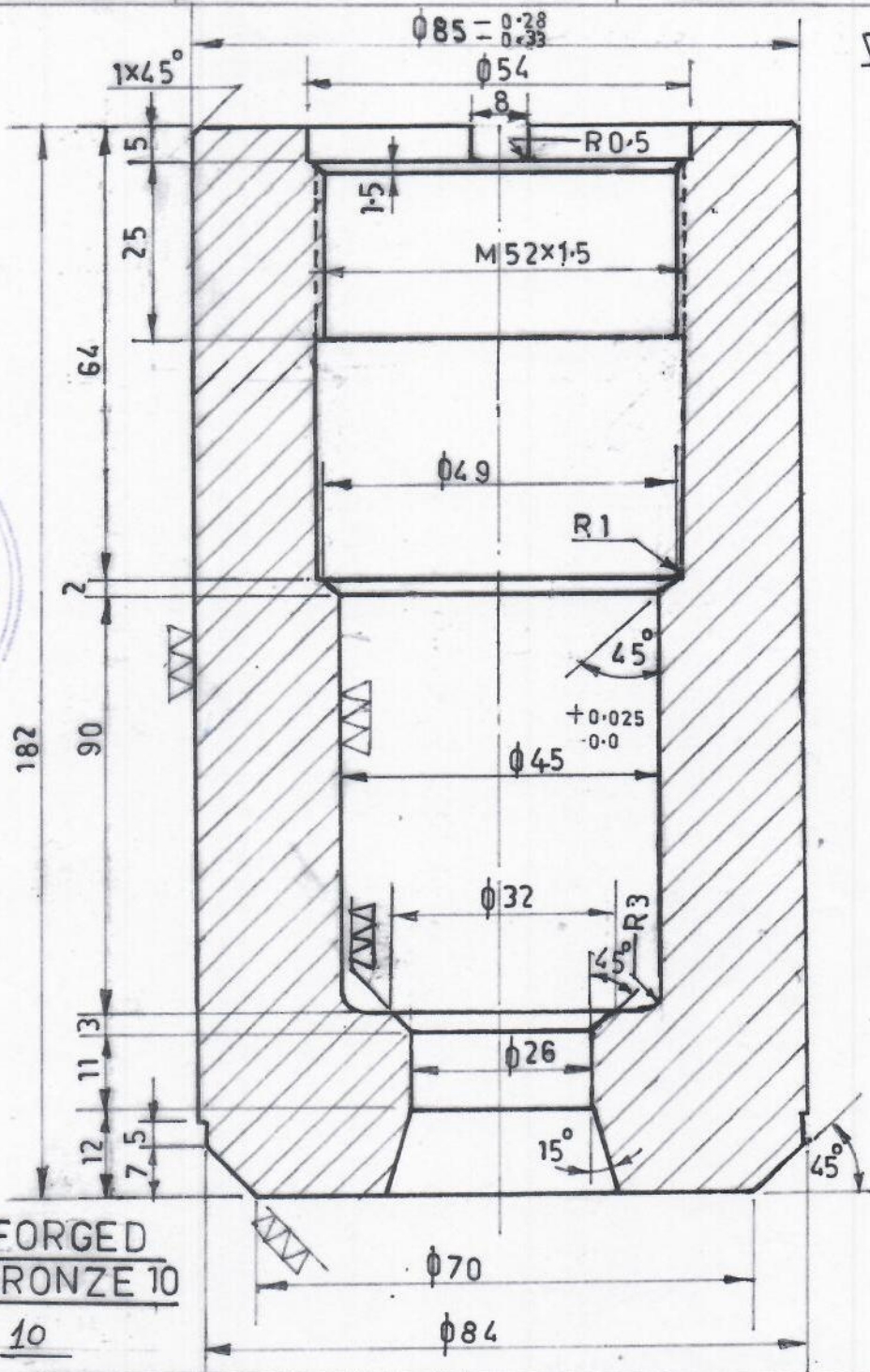


FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

18

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REV	DATE	ALTERED	REV	DATE	ALTERED
		CHECKED			CHECKED



▽(WW)

**MATERIAL-FORGED
ALUMINUM BRONZE 10**
GALMBz 10

NOTE:-



BHARAT HEAVY ELECTRICALS LTD
UNIT: C.F.F.P., HARDWAR.

DEPT.	CODE	SCALE	WEIGHT (KG)	REF. TO ASSY. DRG.	ITEM N
		N.T.S.	6.9	24-260-433	5/1
VALVE CONE FOR Ø70 ME					
(FOR MAIN CONTROL UNIT OF 75/90MN PRESS)					
DRAWN	NAME	SIGN.	DATE		
CHECKED	P.B. GUPTA		25-3		
APPROVED	-D-		21/3/19		

Dimensions to be Controlled Within Limits as Shown
Machining Tolerance + .25 mm Unless Otherwise
Shown. Non Machining Tolerance ±

CARD
CODE

DRAWING NO.
021-01-064

15 16 REV.

SHEET NO. - 1

NO. OF SHEETS. - 1

FF8181011228

Inventory No.

Sign. & Date

Ref. Drg. No.

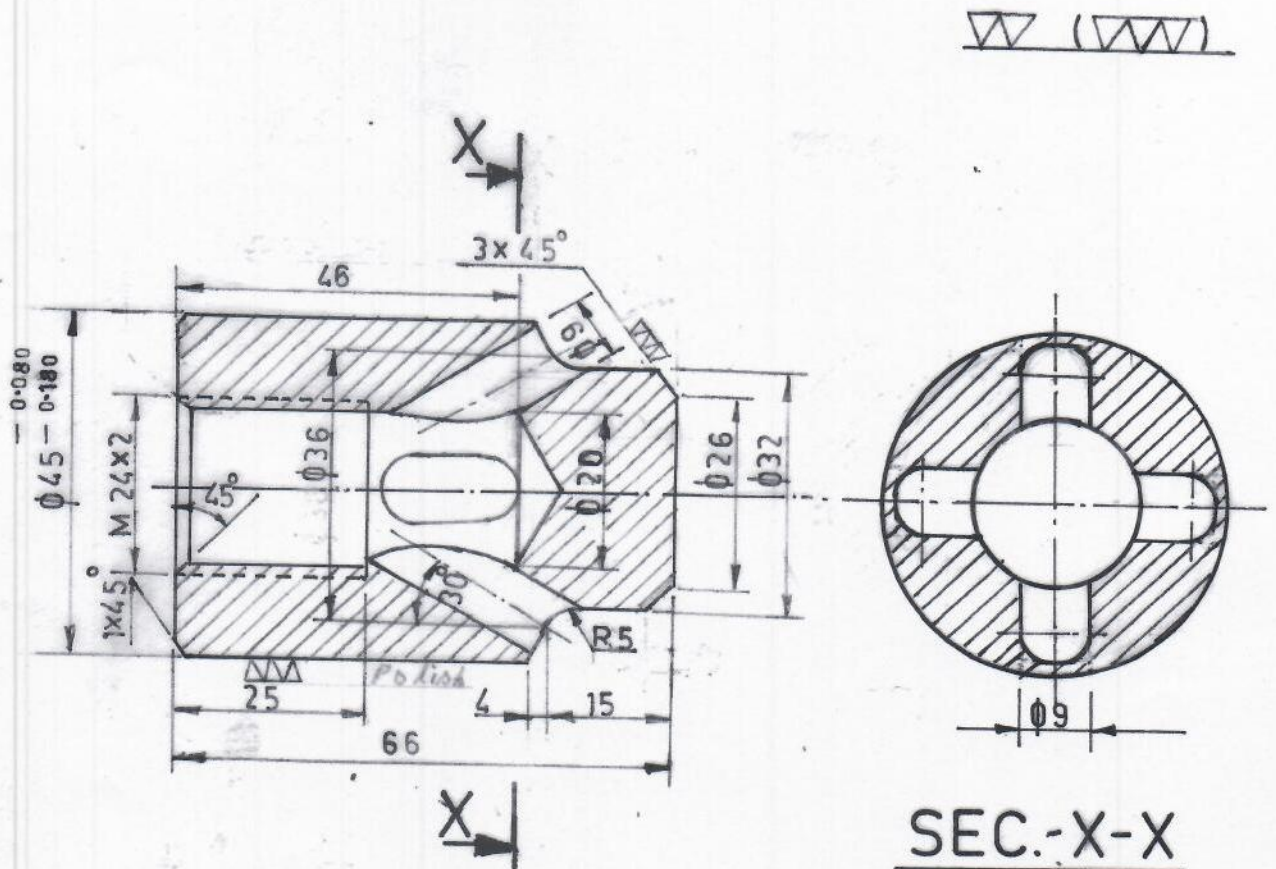
8

FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

17

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REV	DATE	ALTERED	REV	DATE	ALTERED
		CHECKED			CHECKED



MATERIAL - X 15 Cr 13

DRG NO TO BE PUNCHED ON THE ITEM.



BHARAT HEAVY ELECTRICALS LTD.

UNIT: C.F.F.P., HARDWAR.

DEPT.	CODE	SCALE	WEIGHT (Kg)	REF. TO ASSY. DRG.	ITEM NO.
		1:1	0.85	24-260-433	4/1

PILOT VALVE (FOR ME 070)

(FOR MAIN CONTROL UNIT OF 75/90 MN PRESS)

DRAWN	CHECKED	APPROVED	NAME	SIGN.	DATE
			V.K SHARMA		22-3-97
			P.B. GUPTA		21/3/97
			DO.		

Dimensions to be Controlled Within Limits as Shown
Machining Tolerance + .25 mm Unless Otherwise Shown. Non Machining Tolerance ±

CARD CODE

DRAWING NO. 021-01-065

15 18 REV. 1

SHEET NO. - 1

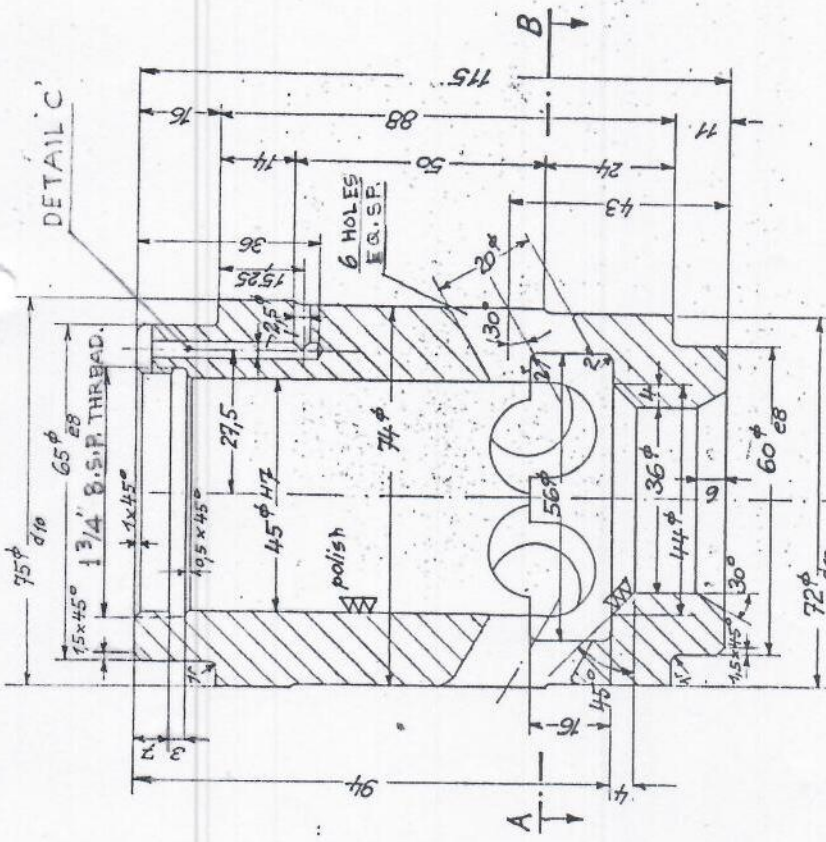
NO. OF SHEETS, - 1

FF8181011236

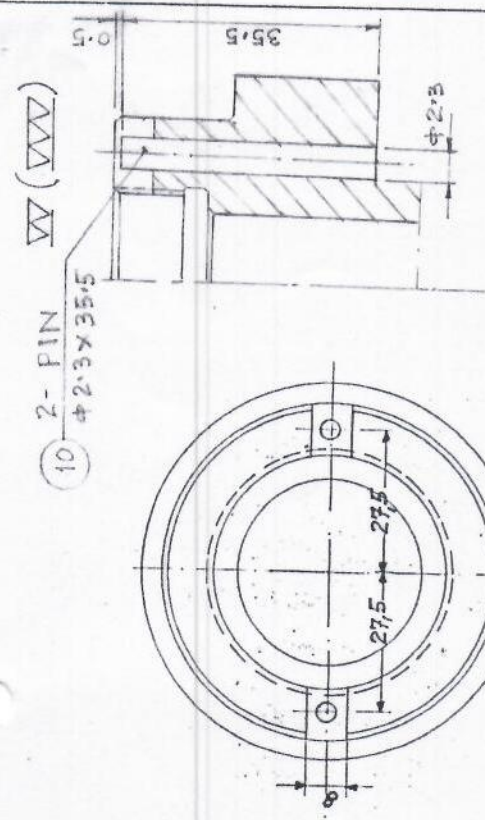
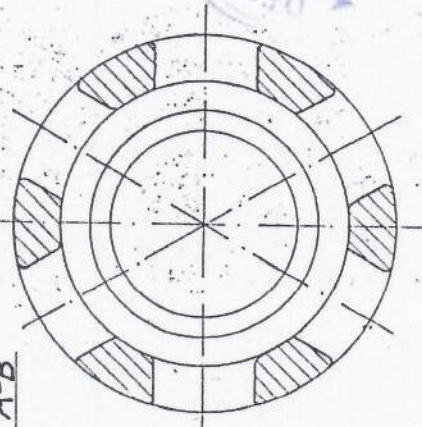
Inventory No.

Sign. & Date

Ref. Drg. No.



SEC.- A-B



TOP VIEW

DETAIL'S 'C'

φ75 d10	- 0.11
φ65 e8	- 0.06
φ45 H7	- 0.1
φ60 e8	- 0.06
φ72 d10	- 0.1

MATERIAL: GAlMBZ10
(FORGED ALUMINIUM BRONZE-10)

DRG.NO. TO BE PUNCHED ON THE ITEM

BHARAT HEAVY ELECTRICALS LTD.
UNIT: CENTRAL FOUNDRY FORGE PLANT.
HARDWAR.

DEPTT. DESIGN	SCALE 1:1	WEIGHT KGS 2.08	24-260-484	1.10
TITLE VALVE SEAT		NAME		
E 36		DRAWN		
FOR LONG TRAVEL, 75/90 M.M.		WORKED		
PRESS.		CHECKED		
DRAWING NO. 021-01-077		APPROVED		
SHEET NO. 1		NO OF SHEETS 1		

DESIGN BUREAU C.F.F.P. ★
ISSUED ON 04 JAN 2021
PHEI

INVENTORY NO. PF8181010809

15

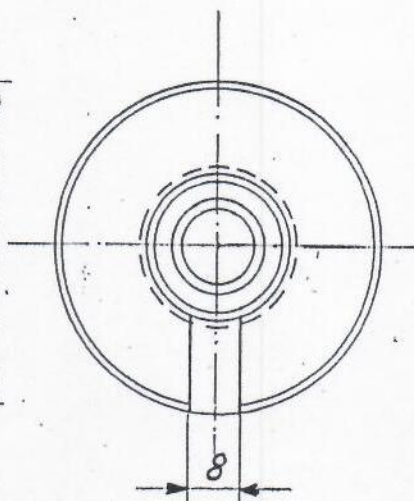
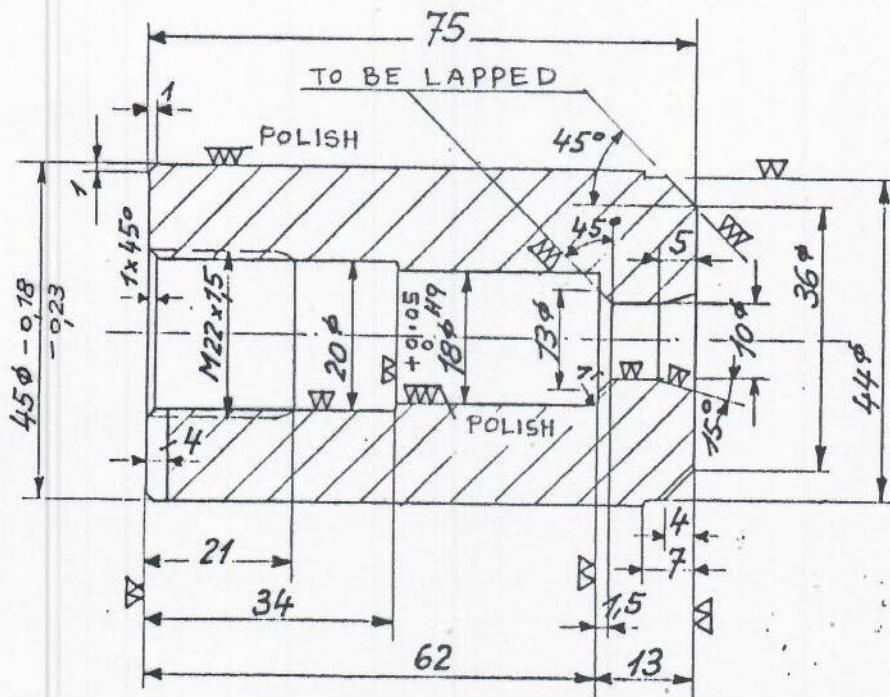
Ref. Drg. No. ITEM No. 2



UNIT: C.F.F.P., HARDWAR.

2

NO. OF SHEETS, 1

$$\underline{\nabla} \left(\underline{\nabla \nabla} \quad \underline{\nabla \nabla \nabla} \right)$$


(FORGED ALUMINUM BRONZE - 10)

DRG. NO. TO BE PUNCHED ON THE ITEM

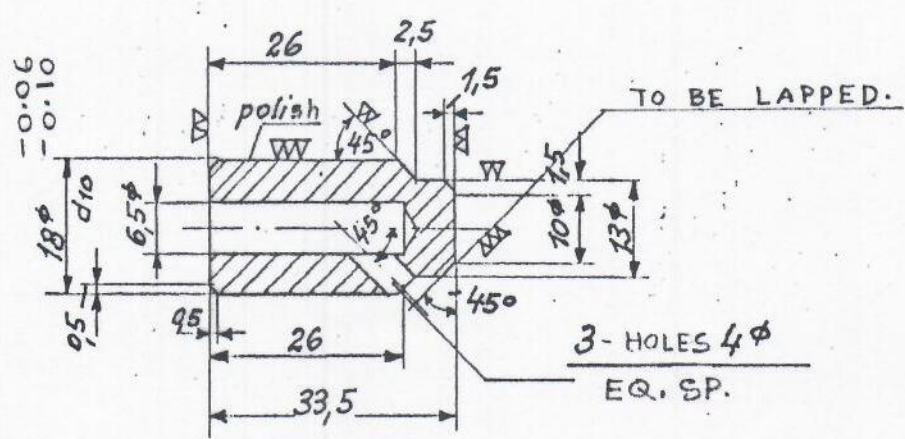
FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

(14)

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REV	DATE	ALTERED	REV	DATE	ALTERED
		CHECKED			CHECKED

▽ (▽ ▽ ▽ ▽)



MATERIAL: X 20 Cr 13

DRG. NO TO BE PUNCHED ON THE ITEM.



BHARAT HEAVY ELECTRICALS LTD.
UNIT: C.F.F.P., HARDWAR.

DEPT. DESIGN.	CODE	SCALE	WEIGHT (KG)	REF. TO ASSY. DRG.	ITEM NO.
		1:1	0.06	24-260-485	3
PILOT VALVE CONE E 36 & E 36 F FOR LONG TRAVEL, 75/90 MN PRESS.				NAME	SIGN.
Dimensions to be Controlled Within Limits as Shown Machining Tolerance + .25 mm Unless Otherwise Shown. Non Machining Tolerance ±				DRAWN	DATE
				CHECKED	
				APPROVED	
CARD CODE				DRAWING NO.	REV.
				021-01-076	0
				SHEET NO.	NO. OF SHEETS
				1	1

24-260-485
Ref. Drg. No. ITEM No. 3

FF 818101122

(12)

SIZE A1



$\phi 68 \text{ e8}$	- 0.06 - 0.106
$\phi 70 \text{ e8}$	- 0.06 - 0.106
$\phi 40 \text{ H7}$	+ 0.025 0
$\phi 48 \text{ e8}$	- 0.05 - 0.089
$\phi 60 \text{ d10}$	- 0.1 - 0.22

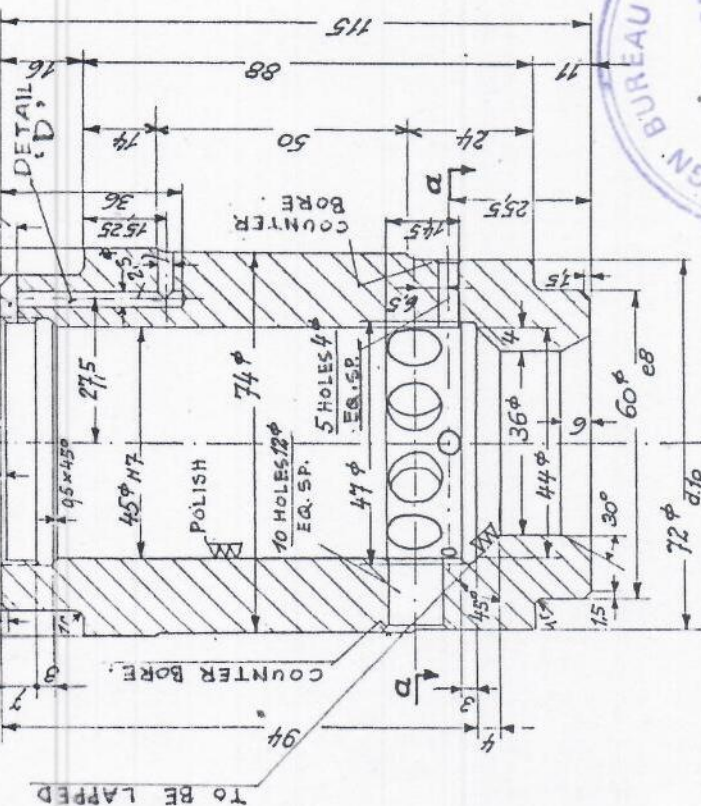
DRG. NO. TO BE PUNCHED ON THE ITEM

BHARAT HEAVY ELECTRICALS LTD.
UNIT : CENTRAL FOUNDRY FORGE PLANT.
HARDWAR.

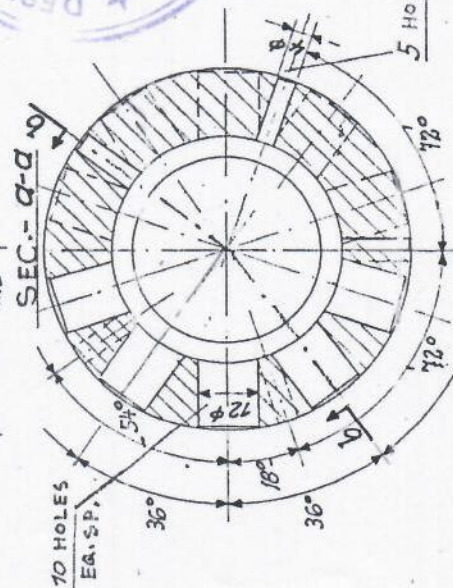
DEPT.	DESIGN	SCALE	1' = 1'	WEIGHT (KGS.)	2.1	24.260 - 434				4
TITLE VALVE SEAT MU-26 FOR MAIN CONTROL, PRESS 75/90 MN.						DRAWN	NAME	SIGN	DATE	
						WORKED	ASHOK KUMAR	ASHOK	6.5.98	
						CHECKED	PBG			
						APPROVED	PBG		20/5/98	
						DRAWING NO.		021-01-079		0
						SHEET NO.		1		NO OF SHEETS

MATERIAL: GAlMBz 10
(FORGED ALUMINIUM BRONZE-10)

2. PIN



TO BE LAPPED



INVENTORY NO. FF 8181010795

TOP VIEW

DETAILS 'D'

475 d10	- 0.1 - 0.22
465 e8	- 0.06 - 0.1
445 H7	+ 0.045 0
460 e8	- 0.06 - 0.1
472 d10	- 0.1 - 0.22

MATERIAL: GAIMBZIO
(FORGED ALUMINIUM
-BRONZE - 10)

ORG. NO. TO BE PUNCHED ON THE ITEM

BHARAT HEAVY ELECTRICALS LTD.
UNIT : CENTRAL FOUNDRY FORGE PLANT.
HARDWAR.

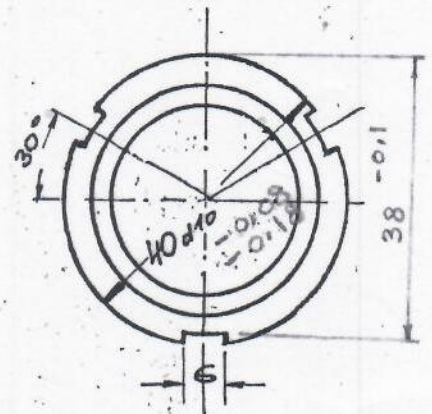
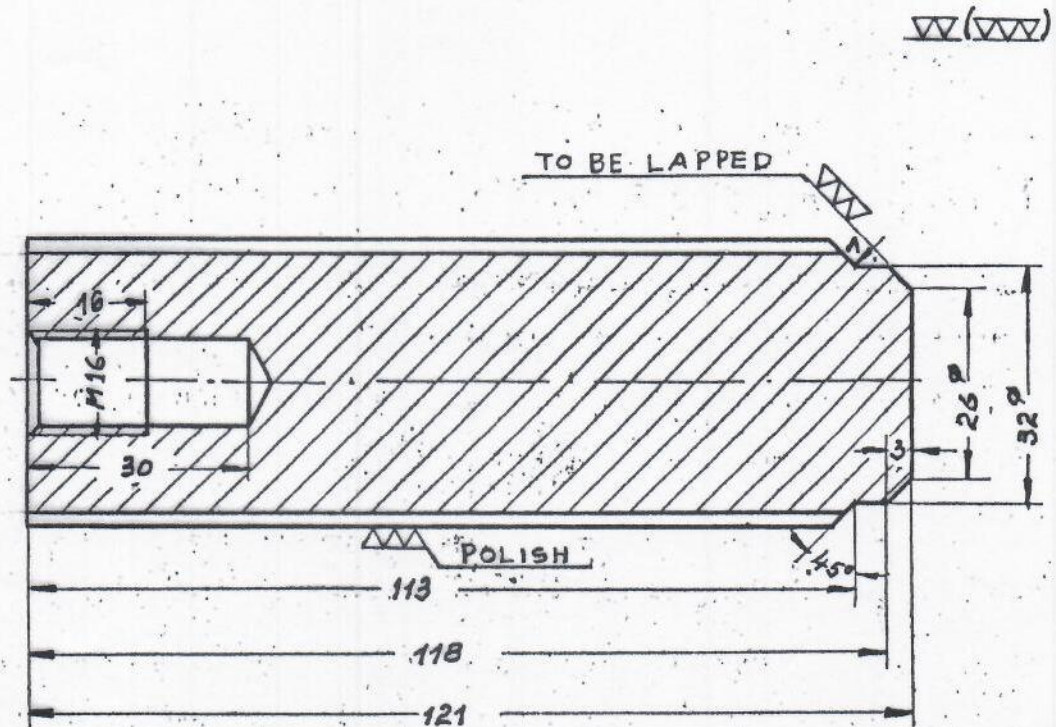
DEPT.	DESIGN.	SCALE	1:1	WEIGHT (KGS)	2.13	24-260-A85	1,9
TITLE				VALVE SEAT E 36 F FOR LONG TRAVEL, 75/90 MM. PRESS.			
				DRAWN	NAME	SIGN	DATE
				WORKED	ASAD KADHAN	Shah	27-4-9
				CHECKED	PBG		
				APPROVED	PBG		
				DRAWING NO.		021-01-074	0
				SHEET NO.		1	NO OF SHEETS
							1

506 43

FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

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REV	DATE	ALTERED	REV	DATE	ALTERED
		CHECKED			CHECKED



MATERIAL: GAIMBZ 10

(FORGED ALUMINIUM BRONZE - 10)

DRG. NO. TO BE PUNCHED ON THE ITEM



BHARAT HEAVY ELECTRICALS LTD.

UNIT: C.F.F.P., HARDWAR.

DEPT.	CODE	SCALE	WEIGHT (KG)	REF. TO ASSY. DRG.	ITEM NO.																
		1:1	1.5																		
VALVE CONE MU-26 FOR MAIN CONTROL, PRESS 75/90 MN.			<table border="1"> <tr> <td></td> <td>NAME</td> <td>SIGN.</td> <td>DATE</td> </tr> <tr> <td>DRAWN</td> <td>ASHOK K.R.</td> <td>Gshok</td> <td>5-5-98</td> </tr> <tr> <td>CHECKED</td> <td>PBG</td> <td></td> <td></td> </tr> <tr> <td>APPROVED</td> <td>PBG</td> <td></td> <td></td> </tr> </table>				NAME	SIGN.	DATE	DRAWN	ASHOK K.R.	Gshok	5-5-98	CHECKED	PBG			APPROVED	PBG		
	NAME	SIGN.	DATE																		
DRAWN	ASHOK K.R.	Gshok	5-5-98																		
CHECKED	PBG																				
APPROVED	PBG																				
Dimensions to be Controlled Within Limits as Shown Machining Tolerance + .25 mm Unless Otherwise Shown. Non Machining Tolerance ±			CARD CODE 15	DRAWING NO. 021-01-078 SHEET NO. 1 NO. OF SHEETS. 1																	

SIZE: A4

24.260 - 434
Ref. Drg. No. ITEM - 3

Sign. & Date

Inventory No.

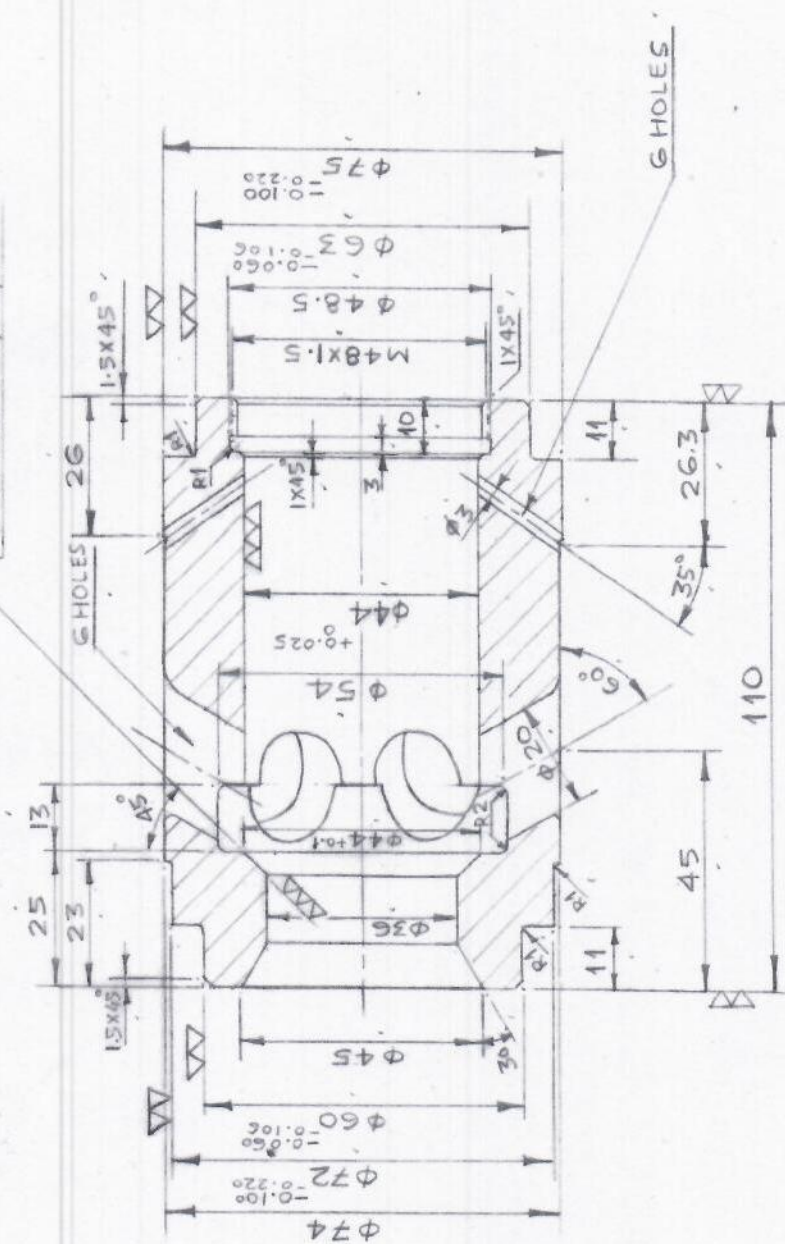
FF8181011260

ST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN M.M.)

ST ANGLE PROJECTION

THIS SURFACE SHOULD
MATCH PERFECTLY
WITH SURFACE IN
DRG. NO. 021, 01106

$$(\Delta\Delta\Delta, \Delta\Delta)\Delta$$


DRUG NO. TO BE PUNCHED ON THE ITEM.

BHARAT HEAVY ELECTRICALS LIMITED.
UNIT:CENTRAL FOUNDRY FORGE PLANT.

HARDWARE

DEPTT. DESIGN BUREAU		SCALE 1:1	WEIGHT(KGS.) 2.0	REF. TO ASSY. DRG.	ITEM NO.
TITLE VALVE SEAT RV 3G FOR 75/90 MN FORGING PRESS				DRAWN KISHORILAL	SIGN. [Signature]
				CHECKED P.B. GUPTA	DATE 13.9.00
				APPROVED P.B. GUPTA	[Signature] 13.9.00
DRAWING NO. 021, 01, 105			REV. 0		
SHEET NO. 1			NO. OF SHEETS 1		

Dimensions to be controlled within limits as shown
Machining Tolerance ± 0.25 mm Unless Otherwise
Shown. Non Machining Tolerance $\pm$

SHEET NO.	1	NO. OF SHEETS
-----------	---	---------------

SIZE-A.3

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Ref. Drg. No. 24-260-464
ITEM NO. 1

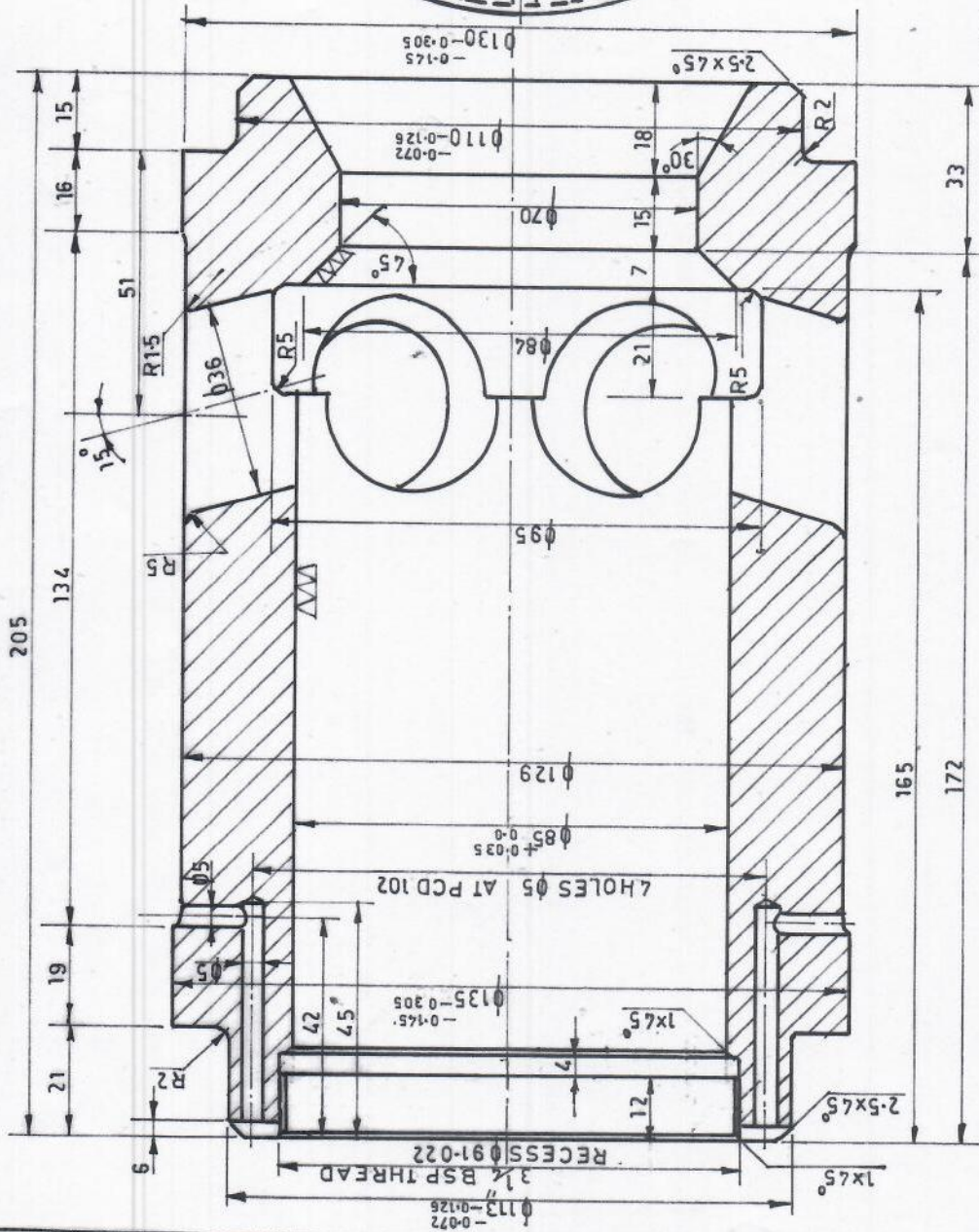
Sign & Date

Inventory No.

FF8181011341

FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

W(WW)



MATERIAL - FORGED
ALUMINUM BRONZE 10 (GALMBZ10)

DRG. No. TO BE PUNCHED ON THE ITEM.

BHARAT HEAVY ELECTRICALS LTD.
UNIT : CENTRAL FOUNDRY FORGE PLANT.
HARDWAR.

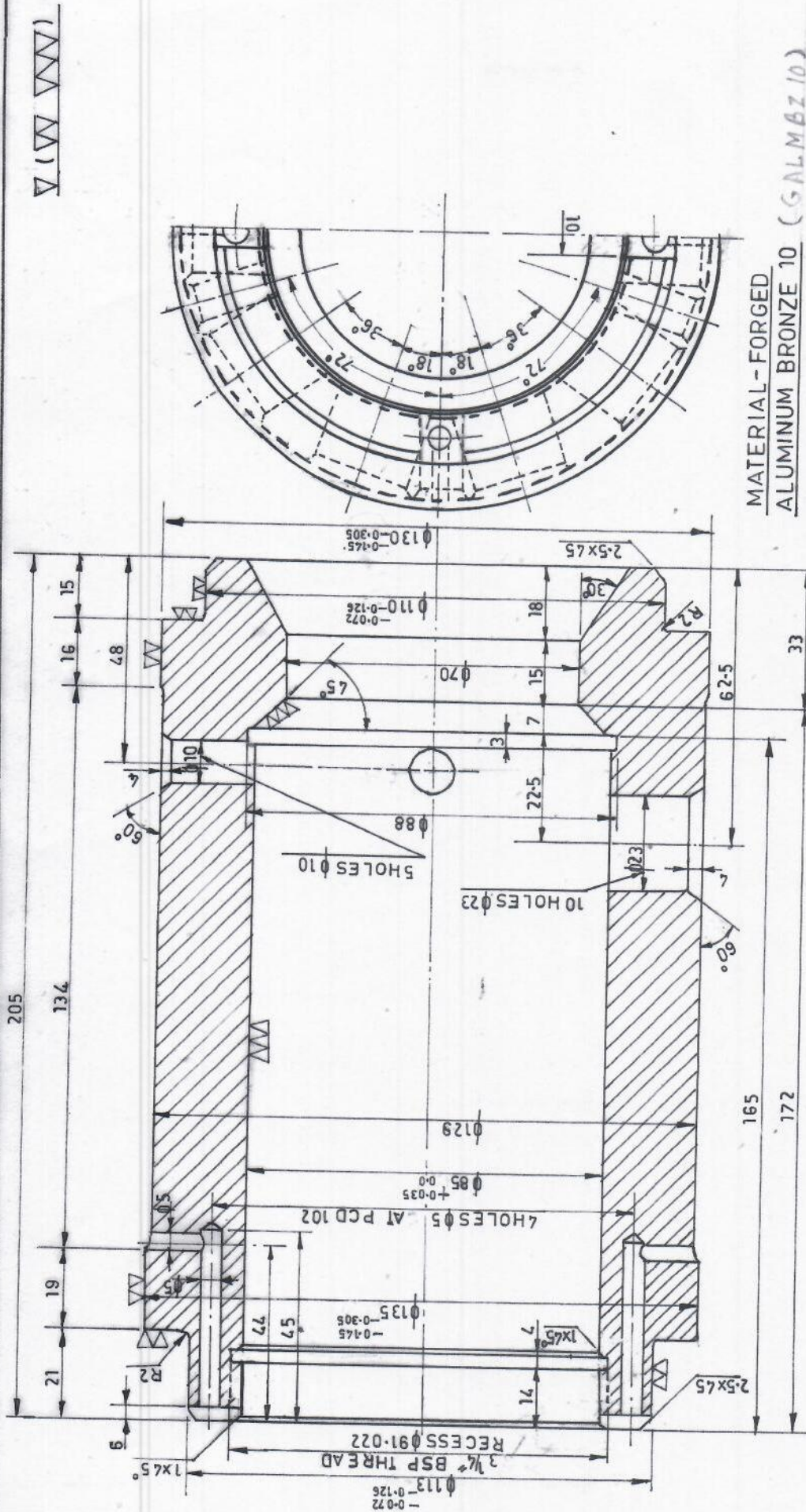


DEPT.	SCALE	WEIGHT (KGS)	REF. DRG NO	ITEM NO
	1:1	13.5	22-260-432	61
TITLE VALVE SEAT FOR ME 070				
MAIN & AUX. CONTROL UNIT OF 75/90				
MN PRESS				
DRAWN		NAME		SIGN
V. K. SHARMA		P. B. GUPTA		28-3-97
WORKED		APPROVED		21-01-068
CHECKED		DRAWING NO.		REV.
-DO-		021-01-068		0
SHEET NO. - 1		NO OF SHEETS - 1		SIZE - A3



INVENTORY NO FF 8181011198

FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)



MATERIAL - FORGED

ALUMINUM BRONZE 10 (GALMBZ 10)

DRG NO. TO BE PUNCHED ON THE ITEM



BHARAT HEAVY ELECTRICALS LTD.
UNIT : CENTRAL FOUNDRY FORGE PLANT.
HARDWARE.

DEPT.	SCALE	WEIGHT (KGS)	ITEM NO	DATE	SIGN
	1:1	13.5	22-260-433	27.3.97	
TITLE VALVE SEAT FOR ME 070					
FOR MAIN CONTROL UNIT OF 75/90 MN					
PRESS					
DRAWN	V.K. SHARMA	NAME			
CHECKED	P.B. GUPTA	WORKED			
APPROVED	-DO-	CHECKED			
DRAWING NO.	021-01-067	REV.			
SHEET NO. - 1		NO OF SHEETS - 1			



INVENTORY NO. FF 2181011201

19

SIZE - A3

