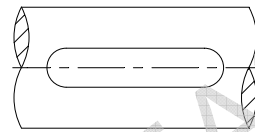
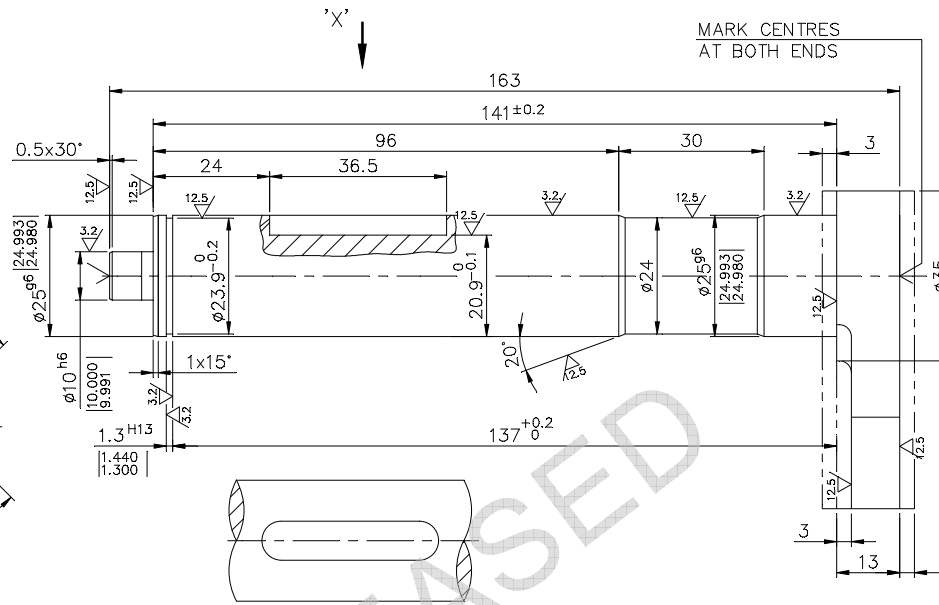
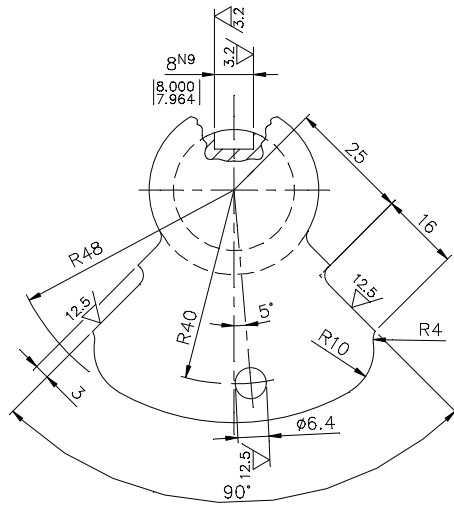


DRG NO 5046789

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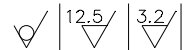


VIEW-X

MATERIAL SPECIFICATION	
ALLOY STEEL FORGING (20MnCr5)	
CHEMICAL COMPOSITION-	
CARBON	- 0.17 TO 0.22
MANGANESE	- 1.10 TO 1.40
SILICON	- 0.15 TO 0.40
CHROMIUM	- 1.00 TO 1.30
PHOSPHOROUS	- 0.035 MAX.
SULPHUR	- 0.035 MAX.
PROPERTIES-	
- IN NORMALISED CONDITION	
HARDNESS HB	- 217 (MAX.)
TENSILE STRENGTH-	(MIN.)-56Kg/mm ²
- AFTER MACHINING & HARDENING	
TENSILE STRENGTH-	100-140 Kg/mm ²
ENLOGATION	- (MIN.) 8%

- HARDEN & TEMPER HRC 30-35.
- APPLY TRP CASTROL-RUSTILO 630/HP-RUSTOP 285 FOR STORAGE.
- RADIUS NOT SHOWN=R2.5

PRE GRINDING DIM. FOR ϕ 24.993 TO BE ϕ 25.65
24.980 25.60



TOOL LIST		
ITEM	TOOL NO.	DESCRIPTION
-	1463690	COLLET
-	1463691	DRILL JIG
-	1463692	COPY MILLING FIXTURE
-	1463693	COPY MILLING TEMPLATE
-	1463098	GROOVING TOOL 1.3 H13
-	1463998	90°ANGLE PROFILE GAUGE 8 N9
-	1520092	SPLIT BUSH
-	1520293	SETTING PIECE ON SELF CENTRING VICE

VAR	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.ND.	MATERIAL CODE	A	UNIT	KG.
001	FORGING PART NO. 5257721	01 001 ALLOY STEEL FORGING				TO SPECN.			0.80
VAR 00	REMARKS	VAR ND. ITEM ND.			VAR	MATL. SPNC.	C	UNIT	QTY

ADDITIONAL INFORMATION				TYPE OF PRODUCT OR NAME OF CUST/PROJ		ON LOAD TAPCHANGER					
STATUS OF DRAWING				BHARAT HEAVY ELECTRICALS LIMITED		DRN	V.KUMAR	Sd/-	15.12.76	NO. OF VAR	
DISTRIBUTION OF PRINTS				BHOPAL		CKD	B.S.R.	Sd/-	19.12.76		
SWE SWM TCX				Bharat Heavy Electricals Limited		APPD	B.S.S.	Sd/-	20.12.76		
1	3	1		DEPT SWE	UN. TOL.DIMGR.	SCALE	WEIGHT (KG.)	REF TO ASSY	ITEM NO.	NO. OF ITEMS	
16	8.09.08	ALTD AKU CKD KS APPD SKP		409	M AA 0230208	1:1		5010335		001	
DRG. REDRAWN.				TITLE				DRG NO		REV.	
(D.C.A. NO. 21883)				DRIVE SHAFT				5046789		16	
								SHT.ND. 01	NO. OF SHT.	01	

5046789-R15-S01 REF.DRG.ND.

SIGN. & DATE

INVENTORY NO.