

MAK 6M20

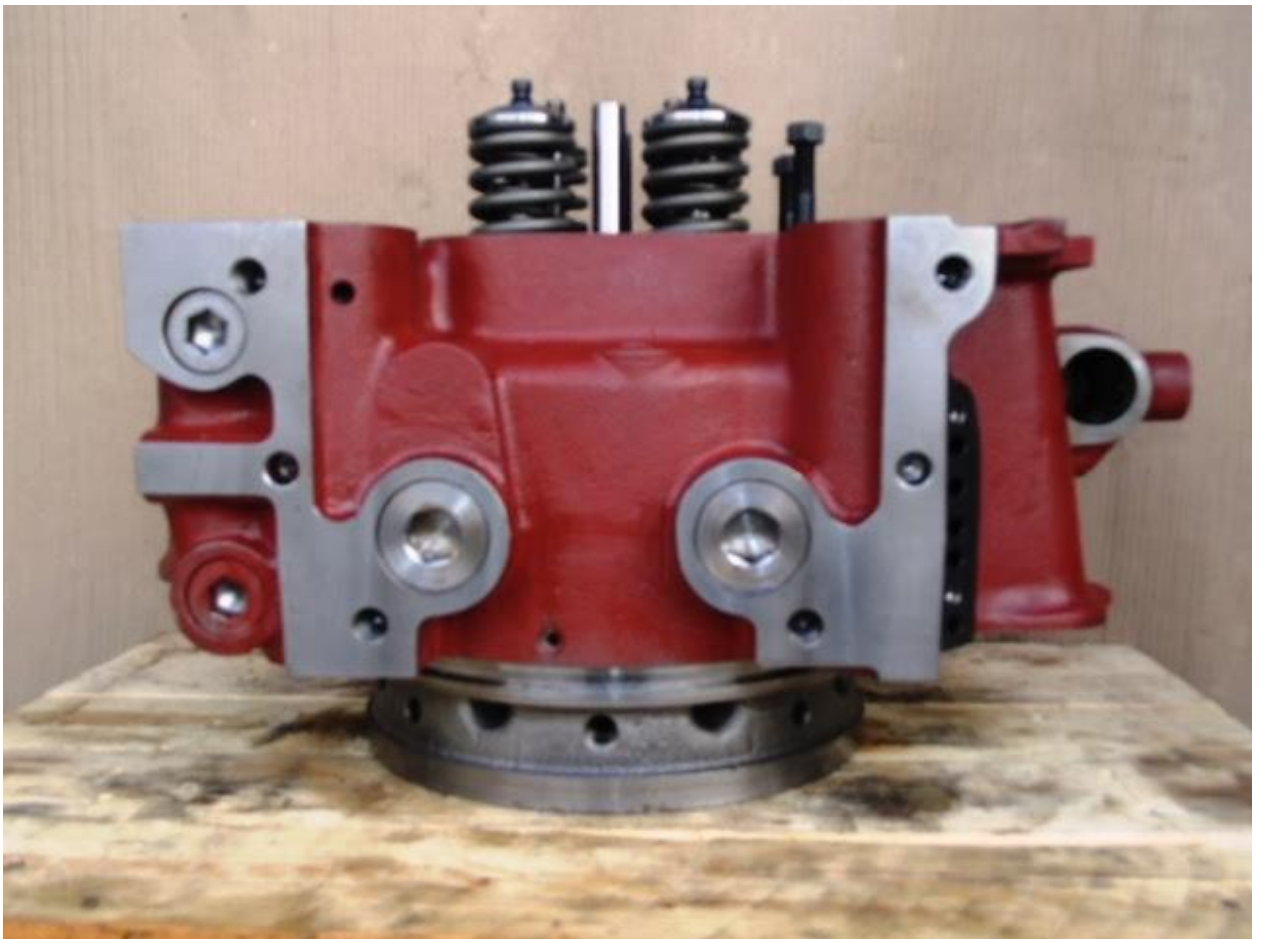
POS	DESCRIPTION	CONDITION	QTY
1.	Cylinder Head	Overhauled/Pressure Tested @ 7 Bar	13pc
2.	Cylinder Liner	New	4pc
3.	Piston	Used/Std Grooves	12pc
4.	Connecting Rod	Tested	12pc
5.	Fuel Pump	Serviced	12pc
6.	Lub Oil Pump	Reconditioned	2pc
7.	Piston Pin	New	4pc
8.	Piston Pin Bush	New	6pc
9.	Piston Ring Set	New	3sets
10.	Inlet Valve	New	12pc
11.	Exhaust Valve	New	12pc
12.	Seat,Ex-Valve	New	12pc
13.	Seat,In-Valve	New	18pc
14.	Valve Guide	New	12pc
15.	Nozzle	New	5pc
16.	Delivery Valve	New	6pc
17.	Bolt,Connecting Rod	New	22pc
18.	Gasket, Cyl Head	New	12pc
19.	Indicator Cock	New	7pc
20.	Valve Spring Set	New	12sets
21.	Adjusting Screw, Injector	New	12pc
22.	Rocker Arm	Recon	4pc
23.	Push Rod	New	12pc
24.	Rotator, Valve	New	12pc
25.	Bush, Rocker Arm	New	12pc
26.	Crankshaft	Used/Std Size	2pc
27.	Complete Engine	Used/Good Condition	2 Unit

Note ***

All parts offered are new & original with markings.

Delivery: Immediate (Ex-Stock)

Inspection: Mumbai, INDIA







BHARAT BORING WORKS

1/2, Jogani Industrial Estate, 541, Senapati Bazar Marg, P. O. Box No 17908, Dadar (West), Mumbai - 400 028

Reconditioning of Components for DIESEL GENERATING SETS, MARINE ENGINES & ALL TYPES OF COMPRESSORS

CRANKSHAFT INSPECTION REPORT BEFORE GRINDING

Report No. : BBW/DD/INSP/445/2013-2014	Date: 12 th March 2014	Our Job No. 8203
Customer's Name	Vessel	
Engine	Make: MAK Type: 6M 20	Site of the Work
		At our Works

CRANKSHAFT TEST DATA

Crankshaft Marking No. I2 133 7.25 10.01.01		THYSSON T.V.R.										Journal std. size: 180.00 mm. Next undersize: Crank Pin std size: 152.00 mm. Next undersize:			
CI.13.7.25.10.00-11 A R26135 42CRM04 305830 D.S.F. 32-3029 L.R. QA01560 B544513 2 Q.L. 94 (X6)															
Journal No.		1		2		3		4		5		6		7	
Dia. of Journal	a1	a2	a3	a4	a5	a6	a7	a8	a9	a10	a11	a12	a13	a14	
	A	179.94	179.94	179.95	179.94	179.94	179.94	179.95	179.95	179.95	179.95	179.94	179.94	179.95	179.95
Con. Pin	b1	b2	b3	b4	b5	b6	b7	b8	b9	b10	b11	b12			
	A	151.92	151.92	151.94	151.94	151.94	151.94	151.94	151.95	151.95	151.93	151.93			
Dia. of Con. Pin	b1	b2	b3	b4	b5	b6	b7	b8	b9	b10	b11	b12			
	A	151.92	151.92	151.94	151.94	151.94	151.94	151.94	151.95	151.95	151.93	151.93			
Thickness	c1	c2	c3	c4	c5	c6	c7	c8	c9	c10	c11	c12			
	A	151.92	151.92	151.94	151.94	151.94	151.94	151.94	151.95	151.95	151.93	151.93			
Before grinding															
Observation	CRANKSHAFT ALL THE MAIN JOURNALS AND CON. PINS READINGS FROM FREE END BEFORE GRINDING.														
Result															

For BHARAT BORING WORKS

SUDESH H. KOTIAN
Snm # 1001A (03/06)

Phone : 24220305 / 24222995 / 24229477 / 24313622 / 65804067. Fax : 91-22-24313624.
mail : admin@bharatboringworks.com / sales@bharatboringworks.com / bbw@mtl.net.in Website : www.bharatboringworks.com

WE HAVE NO OTHER BRANCH





BHARAT BORING WORKS

1-2, Jogani Industrial Estate, 541, Senapati Bapat Marg,
P.O. box No.17008, Dadar (w), Mumbai - 400 028.

Reconditioning of Components for DIESEL GENERATING SETS, MARINE ENGINES
and all types of COMPRESSORS

Ref. No.: BBW/DD/R/1863/2013-2014
Date: 12th March 2014

HARDNESS TEST REPORT

Client:	Our Job No. 8203	
Engine: MAK Model: 6M 20	Vessel:	
Crankshaft Marking number 12 1.13.7-25.10.01-01 CE13.7-25.10.00-11 A R26135 42CRM04 305830 D.S.F. 32-3029 LR QA01560 85845D 2 G/L 94 (X6)	Test Site: At our Works Test Date: 12.03.2014	
Hardness Tester: OPTEL DIGITAL	Maker: OPTEL INDIA	Model: HT-7 HA74

Area to be examined: (As per sketch):

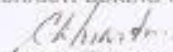


Calibration Ref: Standard 644 HB with 5 Kg. Bottom support
Acceptable Standard: As per Maker

SR. NO.	PART	LOCATION OF READINGS				ACCEPTABILITY
		A	B	A'	B'	
1	Main Journals	245	260	270	242	As noted
2	Main Journals	255	257	260	276	As noted
3	Main Journals	270	250	273	260	As noted
4	Main Journals	266	269	230	270	As noted
5	Main Journals	265	238	240	275	As noted
6	Main Journals	270	250	274	260	As noted
7	Main Journals	269	245	271	260	As noted
SR. NO.	PART	LOCATION OF READINGS				ACCEPTABILITY
		A	B	A'	B'	
1	Con. Pins	270	259	260	271	As noted
2	Con. Pins	255	230	268	274	As noted
3	Con. Pins	272	270	265	249	As noted
4	Con. Pins	258	263	255	265	As noted
5	Con. Pins	232	261	250	268	As noted
6	Con. Pins	249	263	254	270	As noted

Remarks: Crankshaft all the Main Journals and Con. Pins hardness readings before grinding ranges from HB: 230 To 276

for BHARAT BORING WORKS


(SUDESH KOTIAN)
Form # 10/04(10/00)





BHARAT BORING WORKS

1-2, Jogani Industrial Estate, 541, Senapati Bapat Marg,
Po. box No.17008, Dadar (w), Mumbai - 400 028.

**Reconditioning of Components for DIESEL GENERATING SETS, MARINE ENGINES
and all types of COMPRESSORS**

OUR JOB NO.: 8203

Ref. No.: BBW/MPI/R/6693/2013-2014

Date: 12th March 2014

REPORT OF MAGNETIC PARTICLE INSPECTION

Navi Mumbai

ORDER NO. & DATE : Verbal

VESSEL :
ENGINE :
TEST MATERIAL :
Make: MAK Model: 6M 20
Crankshaft: One No.
Crankshaft marking number
12.1.13.7-25.10.01-01 THYSSGN
CL13.7-25.10.00-11 A T.U.R.
R26135 42CRM04 305830
D.S.F. 32-3029 LR Q-A01560
85845D 2 GL 94 (X6)

TEST EQUIPMENT : C-quip 9DXL (Yoke Technic A/C Current)
TEST PROCEDURE : Green yellow Fluorescent Powder suspended in kerosene
oil. Inspection under blue light (UV Lamp). Calibration
on test plate and field indicator.

TEST STANDARD : As per ASTM E 709-80
TEST SITE : At our Works, Dadar (W), Mumbai
TEST DATE : 12.03.2014

OBSERVATION : One number **CRANKSHAFT** was tested for Wet
Fluorescent Magnetic Particle Test. Crankshaft all
the Main Journals and Con. Pins before grinding
found satisfactory with no indication of cracks.

REMARKS : The test was carried out by
MR. C.W. MARTIN, NDT Engineer,
ASNT LEVEL II, MT/11/4797

For **BHARAT BORING WORKS**

(SUDESH H. KOTIAN)

Form # 10/02(03/00)

