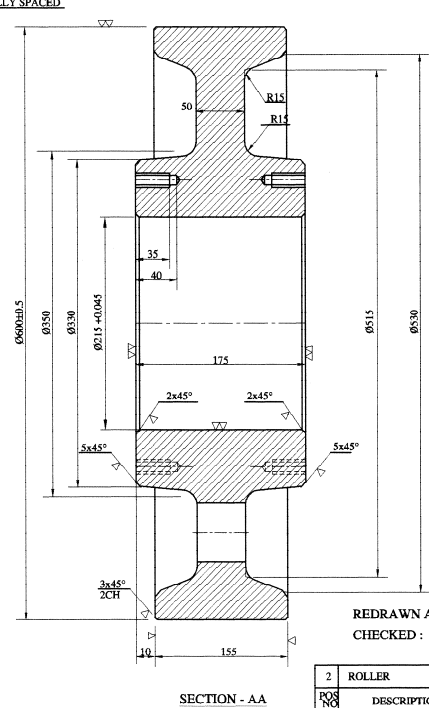
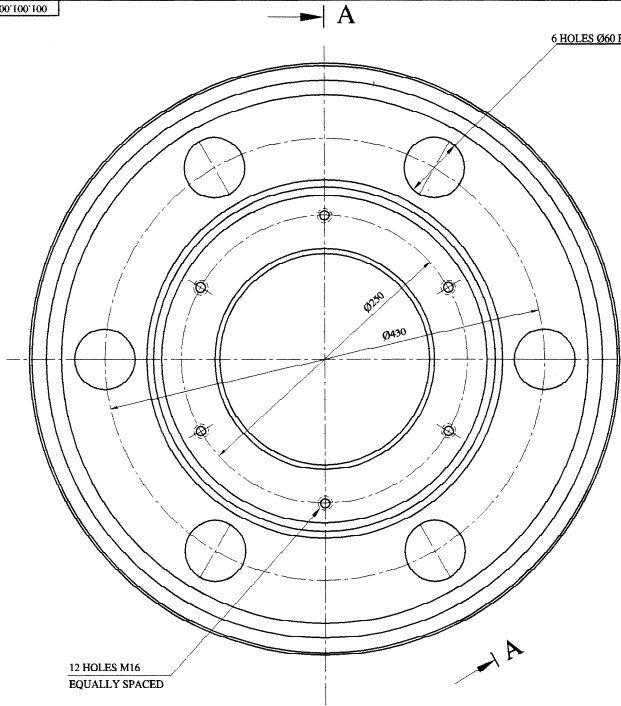


V900'00 100'100

FOR THE REST



AGREED TO REVISION 'A'

Sd/- Dated 25.08.06
(RAMAN)
DGM(M)/HRCF

REDRAWN AFTER REVISION: M. P. LAKRA
CHECKED: S.K. BHATTACHARYA.

SECTION - AA

NOTES:

REF. DOCUMENT :- H.E.C. (H.M.B.) NO. 1507-27-511
THIS DRAWING IS TRACED FROM BSL ARCH.NO. CO-H/1559

TECHNICAL INSTRUCTIONS

1. FREE TOLERANCES TO BE TAKEN AS PER MEDIUM CLASS OF IS:2102-93.
4. ITEM TO BE TESTED ULTRASONICALLY TO QUALITY LEVEL 2 OF BHEL STD.FF.NDT.001(PLD INS-46-001)
5. OVALITY AND TAPER OF SURFACE ON Ø215±0.045 SHOULD NOT EXCEED 0.02mm.
6. THE SURFACE OF Ø660±0.5 SHOULD BE SORBITISED TO HB 300-320, DEPTH OF HARDNESS TO BE 8-10mm.

REVISION A

1. CAST DESIGN HAS BEEN CHANGED TO FORGED DESIGN IN AGREEMENT WITH INDENTING SHOP IN VIEW OF INCREASED WAGON LOAD BY RAILWAYS
2. MACHINING AND TOLERANCES INDICATED AS PER INDIAN STANDARDS.

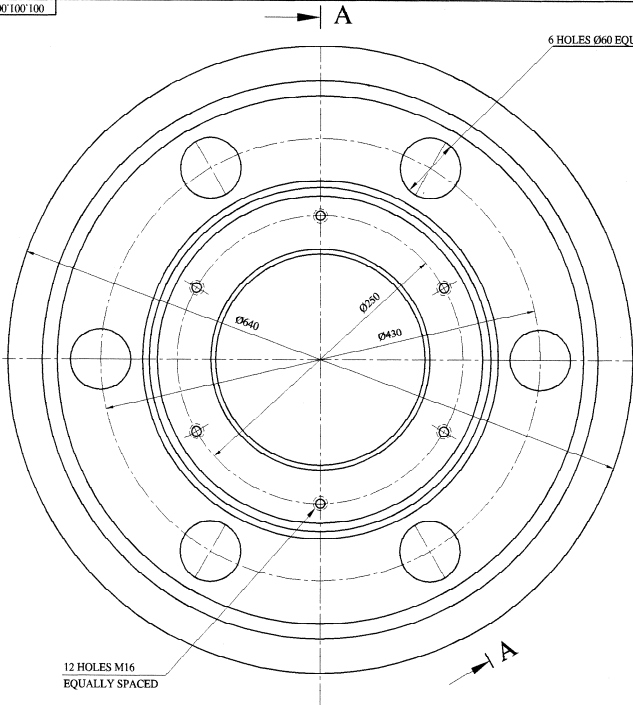
2	ROLLER	4	165	55C8	HMB 1507	001.001
POS NO	DESCRIPTION	QTY	UNIT	MATERIAL	G.ASSLY DRG. NO.	SC. DRG. NO

BOKARO STEEL PLANT	
SHOP	COKE-OVENS
UNIT	WAGON TIPLER DPR NO. 001.001
DESCRIPTION OF DRAWING	DETAIL OF MIDDLE ROLLER SUPPORT (INSTALLED IN THE TIPLING MECHANISM)
DRAWN	DATE
CHECKED	M.SINGARIAH
TRACED	B.MANDAL
SUBMITTED	
APPROVED	
001.001 00.006A	



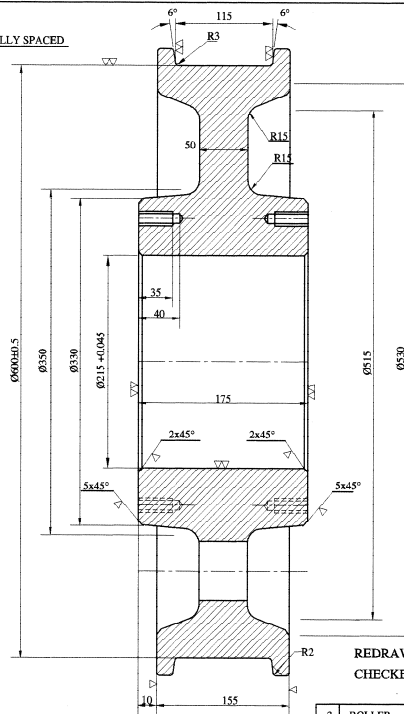
MPL226

1:1



12 HOLES M16
EQUALLY SPACED

6 HOLES Ø60 EQUALLY SPACED



SECTION - AA

FOR THE REST

AGREED TO REVISION 'A'

Sd/- Dated 25.08.06
(RAMAN)
DGM(M)/HRCF

REDRAWN AFTER REVISION: M. P.LAKRA
CHECKED: S.K.BHATTACHARYA.

NOTES:

REF. DOCUMENT :- H.E.C. (H.M.B.) NO. 1507-27-496
THIS DRAWING IS TRACED FROM BSL ARCH.NO. CO-H/1557.

REVISION A

1. CAST DESIGN HAS BEEN CHANGED TO FORGED DESIGN IN AGREEMENT WITH INDENTING SHOP IN VIEW OF INCREASED WAGON LOAD BY RAILWAYS.
2. MACHINING AND TOLERANCES INDICATED AS PER INDIAN STANDARDS.

TECHNICAL INSTRUCTIONS

1. FREE TOLERANCES TO BE TAKEN AS PER MEDIUM CLASS OF IS:2102-93.
4. ITEM TO BE TESTED ULTRASONICALLY TO QUALITY LEVEL 2 OF BHSL STD.FF.NDT.001(PLD INS-46-001)
5. OVALITY AND TAPER OF SURFACE ON Ø215±0.045 SHOULD NOT EXCEED 0.02mm.
6. SURFACE OF Ø600±0.5 & INSIDE SURFACE OF FLANGE TO BE SORBTTISED TO HB 300-320, DEPTH OF HARDNESS TO BE 8-10mm.

2	ROLLER	4	185	55C8	HMB 1507	001.001
POS NO	DESCRIPTION	QTY	UNIT	MATERIAL	G.ASSLY	DRG. NO
		WT.KG			SC.	DRG. NO

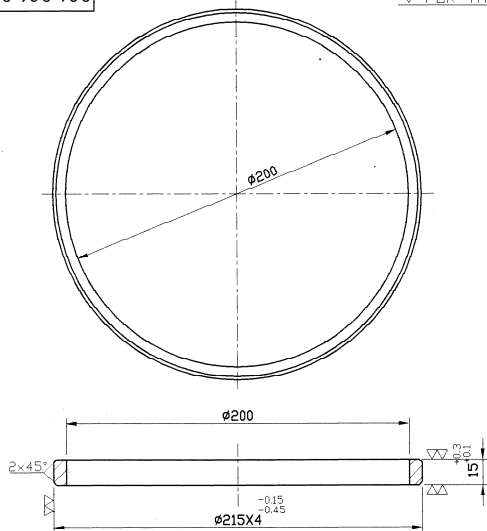
BOKARO STEEL PLANT					
SHOP COKE-OVENS					
UNIT WAGON TIPLER DPR NO. 001.001					
DESCRIPTION OF DRAWING DETAIL OF ROLLER SUPPORTS (END) (INSTALLED IN THE TIPLING MECHANISM)					
DRAWN		DATE		DATE	DEC'71
CHECKED	M.SINGARIAH	Sd/-		SCALE	1:2.5
TRACED	B.MANDAL				001.001
SUBMITTED					00.007A
APPROVED					



MPL225

001.001.00.033A

▽ FOR THE REST



REV. A

MATERIAL UPDATED

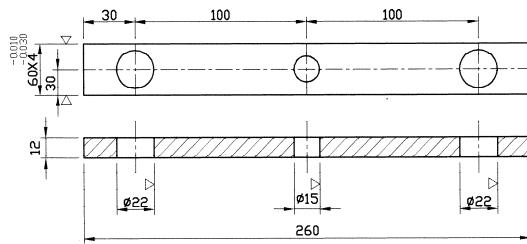
Sd.: -S.K. BHATTACHARYA
Dt. 18.11.05

DIGITISED FROM H.M.B. DRG.NO.-1507.27.507

NO	DESCRIPTION	QTY	UNIT WT.KG	MATERIAL	DRG. NO.	SC.	DRG. NO.
23	RING	4	0.4	Fe410WA IS:2062-92	001.001. 00.013B	1-2	001.001. 00.033A

001.001.00.034A

▽ FOR THE REST



REV. A

MATERIAL UPDATED

Sd.: -S.K. BHATTACHARYA
Dt. 22.11.05

DIGITISED FROM H.M.B. DRG.NO.-1507.02.134

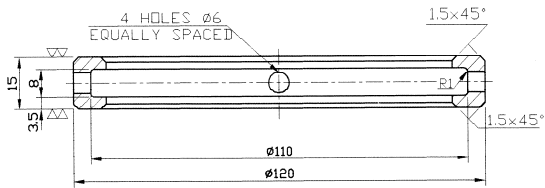
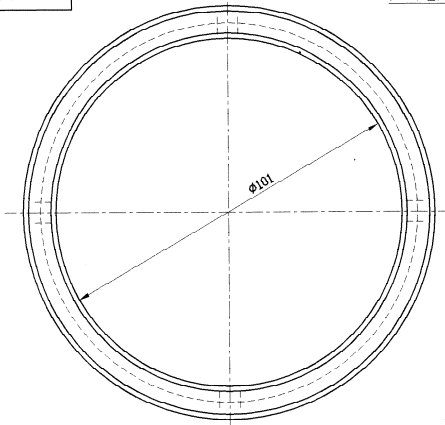
NO	DESCRIPTION	QTY	UNIT WT.KG	MATERIAL	DRG. NO.	SC.	DRG. NO.
20	AXLE LOCKING DEVICE	2	1.36	Fe410WA IS:2062-92	001.001. 00.013B	1-2	001.001. 00.034A

	BOKARO STEEL PLANT				
SHOP	COKE OVEN & BY PRODUCT PLANT				
UNIT	WAGON TIPPLER (D.P.R.NO.-001/001)				
DESCRIPTION OF DRAWING	DETAILS OF ROLLER SUPPORT (END)				
	DIGITISED	H.P. BHOGTA	<i>Bhoga</i>	DATE	NOV.2006
	CHECKED	S.K.B.	<i>S.K.B.</i>	JOB NO	11202
	SUBMITTED	N.K. JA			001.001.00.033A
	APPROVED	K.N. JHA			001.001.00.034A

HP695-A3

001.001.00.037A

▽ FOR THE REST



DIGITISED FROM H.M.B. DRG.NO.-1507.02.132

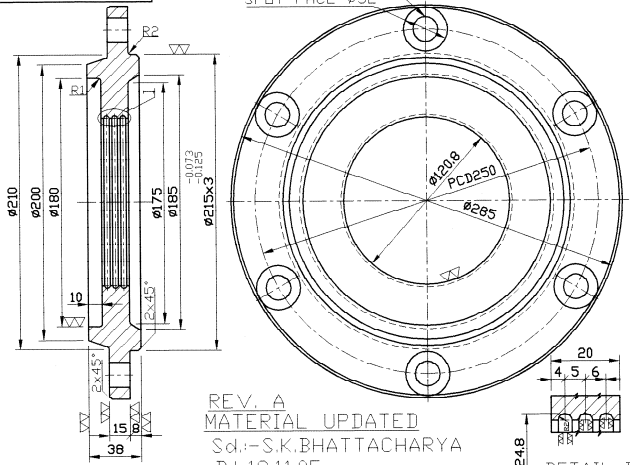
REV. A
 MATERIAL UPDATED
 Sd.: -S.K.BHATTACHARYA
 Dt.18.11.05

NO	DESCRIPTION	QTY	UNIT WT.KG.	MATERIAL	DRG. NO.	SC.	DRG. NO.
17	RING	4	0.3	Fe410WA IS:2062-92	001.001. 00.013B	1:1	001.001. 00.037A

001.001.00.038A

6 HOLES Ø18 EQUI. SPACED
 SPOT FACE Ø32

▽ FOR THE REST



REV. A
 MATERIAL UPDATED
 Sd.: -S.K.BHATTACHARYA
 Dt.18.11.05

DIGITISED FROM H.M.B. DRG.NO.-1507.27.514

DETAIL-1
 SCALE-NTS

NO	DESCRIPTION	QTY	UNIT WT.KG.	MATERIAL	DRG. NO.	SC.	DRG. NO.
12	COVER	8	10.75	Fe410WB IS:2062-92	001.001. 00.013B	1:2.5	001.001. 00.038B

	BOKARO STEEL PLANT			
SHOP	COKE OVEN & BY PRODUCT PLANT			
UNIT	WAGON TIPPLER (D.P.R.NO.-001/001)			
DESCRIPTION OF DRAWING	DETAILS OF ROLLER SUPPORT (END)			
DIGITISED	H.P.BHOGTA	<i>Bhagta</i>	DATE	NOV.2006
CHECKED	S.K.B.	<i>S.K.B.</i>	JOB NO	11202
SUBMITTED	N.K.JHA		001.001.00.037A	
APPROVED	K.N.JHA		001.001.00.038A	

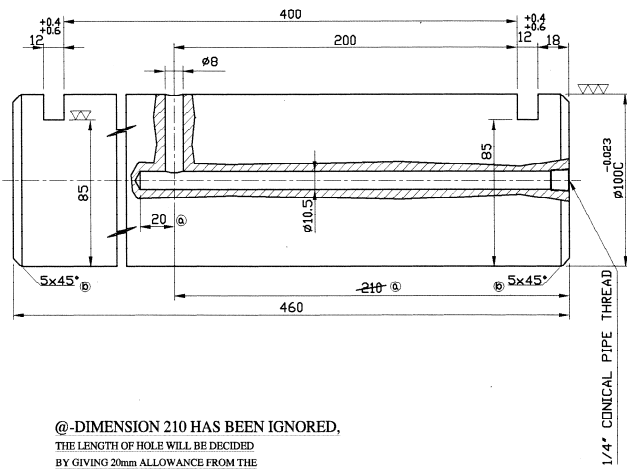
HP696-A3

001.001.00.0400

▽ FOR THE REST

001.001.00.039A

▽ FOR THE REST



@-DIMENSION 210 HAS BEEN IGNORED,
THE LENGTH OF HOLE WILL BE DECIDED
BY GIVING 20mm ALLOWANCE FROM THE
AXIS OF Ø8 HOLE IN RADIAL DIRECTION.

REV. B-DIMENSION REVISED AS PER
PER LETTER NO.-MPHM/10/88-296
Dt.4.2.88 OF RM & MHP Sd.-15.02.88

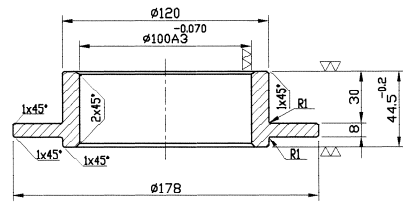
REVISION C

MATERIAL UPDATED.

Sd.-18.11.05
(S.K.BHATTACHARYA)

DIGITISED FROM H.M.B. DRG.NO.-1507.02.128

POS NO	DESCRIPTION	QTY	UNIT	MATERIAL	G.A. DRG. NO.	SC	DRG. NO
10	AXLE	4	28.5	40C4 JS-4570-61	001.001. 00.013B	1,2	001.001. 00.040C



REVISION A

MATERIAL UPDATED.

Sd.-18.11.05
(S.K.BHATTACHARYA)

DIGITISED FROM H.M.B. DRG.NO.-1507.02.129

POS NO	DESCRIPTION	QTY	UNIT	MATERIAL	G.A. DRG. NO.	SC	DRG. NO
11	BUSH	8	2.35	St. 25 IS-226-62	001.001. 00.013B	1,2	001.001. 00.039A

BOKARO STEEL PLANT			
SHOP	COKE OVEN & BY PRODUCT PLANT		
UNIT	WAGON TIPLER (D.P.R.NO.-001/001)		
DESCRIPTION OF DRAWING	DETAILS OF ROLLER SUPPORT		
DIGITISED	HP,BHOGTA	DATE	NOV.2006
CHECKED	S.K.B.	POB NO	11202
SUBMITTED	N.K.JHA		001.001.00.039A
APPROVED	K.N.JHA		001.001.00.040C

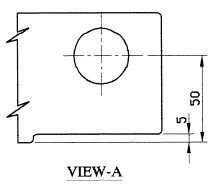
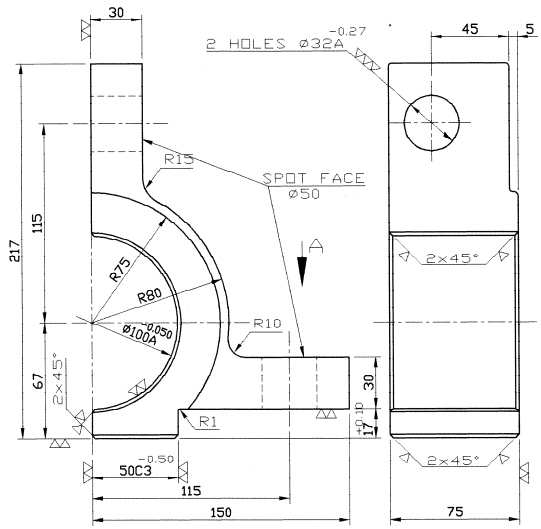
HP697-A3

001.001.00.044A

FOR THE REST

001.001.00.044A

FOR THE REST



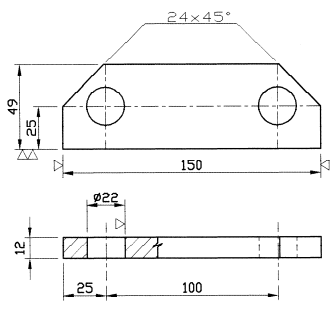
TECHNICAL REQUIREMENTS:-

- UNSHOWN CAST RADII ARE 5mm.
- Ø32A, Ø100A AND END PLANES TO BE MACHINED IN ASSLY WITH CROSS-BEAM.

REVISION A
MATERIAL UPDATED
Sd:-S.K.BHATTACHARYA
Dt.13.12.05

DIGITISE FROM H.M.B. DRG.NO.-1507.02.108

POS NO	DESCRIPTION	QTY	UNIT	MATERIAL	G.A. DRG. NO.	SC.	DRG. NO
1	COVER (LH)	4	5.4	CS280-520 IS:1030-89	001.001. 00.013B	1.2	001.001. 00.044A



TECHNICAL REQUIREMENT:-
UNMACHINED EDGES SHOULD BE CLEANED.

DIGITISED FROM H.M.B. DRG.NO.-1507.02.107

POS NO	DESCRIPTION	QTY	UNIT	MATERIAL	G.A. DRG. NO.	SC.	DRG. NO
3	AXLE LOCKING DEVICE	8	0.6	FS410WA IS:2004-91	001.001. 00.013	1.2	001.001. 00.044A

		BOKARO STEEL PLANT	
SHOP		COKE OVEN & BY PRODUCT PLANT	
UNIT		WAGON TIPLER (D.P.R.NO.-001/001)	
DESCRIPTION OF DRAWING		DETAILS OF ROLLER SUPPORT (END)	
DIGITISED	RP.BHOGTA	DATE	NOV.2006
CHECKED	S.K.B	POB NO	11202
SUBMITTED	N.K.JHA		001.001.00.043A
APPROVED	K.N.JHA		001.001.00.044A

REVISION A
MATERIAL UPDATED
Sd:-S.K.BHATTACHARYA
Dt.13.12.05

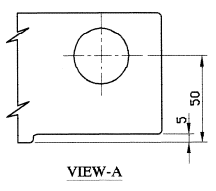
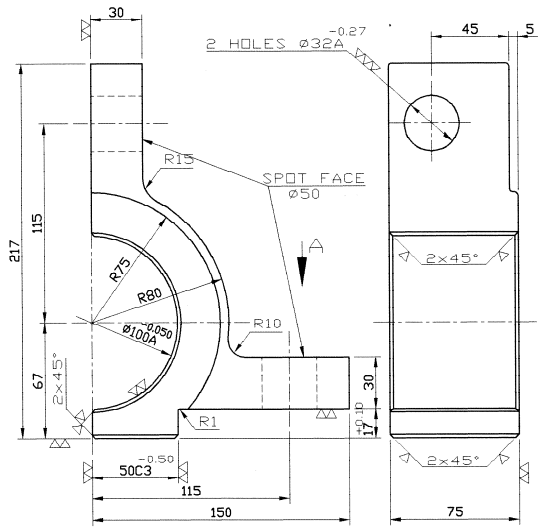
HP693-A3

001.001.00.044A

FOR THE REST

001.001.00.044A

FOR THE REST



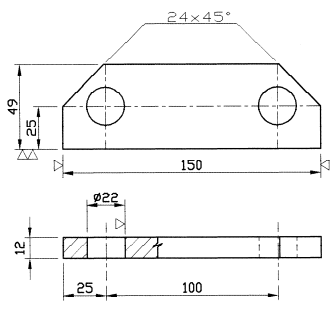
TECHNICAL REQUIREMENTS:-

- UNSHOWN CAST RADII ARE 5mm.
- Ø32A, Ø100A AND END PLANES TO BE MACHINED IN ASSLY WITH CROSS-BEAM.

REVISION A
MATERIAL UPDATED
Sd:-S.K.BHATTACHARYA
Dt.13.12.05

DIGITISE FROM H.M.B. DRG.NO.-1507.02.108

POS NO	DESCRIPTION	QTY	UNIT	MATERIAL	G.A. DRG. NO.	SC.	DRG. NO
1	COVER (LH)	4	5.4	CS280-520 IS:1030-89	001.001. 00.013B	1.2	001.001. 00.044A



TECHNICAL REQUIREMENT:-
UNMACHINED EDGES SHOULD BE CLEANED.

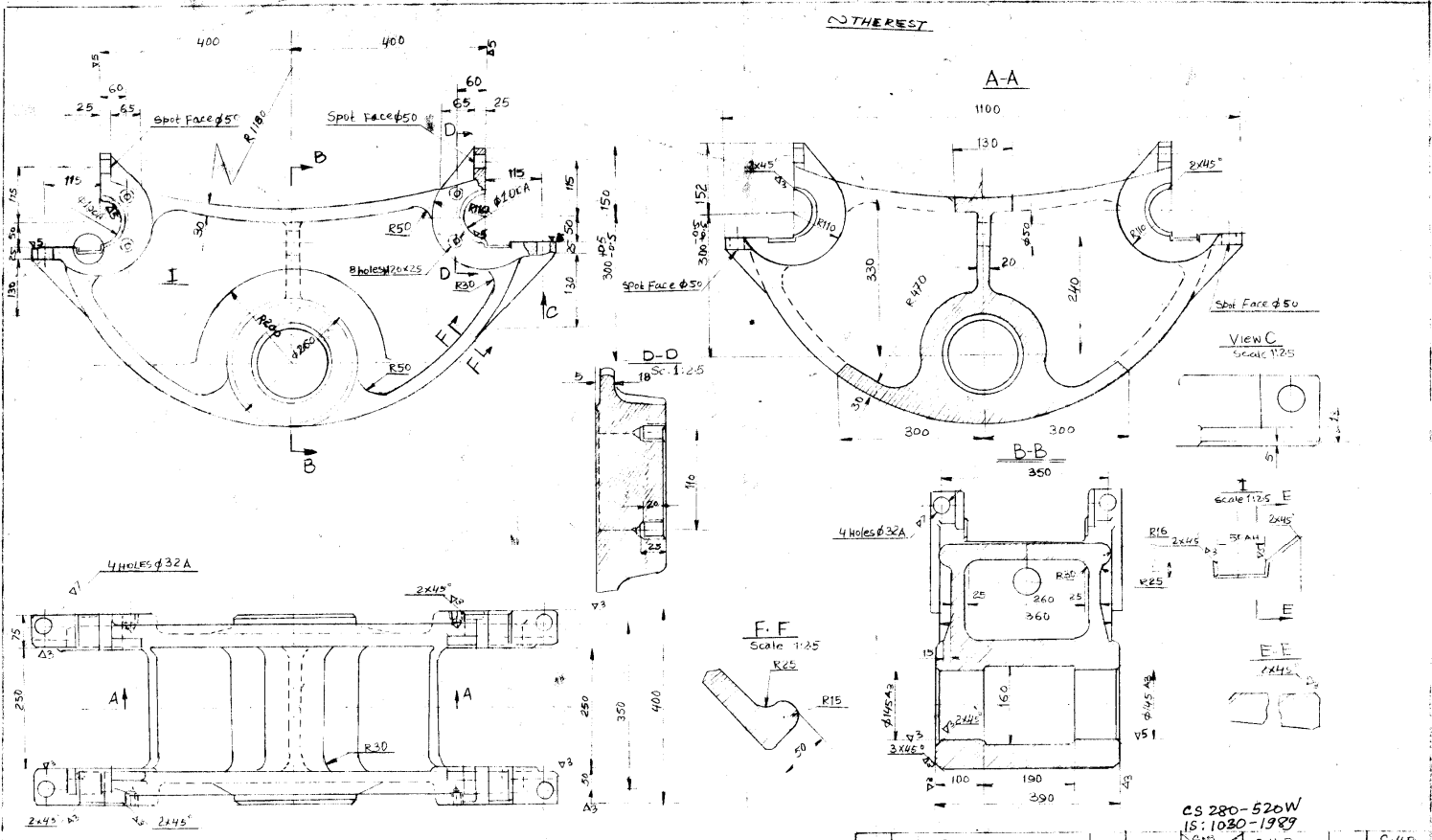
DIGITISED FROM H.M.B. DRG.NO.-1507.02.107

POS NO	DESCRIPTION	QTY	UNIT	MATERIAL	G.A. DRG. NO.	SC.	DRG. NO
3	AXLE LOCKING DEVICE	8	0.6	FS410WA IS:2004-91	001.001. 00.013	1.2	001.001. 00.043A

BOKARO STEEL PLANT	
SHOP	COKE OVEN & BY PRODUCT PLANT
UNIT	WAGON TIPLER (D.P.R.NO.-001/001)
DESCRIPTION OF DRAWING	DETAILS OF ROLLER SUPPORT (END)
DIGITISED	HP.BHOGTA
CHECKED	S.K.B
SUBMITTED	N.K.JHA
APPROVED	K.N.JHA
DATE	NOV.2006
POB NO	11202
001.001.00.043A & 001.001.00.044A	

REVISION A
MATERIAL UPDATED
Sd:-S.K.BHATTACHARYA
Dt.13.12.05

HP693-A3



1. UN SHOWN CAST RADIAL ARE 10m.m.
2. φ100A AND END PLACES ARE TO 1 JOINED IN ABELATY WITH COVERS AS DRG.No. 750702.105A.

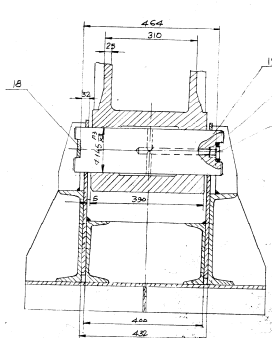
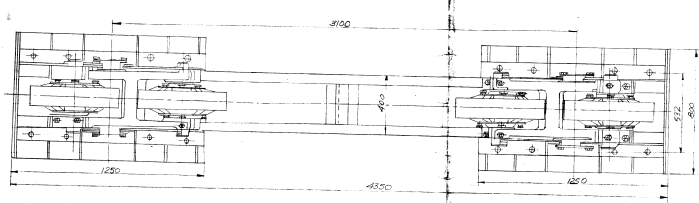
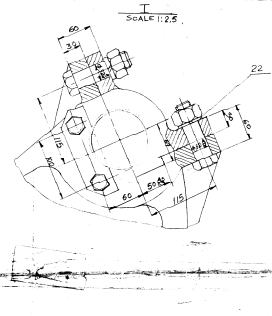
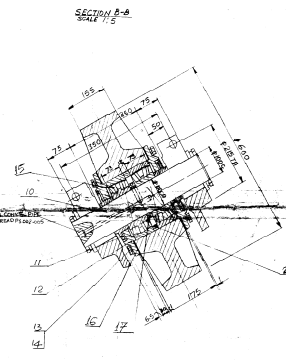
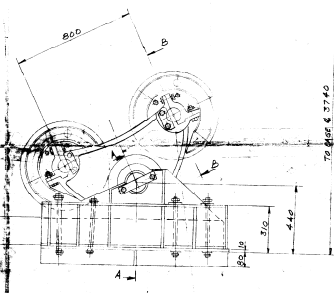
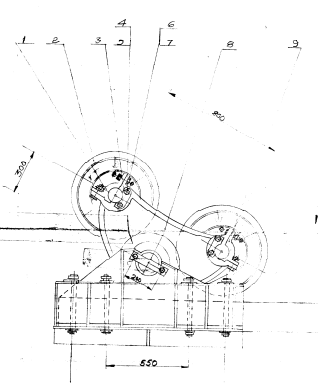
CS 280-520W
IS: 1030-1989

POS NO	DESCRIPTION	QTY	UNIT WT	MATERIAL	G.A.DRG	SC	DRG.NO
8	CROSS BEAM	2	1400	CS 280-520W IS: 1030-1989	406/4-7	115	C.H.P 767

BOKARO STEEL PLANT

SHOP	COKE OVEN & BY PRODUCT PLANT
UNIT	C.H.P (01/001)
CROSS BEAM	

REF.DRG NO	DRAWN	DATE
150702.109 (HIMB)	TRACED A.A.KHAN 24/83	FEB. 83
	CHECKED A.K.SINHA 24/83	SCALE 1:15
	SUBMITTED	C.H.P
	APPROVED	0767



BASED ON H.M.D. DFG NO. 1507 27 510 A
ARCH. NO. CO. 4
1956

NO.	DESCRIPTION	QTY	UNIT	REMARKS
150720	CHP-126 23 RING	4	PC	
150721	CHP-127 24 RING	4	PC	
150722	CHP-128 25 RING	4	PC	
150723	CHP-129 26 RING	4	PC	
150724	CHP-130 27 RING	4	PC	
150725	CHP-131 28 RING	4	PC	
150726	CHP-132 29 RING	4	PC	
150727	CHP-133 30 RING	4	PC	
150728	CHP-134 31 RING	4	PC	
150729	CHP-135 32 RING	4	PC	
150730	CHP-136 33 RING	4	PC	
150731	CHP-137 34 RING	4	PC	
150732	CHP-138 35 RING	4	PC	
150733	CHP-139 36 RING	4	PC	
150734	CHP-140 37 RING	4	PC	
150735	CHP-141 38 RING	4	PC	
150736	CHP-142 39 RING	4	PC	
150737	CHP-143 40 RING	4	PC	
150738	CHP-144 41 RING	4	PC	
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150746	CHP-152 49 RING	4	PC	
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150769	CHP-175 72 RING	4	PC	
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150797	CHP-203 100 RING	4	PC	
150798	CHP-204 101 RING	4	PC	
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150800	CHP-206 103 RING	4	PC	
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150803	CHP-209 106 RING	4	PC	
150804	CHP-210 107 RING	4	PC	
150805	CHP-211 108 RING	4	PC	
150806	CHP-212 109 RING	4	PC	
150807	CHP-213 110 RING	4	PC	
150808	CHP-214 111 RING	4	PC	
150809	CHP-215 112 RING	4	PC	
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150816	CHP-222 119 RING	4	PC	
150817	CHP-223 120 RING	4	PC	
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150819	CHP-225 122 RING	4	PC	
150820	CHP-226 123 RING	4	PC	
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150824	CHP-230 127 RING	4	PC	
150825	CHP-231 128 RING	4	PC	
150826	CHP-232 129 RING	4	PC	
150827	CHP-233 130 RING	4	PC	
150828	CHP-234 131 RING	4	PC	
150829	CHP-235 132 RING	4	PC	
150830	CHP-236 133 RING	4	PC	
150831	CHP-237 134 RING	4	PC	
150832	CHP-238 135 RING	4	PC	
150833	CHP-239 136 RING	4	PC	
150834	CHP-240 137 RING	4	PC	
150835	CHP-241 138 RING	4	PC	
150836	CHP-242 139 RING	4	PC	
150837	CHP-243 140 RING	4	PC	
150838	CHP-244 141 RING	4	PC	
150839	CHP-245 142 RING	4	PC	
150840	CHP-246 143 RING	4	PC	
150841	CHP-247 144 RING	4	PC	
150842	CHP-248 145 RING	4	PC	
150843	CHP-249 146 RING	4	PC	
150844	CHP-250 147 RING	4	PC	
150845	CHP-251 148 RING	4	PC	
150846	CHP-252 149 RING	4	PC	
150847	CHP-253 150 RING	4	PC	
150848	CHP-254 151 RING	4	PC	
150849	CHP-255 152 RING	4	PC	
150850	CHP-256 153 RING	4	PC	
150851	CHP-257 154 RING	4	PC	
150852	CHP-258 155 RING	4	PC	
150853	CHP-259 156 RING	4	PC	
150854	CHP-260 157 RING	4	PC	
150855	CHP-261 158 RING	4	PC	
150856	CHP-262 159 RING	4	PC	
150857	CHP-263 160 RING	4	PC	
150858	CHP-264 161 RING	4	PC	
150859	CHP-265 162 RING	4	PC	
150860	CHP-266 163 RING	4	PC	
150861	CHP-267 164 RING	4	PC	
150862	CHP-268 165 RING	4	PC	
150863	CHP-269 166 RING	4	PC	
150864	CHP-270 167 RING	4	PC	
150865	CHP-271 168 RING	4	PC	
150866	CHP-272 169 RING	4	PC	
150867	CHP-273 170 RING	4	PC	
150868	CHP-274 171 RING	4	PC	
150869	CHP-275 172 RING	4	PC	
150870	CHP-276 173 RING	4	PC	
150871	CHP-277 174 RING	4	PC	
150872	CHP-278 175 RING	4	PC	
150873	CHP-279 176 RING	4	PC	
150874	CHP-280 177 RING	4	PC	
150875	CHP-281 178 RING	4	PC	
150876	CHP-282 179 RING	4	PC	
150877	CHP-283 180 RING	4	PC	
150878	CHP-284 181 RING	4	PC	
150879	CHP-285 182 RING	4	PC	
150880	CHP-286 183 RING	4	PC	
150881	CHP-287 184 RING	4	PC	
150882	CHP-288 185 RING	4	PC	
150883	CHP-289 186 RING	4	PC	
150884	CHP-290 187 RING	4	PC	
150885	CHP-291 188 RING	4	PC	
150886	CHP-292 189 RING	4	PC	
150887	CHP-293 190 RING	4	PC	
150888	CHP-294 191 RING	4	PC	
150889	CHP-295 192 RING	4	PC	
150890	CHP-296 193 RING	4	PC	
150891	CHP-297 194 RING	4	PC	
150892	CHP-298 195 RING	4	PC	
150893	CHP-299 196 RING	4	PC	
150894	CHP-300 197 RING	4	PC	
150895	CHP-301 198 RING	4	PC	
150896	CHP-302 199 RING	4	PC	
150897	CHP-303 200 RING	4	PC	
150898	CHP-304 201 RING	4	PC	
150899	CHP-305 202 RING	4	PC	
150900	CHP-306 203 RING	4	PC	
150901	CHP-307 204 RING	4	PC	
150902	CHP-308 205 RING	4	PC	
150903	CHP-309 206 RING	4	PC	
150904	CHP-310 207 RING	4	PC	
150905	CHP-311 208 RING	4	PC	
150906	CHP-312 209 RING	4	PC	
150907	CHP-313 210 RING	4	PC	
150908	CHP-314 211 RING	4	PC	
150909	CHP-315 212 RING	4	PC	
150910	CHP-316 213 RING	4	PC	
150911	CHP-317 214 RING	4	PC	
150912	CHP-318 215 RING	4	PC	
150913	CHP-319 216 RING	4	PC	
150914	CHP-320 217 RING	4	PC	
150915	CHP-321 218 RING	4	PC	
150916	CHP-322 219 RING	4	PC	
150917	CHP-323 220 RING	4	PC	
150918	CHP-324 221 RING	4	PC	
150919	CHP-325 222 RING	4	PC	
150920	CHP-326 223 RING	4	PC	
150921	CHP-327 224 RING	4	PC	
150922	CHP-328 225 RING	4	PC	
150923	CHP-329 226 RING	4	PC	
150924	CHP-330 227 RING	4	PC	
150925	CHP-331 228 RING	4	PC	
150926	CHP-332 229 RING	4	PC	
150927	CHP-333 230 RING	4	PC	
150928	CHP-334 231 RING	4	PC	
150929	CHP-335 232 RING	4	PC	
150930	CHP-336 233 RING	4	PC	
150931	CHP-337 234 RING	4	PC	
150932	CHP-338 235 RING	4	PC	