	ALTERED <i>D. Anand</i>
		CHECKED <i>SSM. Kumar</i>
		APPROVED <i>G. Loganathan</i>

CONVERTED TO
AUTO CAD DRAWING


3.2//1.6//

Ø180	f7	-0.043
		-0.083



ALL SHARP CORNERS CHAMFERED TO 0.5x45°

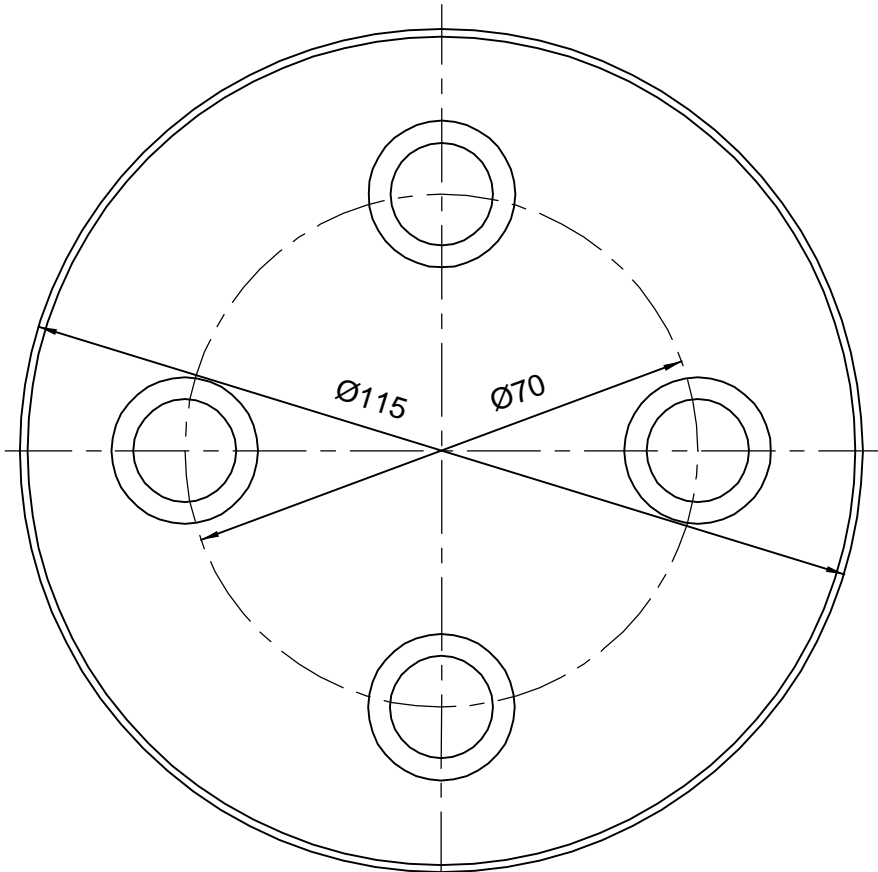
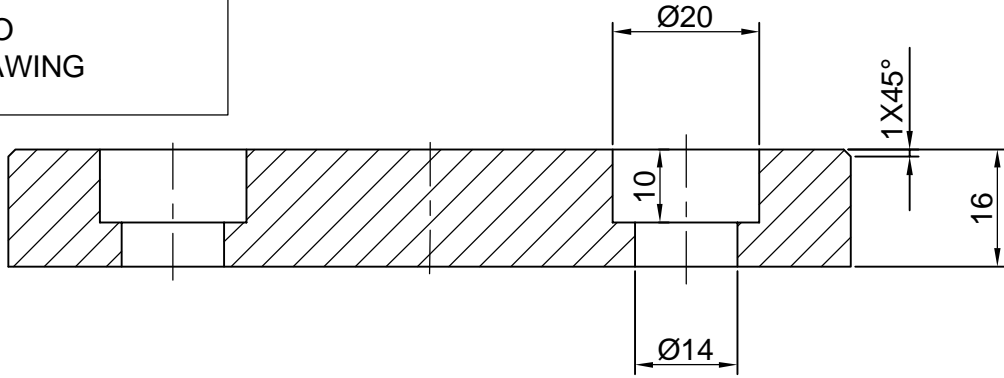
CAUTION: THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

				St: 52 IS:1079	
ITEM NO	DESCRIPTION	DRAWING NO		MATL CODE	UNIT WT
				MATL SPEC	QTY
EQPT: STRETCH REDUCING MILL					
		Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME
				CHD	SIGNATURE
				APPD	DATE
DEPT	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM
SSTP	φ/M/f	1:2.5	5.4	0-7-1155-15-11046	54
CODE	IS: 2102			REF TO OLD DWG NO	
456				29003	
TITLE			CARD CODE	DRAWING NO :	REV
SRM - SEALING COVER (GEAR BOX DRIVE)			U 01	4-7-1155-15-03867	01

ALL DIMENSIONS ARE IN MM


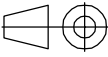
REV 01	DATE	ALTERED	<i>D. Anand</i>
	25-03-11	CHECKED	<i>SSM. Kumar</i>
		APPROVED	<i>J. Loganathan</i>
<p>CONVERTED TO AUTO CAD DRAWING</p>			

3.2//1.6//



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ITEM NO	DESCRIPTION	DRAWING NO	ST-52 IS:1079	UNIT WT
			MATL CODE	QTY
			MATL SPEC	

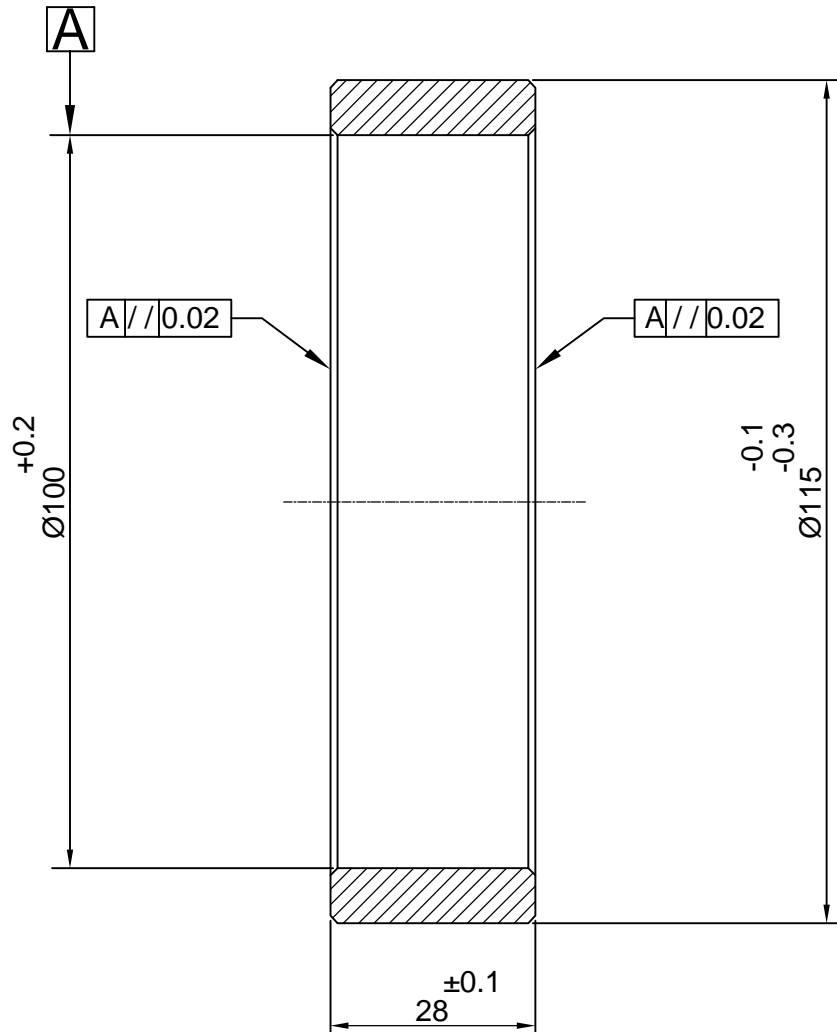
EQPT: STRETCH REDUCING MILL						
	Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME	SIGNATURE	DATE
			CHD	D.ANAND	<i>D. Anand</i>	17-03-11
			APPD	SSN.KUMAR	<i>SSM. KUMAR</i>	17-03-11
				G.LOGANATHAN	<i>J. Loganathan</i>	17-03-11
DEPT SSTP	GRADE OF UNTOL. DIM		SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM
CODE 456	$\phi/M/F$ IS: 2102		1:1	0.82	0-7-1155-15-11046	81
TITLE			CARD CODE	DRAWING NO :	REV	
SRM - END DISC (GEAR BOX DRIVE)			U 01	4-7-1155-15-03868	01	

ALL DIMENSIONS ARE IN MM

REV	DATE	ALTERED	<i>D. Anand</i>
01	26-03-11	CHECKED	<i>SSN. Kumar</i>
		APPROVED	<i>J. Loganathan</i>


**CONVERTED TO
AUTO CAD DRAWING**

1.6/



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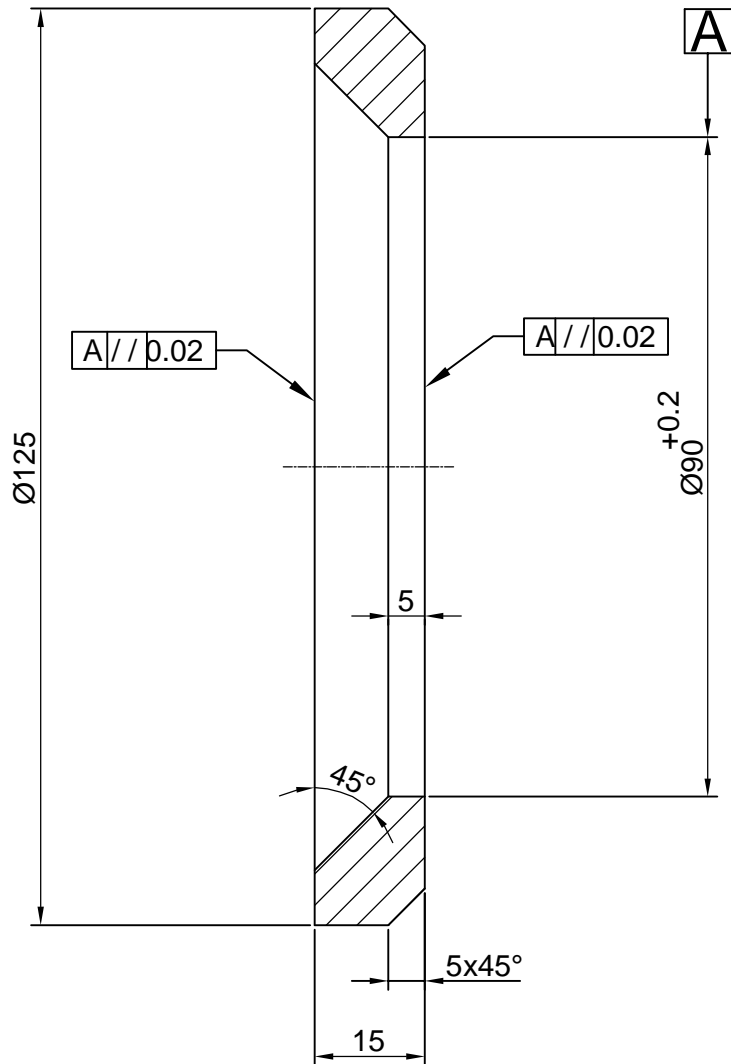
				Fe 540, IS : 8500			
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE		UNIT WT		
			MATL SPEC		QTY		
EQPT: STRETCH REDUCING MILL							
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME	SIGNATURE	DATE		
		CHD	D.ANAND	<i>D. Anand</i>	17-03-11		
		APPD	SSN.KUMAR	<i>SSN. KUMAR</i>	17-03-11		
DEPT		GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM	
SSTP		φ/M/f	1:1	0.55	0-7-1155-15-11046	86	
CODE		IS: 2102			REF TO OLD DWG NO		
456					29076		
TITLE			CARD CODE	DRAWING NO :			REV
SRM - DISTANCE SLEEVE (GEAR BOX DRIVE)			U 01	4-7-1155-15-03870			01

ALL DIMENSIONS ARE IN MM

REV 01	DATE	ALTERED	<i>D. Anand</i>
	26.03.2011	CHECKED	<i>SSM. Kumar</i>
		APPROVED	<i>J. Loganathan</i>

1.6/

CONVERTED TO AUTO CAD
DRAWING




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ITEM NO	DESCRIPTION	DRAWING NO	Fe 540 IS:8500	UNIT WT
			MATL CODE	QTY
			MATL SPEC	

EQPT: STRETCH REDUCING MILL

 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014	DRN	NAME D.ANAND	SIGNATURE <i>D. Anand</i>	DATE 17-03-11
	CHD	SSN.KUMAR	<i>SSM. KUMAR</i>	17-03-11
	APPD	G.LOGANATHAN	<i>J. Loganathan</i>	17-03-11

DEPT SSTP	GRADE OF UNTOL. DIM $\phi/M/f$ IS: 2102	SCALE 1:1	WEIGHT (Kg) 0.52	REF TO ASSY DWG NO 0-7-1155-15-11046	ITEM 87
CODE 456				REF TO OLD DWG NO 29078	

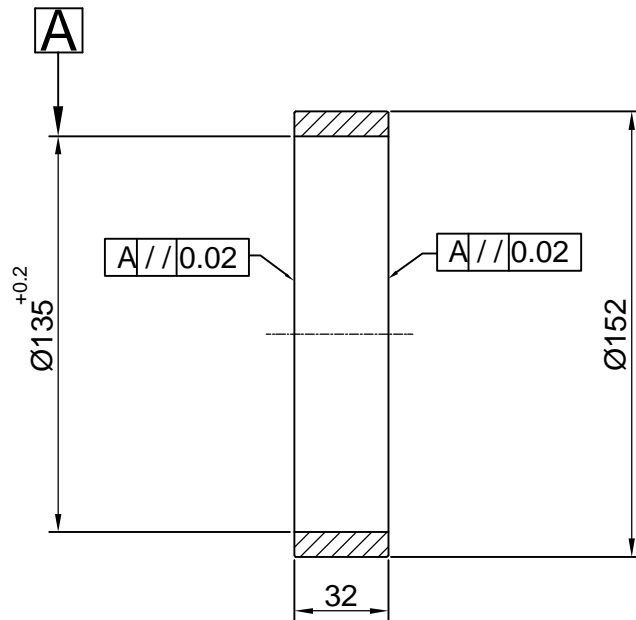
TITLE SRM - DISTANCE SLEEVE (GEAR BOX DRIVE)	CARD CODE U 01	DRAWING NO : 4-7-1155-15-03871	REV 01
--	-------------------	--	-----------

ALL DIMENSIONS ARE IN MM

REV	DATE	ALTERED	<i>D. Anand</i>
01	26.03.2011	CHECKED	<i>SSM. Kumar</i>
		APPROVED	<i>J. Loganathan</i>


CONVERTED TO AUTO CAD DRAWING

1.6 /



ALL SHARP CORNERS CHAMFERED TO 0.5x45°

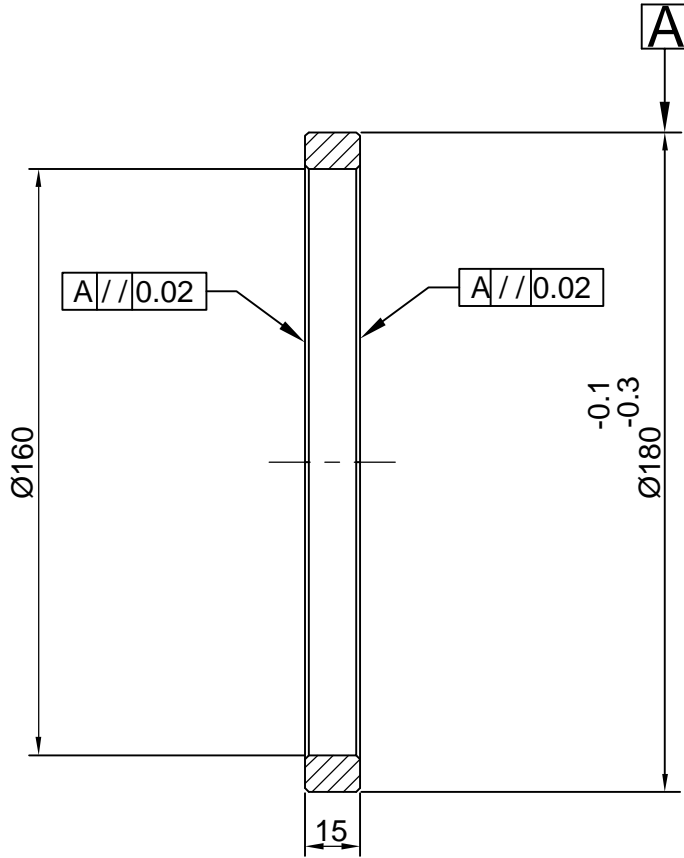
CAUTION: THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

				Fe 540 IS : 8500		
ITEM NO	DESCRIPTION	DRAWING NO		MATL CODE	UNIT WT	
				MATL SPEC	QTY	
EQPT: STRETCH REDUCING MILL						
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME D.ANAND	SIGNATURE <i>D. Anand</i>	DATE 17-03-11	
		CHD	SSN.KUMAR	<i>SSM. KUMAR</i>	17-03-11	
		APPD	G.LOGANATHAN	<i>J. Loganathan</i>	17-03-11	
DEPT SSTP	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM	
456	$\phi/M/f$ IS: 2102	1:2.5	0.96	0-7-1155-15-11046	88	
				REF TO OLD DWG NO		
				29079		
TITLE SRM - DISTANCE SLEEVE (GEAR BOX DRIVE)			CARD CODE U 01	DRAWING NO : 4-7-1155-15-03872		REV 01

ALL DIMENSIONS ARE IN MM

REV 01	DATE	ALTERED	<i>D. Anand</i>
	26.03.2011	CHECKED	<i>SSM. Kumar</i>
		APPROVED	<i>J. Loganathan</i>
CONVERTED TO AUTO CAD DRAWING			

1.6/





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			Fe 540 IS:8500	
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT
			MATL SPEC	QTY

EQPT: **STRETCH REDUCING MILL**

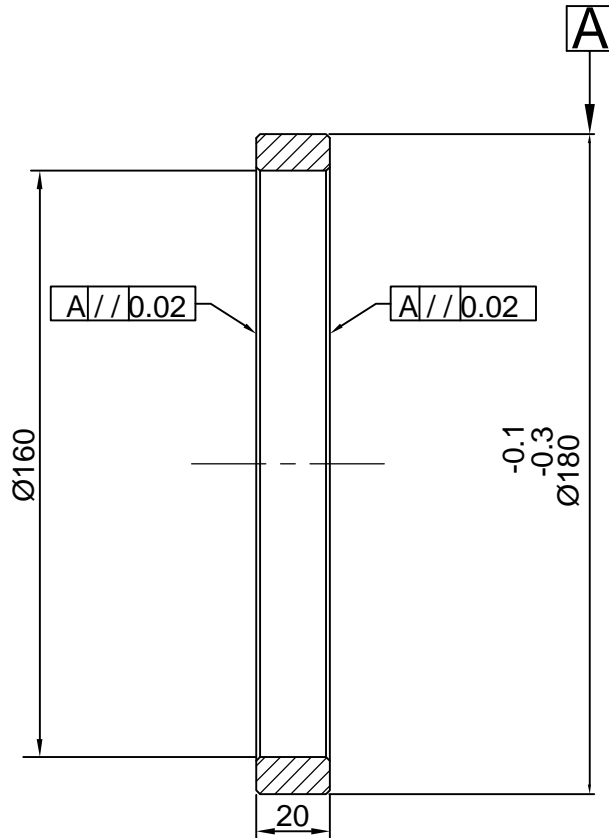
	Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME D.ANAND	SIGNATURE <i>D. Anand</i>	DATE 17-03-11
			CHD	SSN.KUMAR	<i>SSM. KUMAR</i>	17-03-11
			APPD	G.LOGANATHAN	<i>J. Loganathan</i>	17-03-11
DEPT SSTP	GRADE OF UNTOL. DIM		SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM
CODE 456	$\phi / M / F$ IS: 2102		1:2	0.6	0-7-1155-15-11046	89
TITLE SRM - DISTANCE SLEEVE (GEAR BOX DRIVE)			CARD CODE U 01	DRAWING NO : 4-7-1155-15-03873		REV 01

ALL DIMENSIONS ARE IN MM

REV 01	DATE	ALTERED	<i>D. Anand</i>
	26.03.2011	CHECKED	<i>SSM. Kumar</i>
		APPROVED	<i>J. Loganathan</i>

1.6/

CONVERTED TO AUTO CAD
DRAWING


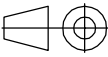


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			Fe 540, IS : 8500	
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT
			MATL SPEC	QTY

EQPT: **STRETCH REDUCING MILL**

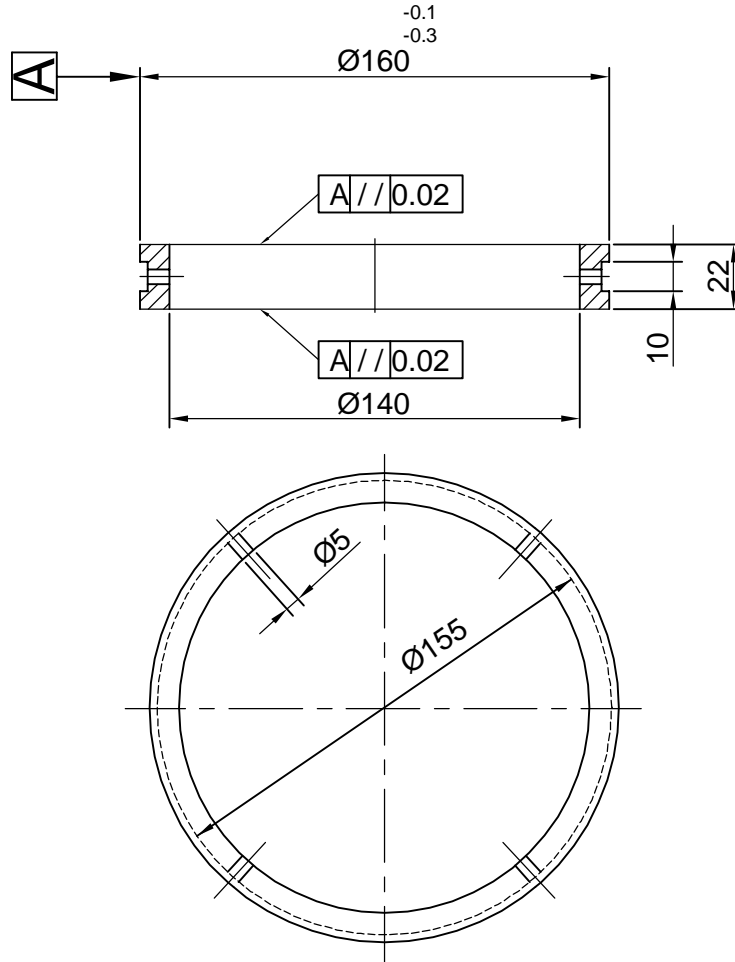
	Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME D.ANAND	SIGNATURE <i>D. Anand</i>	DATE 17-03-11
			CHD	SSN.KUMAR	<i>SSM. KUMAR</i>	17-03-11
			APPD	G.LOGANATHAN	<i>J. Loganathan</i>	17-03-11
DEPT SSTP	GRADE OF UNTOL. DIM		SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM
CODE 456	$\phi/M/f$ IS: 2102		1:2	0.8	0-7-1155-15-11046	90
TITLE			CARD CODE	DRAWING NO :	REV	
SRM - DISTANCE SLEEVE (GEAR BOX DRIVE)			U 01	4-7-1155-15-03874	01	

ALL DIMENSIONS ARE IN MM

REV 01	DATE	ALTERED	<i>D. Anand</i>
	26.03.2011	CHECKED	<i>SSM. Kumar</i>
		APPROVED	<i>G. Loganathan</i>

CONVERTED TO AUTO CAD
DRAWING

1.6/


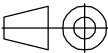


ALL SHARP CORNERS CHAMFERED TO 0.5x45°

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			Fe 540 IS:8500	
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT
			MATL SPEC	QTY

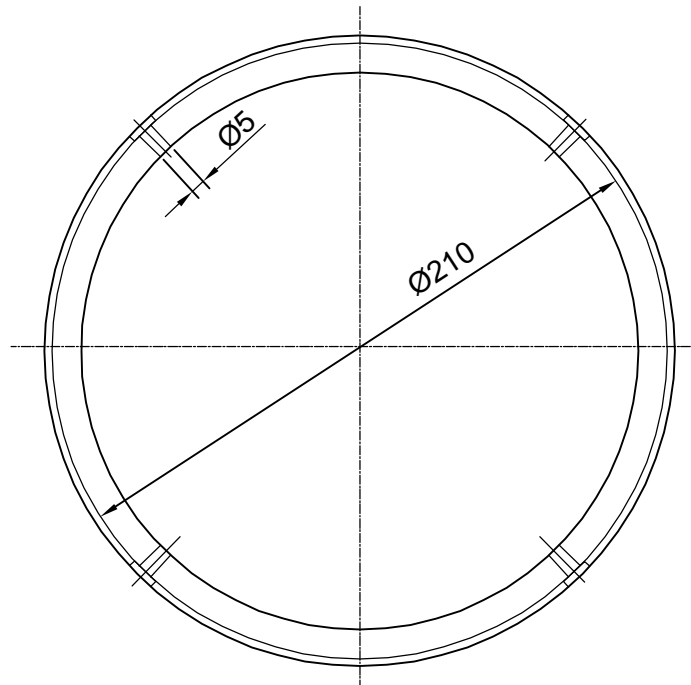
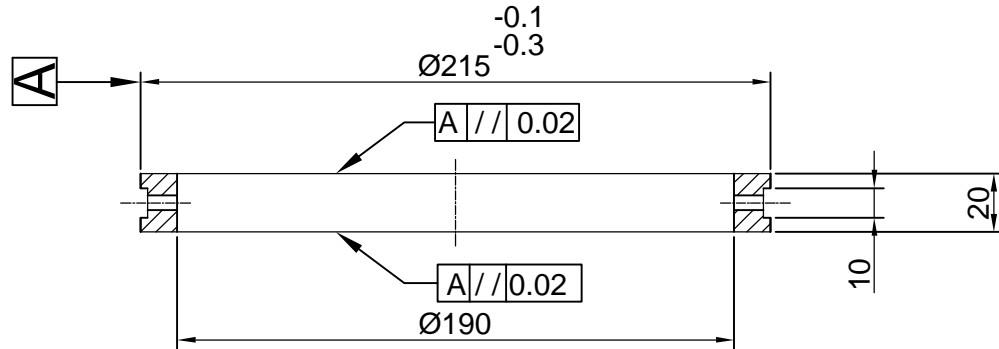
EQPT: STRETCH REDUCING MILL

	Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME D.ANAND	SIGNATURE <i>D. Anand</i>	DATE 17-03-11
			CHD	SSN.KUMAR	<i>SSM. KUMAR</i>	17-03-11
			APPD	G.LOGANATHAN	<i>G. Loganathan</i>	17-03-11
DEPT SSTP	GRADE OF UNTOL. DIM		SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM
CODE 456	$\phi / M / f$ IS: 2102		1:2.5	0.8	0-7-1155-15-11046	91
TITLE			CARD CODE	DRAWING NO :	REF TO OLD DWG NO	REV
SRM - DISTANCE SLEEVE (GEAR BOX DRIVE)			U 01	4-7-1155-15-03875	29020	01

ALL DIMENSIONS ARE IN MM


REV 01	DATE	ALTERED	<i>D. Anand</i>
	26.03.2011	CHECKED	<i>SSM. Kumar</i>
		APPROVED	<i>J. Loganathan</i>
CONVERTED TO AUTO CAD DRAWING			

1.6/



ALL SHARP CORNERS CHAMFERED TO 0.5x45°

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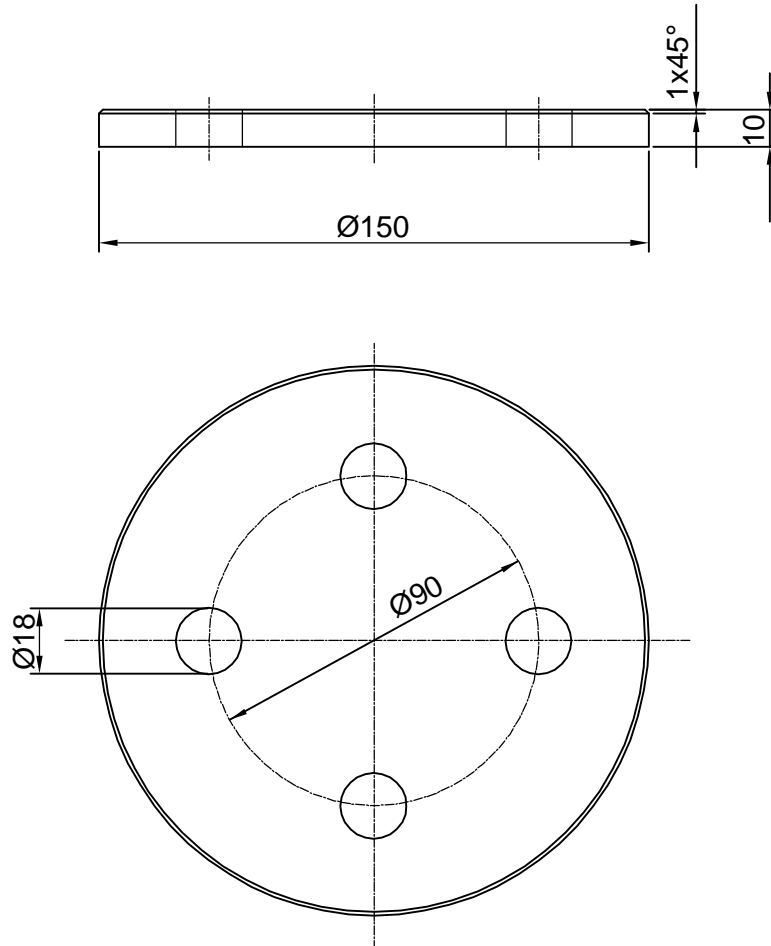
				Fe 540 IS:8500		
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE		UNIT WT	
			MATL SPEC		QTY	
EQPT: STRETCH REDUCING MILL						
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME D.ANAND	SIGNATURE <i>D. Anand</i>	DATE 17-03-11	
		CHD	SSN.KUMAR	<i>SSM. KUMAR</i>	17-03-11	
		APPD	G.LOGANATHAN	<i>J. Loganathan</i>	17-03-11	
DEPT SSTP	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM	
CODE 456	$\phi/M/f$ IS: 2102	1:2.5	1	0-7-1155-15-11046	92	
TITLE SRM - DISTANCE SLEEVE (GEAR BOX DRIVE)				REF TO OLD DWG NO 29072		
			CARD CODE U 01	DRAWING NO : 4-7-1155-15-03876	REV 01	

ALL DIMENSIONS ARE IN MM

REV	DATE	ALTERED	<i>D. Anand</i>
01	26.03.2011	CHECKED	<i>SSM. Kumar</i>
		APPROVED	<i>G. Loganathan</i>

3.2/

CONVERTED TO AUTO CAD
DRAWING



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ITEM NO	DESCRIPTION	DRAWING NO	ST-52 IS:1079	UNIT WT
			MATL CODE	QTY
			MATL SPEC	

EQPT: **STRETCH REDUCING MILL**



Bharat Heavy Electricals Ltd
SEAMLESS STEEL TUBE PLANT
TIRUCHIRAPALLI - 620014

DRN	NAME	SIGNATURE	DATE
	D.ANAND	<i>D. Anand</i>	17-03-11
CHD	SSN.KUMAR	<i>SSM. KUMAR</i>	17-03-11
APPD	G.LOGANATHAN	<i>G. Loganathan</i>	17-03-11

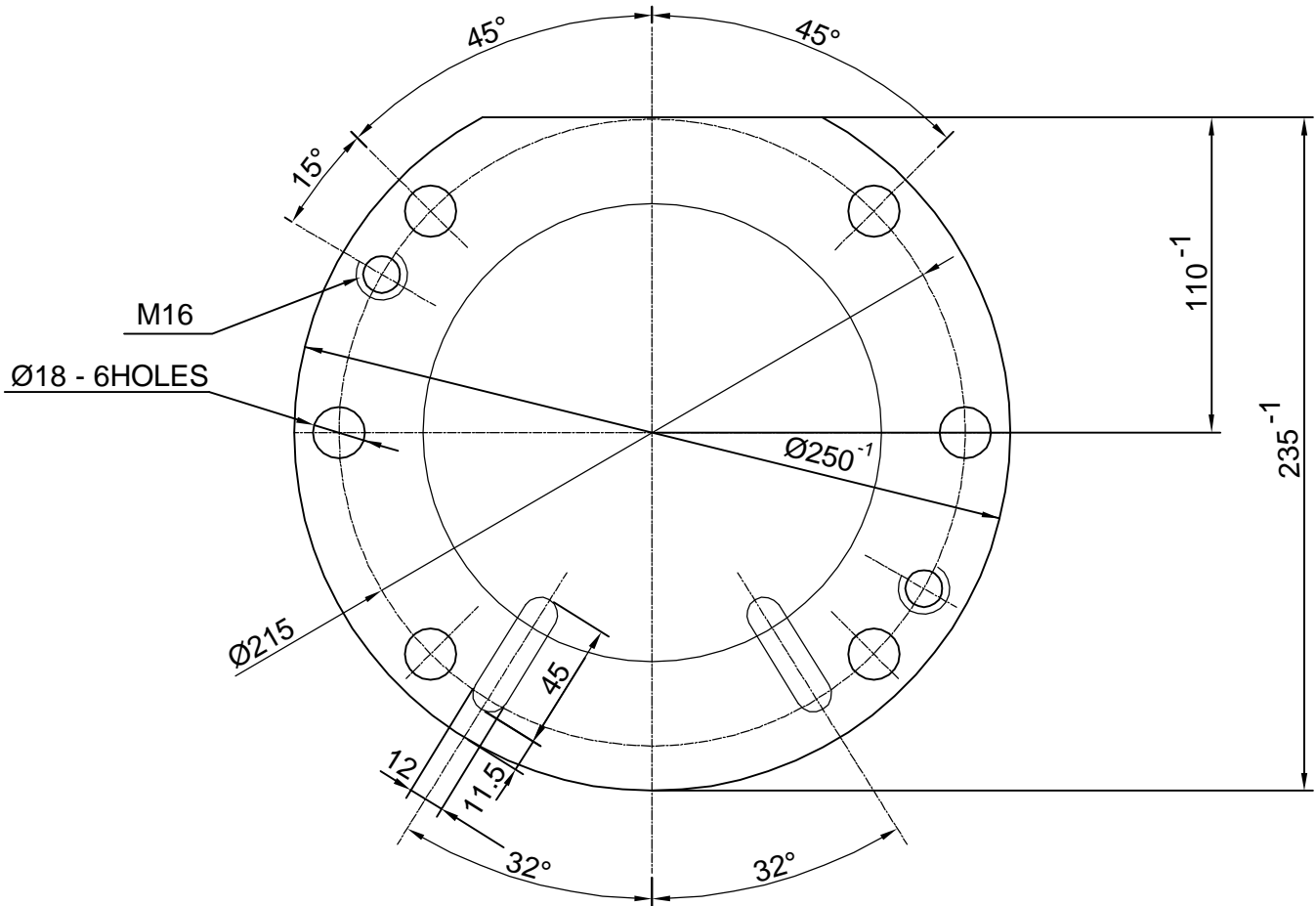
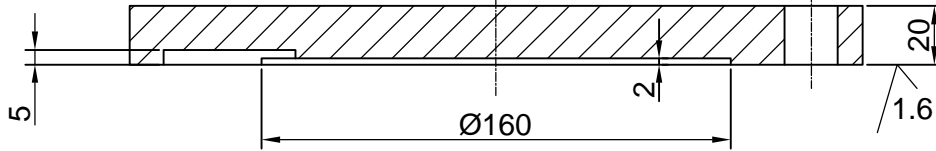
DEPT	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM
SSTP	Ø/M/F	1:2	0.36	0-7-1155-15-11046	94
CODE	IS: 2102			REF TO OLD DWG NO	
456				29019	

TITLE	CARD CODE	DRAWING NO :	REV
SRM - END DISC (GEAR BOX DRIVE)	U 01	4-7-1155-15-03877	01

ALL DIMENSIONS ARE IN MM

REV 01	DATE 29.5.95	ALTERED CHECKED APPROVED	A.AROCIKAM S.S.SUNDARAM	REV 02	DATE 26.3.11	ALTERED CHECKED APPROVED	D. Anand SSN.KUMAR G. Loganathan
MATL . SPEC. Fe 540 IS : 8500 WAS St . 52 , IS : 1079				CONVERTED TO AUTO CAD DRAWING			

3.2 / 1.6



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ITEM NO	DESCRIPTION	DRAWING NO	Fe 540 , IS : 8500	UNIT WT
			MATL CODE	QTY
			MATL SPEC	

EQPT: **STRETCH REDUCING MILL**



Bharat Heavy Electricals Ltd
SEAMLESS STEEL TUBE PLANT
TIRUCHIRAPALLI - 620014

DRN	NAME D.ANAND	SIGNATURE <i>D. Anand</i>	DATE 17-03-11
CHD	SSN.KUMAR	<i>SSN.KUMAR</i>	17-03-11
APPD	G.LOGANATHAN	<i>G. Loganathan</i>	17-03-11

DEPT SSTP	GRADE OF UNTOL. DIM ϕ/M/F IS: 2102	SCALE 1:2	WEIGHT (Kg) 4.5	REF TO ASSY DWG NO 0-7-1155-15-11046	ITEM 161
CODE 456				REF TO OLD DWG NO 28999	

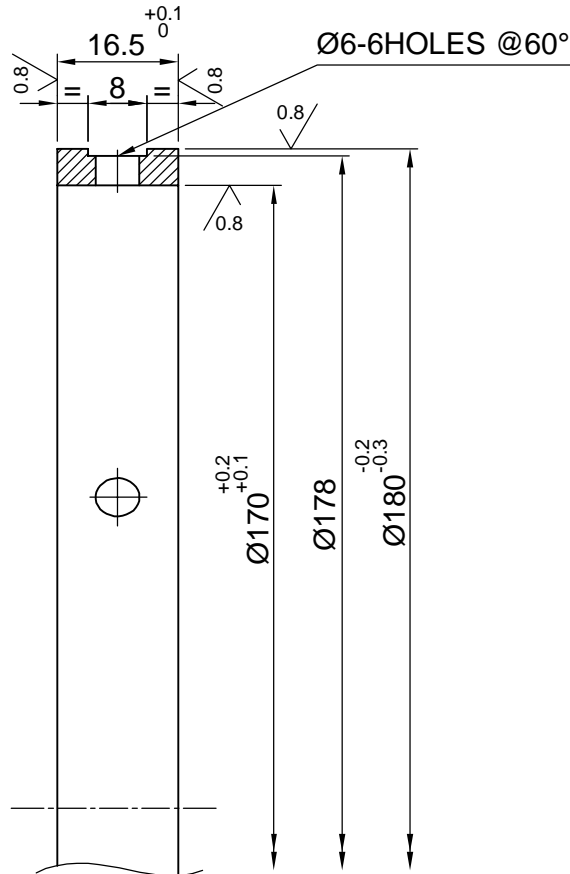
TITLE SRM - SEALING COVER (GEAR BOX DRIVE)	CARD CODE U 01	DRAWING NO : 4-7-1155-15-03879	REV 02
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ALL DIMENSIONS ARE IN MM

REV	DATE	ALTERED	S.KIRUBAHARAN
01	21.01.12	CHECKED	SSN.KUMAR
		APPROVED	G.LOGANATHAN



1.6 / 0.8 /

REF. ASSY DRG.NO & ITEM NO.
WERE 9-7-1155-15-00216 & 170



NOTE TO SHOP MTCE
ON RECEIPT WIDTH 16.5^{+0.1} TO BE GROUND
TO MATCH THE ASSY

HARDEN TO HRC 60^{±2}

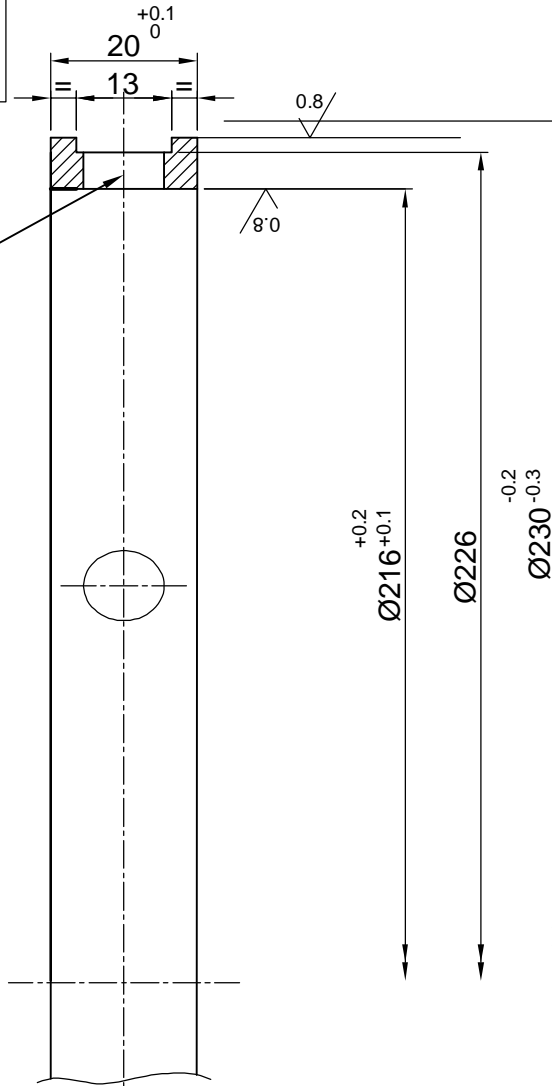
CAUTION: THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.			103Cr1 IS:4398		
	ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT
				MATL SPEC	QTY
	EQPT: STRETCH REDUCING MILL				
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014	DRN	NAME	SIGNATURE	DATE	
	CHD	SSN.KUMAR	<i>SSN.KUMAR</i>	21.03.03	
	APPD	S.SHANMUGASUNDARAM	<i>S.S.SUNDARAM</i>	21.03.03	
DEPT SSTP	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM
456	 IS: 2102	1:1	0.32	0-7-1155-15-11046	181
TITLE			CARD CODE	REF TO OLD DWG NO	REV
SRM - SPACER FOR BRG 30220J2/DF-GEAR BOX ASSY			U 01	DRAWING NO : 4-7-1155-15-06206	01

ALL DIMENSIONS ARE IN MM

REV	DATE	ALTERED	S.KIRUBAHARAN
01	21.01.12	CHECKED	SSN.KUMAR
		APPROVED	G.LOGANATHAN

1.6/0.8/

DIMENSIONS Ø230,Ø226
 Ø216,20 &13 WERE RESPECTIVELY
 Ø214,Ø209,Ø190,14.5 &10
 REF. DRG NO.&ITEM DRG NO.WERE
 9-7-1155-15-00216 & 171



HOLE Ø11- 6 HOLES @ 60°

NOTE TO SHOP MTCE

ON RECEIPT WIDTH 20^{+0.1} TO BE GROUND
 TO MATCH THE ASSY

HARDEN TO HRC 60^{±2}

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ITEM NO	DESCRIPTION	DRAWING NO	103Cr1 IS:4398	UNIT WT
			MATL CODE	QTY
			MATL SPEC	

EQPT: STRETCH REDUCING MILL

	Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014	DRN	NAME	SIGNATURE	DATE
		CHD	B.ASHOKKUMAR	<i>S. SHANMUGASUNDARAM</i>	22.02.03
		APPD	SSN.KUMAR	<i>SSN.KUMAR</i>	21.03.03
			S.SHANMUGASUNDARAM	<i>S.S. SHANMUGASUNDARAM</i>	21.03.03

DEPT	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM
SSTP	IS: 2102	1:1	0.77	0-7-1155-15-11046	182
CODE				REF TO OLD DWG NO	
456					

TITLE	CARD CODE	DRAWING NO :	REV
SRM - SPACER FOR BRG 30226J2/DF-GEAR BOX ASSY	U 01	4-7-1155-15-06207	01