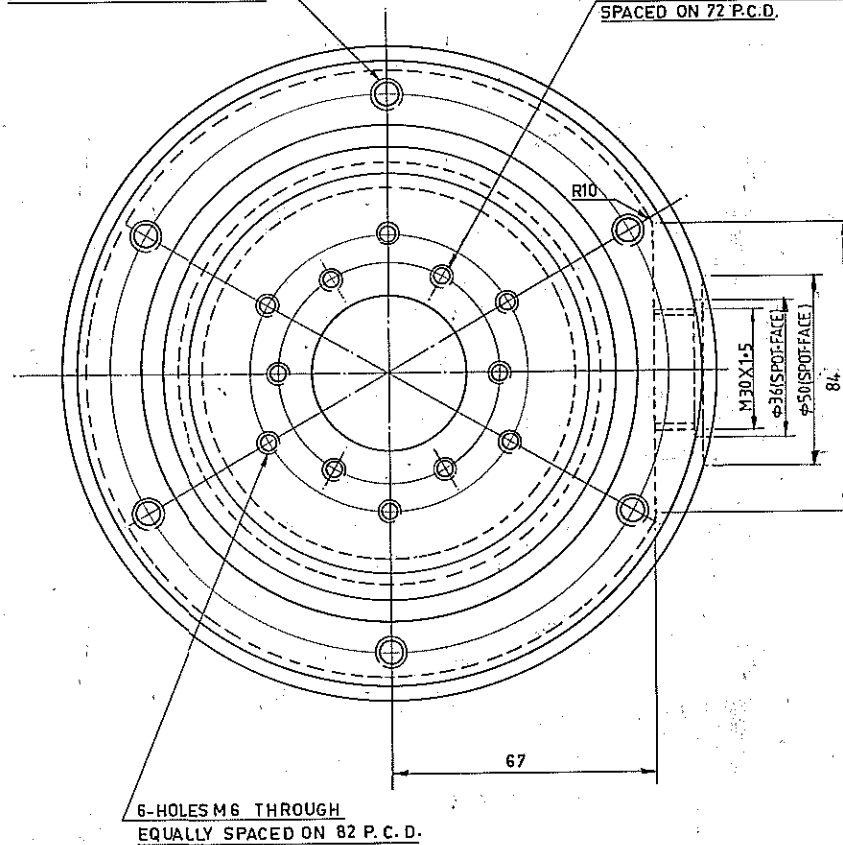


6-HOLES M8 X 15 DEEP.
EQUALLY SPACED ON 148 P.C.D.
(MUST NOT BREAK THROUGH)

6 HOLES M6 THROUGH EQUALLY
SPACED ON 72 P.C.D.



6-HOLES M6 THROUGH
EQUALLY SPACED ON 82 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.

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ST 950172	001	TOP CAP AL. ALLOY DIE CASTING	1	AA 19950	KG
VAR. NO.	REMARKS	DESCRIPTION	DRAWING NO.	MATL. CODE	UNIT WT.

ADDITIONAL INFORMATION		TYPE OF PRODUCT OR NAME OF CUSTOMER / PROJECT		52/72.5 K.V. O.I.P. BUSHING	
STATUS OF DRAWING		Bharat Heavy Electricals Ltd.		Bhopal	
DISTRIBUTION OF PRINTS		BCE		GRADE-OP UN-TOL DIM-C/M/F	
BCE	BCM	TCX	QAX	FYM	
1	4	1	1	2	
REV. DATE	ALTD	REV. DATE	ALTD	REV. DATE	ALTD
05 12-09-97	CHD	04 15-1-98	CHD	03 8-1-92	CHD
AT φ36 (SPOT FACE) UNDER CUT WAS 2 DEEP. NOTES 4,5 & 6 ADDED. TOOL LIST OMITTED.		FINISH WT. WAS 3-600 KG.		SPOT FACE φ36 X 2 DEEP ADDED. (ZONE. H-10)	
		M16 TAPPE HOLE AND SPOT FACE φ32 ADDED.		M/C MARK AT φ56 & φ105 ADDED. DIMENSION 84 WAS 76.	
REV. DATE		DATE		ALtered BRM	
01 1-6-91		1-6-91		CHECKED	
ZONE		M/C		MARK AT φ56 & φ105 ADDED. DIMENSION 84 WAS 76.	
DEPT. BCE		SCALE N.T.S.		WEIGHT (Kg) 4.000	
CODE 421		REF. TO ASSY. DRG. 0 538 01 01009		ITEM NO. 005	
TITLE TOP CAP		DRAWING NO. 1 538 04 01 031		REV. 05	
		SHEET NO. 1		NO. OF SHEETS 01	

REV. DATE	ALTD	REV. DATE	ALTD	REV. DATE	ALTD
05 12-09-97	CHD	04 15-1-98	CHD	03 8-1-92	CHD
AT φ36 (SPOT FACE) UNDER CUT WAS 2 DEEP. NOTES 4,5 & 6 ADDED. TOOL LIST OMITTED.		FINISH WT. WAS 3-600 KG.		SPOT FACE φ36 X 2 DEEP ADDED. (ZONE. H-10)	
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