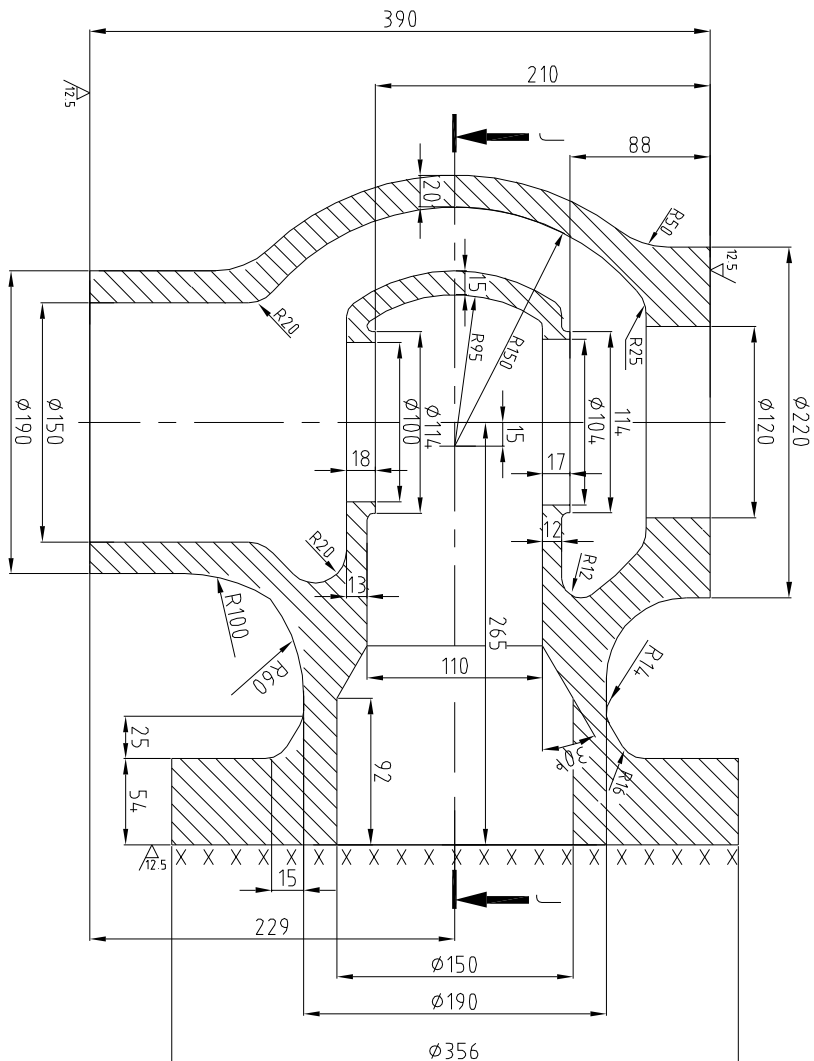
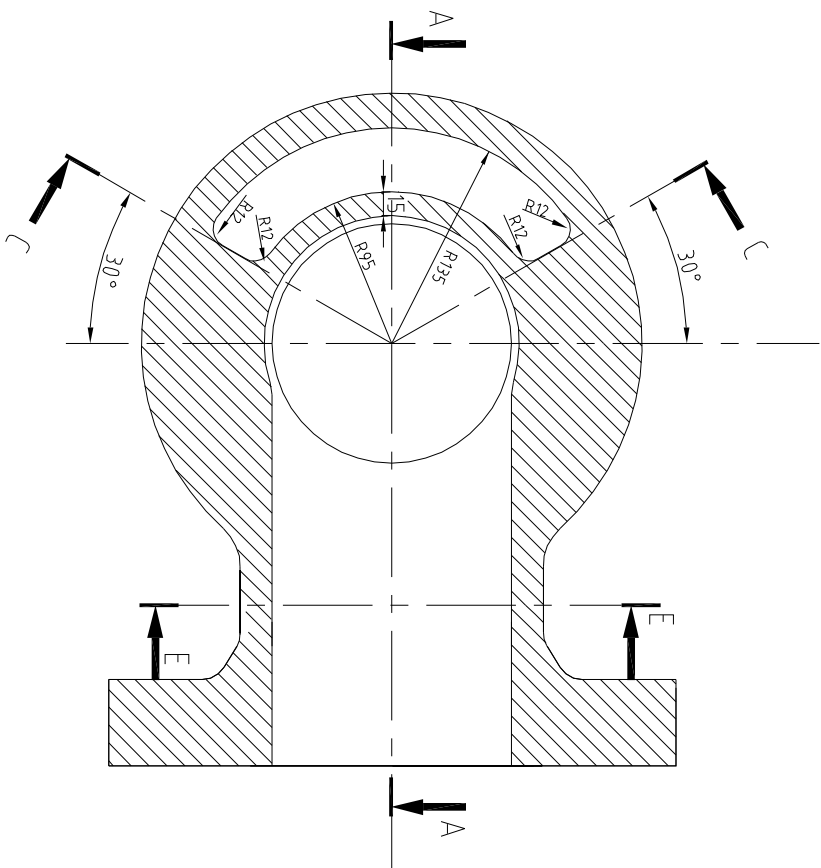


SECTION A-A



SECTION J-J



- 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 PLATES SHOWN THU 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.

DESIGN PARAMETERS 31 BAR/4.00°C	
TCxxx	HY19571
MATL CODE	MATL SPE

TYPE OF PRODUCT		NAME OF CUSTOMER		FABRICATION - HEAVY ELECTRICALS LTD		HYPERBARIC	
TITLE		VALVE BODY CASTING		P-440			
DATE	UNIT, PART	SIZE	WEIGHT (LBS)	QTY	DRW NO	DATE	BY
11/10/54	valve	11	125	1	0-30551-1, 00001	11/10/54	W.A.D.
DRAWING NO.				0-30551-1, 00001			
REF TO ASSY DRW				N.A.			
DATE				N.A.			
NO. OF SHIP				100			