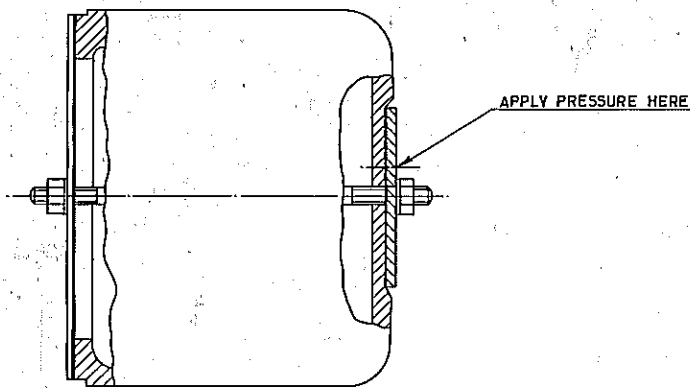
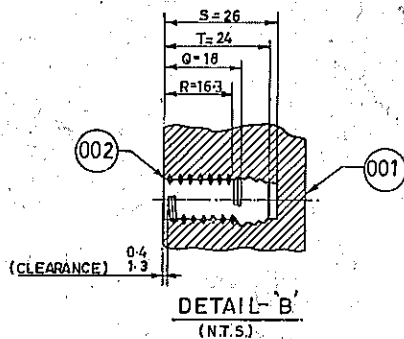
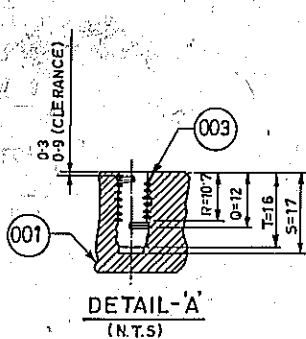


DRG. NO. 1 538 04 01 005

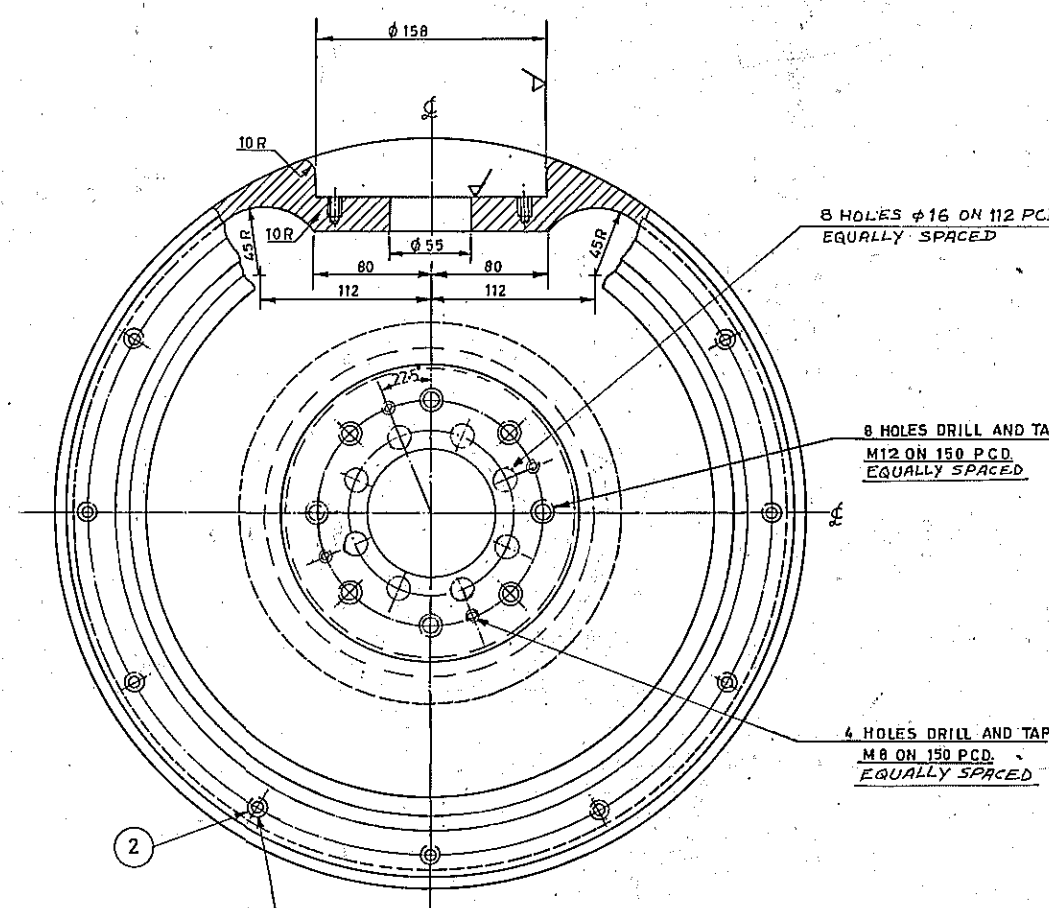
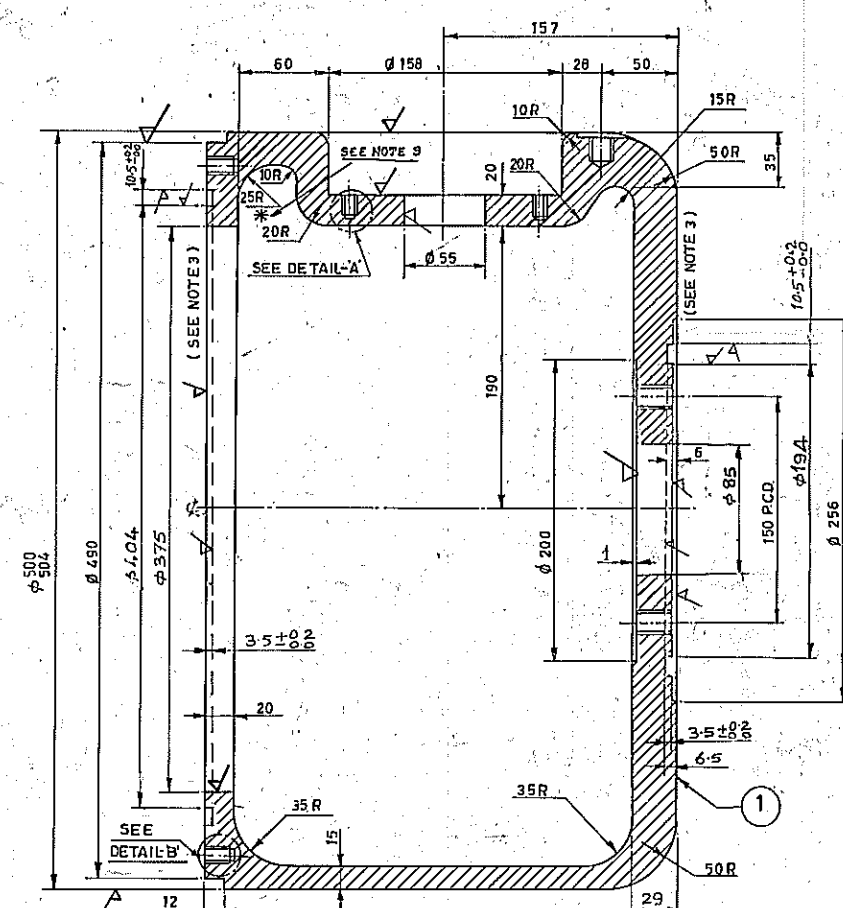


R-ENTERING PORTION OF SCREW (MAX.)
Q-FULL TAPPED THREAD LENGTH (MIN.)
T-TAP DEPTH (MIN.)
S-DRILL DEPTH.

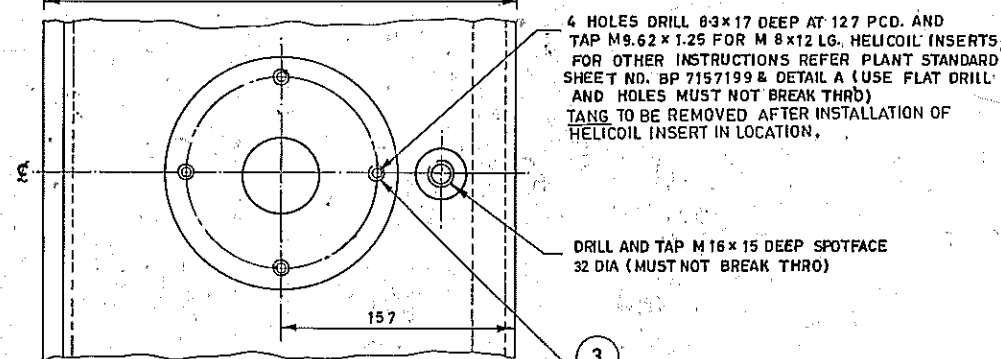
STYLE LIST			
STYLE	IT. INCLUDED	DESCRIPTION	RECORDED SIGN. DATE
906699	VAR.00	TOP CAP CASTING	Sd- 11-3-84

TOOL LIST		
ITEM	TOOL	DESCRIPTION
001	1492498	GRAVITY DIE CAST TOOL

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.



- NOTES:-**
- THE CASTING SHOULD BE FREE FROM BLOW HOLES AND CRACKS. OUTER SURFACES SHOULD BE FREE FROM ANY SHARP EDGES AND SHOULD BE SMOOTH FINISHED.
 - FINISHED MACHINED CASTING MUST BE AIR PRESSURE TESTED AT 3 KG/CM² WITHOUT ANY LEAKAGE FOR 30 MINUTES.
 - MACHINED SURFACES TO BE PROTECTED FROM DENTS AND SCRATCHES WHILE HANDLING.
 - ALL THREADED HOLES MUST BE PERPENDICULAR TO THE RESPECTIVE MACHINED SURFACES.
 - USE OF 'M SEAL' OR ANY OTHER FILLING MATERIAL FOR PATCH UP WORK OF CASTING DEFECTS AND ALUMINIUM PAINTING THERE AFTER IS STRICTLY PROHIBITED.
 - ALL MACHINED DIMENSIONS TO HAVE A TOLERANCE OF ± 0.25 MM UNLESS OTHERWISE SPECIFIED.
 - OUTER SURFACES OF THE CASTING MAY HAVE SUITABLE TAPERS FOR EASY REMOVAL OF THE MOULDS.
 - ALL RADII SHOWN ON THE DRG. MAY BE ALTERED SUITABLY FOR EASY MAKING OF CASTINGS.
 - IF φ504 (MAX) IS OVERSIZE IN CASTING, THIS IS TO BE MAINTAINED BY MACHINING.
 - * 9. RADIUS 25 R. & WALL THICKNESS CAN BE ADJUSTED TO ACHIEVE THIS.



12 HOLES DRILL 12x26 DEEP AT 460 P.C.D. AND TAP M14.27x1.75 FOR M12 x 18 LG. HELICOIL INSERTS. FOR OTHER INSTRUCTIONS REFER PLANT STANDARD SHEET NO. BP 7157199 & DETAIL A (USE FLAT DRILL AND HOLES MUST NOT BREAK THRO) AND DETAIL-B' (USE FLAT DRILL & HOLES MUST NOT BREAK THRO) TANG TO BE REMOVED AFTER INSTALLATION OF HELICOIL INSERT IN LOCATION.

REV.	DATE	ALTD.	BY	REV.	DATE	ALTD.	BY	REV.	DATE	ALTD.	BY	REV.	DATE	ALTD.	BY	REV.	DATE	ALTD.	BY
4				003															
12				002															
1				001															

ADDITIONAL INFORMATION
OLD DRG. REF. F 914170

STATUS OF DRAWING

DISTRIBUTION OF PRINTS
OAX-1, BCE-1, BCM-4, TCX-1, FOUNDRY-2

TYPE OF PRODUCT OR NAME OF CUSTOMER / PROJECT
420 KV-O.I.P. CONDENSER BUSHING

BHARAT HEAVY ELECTRICALS LTD. BHOPAL

DRM. S.K. SHARMA
CHD. H.L.
APPD. P.D.G.

SCALE: 1:2.5

WEIGHT (Kg): 38.000

REF. TO ASSY. DRG.: 1 538 01 01 001 & 007

ITEM NO. 008

DRAWING NO. 1 538 04 01 005

SHEET NO. 1

TITLE: **TOP CAP**

REV.	DATE	ALTD.	BY	REV.	DATE	ALTD.	BY	REV.	DATE	ALTD.	BY	REV.	DATE	ALTD.	BY	REV.	DATE	ALTD.	BY
09	16.2.06	CHD.	SdV	07	1.96	CHD		06	11.8.92	CHD		05	24.72	CHD		05	24.72	CHD	

NOTE - 9 ADDED.

DIM: 66 WAS 100. φ240X6 DEEP OMITTED. 4 HOLES M8 ON 120 PCD WAS 150 PCD. 8 HOLES M12 WAS M16 (500) 6 HOLES M16 ON 112 PCD. GROOVE φ40 X 10 SX35 DEEP AT 112 X 10 SX35 DEEP. ADDED.

FINISH WT WAS 46 KG APPROX.

φ500 WAS MENTIONED φ504 (MAX.) M/C ON OUTER DIA. WAS NOT ON. NOTE-9 DELETED.

DRG. RETRACTED. MACHINED SURFACES MARKED MACHINING GRADE Ra 0.8 OMITTED. NOTE 9 & M/C MARK AT φ375 ADDED.