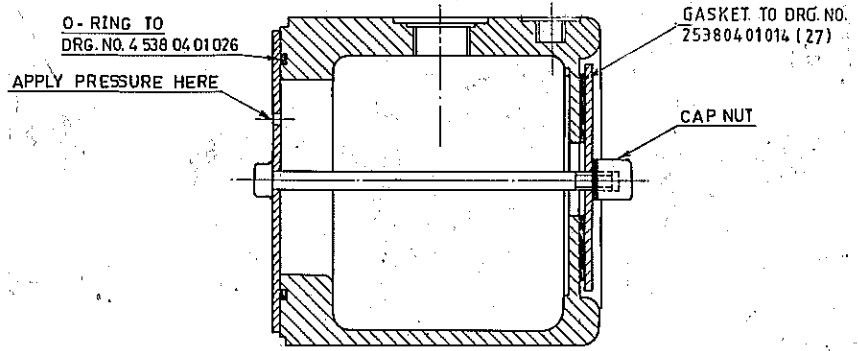
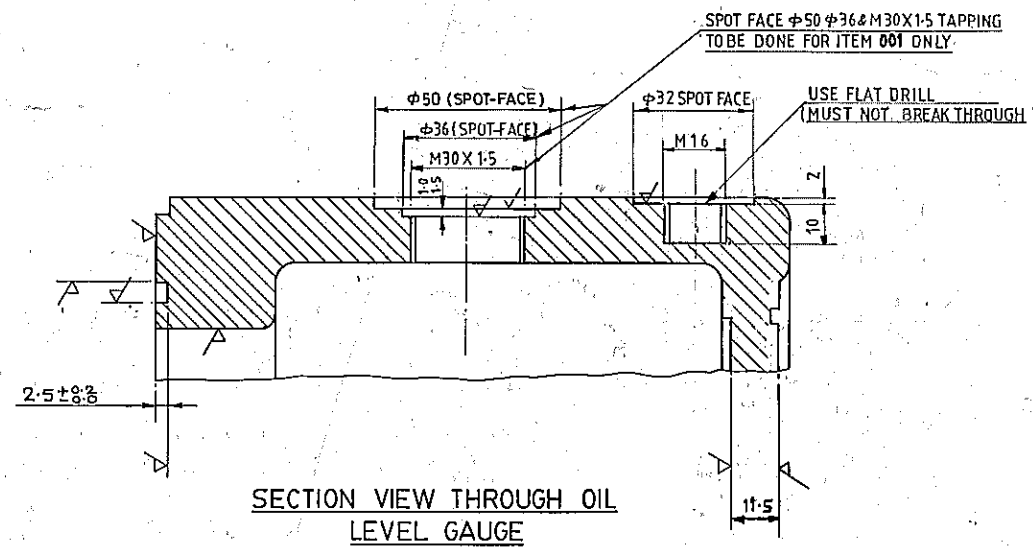


7E010708E5 1 ON'DRG

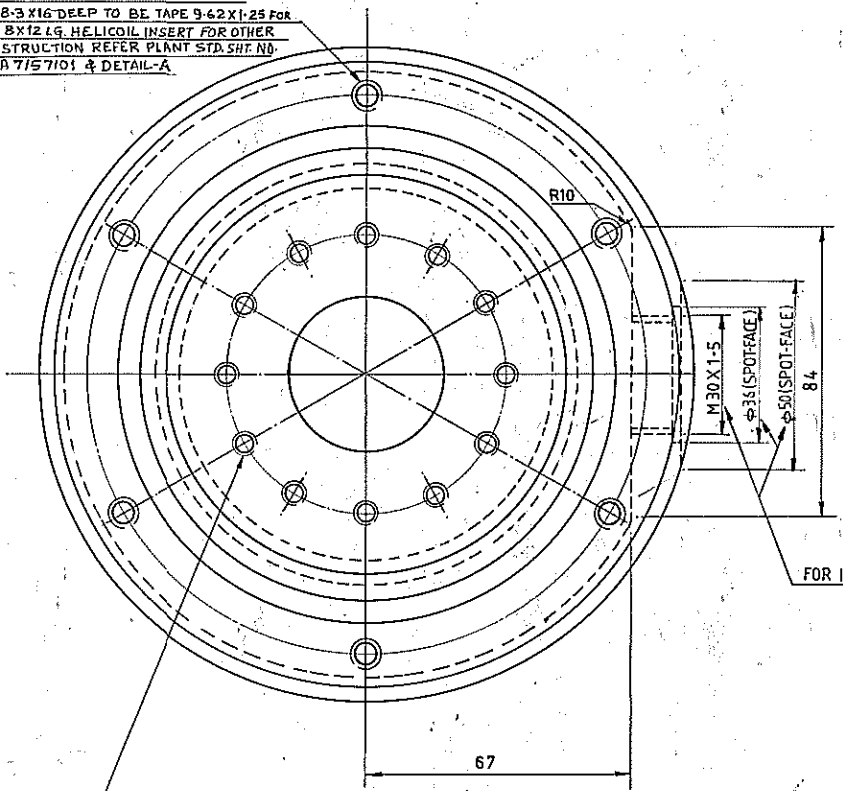


STYLE LIST				
STYLE	VT. INCLUDED	DESCRIPTION	RECORDED	
			SIGN	DATE
950173	VAR.00	TOP CAP - 52/725 KY-3150A BUSHING	[Signature]	7-3-91
950182	VAR.01	TOP CAP 52/725KY BUSHING	[Signature]	7-3-91

SECTION VIEW THROUGH OIL LEVEL GAUGE

ARRGT. FOR PRESSURE TESTING

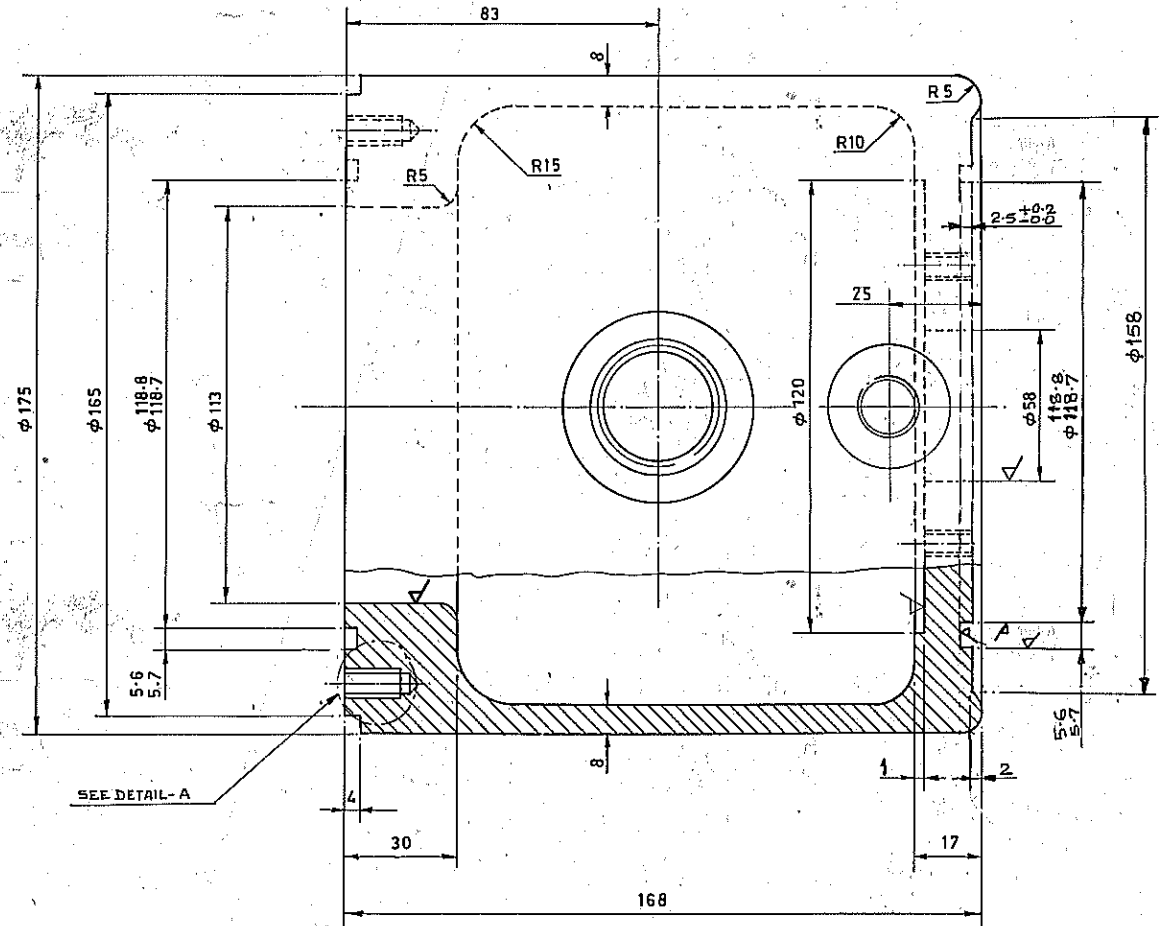
6-HOLES DRILL 8.3 X 18 DEEP EQUALLY SPACED ON 148 P.C.D. (MUST NOT BREAK THROUGH)
 8.3 X 18 DEEP TO BE TAPE 9.62 X 1.25 FOR M 8 X 12 LG. HELICOIL INSERT FOR OTHER INSTRUCTION REFER PLANT STD. SHE. NO. AA 7157101 & DETAIL-A



12-HOLES M6 THROUGH EQUALLY SPACED ON 88 P.C.D.

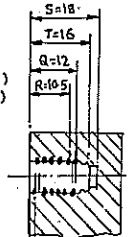
NOTES:-

1. THE CASTING SHOULD BE FREE FROM BLOW HOLES AND CRACKS. OUTER SURFACE SHOULD BE FREE FROM ANY SHARP EDGES AND SHOULD BE SMOOTH FINISHED.
2. MACHINED SURFACES MUST BE PROTECTED FROM DENTS AND SCRATCHES WHILE HANDLING AND TRANSPORT.
3. FINISHED MACHINED CASTING MUST BE AIR PRESSURE TESTED AT 3 Kg./cm² WITHOUT ANY LEAKAGE FOR 30 MINUTES.
4. ALL THREADED HOLES MUST BE PERPENDICULAR TO THE RESPECTIVE MACHINED SURFACE.
5. ALL MACHINED DIMENSIONS TO HAVE TOLERANCE OF ±0.25 MM UNLESS OTHERWISE SPECIFIED.
6. THREAD: PITCH COARSE / FINE TO LATEST REV. OF IS: 4218 (PART-IV) TOLERANCE QUALITY MEDIUM CLASS 6g.



QTY	ITEM NO.	DESCRIPTION	UNIT	WEIGHT (KG)
6	003	HELICOIL INSERT STAINLESS STEEL M8 X 12 LG.		
1	002	TOP CAP AL. ALLOY DIE CASTING	AA 19950	KG
1	001	TOP CAP AL. ALLOY DIE CASTING	AA 19950	KG

R - ENTERING PORTION OF SCREW (MAX.)
 G - FULL TAPPED THREAD LENGTH (MIN.)
 T - TAP DEPTH (MIN.)
 S - DRILL DEPTH.



DETAIL-A

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.

INVENTORY NO. SIGN. & DATE REF. DRG. NO.

REV	DATE	ALTD	BY	REV	DATE	ALTD	BY	REV	DATE	ALTD	BY	REV	DATE	ALTD	BY	REV	DATE	ALTD	BY	REV	DATE	ALTD	BY				
07	19-02-08	EHD		06	11-09-97	CHD		05	15-12-94	CHD		04	21-8-92	CHD		03	8-1-92	CHD		02	9-8-91	CHD		01	3-8-91	CHD	
VAR.01, 11.003, GROOVE DIM. 118.3 & 118.7 & DETAIL-A ADDED. AT 50 (SPOT-FACE) UNDER CUT WAS 2 DEEP. NOTES 4,5 & 6 ADDED. TOOL LIST OMITTED. FINISH WT. WAS 3.600 KG AT BOTTOM END O-RING GROOVE FROM SECTIONAL VIEW OMITTED. SPOT FACE 36 X 2 DEEP ADDED. (ZONE, H-10) M 16 TAPPED HOLE AND SPOT FACE 32 ADDED. M/C MARK AT 58 & AT 113 ADDED. DIMENSION 84 WAS 76. ITEM 002 ADDED.																											

ADDITIONAL INFORMATION

STATUS OF DRAWING: M

DISTRIBUTION OF PRINTS: BCE 4, TCM 1, QAX 1, FYM 2

TYPE OF PRODUCT OR NAME OF CUSTOMER / PROJECT: 52/72.5KV. 3150A OIP BUSHING

BHARAT HEAVY ELECTRICALS LTD. BHOPAL

SCALE: N.T.S. WEIGHT (KG): 4.000

DRAWING NO. 1 538 04 01 032

SHEET NO. 1