

6174-0031

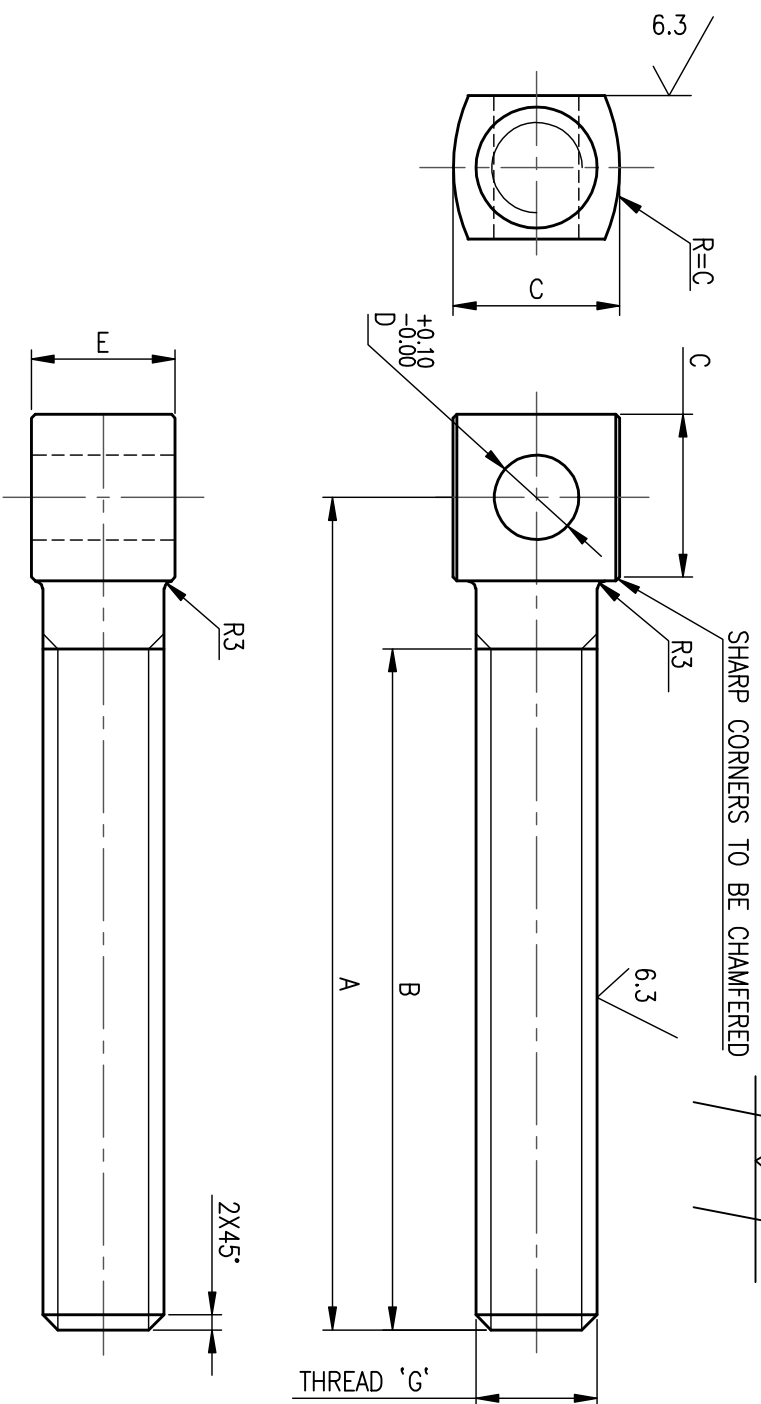
ON DRG

FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN MILLIMETERS)

FOR PRODUCTION
REF: PROA:500 OR UNTOL. DIMNS

01	Item	ADJUSTING BOLT
02	Application	Used for connecting the chain with Guillotine gate blade. Also for adjusting the tension of the chain
03	Scope of supply	Supply of adjusting bolt with blackodised condition with rust preventive oil.
04	Material	ASTM A 193 GR.B7
05	Method of manufacturing	i) The supplier shall procure hot rolled bars in annealed or in hardened and tempered condition free from seams and surface laminations from approved steel makers. ii) The adjusting bolt shall be forged. iii) Threads shall be formed by thread rolling only. Heat treatment if required shall be carried out prior to thread forming.
06	Thread	Threads as per IS-4218 PART II, with coarse pitch if not specified and general tolerance as per IS-2102.
07	Marking	All bolts shall be punched with manufacturer's identification symbol on the top of the head along with grade symbol 193 B7.
08	Hardness	The hardness of the finished bolt at the end or near the end shall be in the range 25-34-HRC. Hardness survey shall be carried out based on suitable sample plan as per IS 2500 level II.
09	Dimensions	As per drawing.
10	Inspection	a) The threads shall be checked with calibrated thread ring gauge. b) Test specimen shall be prepared as per ASM A 370. Tensile test shall be carried out on the specimen as prescribed in ASTM 193. c) The bolts shall have bright scale free finish. d) Necessary material test certificate shall be submitted for material chemistry, mechanical properties and hardness.
11	Packing and Preservation	i) Immediately after thread rolling, the bolts shall be blackodised or phosphated and preserved with a mild coat of quick drying rust preventive oil which is kerosene washable. ii) Each bolt shall be kept in cartons for protecting the thread. Then they are packed in a polythene bag. Finally these bags are packed in a transportable wooden box.

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SL NO	DESCRIPTION	A	B	ØC	ØD	E	G	BPS CODE	WEIGHT	BHEL REFERENCE	
										OLD CODE	CHAIN NUMBER
01	ADJUSTING BOLT M16-90	110	90	22	11.5	19	M16	942856150622	0.300	96-145-109-01	RO 622
02	ADJUSTING BOLT M16-125	150	125	25	13	19	M16	942856150078	0.40	96-145-110	W 78
03	ADJUSTING BOLT M16-130	160	130	32	14.5	19	M16	942856150082	0.70	96-145-111	W 82
04	ADJUSTING BOLT M24-160	200	160	40	14.5	27	M24	942856150124	1.30	96-145-114	W 124
05	ADJUSTING BOLT M24-250	300	250	50	18	27	M24	942856150132	2.00	96-145-115	W 132
06	ADJUSTING BOLT M39X3-250	305	250	76	38.1	42	M39X3	942856154824	4.30	96-145-153-01	RO 4824

REV. 02	DATE	ALTERED	REV. 01	DATE	ALTERED
		CHECKED			S.KALAIARASAN
ZONE			ZONE		J.KUPPAN
					MARKING 'A' SHIFTED FROM BOLT NECK TO BOLT HOLE CENTRE.

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TYPE OF PRODUCT
OR NAME OF
CUSTOMER / PROJECT



Bharat Heavy Electricals Ltd
UNIT: BOILER AUXILIARIES PLANT
RANIPET - 632 406

DRAWN	S.KALAIARASAN	SIGN		DATE	04/09/10	No. OF VAR.
CHKD.	K.SARANAMAN			21/09/10		
APPD.	V.KESAVAN					

DEPT.	DP	GRADE OF UNTOL. DIM.	SCALE	WEIGHT (KG.)	REF. TO ASSY. / OLD DRG.	ITEM No. OF ITEM
877	500	1:1		3-48-490-34649/09		

TITLE	CARD CODE	DRAWING No.	REV.
ADJUSTING BOLT	U 01	6174-0031	01