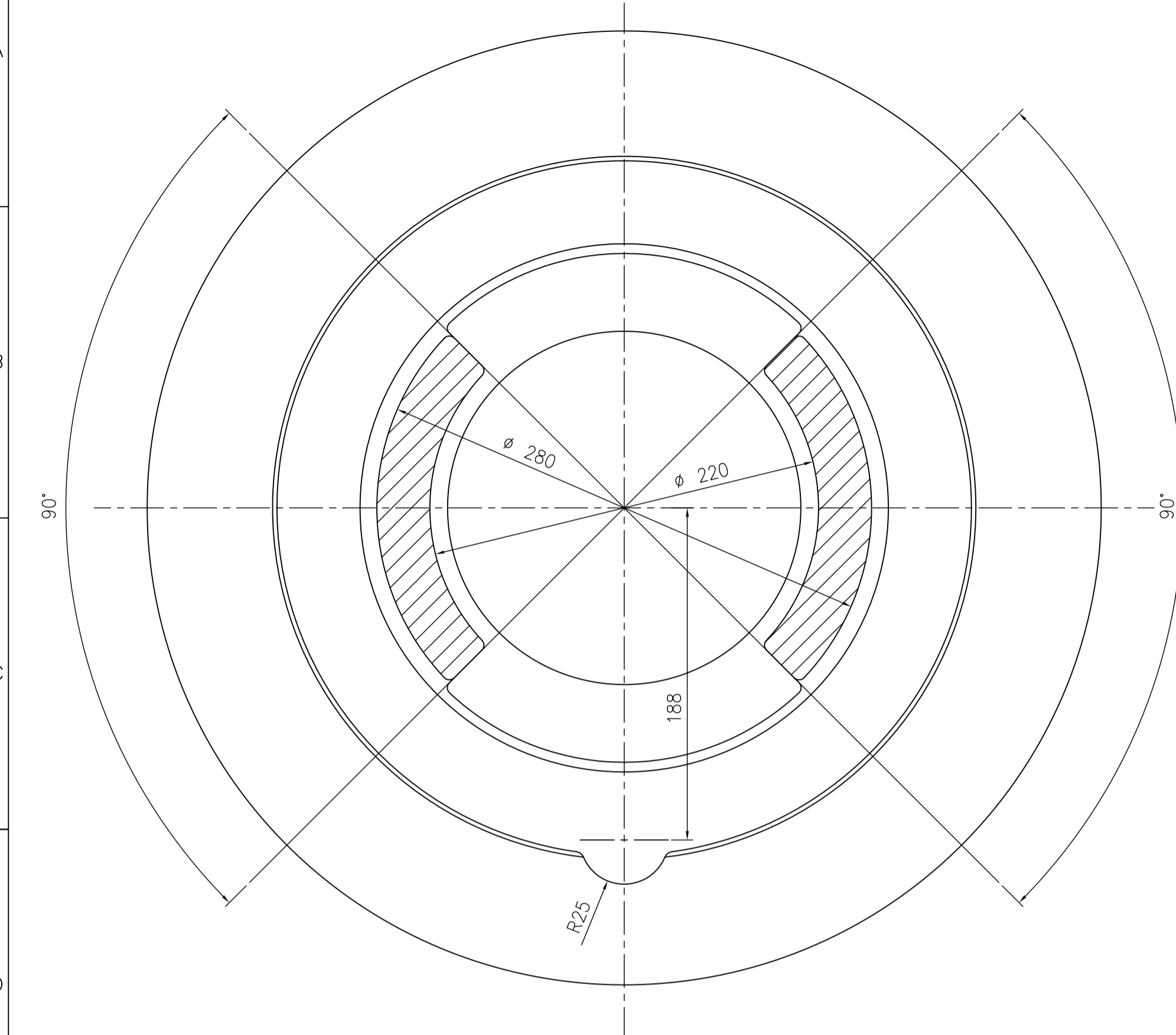
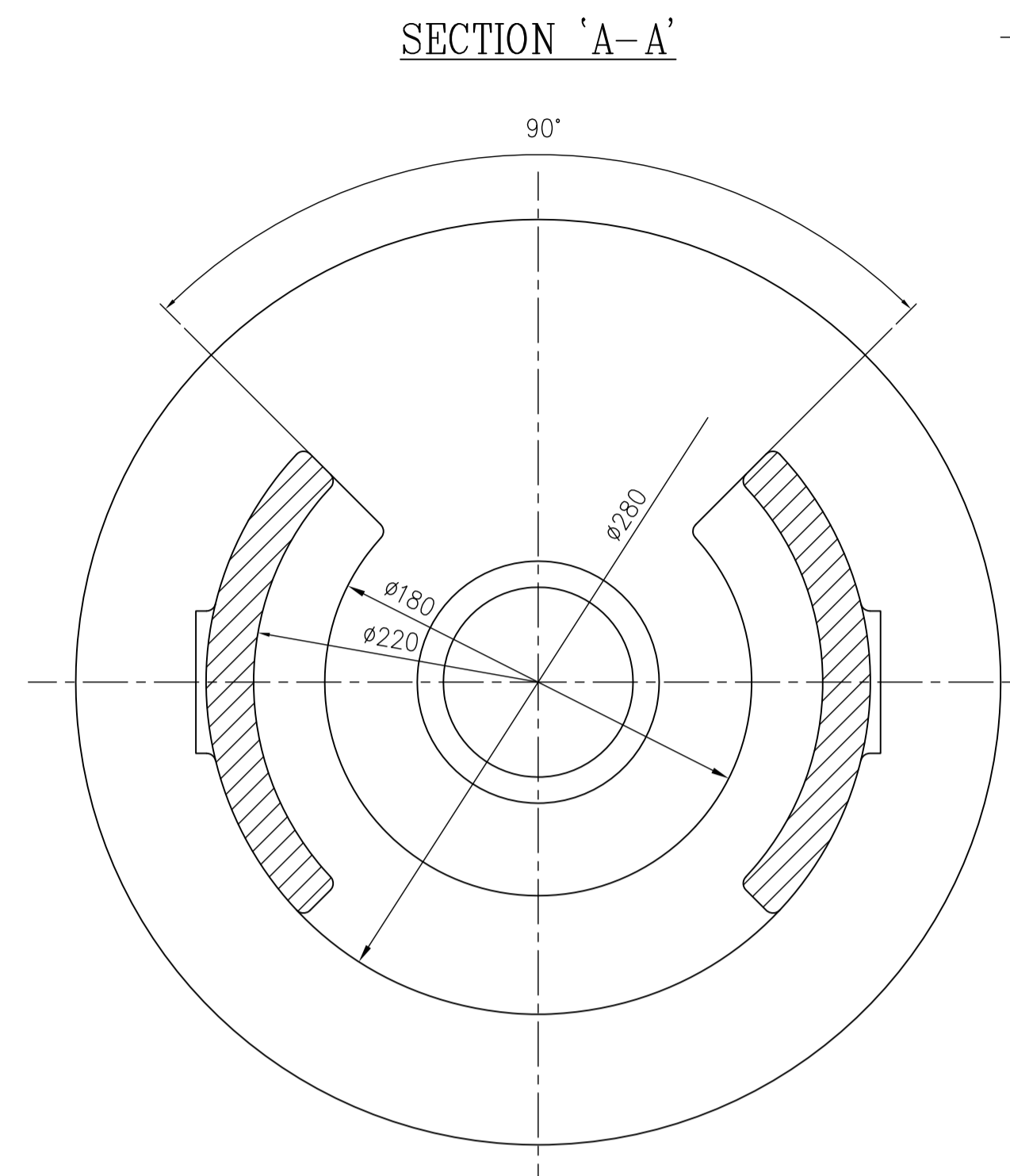
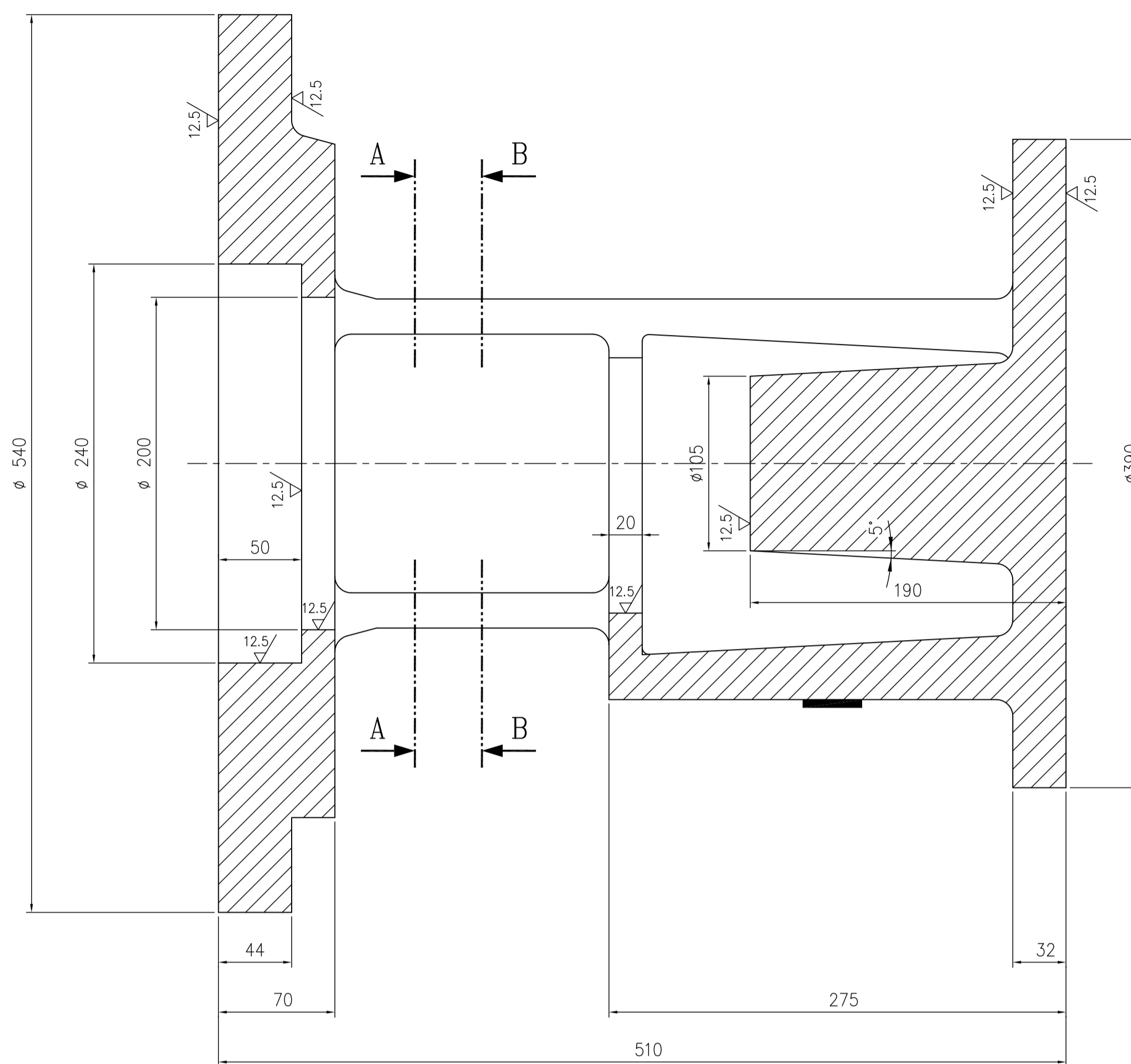


DRG. NO. 1-305-57-10001
SHT. 1 OF 1

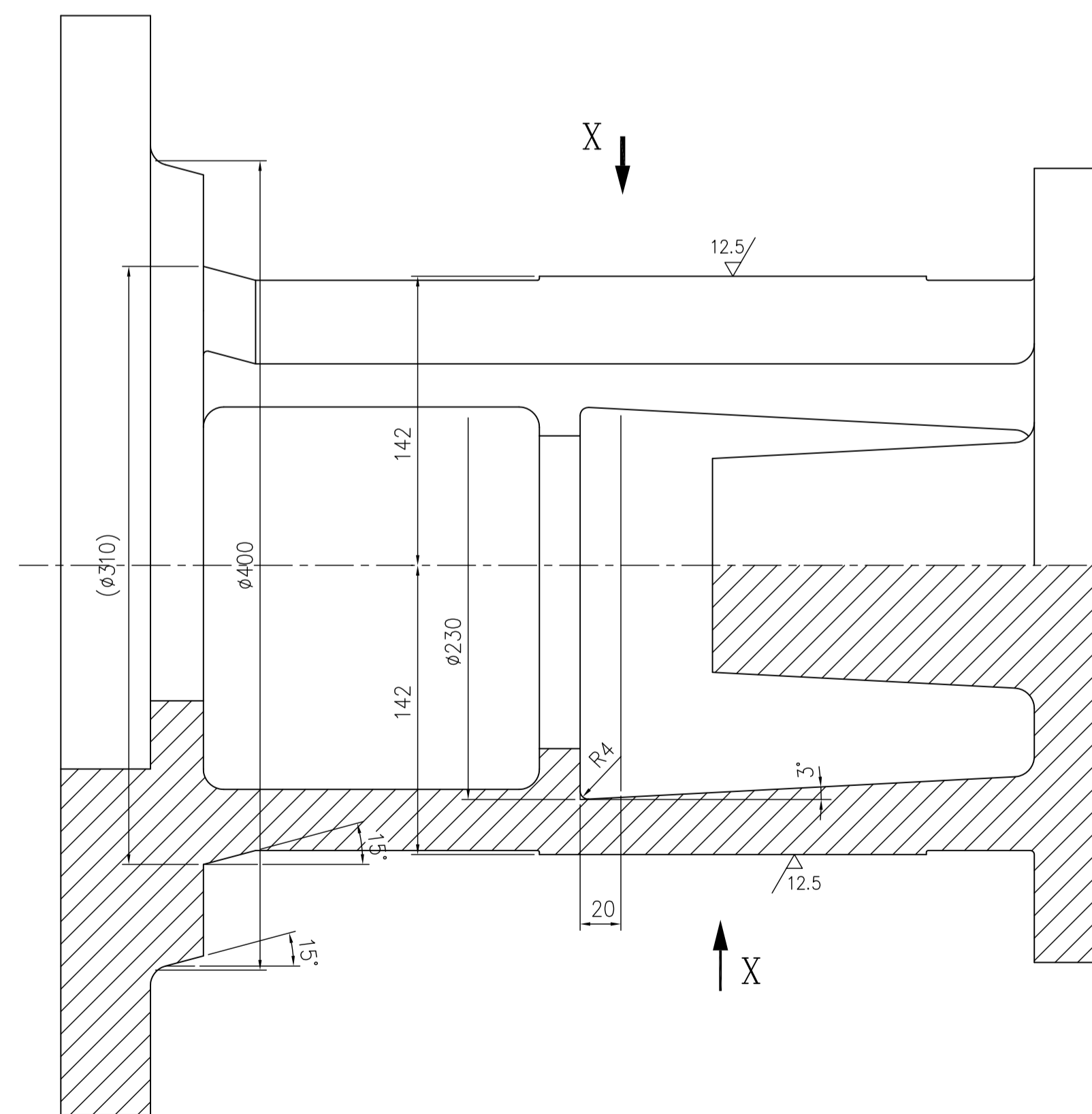
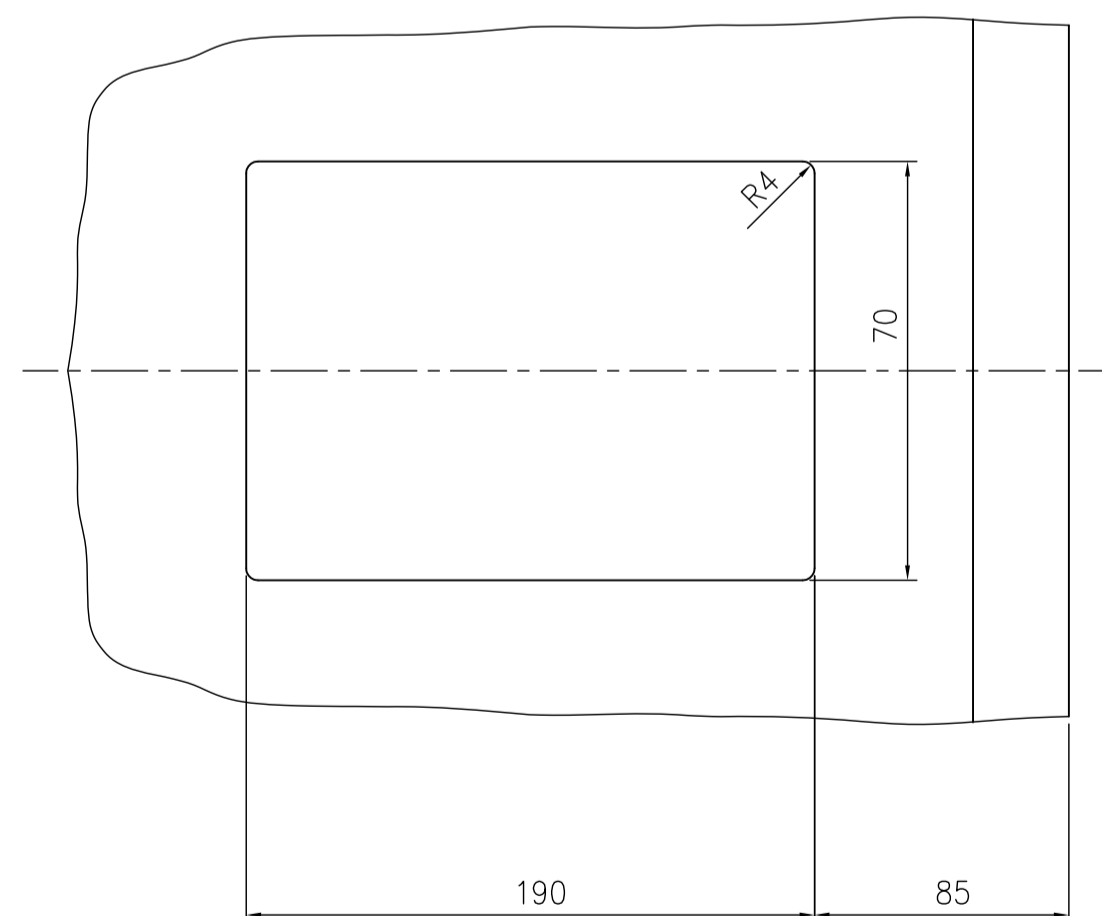
SECTION 'B-B'



SECTION 'A-A'



VIEW - "X"



NOTES :-

- CASTING TO BE SUPPLIED AS PER PLANT PURCHASE SPECIFICATION NUMBER AS MENTIONED IN THE VARIANT TABLE.
- TWO INTEGRALS KEEL BLOCKS ARE TO BE PROVIDED ON EACH CASTING AT APPROPRIATE PLACES.
- THE CASTING SHOULD NOT CONTAIN ANY CHAPLETS AND CHILLS.
- WELDED ON CORE PRINTS TO BE MARKED WITH CENTRE PUNCH FOR IDENTIFICATION.
- MARKING AS PER PLANT PURCHASE SPECIFICATION TO BE MADE AT PLACES SHOWN THUS .
- UNMENTIONED RADII R = 10mm.
- NDT QUALITY LEVEL : (M.P.I.U.T.) THE CASTING SHALL CONFORM TO QUALITY LEVEL₂(DIN 17245-77) FOR GS-17 Cr Mo V 511 AND GS-17 Cr Mo 55.
- THE CASTING SHALL CONFORM TO QUALITY LEVEL 2 (III) AS PER HW 046119 FOR GX 22 Cr Mo V 12.1 V.
- THE CASTING SHALL BE SUPPLIED IN ROUGH MACHINED CONDITION WITH 3± 1MM ALLOWANCE ON ALL SURFACES SHOWN WITH MACHINING SYMBOL FOR HW 19565.

HW19565	-	GX-22 Cr Mo V 121V	-04
AA19522	HY19573	GS-17 Cr Mo V 511	-03
HY19569	HY19770	GS - C 25	-02
AA19523	HY19571	GS-22 Mo 4	-01
HY19576	HY19572	GS-17 Cr Mo 55	-00
SPECIFICATION	SPECIFICATION	MATERIAL	XX VAR

TYPE OF PRODUCT OR NAME OF CUSTOMER		BHARAT HEAVY ELECTRICALS LTD. HYDERABAD		DRN. P.P.K	SIGN. V.V.RAO	DATE 23.2.89	NO. OF VAR.
DEPT. I.T.D. CODE 415	UNTO. DIMS. GR. 2/M/F	SCALE 1:2.5	WEIGHT (KG) 161	REF. TO ASSY. ORG.	ITEM NO.	NO. OF ITEMS	
TITLE INTERMEDIATE PIECE BZ		DRAWING NO. 1-305-57-10001		REV. 05			
		SHT. No 1		NO. OF SHT. 1			

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GENERAL DIMENSIONAL LIMITS, FITS & TOLERANCES AS PER HY0230261

REV. DATE	ALTERED	REV. DATE	ALTERED	REV. DATE	ALTERED	REV. DATE	ALTERED	REV. DATE	ALTERED	REV. DATE	ALTERED	REV. DATE	ALTERED	REV. DATE	ALTERED	REV. DATE	ALTERED	REV. DATE	ALTERED
05	06.11.13	04	10.03.13	03	26.10.92	02	13.2.89	01	18.6.87	05	06.11.13	04	10.03.13	03	26.10.92	02	13.2.89	01	18.6.87
CHD/APPD	CHD/APPD	CHD/APPD	CHD/APPD	CHD/APPD	CHD/APPD	CHD/APPD	CHD/APPD	CHD/APPD	CHD/APPD	CHD/APPD	CHD/APPD	CHD/APPD	CHD/APPD	CHD/APPD	CHD/APPD	CHD/APPD	CHD/APPD	CHD/APPD	CHD/APPD
SG	SG	SG	SG	SG	SG	SG	SG	SG	SG	SG	SG	SG	SG	SG	SG	SG	SG	SG	SG
REVISED IN GENERAL		MISSING DIMENSIONS ADDED REVISED IN GENERAL		VAR 04 ADDED. NOTE No. 8 & 9 ARE ADDED.		NOTES MODIFIED AND SPECN. MODIFIED (TCS)		NOTE : MODIFIED SPEC. ADDED IN VAR TABLE											