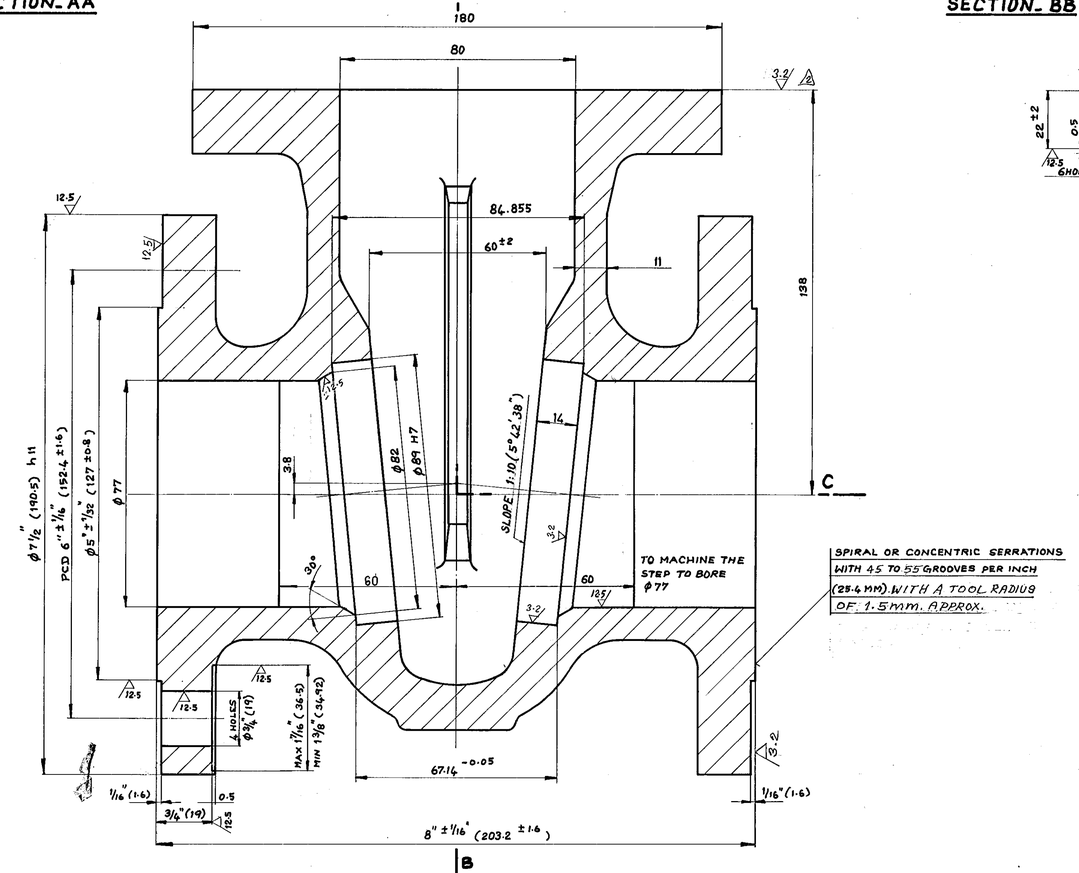
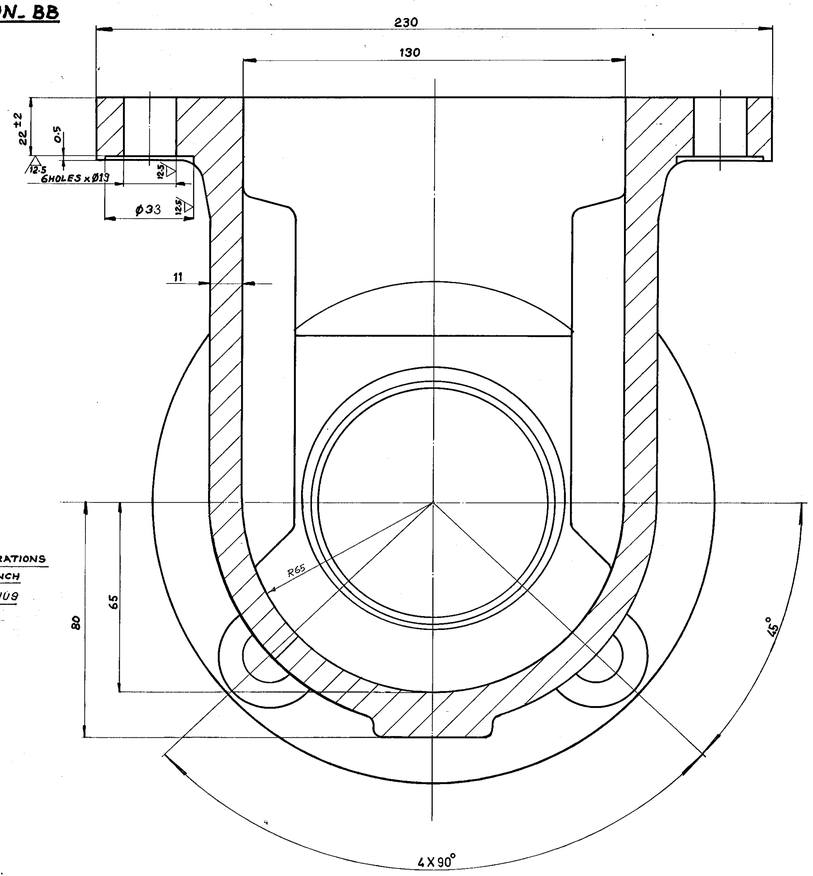
FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP/QP

SECTION-AA



SPIRAL OR CONCENTRIC SERRATIONS WITH 45 TO 55 GROOVES PER INCH (25.4 MM). WITH A TOOL RADIUS OF 1.5 mm. APPROX.

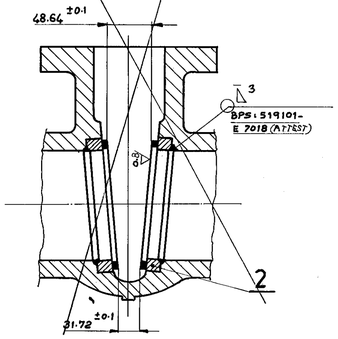
SECTION-BB



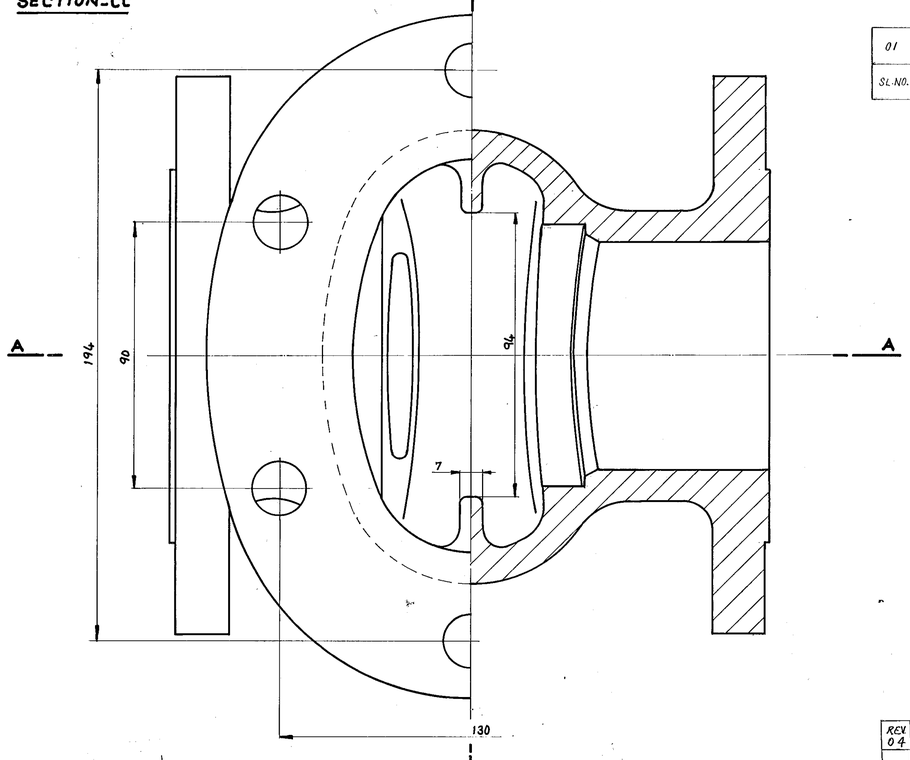
Ø89 H7	+0.035 / 0
Ø190.5 h11	0 / -0.290

BODY ASSEMBLY

AFTER SEATRING WELDING.



SECTION-CC



SL.NO.				
01	I-V-N025-02864/04	93102 622 0000	A 216 WCB NR (ATTEST)	10
	I-V-N025-02864 R/02	92 0270370000		
	DRAWING NO.	COMP CODE	MATL. SPECN.	SCRAP SORT
	BODY CASTING DRAWING NO.	MATL CODE		

REV	DATE	ALTD:- T.L.R	CHD & APPD:-
04	19.4.99		

SERRATION NOTE MODIFIED TO LATEST STD. REFER DCN. CS: 1003

	DATE	ALTD:- T.L.R	CHD & APPD:-
03	19.02.96		

FLANGE FACING NOTES REVISED TO THE LATEST 672. TABULATION MODIFIED REFER DCN. CS: 0554

	DATE	ALTD:- T.L.R	CHD:- S.K.
02	27.11.93		

SURFACE FINISH 12.5 WAS 3.2 & BODY VASSY DETAIL DELETED REFER DCN. No. CS: 0224

	DATE	ALTERED	L. Rangasamy
	7.10.92	CHECKED	S.K.

1) Ø194 Ø33 WERE Ø18 Ø30 RESPECTIVELY
2) DCN. No. CV/0059 DT: 6.10.92

ZONE

BHARAT HEAVY ELECTRICALS LTD.,
BOILER PLANT UNIT, TIRUCHIRAPALLI-14

FIRST ANGLE	SCALE	DRAWN	J. PRABAKAR
		CHECKED	
		APPROVED	S. KUMAR
ALL DIMENSIONS IN MILLIMETRES		DATE	16 06 89

TOTAL NET WT (KG): 16.63
TYPE:
NEW/OLD DRG. NO.:

CAUTION
THE INFORMATION CONTAINED IN THIS DRAWING IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LTD., BOILER PLANT UNIT, TIRUCHY-14 AND SHALL NOT BE USED WITHOUT THEIR EXPRESS WRITTEN PERMISSION IN ANY FORM OR PART THEREOF FOR ANY OTHER PURPOSE THAN FOR WHICH IT IS SENT TO YOU.

33-113

TITLE: BODY (3" 150 CLASS)

DRAWING NO.: 1-V-N025-02864

REVISION: 04