

1

[illegible]
$$\frac{3.2}{\nabla} \left(\frac{1.6}{\nabla} \frac{0.8}{\nabla} \right)$$


Title.			
DETAIL OF DRIVEN SHAFT			
Drawing No.:- 4174-42		Revision	Sheet
Plot Date :- 27-02-2012			1

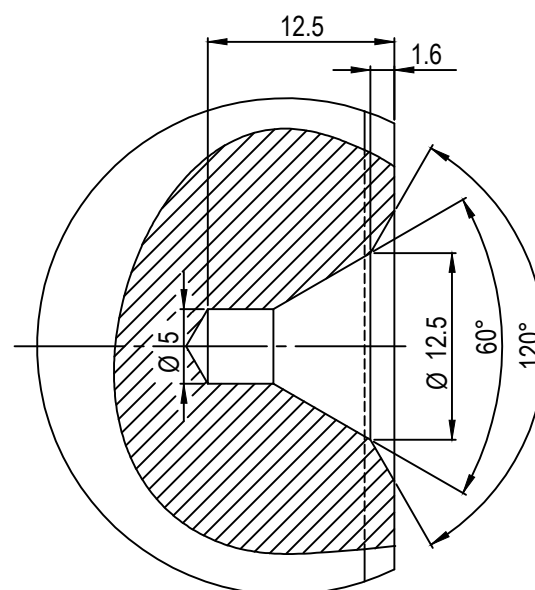
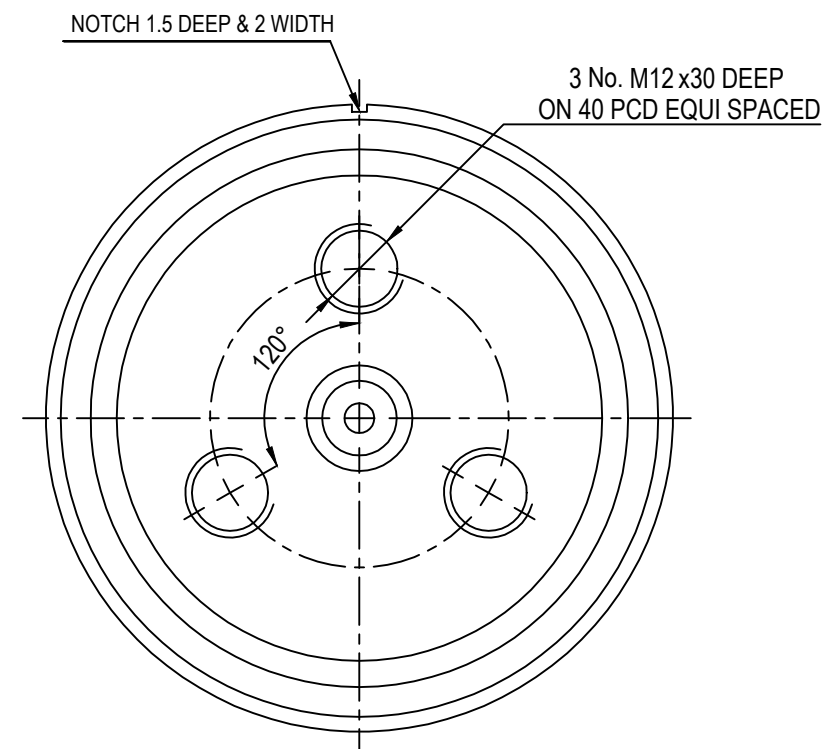
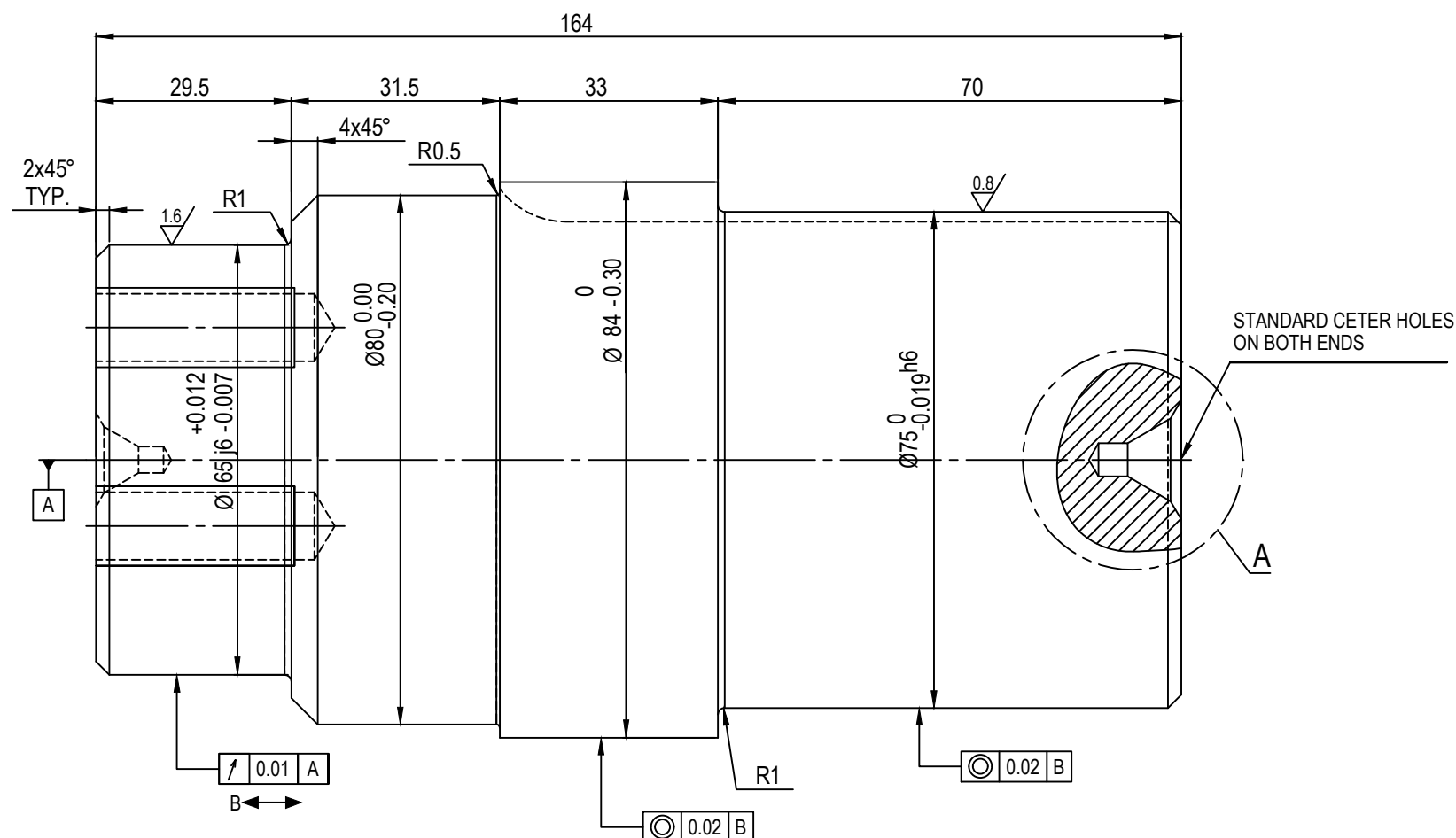
	P.P. Rolling Mills Mfg. Co. Pvt. Ltd. Plot No. I-42, DLF Ind. Area, Phase-I, Faridabad (Haryana) Phone +91 -11 - 26836340, 26848885, 26313774 Fax. +91-11-26836335, website: www.pprm.in	Scale	Title.		
		1:1.5	DETAIL OF DRIVEN SHAFT		
			Drawing No.:- 4174-42	Revision	Sheet
			Plot Date :- 27-02-2012		1

BHEL DRG NO:2-9-1157-00-00230

Drawing No.	4174-96
Sheet	Next
01	-

Please Do Not Scale. If in Doubt, ASK.

REV.	ALT.No.	REVISION DETAILS	DRAWN	CHECKED	APPROVED
-	△	-	-	-	-

$$\frac{3.2}{\nabla} / \left(\frac{1.6}{\nabla}, \frac{0.8}{\nabla} \right)$$


DETAIL:-A
SCALE:-2:1

2	01	40C8	IS:1570-II	SHAFT	5.74	11.48	-
QTY.	TEM NO.	MATERIAL	IS & DIN	DESCRIPTION	Each	Total	REMARKS
			Std.		WEIGHT (Kg.)		

Key Characteristics: -		Material 40C8	Heat Treatment -	Hardness -	
Client :- BHEL		Job No. :- 000135/11-12			
Drawn By / Date	EW / 13-10-2011	Format/Sh.Size CAD/A3 Scale 1:1	Equi. ROLLER TABLE-2		
Chkd. By / Date	RAJESH / 17-02-12				
Appr. By / Date	B.M.T / 17-02-12		Title. DETAIL OF SHAFT		
PPRM  P.P. Rolling Mills Mfg. Co. Pvt. Ltd. Plot No. I-42, DLF II Ind Area, Phase-I, Faridabad (Haryana) Phone +91 -11 - 26836340, 26848885, 26313774 Fax. +91-11-26836335, website:www.pprm.in		Drawing No.:- 4174-96			
		Plot Date :- 27-02-2012		1 OF 1	0

Machinist's Note:-

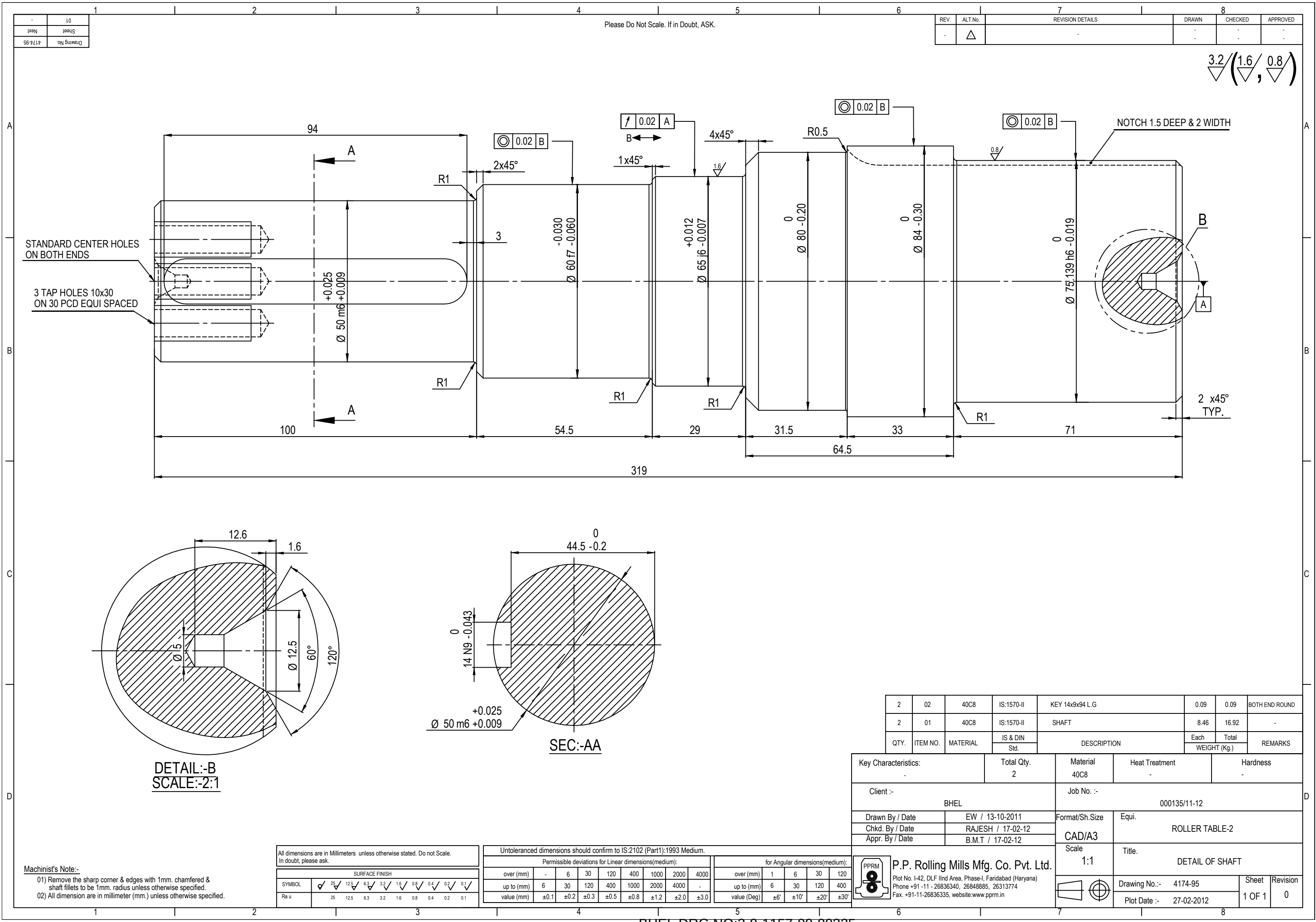
- 01) Remove the sharp corner & edges with 1mm. chamfered & shaft fillets to be 1mm. radius unless otherwise specified.
02) All dimension are in millimeter (mm.) unless otherwise specified.

All dimensions are in Millimeters unless otherwise stated. Do not Scale. In doubt, please ask.										
SURFACE FINISH										
SYMBOL										
Ra u	25	12.5	6.3	3.2	1.6	0.8	0.4	0.2	0.1	

Toleranced dimensions should conform to IS:2102 (Part1):1993 Medium.													
Permissible deviations for Linear dimensions (medium):									for Angular dimensions (medium):				
over (mm)	-	6	30	120	400	1000	2000	4000	over (mm)	1	6	30	120
up to (mm)	6	30	120	400	1000	2000	4000	-	up to (mm)	6	30	120	400
value (mm)	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	±3.0	value (Deg)	±6'	±10'	±20'	±30'



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Fax. +91-11-26836335, website:www.pprm.in

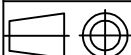


Machinist's Note:-
01) Remove the sharp corner & edges with 1mm. chamfered & shaft fillets to be 1mm. radius unless otherwise specified.
02) All dimension are in millimeter (mm.) unless otherwise specified.

All dimensions are in Millimeters. unless otherwise stated. Do not Scale. In doubt, please ask.									
SURFACE FINISH									
SYMBOL	✓	25	12.5	6.3	3.2	1.6	0.8	0.4	0.2
Ra u	25	12.5	6.3	3.2	1.6	0.8	0.4	0.2	0.1

Untoleranced dimensions should confirm to IS:2102 (Part1):1993 Medium.									
Permissible deviations for Linear dimensions (medium):									
over (mm)	-	6	30	120	400	1000	2000	4000	
up to (mm)	6	30	120	400	1000	2000	4000	-	
value (mm)	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	±3.0	

for Angular dimensions (medium):				
over (mm)	1	6	30	120
up to (mm)	6	30	120	400
value (Deg)	±6'	±10'	±20'	±30'

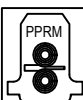
2	02	40C8	IS:1570-II	KEY 14x9x94 L.G	0.09	0.09	BOTH END ROUND	
2	01	40C8	IS:1570-II	SHAFT	8.46	16.92	-	
QTY.	ITEM NO.	MATERIAL	IS & DIN	DESCRIPTION	Each	Total	REMARKS	
			Std.		WEIGHT (Kg.)			
Key Characteristics:			Total Qty.	Material	Heat Treatment		Hardness	
-			2	40C8	-		-	
Client :-				Job No. :-				
BHEL				000135/11-12				
Drawn By / Date		EW / 13-10-2011		Format/Sh.Size	Equi.			
Chkd. By / Date		RAJESH / 17-02-12		CAD/A3	ROLLER TABLE-2			
Appr. By / Date		B.M.T / 17-02-12						
P.P. Rolling Mills Mfg. Co. Pvt. Ltd. Plot No. I-42, DLF IInd Area, Phase-I, Faridabad (Haryana) Phone +91 -11 - 26836340, 26848885, 26313774 Fax. +91-11-26836335, website:www.pprm.in				Scale	Title.			
				1:1	DETAIL OF SHAFT			
						Drawing No.:-		4174-95
Plot Date :-		27-02-2012	1 OF 1			0		

BHEL DRG NO:3-9-1157-00-00324

NOTE:-

1. UNSPECIFIED RADII TO BE 5 TO 10mm.
2. CASTING SHOULD BE FREE FROM BLOW HOLES & TO BE SAND BLASTED.
3. ALL UNMACHINED SURFACES TO BE SMOOTH IN THE CASTING MAINTAINING THE DIMENSIONS.
4. ALL DIMENSIONS MENTIONED ARE FINISHED SIZE M/C. ALLOWANCE TO BE 5 TO 10mm ON EACH SURFACE.

MATL.- CAST STEEL - IS:1030, Gr- 230 - 450N

2	01	CAST STEEL	IS:3030	SUPPORT ROLL (FOR SPROCKET)		50.08	100.16	230-450N	
QTY.	ITEM NO.	MATERIAL	IS & DIN Std.	DESCRIPTION			Each	Total	REMARKS
							WEIGHT (Kg.)		
Key Characteristics: -			Total Qty. 2	Material CAST STEEL	Heat Treatment -			Hardness -	
Client :- BHEL				Job No. :- 000135/11-12					
Drawn By / Date		EW / 31-12-2011		Format/Sh. Size	Equi.				
Chkd. By / Date		RAJESH / 17-02-12		CAD/A3	ROLLER TABLE-2				
Appr. By / Date		B.M.T / 17-02-12							
 P.P. Rolling Mills Mfg. Co. Pvt. Ltd. Plot No. I-42, DLF IInd Area, Phase-I, Faridabad (Haryana) Phone +91 -11 - 26836340, 26848885, 26313774 Fax. +91-11-26836335, website:www.pprm.in				Scale 1:2	Title.				
				DETAIL OF SUPPORT ROLL (FOR SPROCKET)					
					Drawing No.:- 4174-07			Sheet	Revision
					Plot Date :- 27-02-2012			1 OF 1	0

Machinist's Note:-

- 01) Remove the sharp corner & edges with 1mm. chamfered & shaft fillets to be 1mm. radius unless otherwise specified.
- 02) All dimension are in millimeter (mm.) unless otherwise specified

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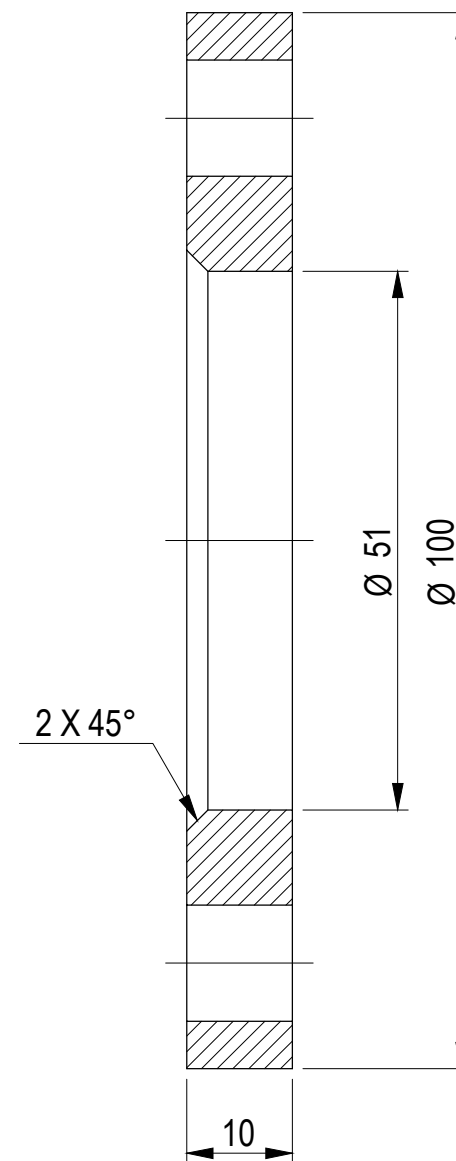
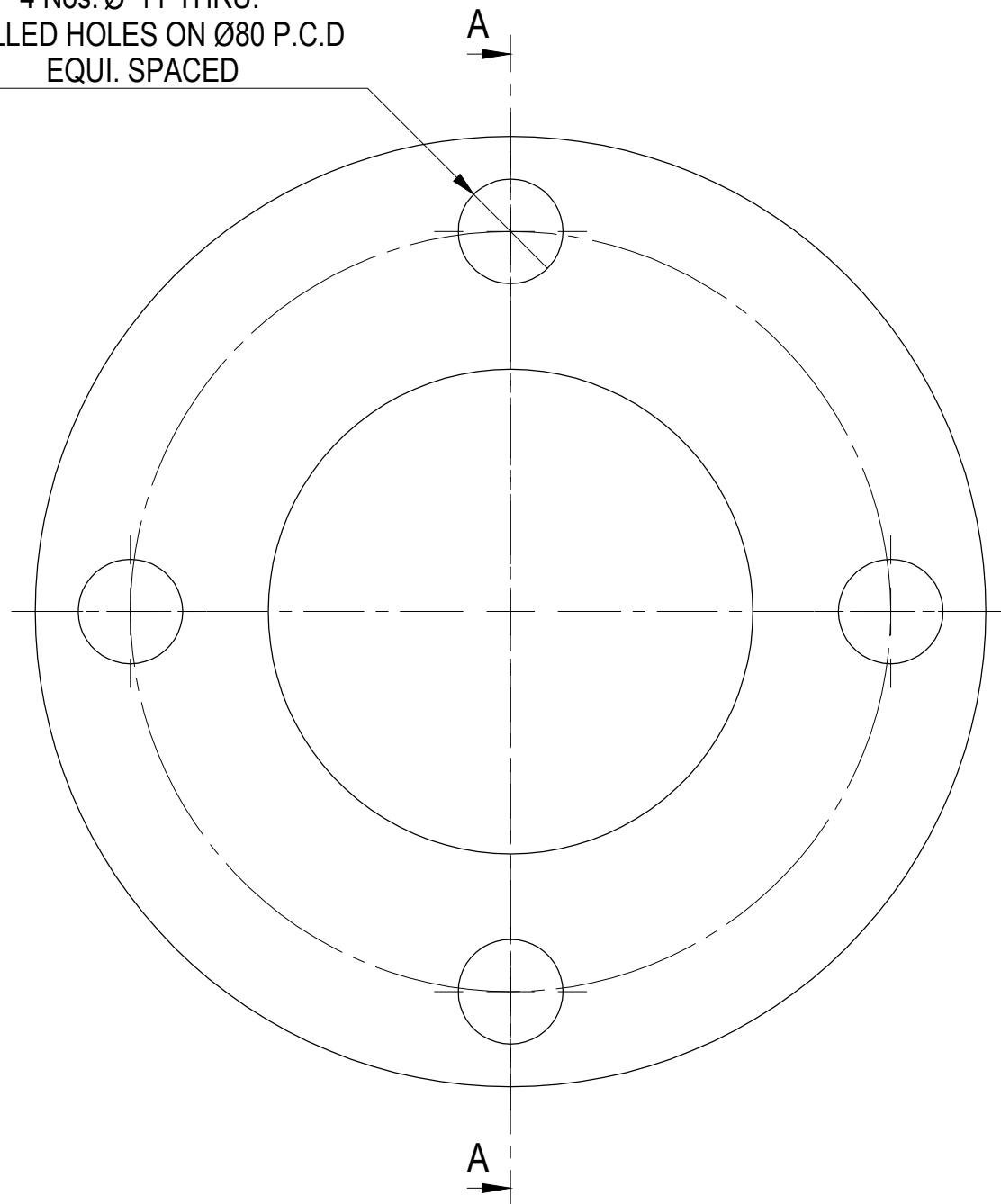
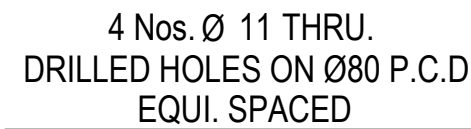
All dimensions are in Millimeters unless otherwise stated. Do not Scale.
In doubt, please ask.

SURFACE FINISH										
SYMBOL										
Ra u	25	12.5	6.3	3.2	1.6	0.8	0.4	0.2	0.1	

Untoleranced dimensions should confirm to IS:2102 (Part1):1993 Medium.

Permissible deviations for Linear dimensions (medium):									for Angular dimensions (medium):				
over (mm)	-	6	30	120	400	1000	2000	4000	over (mm)	1	6	30	120
up to (mm)	6	30	120	400	1000	2000	4000	-	up to (mm)	6	30	120	400
value (mm)	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	±3.0	value (Deg)	±6'	±10'	±20'	±30'

Please Do Not Scale. If in Doubt, ASK.



SECTION A-A

Machinist's Note:-

01) Remove the sharp corner & edges with 1mm. chamfered & shaft fillets to be 1mm. radius unless otherwise specified.

02) All dimension are in millimeter (mm.) unless otherwise specified.

SMS REF. No.- 0301512-00.101_08
BHEL REF. No.-1-7-0123.99-08016

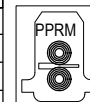
All dimensions are in Millimeters unless otherwise stated.
Do not Scale. If in doubt, please ask.

SURFACE FINISH										
SYMBOL	 25	 12.5	 6.3	 3.2	 1.6	 0.8	 0.4	 0.2	 0.1	
Ra u	25	12.5	6.3	3.2	1.6	0.8	0.4	0.2	0.1	

Untoleranced dimensions should confirm to IS:2102 (Part1):1993 Medium.

Permissible deviations for Linear dimensions (medium):								
over (mm)	-	6	30	120	400	1000	2000	4000
up to (mm)	6	30	120	400	1000	2000	4000	-
value (mm)	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	±3.0

for Angular dimensions(medium):				
over (mm)	1	6	30	120
up to (mm)	6	30	120	400
value (Deg)	±6'	±10'	±20'	±30'



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Fax. +91-11-26836335, website:www.pporm.in

Scale	
-------	--

1.1

Equipment

ROLLER TABLE

Title.	
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DETAIL OF ROLL LOCK PLATE

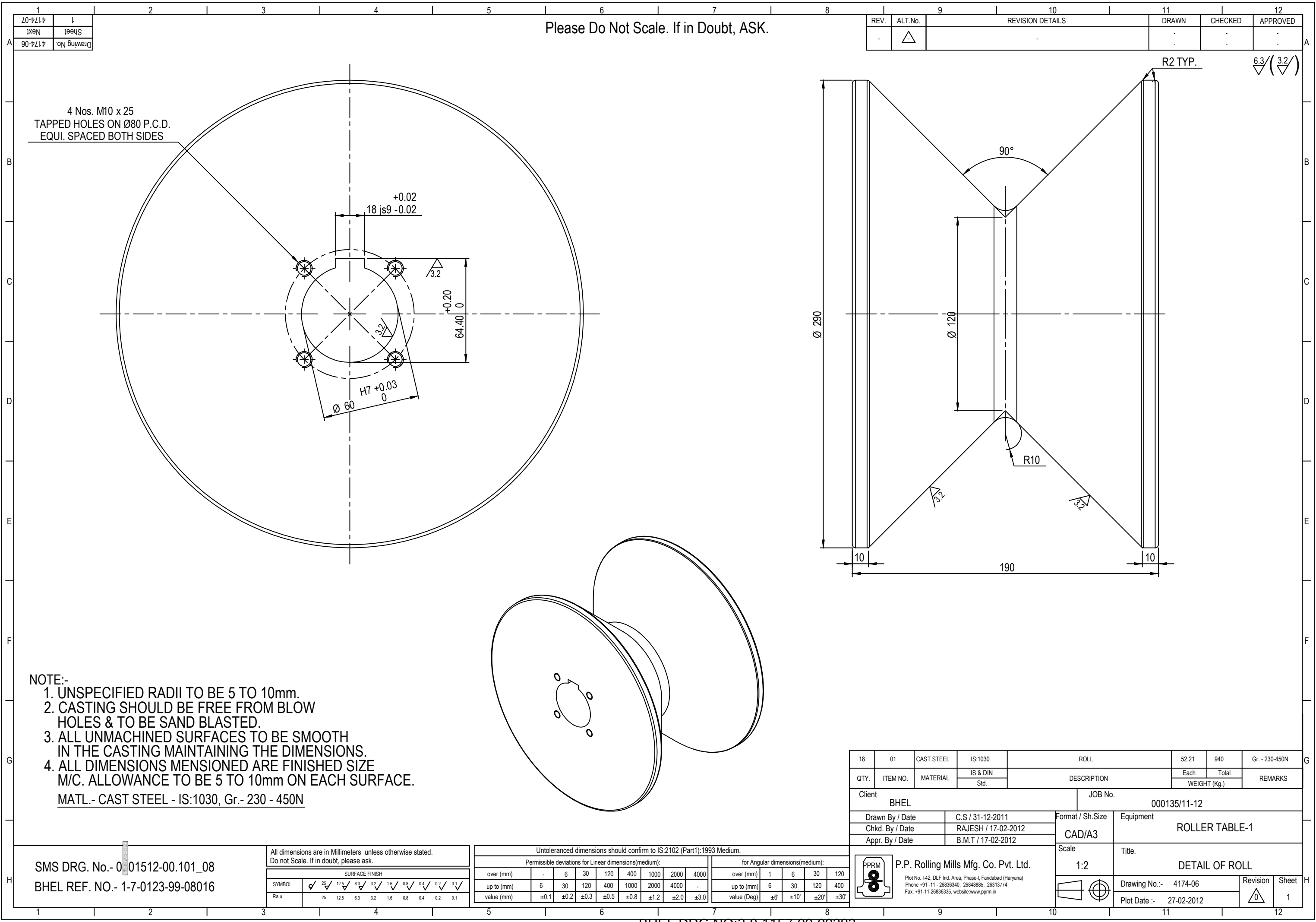
Drawing No.:- 4174-53

Plot Date :- 27-02-2012

Revision Δ

eet	H
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BHEL DRG NO:3-9-1157-00-00288



Please Do Not Scale. If in Doubt, ASK.

REV.	ALT.No.	REVISION DETAILS	DRAWN	CHECKED	APPROVED
-		-	-	-	-

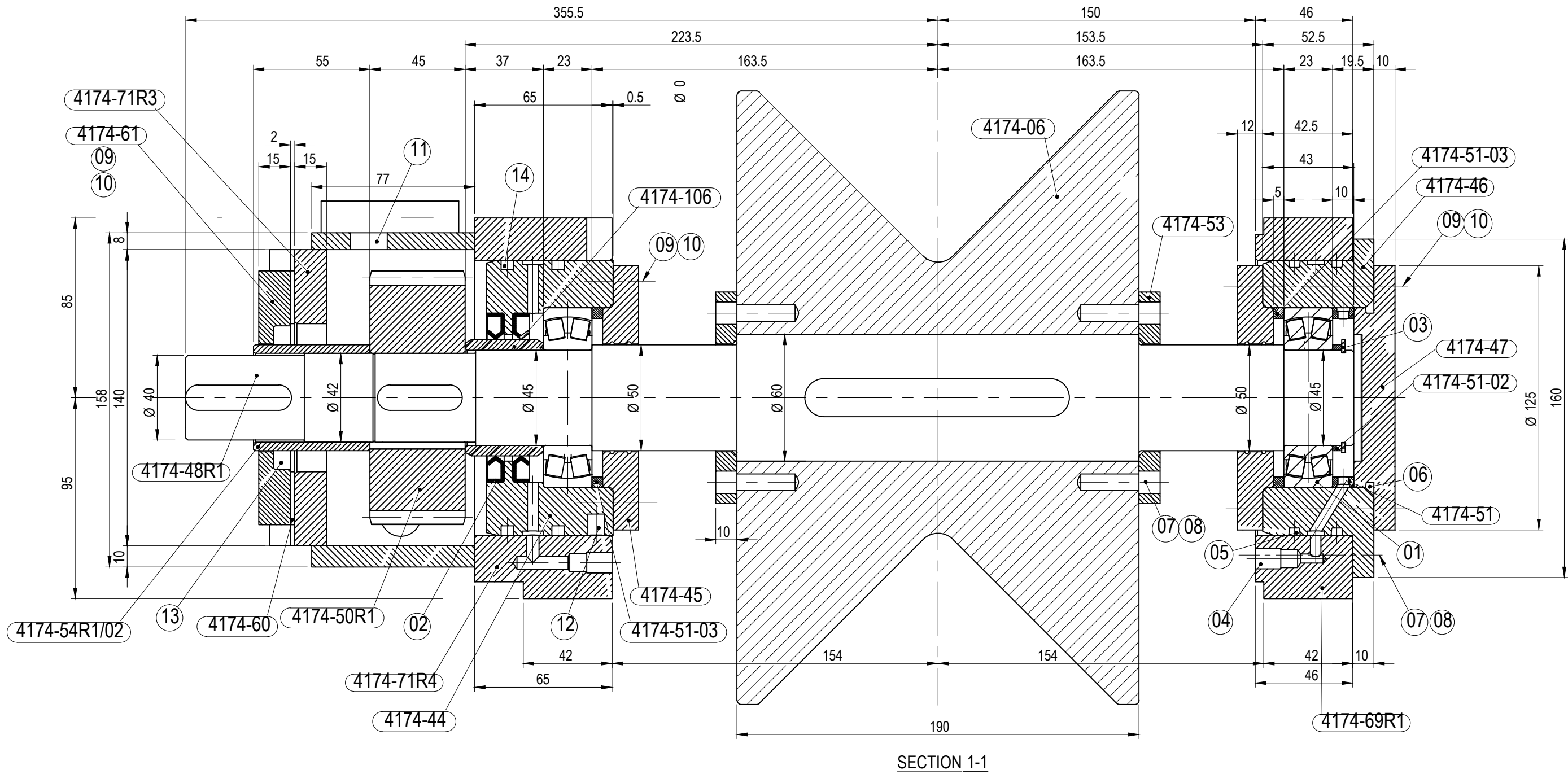
18	01	CAST STEEL	IS:1030	ROLL	52.21	940	Gr. - 230-450N
QTY.	ITEM NO.	MATERIAL	IS & DIN Std.	DESCRIPTION	Each	Total	REMARKS
Client BHEL				JOB No. 000135/11-12	WEIGHT (Kg.)		
Drawn By / Date C.S / 31-12-2011				Format / Sh.Size CAD/A3	Equipment ROLLER TABLE-1		
Chkd. By / Date RAJESH / 17-02-2012				Scale 1:2	Title. DETAIL OF ROLL		
Appr. By / Date B.M.T / 17-02-2012					Drawing No.- 4174-06		
P.P. Rolling Mills Mfg. Co. Pvt. Ltd. Plot No. I-42, DLF Ind. Area, Phase-I, Faridabad (Haryana) Phone +91-11-26836340, 26848885, 26313774 Fax. +91-11-26836335, website:www.pprm.in				Plot Date :- 27-02-2012			Revision
							Sheet 1

SMS DRG. No.- 001512-00.101_08
BHEL REF. NO.- 1-7-0123-99-08016

All dimensions are in Millimeters unless otherwise stated. Do not Scale. If in doubt, please ask.	
SURFACE FINISH	
SYMBOL	
Ra u	25 12.5 6.3 3.2 1.6 0.8 0.4 0.2 0.1

Untoleranced dimensions should conform to IS:2102 (Part1):1993 Medium.															
Permissible deviations for Linear dimensions (medium):								for Angular dimensions (medium):							
over (mm)	-	6	30	120	400	1000	2000	4000	over (mm)	1	6	30	120	400	
up to (mm)	6	30	120	400	1000	2000	4000	-	up to (mm)	6	30	120	400		
value (mm)	± 0.1	± 0.2	± 0.3	± 0.5	± 0.8	± 1.2	± 2.0	± 3.0	value (Deg)	$\pm 6^\circ$	$\pm 10^\circ$	$\pm 20^\circ$	$\pm 30^\circ$		

Please Do Not Scale. If in Doubt, ASK.



1	15	-	-	AIR BREATHER G1-1/2"			
12	14	-	-	O' RING Ø 121x6			
2	13	-	IS:5129	OIL SEAL Ø 50xØ 68x8			SPAREAGE
6	12	-	IS:2293	DOWEL PIN Ø 8x20			
10	11	-	H-T	PLUG M20			VSTI-M
80	10	-	IS:3063	SPRING WASHER M8			
80	09	HTS	IS:1364	HEX. HD. SCREW M8x25			Gr 8.8
72	08	-	IS:3063	SPRING WASHER M10			
72	07	HTS	IS:1364	HEX. HD. SCREW M10x30			Gr 8.8
6	06	-	-	O' RING Ø 80x3			
12	05	-	-	O' RING Ø 123x4			
12	04	-	IS:4009	GREASE NIPPLE 1/8" BSP			
6	03	-	IS:3075	CIRCLIP TYPE-A, Ø 45			
12	02	-	IS:5129	OIL SEAL Ø 55xØ 80x8			SPAREAGE
12	01	-	-	SPHERICAL ROLLER BRG. 22209			
QTY.	ITEM NO.	MATERIAL	IS & DIN Std.	DESCRIPTION	Each	Total	
					WEIGHT (Kg)		
Client Name :- BHEL				Job No. :- 000135/11-12			
Drawn By / Date				Format/Sh. Size	Equi.		
Chkd. By / Date				CAD/A2	ROLLER TABLE-2		
Appr. By / Date				Scale	Title.		
				1:2	DETAIL OF ROLL ASSY. - 2		
					Drawing No. :-	4174-05	Sheet
					Plot Date :-	9/29/2012	Revision
						2 OF 2	1

All dimensions are in Millimeters unless otherwise stated. Do not Scale. In doubt, please ask.									
SURFACE FINISH									
SYMBOL	✓ 25	✓ 12.5	✓ 6.3	✓ 3.2	✓ 1.6	✓ 0.8	✓ 0.4	✓ 0.2	✓ 0.1
Ra u	25	12.5	6.3	3.2	1.6	0.8	0.4	0.2	0.1

Untoleranced dimensions should conform to IS:2102 (Part1):1993 Medium.									
Permissible deviations for Linear dimensions (medium):									
over (mm)	-	6	30	120	400	1000	2000	4000	
up to (mm)	6	30	120	400	1000	2000	4000	-	
value (mm)	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	±3.0	
for Angular dimensions (medium):									
over (mm)	1	6	30	120					
up to (mm)	6	30	120	400					
value (Deg)	±6'	±10'	±20'	±30'					

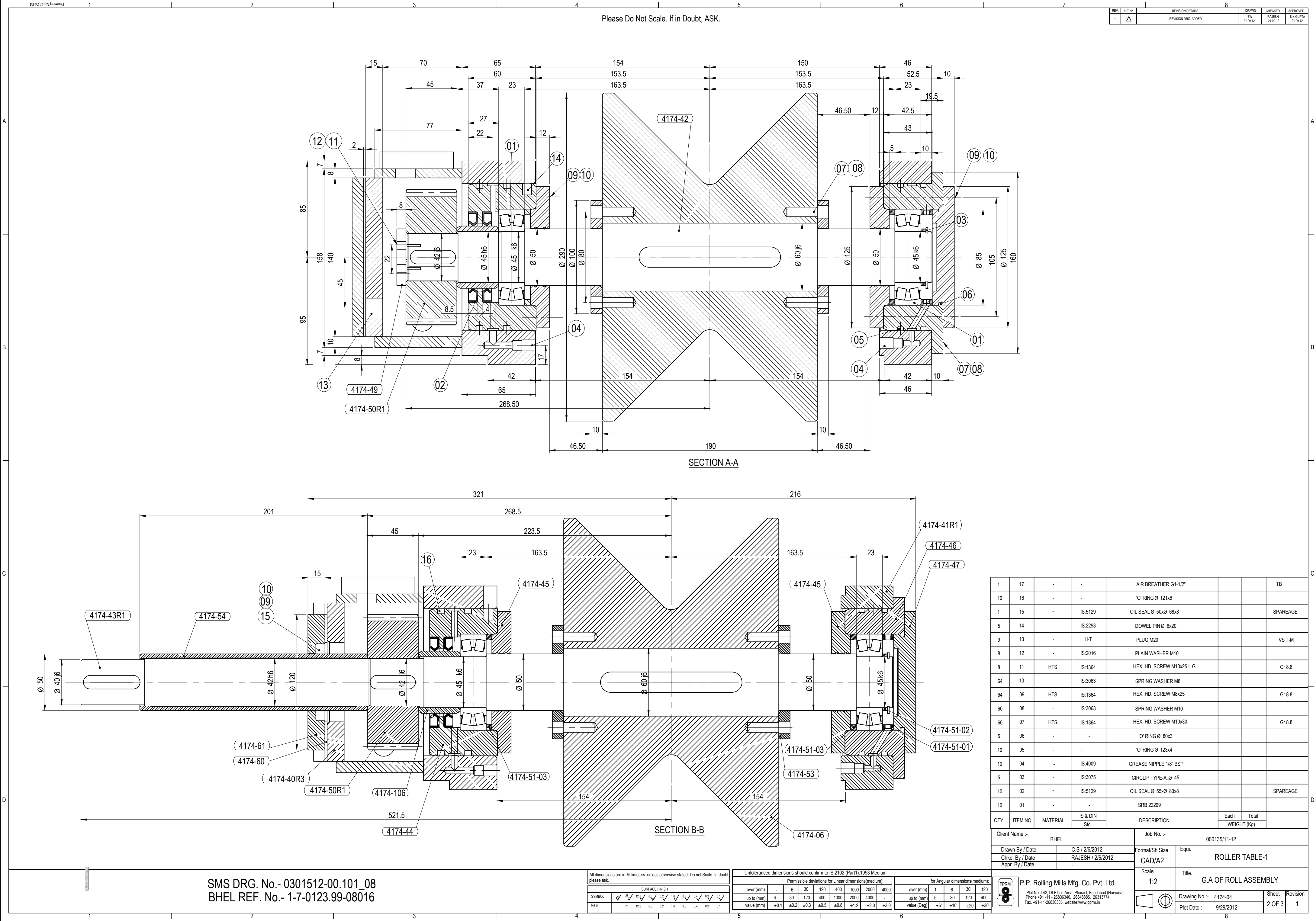
PPRM

P.P. Rolling Mills Mfg. Co. Pvt. Ltd.

Plot No. 142, DLF Ind Area, Phase-I, Faridabad (Haryana)

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Please Do Not Scale. If in Doubt, ASK.

REV	ALT NO.	REVISION DETAILS	DRAWN	CHECKED	APPROVED
1	Δ	REVISION DRG. ADDED	SW	RAJESH	S.K GUPTA
			21.08.12	21.08.12	21.08.12

1	17	-	-	AIR BREATHER G1-1/2"			TB
10	16	-	-	O' RING Ø 121x6			
1	15	-	IS:5129	OIL SEAL Ø 50xØ 68x8			SPAREAGE
5	14	-	IS:2293	DOWEL PIN Ø 8x20			
9	13	-	H-T	PLUG M20			VSTI-M
8	12	-	IS:2016	PLAIN WASHER M10			
8	11	HTS	IS:1364	HEX. HD. SCREW M10x25 L.G			Gr 8.8
64	10	-	IS:3063	SPRING WASHER M8			
64	09	HTS	IS:1364	HEX. HD. SCREW M8x25			Gr 8.8
60	08	-	IS:3063	SPRING WASHER M10			
60	07	HTS	IS:1364	HEX. HD. SCREW M10x30			Gr 8.8
5	06	-	-	O' RING Ø 80x3			
10	05	-	-	O' RING Ø 123x4			
10	04	-	IS:4009	GREASE NIPPLE 1/8" BSP			
5	03	-	IS:3075	CIRCLIP TYPE-A, Ø 45			
10	02	-	IS:5129	OIL SEAL Ø 55xØ 80x8			SPAREAGE
10	01	-	-	SRB 22209			
QTY.	ITEM NO.	MATERIAL	IS & DIN Std.	DESCRIPTION	Each	Total	
					WEIGHT (Kg)		
Client Name :- BHEL				Job No. :-	000135/11-12		
Drawn By / Date C.S / 2/6/2012				Format/Sh. Size	Equi.		
Chkd. By / Date RAJESH / 2/6/2012				CAD/A2	ROLLER TABLE-1		
Appr. By / Date -				Scale	Title		
				1:2	G.A OF ROLL ASSEMBLY		
					Drawing No. :-	4174-04	Sheet
					Plot Date :-	9/29/2012	Revision
						2 OF 3	1

SMS DRG. No.- 0301512-00.101_08
BHEL REF. No.- 1-7-0123.99-08016

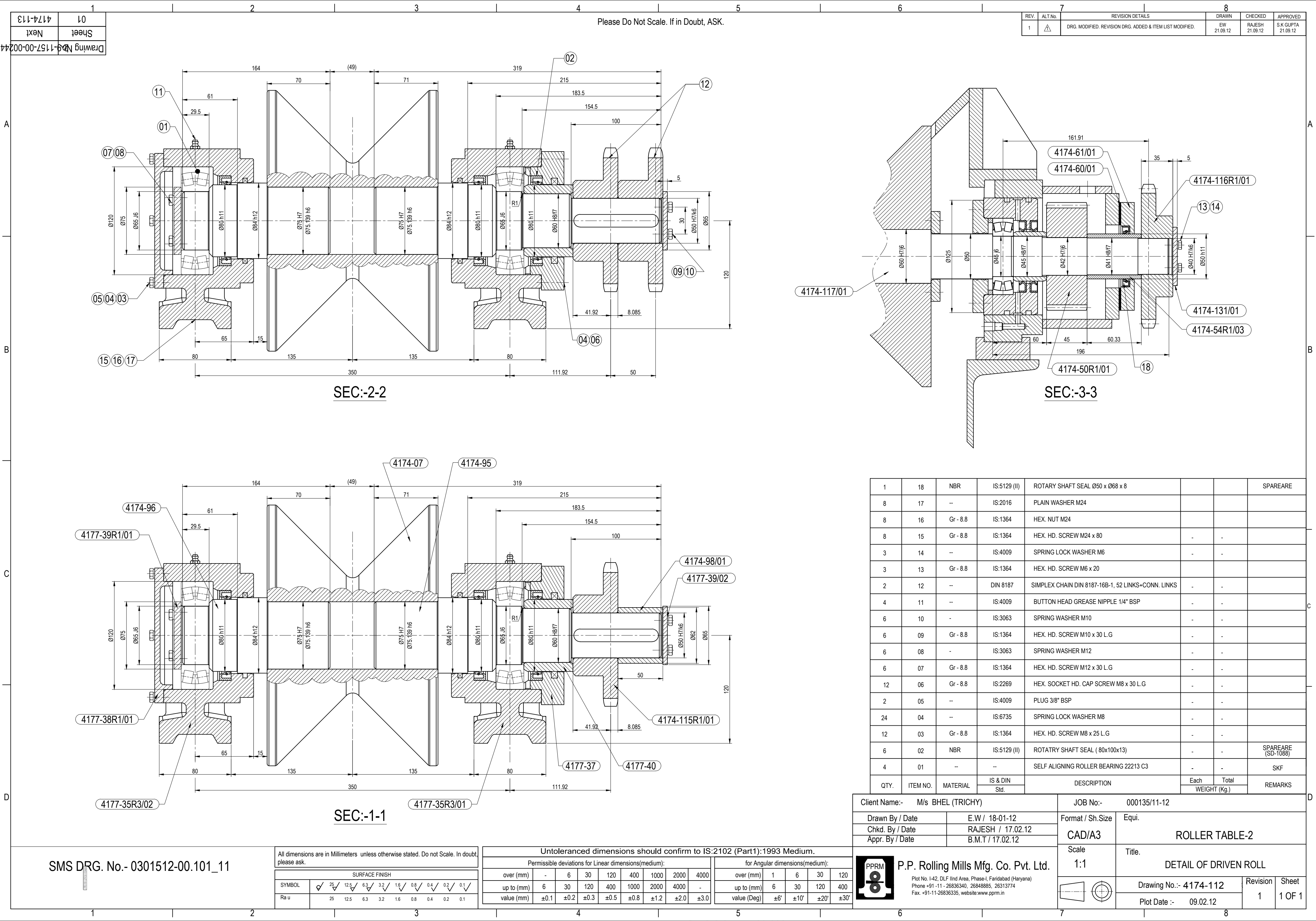
SURFACE FINISH									
SYMBOL	✓ 25	✓ 12.5	✓ 6.3	✓ 3.2	✓ 1.6	✓ 0.8	✓ 0.4	✓ 0.2	✓ 0.1
Ra u	25	12.5	6.3	3.2	1.6	0.8	0.4	0.2	0.1

Permissible deviations for Linear dimensions (medium)									
over (mm)	-	6	30	120	400	1000	2000	4000	
up to (mm)	6	30	120	400	1000	2000	4000	-	
value (mm)	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	±3.0	

for Angular dimensions (medium):				
over (mm)	1	6	30	120
up to (mm)	6	30	120	400
value (Deg)	±6'	±10'	±20'	±30'

Plot No. I-42, DLF Ind Area, Phase-I, Faridabad (Haryana)
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Fax +91-11-26836335, website www.pgm.in

P.P. Rolling Mills Mfg. Co. Pvt. Ltd.
Scale 1:2
Title G.A OF ROLL ASSEMBLY
Drawing No. :- 4174-04
Plot Date :- 9/29/2012
Sheet 2 OF 3
Revision 1



1

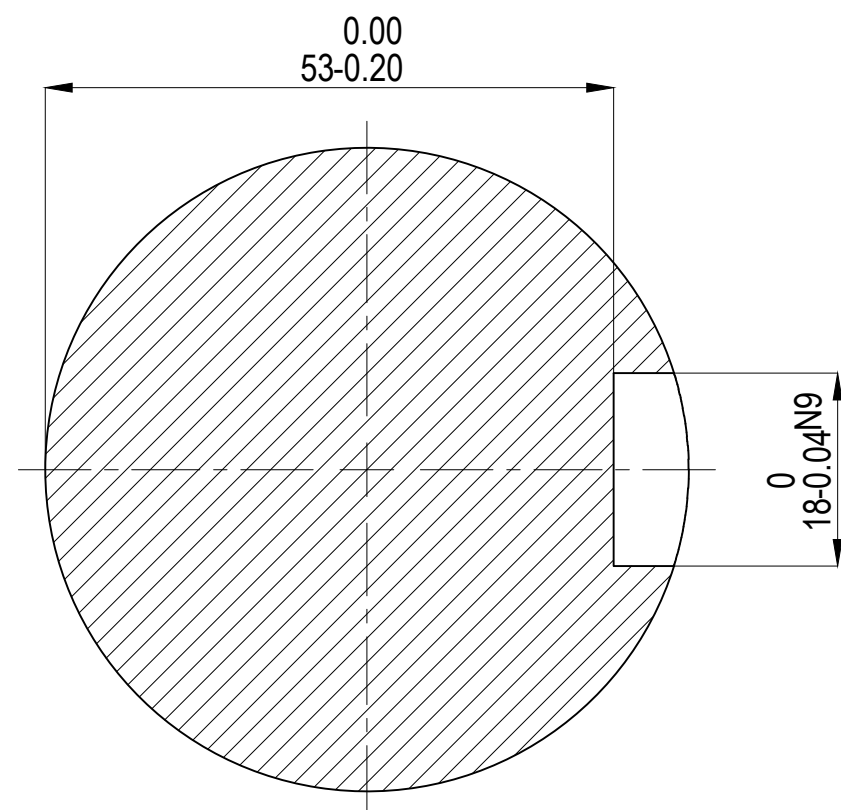
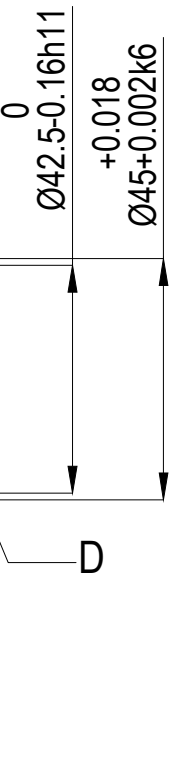
H
$$\frac{3.2}{\nabla} \left(\frac{1.6}{\nabla} \right)$$


4

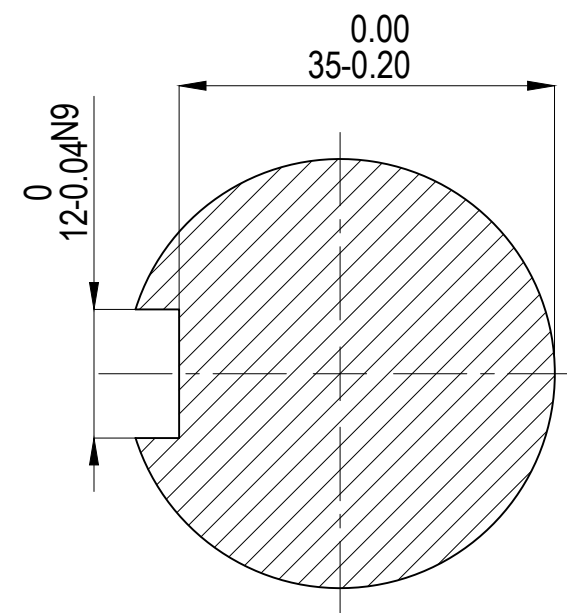
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BHEL DRG NO:2-9-1157-00-00233

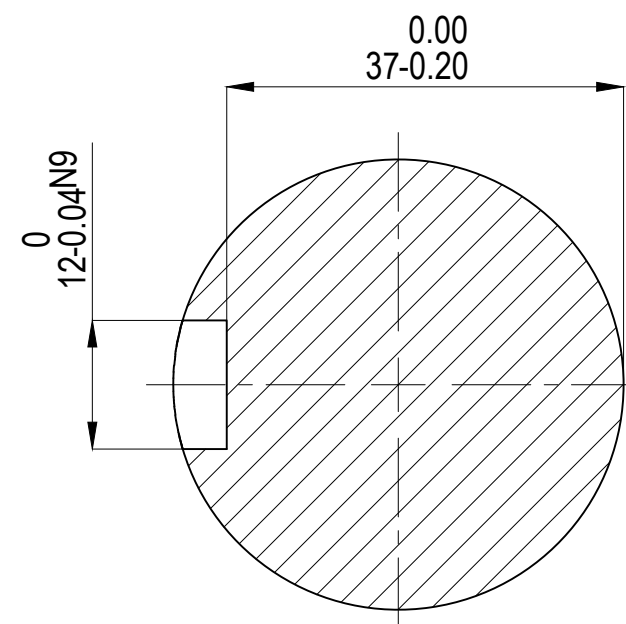
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H
$$\frac{3.2}{\nabla} \left(\frac{1.6}{\nabla} \right)$$


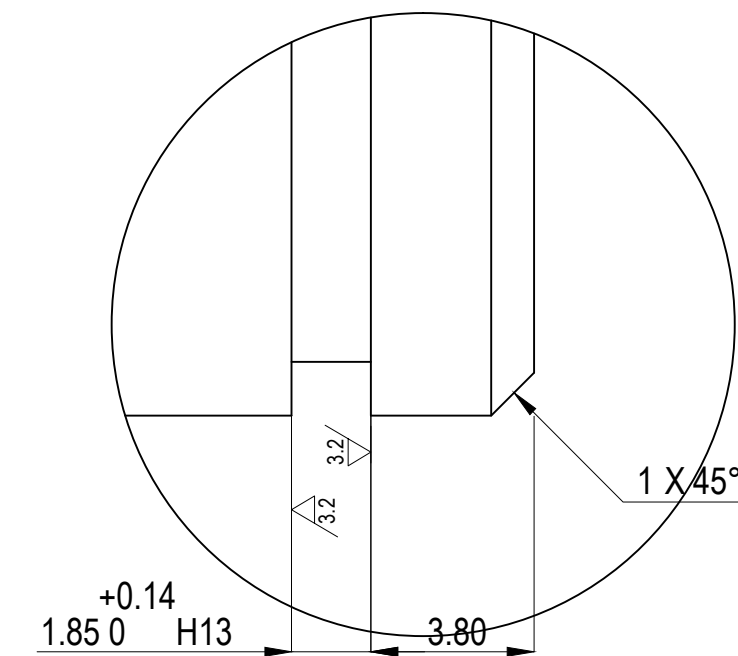
SECTION A-A
SCALE 1 : 1



SECTION B-B
SCALE 1 : 1

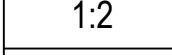


SECTION C-C
SCALE 1 : 1



DETAIL D
SCALE 4 : 1

1	04	40C8	IS:1570-II	KEY 18x11x125 L.G	0.2	0.2	
1	03	40C8	IS:1570-II	KEY 12x8x50 L.G	0.04	0.04	
1	02	40C8	IS:1570-II	KEY 12x8x40 L.G	0.03	0.03	
1	01	45 C8	IS:1875	DRIVE SHAFT	10.45	10.49	
QTY.	ITEM NO.	MATERIAL	IS & DIN Std.	DESCRIPTION	Each	Total	REMARKS
					WEIGHT (Kg.)		

Client		BHEL		JOB No.		000135/11-12		
Drawn By / Date		C.S / 1/10/2012		Format / Sh.Size	Equipment			
Chkd. By / Date		RAJESH / 2/17/2012			ROLLER TABLE-1			
Appr. By / Date		B.M.T / 2/17/2012			CAD/A3			
 P.P. Rolling Mills Mfg. Co. Pvt. Ltd. Plot No. I-42, DLF Ind. Area, Phase-I, Faridabad (Haryana) Phone +91 -11 - 26836340, 26848885, 26313774 Fax. +91-11-26836335, website www.pprm.in				Scale		Title.		
				1:2		DETAIL OF DRIVE SHAFT		
						Drawing No.:- 4174-43		Revision
Plot Date :- 9/29/2012								
						1		

Machinist's Note:-

01) Remove the sharp corner & edges with 1mm. chamfered & shaft fillets to be 1mm. radius unless otherwise specified.

02) All dimension are in millimeter (mm.) unless otherwise specified.

SMS DRG. No.- 0301512-00.101_07

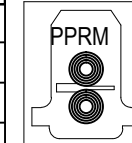
BHEL REF. No.- 1-7-0123.99-08015

All dimensions are in Millimeters unless otherwise stated.
Do not Scale. If in doubt, please ask.

SURFACE FINISH										
SYMBOL										
Ra u	25	12.5	6.3	3.2	1.6	0.8	0.4	0.2	0.1	

Untoleranced dimensions should confirm to IS:2102 (Part1):1993 Medium.

Permissible deviations for Linear dimensions(medium):									for Angular dimensions(medium):				
over (mm)	-	6	30	120	400	1000	2000	4000	over (mm)	1	6	30	120
up to (mm)	6	30	120	400	1000	2000	4000	-	up to (mm)	6	30	120	400
value (mm)	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	±3.0	value (Deg)	±6'	±10'	±20'	±30'



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Phone +91 -11 - 26836340, 26848885, 26313774
Fax. +91-11-26836335, website:www.pprm.in

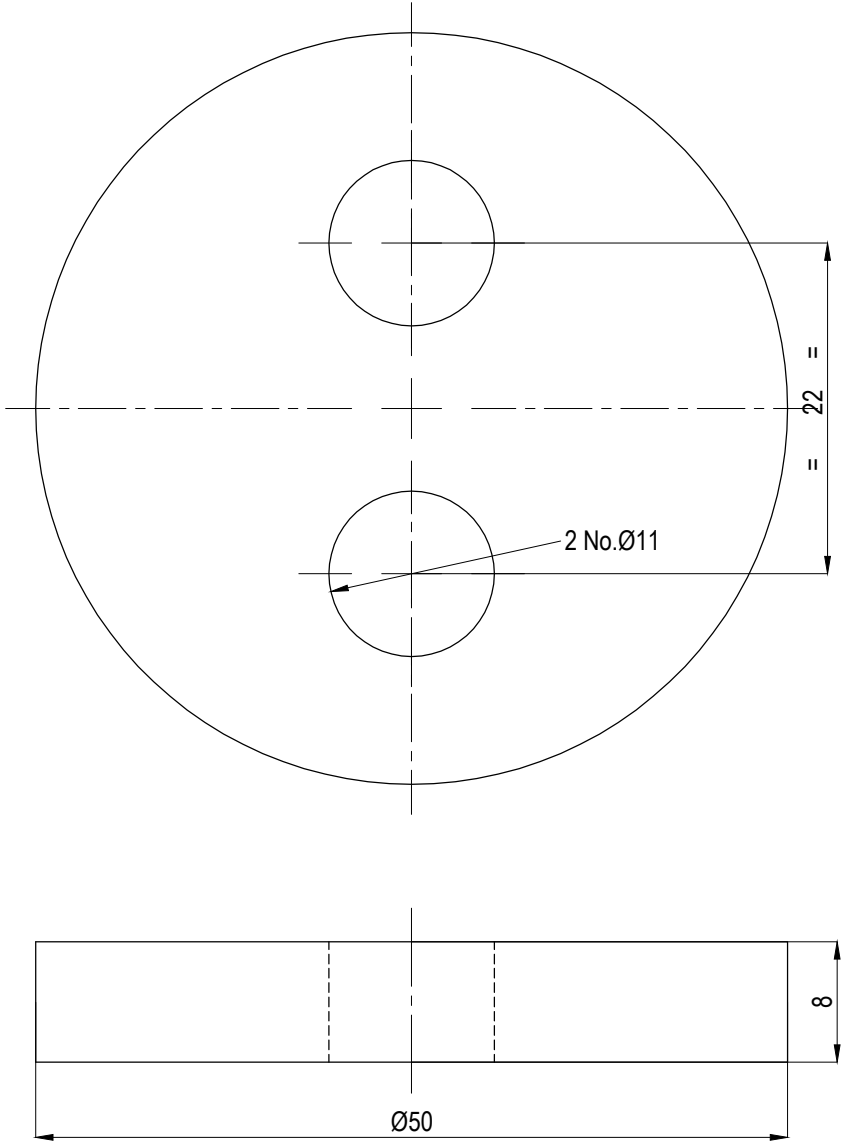
BHEL DRG NO:2-9-1157-00-00231

05-74119	1
Next	Sheet
Drawing No.	4174-49
Rev.	01

Please Do Not Scale. If in Doubt, ASK.

REV.	ALT.No.	REVISION DETAILS	DRAWN	CHECKED	APPROVED
-	△	-	-	-	-

6.3/



BHEL DRG NO:4-9-1157-00-00315

All dimensions are in Millimeters unless otherwise stated.
Do not Scale. If in doubt, please ask.

SYMBOL	SURFACE FINISH
✓	12.5
✓	6.3
✓	3.2
✓	1.6
✓	0.8
✓	0.4
✓	0.2
✓	0.1

Permissible deviations for Linear dimensions (medium):		for Angular dimensions (medium):	
over (mm)	-	over (mm)	1
up to (mm)	6	up to (mm)	6
value (mm)	±0.1	value (Deg)	±10'
	±0.2		±20'
	±0.3		±30'
	±0.5		±40'
	±0.8		±50'
	±1.2		±60'
	±2.0		±70'
	±3.0		±80'

4	01	E25/A	IS-2062	GEAR LOCK PLATE	0.11	0.44	-
QTY.	ITEM NO.	MATERIAL	IS & DIN	DESCRIPTION	Each	Total	REMARKS
Client				BHEL (TRICHY)			
Drawn By / Date				EW / 25-01-2012			
Checked By / Date				RAJESH / 16-02-2012			
Appr. By / Date				B.M.T / 17-02-2012			
Formal / Sh. Size				CAD/A4			
Title				DETAIL OF GEAR LOCK PLATE			
Drawing No.:-				4174-49			
Pld Date :-				27-02-2012			
Revision				Sheet			
1				1			



P.P. Rolling Mills Mfg. Co. Pvt. Ltd.
Plot No. 142, D-2 First Stage, Phase-I, Pochampalli (Hyderabad)
Pin - 501115 (08003055, info@ppm.com)



Scale: 2:1
Job No: 000135/11-12
Equipment: ROLLER TABLE-1