

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

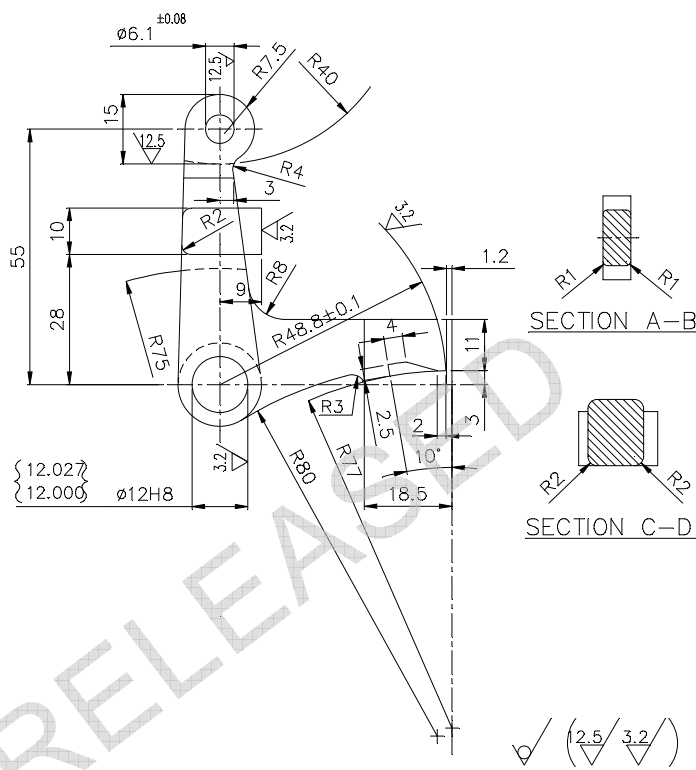
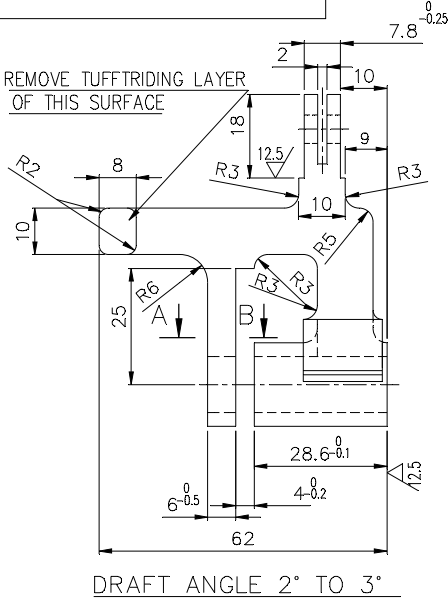
FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

5047250

DRG. NO.

REMOVE TUFFTRIDING LAYER OF THIS SURFACE

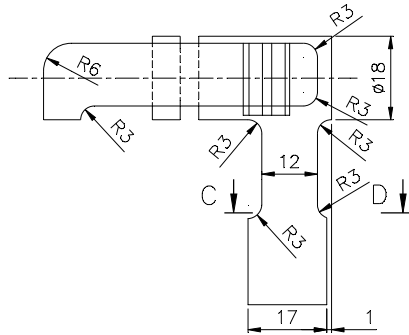


SECTION A-B

SECTION C-D

TOOL LIST		
ITEM	TOOL	DESCRIPTION
-	1463534	TURNING FIXTURE
-	1463535	DRILL JIG
-	1463536	COPY MILLING HOLDING FIXTURE
-	1463537	COPY MILLING TEMPLATE FOR R77,48.8 & 9mm.
-	1463538	HOLDING FIXTURE FOR 2&4mm.SLOT
-	1463539	HOLDING FIXTURE FOR DIM 17mm.
-	1464005	CHECKING FIXTURE FOR R48.8±0.1 & R77 WRT. HOLES $\phi 12^{H8}$ & $\phi 6.1$
-	1520292	HOLDING FIXTURE FOR MAHO.
-	1520588	LAPPING MANDREL $\phi 12H8$
-	1520638	REAMER $\phi 6.1 \pm 0.08$
-	1520639	PLUG GAUGE FOR $\phi 6.1 \pm 0.08$

SPECIFICATION FOR PRECISION STEEL CASTING	
CHEMICAL COMPOSITION :-	
CARBON	0.12-0.18
SILICON	0.15-0.60
MANGANESE	0.40-0.60
SULPHUR	0.035 MAX.
PHOSPHOROUS	0.035 MAX.
CHROMIUM	0.40-0.70
MECHANICAL PROPERTIES :-	
HARDNESS	MAX. 174HB
TENSILE STRENGTH	70-105Kgf/mm. ²
PROOF STRESS	45-52Kgf/mm. ²
PERCENTAGE ELONGATION	11-10



CASTING PART NO.5259881		PRECISION STEEL CASTING (15Cr3) TO SPECN		DRAWING NO.		TO SPECN.		UNIT WT.		QTY.					
59	64	75	78	79	25	29	29	31	34	45	55	56	58	65	72
VAR00	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.NL.	MATL. CODE	A.I.	C.I.	UNIT	KG	UNIT WT.	CS	ZINE
28 → CARD TYPE-3		28 → CARD TYPE-1		28 → CARD TYPE-2		0.23		001		68		71		71	

ADDITIONAL INFORMATION

STATUS OF DRAWING

DISTRIBUTION OF PRINTS

SWE	SWM	TCX
1	3	1

उत्पाद का प्रकार या ग्राहक/परियोजना का नाम
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT



भारत हेवी इलेक्ट्रिकल्स लिमिटेड
भोपाल
BHARAT HEAVY ELECTRICALS LTD.
BHPAL

ON LOAD TAP CHANGER

क्रमांक/DRN	नाम/NAME	हस्ता/ SIGN	दिनांक/ DATE	वे.र. की संख्या/ NO. OF VAR
DRN	S.D.W.	Sd/-	16.12.76	
चक्रा/CHK	B.S.R.	Sd/-	21.12.76	
अनुमोदित/APPD	B.S.S.	Sd/-	2.1.77	

REV.	DATE	ALTERED	AKU
13	24.01.02	CHECKED	SKP
		APPROVED	SK

DRG. REDRAWN
(DCA NO-11189)

मिमा/DEPT SWE
अं. दल. माप की श्रेणी/ UNTIL.DIMS. GR.
कोड/ 409 MEDIUM
AA 0230208



अनुपात/ SCALE 1:1
माप/ WEIGHT (K.G.) -

अं. दुर्भाग का संदर्भ/ REF. TO ASSY. DRG.
5009992

माप सं. / ITEM NO. -
माप संख्या/ NDL OF ITEM 001

शीर्षक/ TITLE

PAWL-1

अं. दुर्भाग का संदर्भ/ REF. TO ASSY. DRG.

5047250

पृष्ठ सं./REV 13

पृष्ठ सं./श. No. 01 पृष्ठों की संख्या/NO. OF SH. 01

A3