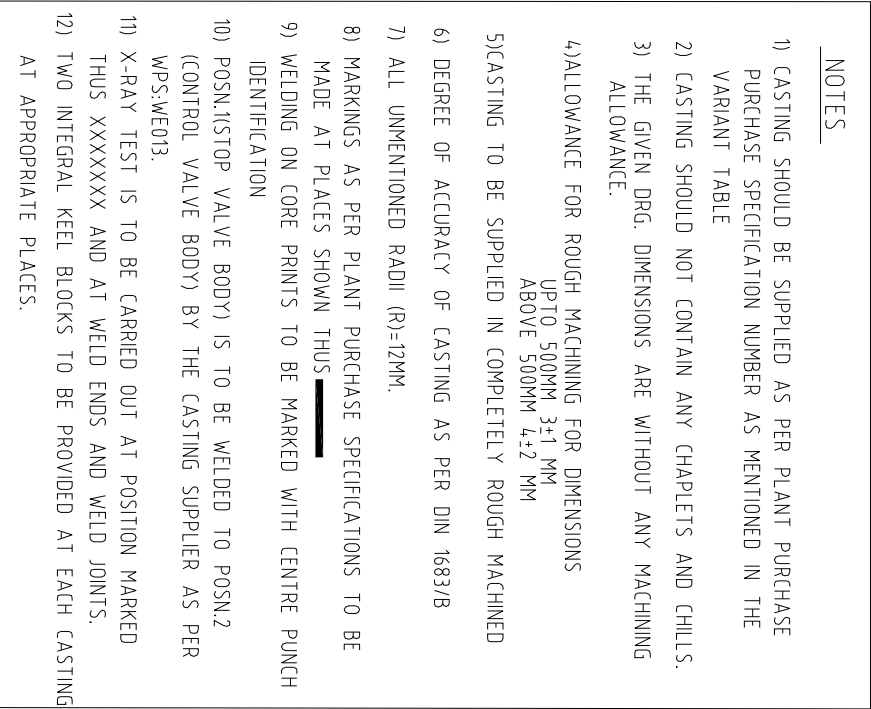




- 1) CASTING SHOULD BE SUPPLIED AS PER PLANT PURCHASE PURCHASE SPECIFICATION NUMBER AS MENTIONED IN THE VARIANT TABLE
- 2) CASTING SHOULD NOT CONTAIN ANY CHAPLETS AND CHILLS
- 3) THE GIVEN DRG. DIMENSIONS ARE WITHOUT ANY MACHINING ALLOWANCE.

4) ALLOWANCE FOR ROUGH MACHINING FOR DIMENSIONS

UPTO 500MM 3+1 MM
ABOVE 500MM 4+2 MM

5)CASTING TO BE SUPPLIED IN COMPLETELY ROUGH MACHINED

6) DEGREE OF ACCURACY OF CASTING AS PER DIN 1683/B

7) ALL UNMENTIONED RADII (R)=12MM.

8) MARKINGS AS PER PLANT PURCHASE SPECIFICATIONS TO BE MADE AT PLACES SHOWN THUS XXXXXXXXXX

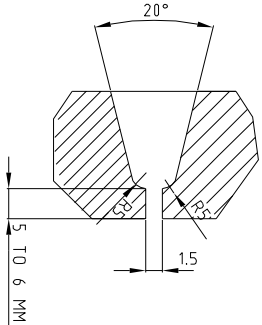
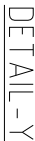
9) WELDING ON CORE PRINTS TO BE MARKED WITH CENTRE PUNCH IDENTIFICATION

10) POSN.1(STOP VALVE BODY) IS TO BE WELDED TO POSN.2
(CONTROL VALVE BODY) BY THE CASTING SUPPLIER AS PER
WPS:WE013.

11) X-RAY TEST IS TO BE CARRIED OUT AT POSITION MARKED
THUS XXXXXXXX AND AT WELD ENDS AND WELD JOINTS.

12) TWO INTEGRAL KEEL BLOCKS TO BE PROVIDED AT EACH CASTING AT APPROPRIATE PLACES.

DETAIL-X



DESIGN PARAMETERS 31 BAR/400°C			
TCxxx	HY9571	00	
MATL CODE	MATL SPEC	VAR	

[illegible]