

11/90330-0000-2-V-0000-03306/17
DRAWING NO.
ON DIMENSIONS

ALL DIMENSIONS ARE IN MILLIMETRES. FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP / QP

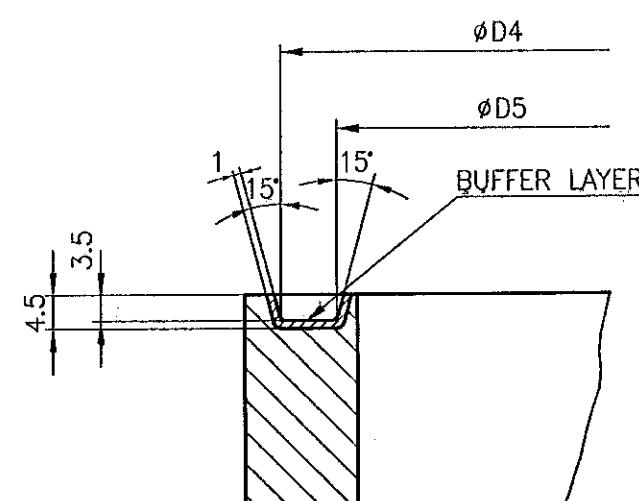
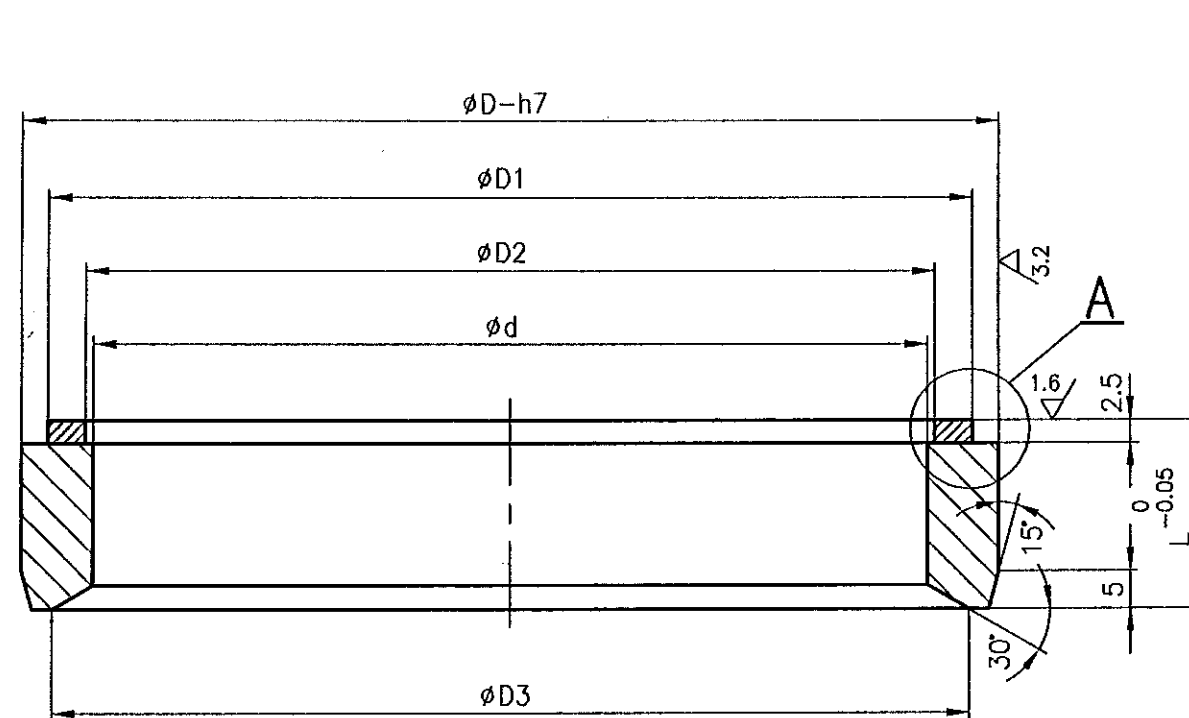
SL. No.	DRAWING No.	COMP.CODE	MATL.SPECN.	DIMENSIONS										SEAT RING Wt.(Kg)	SEAT Wt.(Kg)	ASSY. Wt.(Kg)	SCRAP SORT	APPLICABLE VALVES	SEAT HARDFACE	
				ØD	ØD1	ØD2	ØD3	ØD4	ØD5	Ød	L								SEAT BUFFER LAYER	SEAT FINAL LAYER
1	2-V-N001-03306/07	931021050000	SA515 Gr.70 NORMALISED CERTIFY	170	164	156	163	165	155	152.4	25.5			0.893	0.03	0.923	10	6"-C150	E430	E410
2	2-V-N009-03306/08	931025440000		224	217	209	214	218	208	203.2	24.5			1.16	0.06	1.21	10	8"-C150	E430	E410
3	2-V-N017-03306/06	931025710000		180	172	159	165	173	158	152.4	25.5			1.20	0.08	1.33	10	6"-C300	E430	E410
4	2-V-N025-03306/07	931026460000		89	88	80	82	89	79	77	18.5			0.196	0.012	0.208	10	3"-C150 3"-C300	E430	E410
5	2-V-N033-03306/06	931026240000		122	114	106	110	115	105	102	15.5			0.414	0.016	0.43	10	4"-C150	E430	E410
6	2-V-N041-03306/07	931026250000		330	322	312	319	323	313	$\begin{smallmatrix} +0.1 \\ 0 \\ 305 \end{smallmatrix}$	24.5			2.35	0.077	2.43	10	12"-C150	E430	E410
7	2-V-N057-03306/06	931027840000		278	269	260	266	270	259	254	24.5			1.65	0.07	1.72	10	10"-C150	E430	E410
8	2-V-N065-03306/06	931027850000		294	281	260	267	282	259	254	24.5			2.84	0.19	3.03	10	10"-C300	E430	E410
9	2-V-N089-03306/07	931031300000		234	227	211	214	228	210	203.2	24.5			1.75	0.14	1.89	10	8"-C300	E430	E410
10	2-V-N097-03306/05	931032840000		124	117	108	112	118	107	102	15.5			0.46	0.03	0.490	10	4"-C300	E430	E410
11	2-V-N105-03306/06	931039460000		340	333	310	319	334	309	$\begin{smallmatrix} +0.1 \\ 0 \\ 305 \end{smallmatrix}$	24.5			2.90	0.24	3.14	10	12"-C300	E430	E410
12	2-V-N204-03306/02	931067020000		170	164	156	163	--	--	152.4	25.5			0.893	0.03	0.923	10	6"-C150	NO.LAYER	E308
13	2-V-N205-03306/02	931067030000		224	217	209	214	--	--	203.2	24.5			1.16	0.06	1.21	10	8"-C150	NO.LAYER	E308

12.5 / 3.2 / 1.6

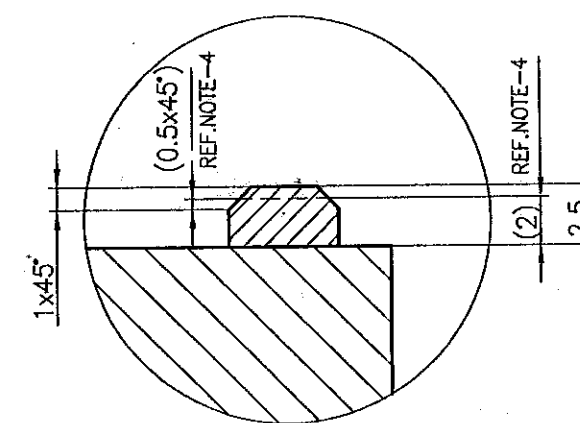
Ø 80-Ø 120 h7	-0.035 0
Ø 120-Ø 180 h7	-0.040 0
Ø 180-Ø 250 h7	-0.046 0
Ø 250-Ø 315 h7	-0.052 0
Ø 315-Ø 400 h7	-0.057 0

NOTE:-

- SEAT HARDNESS 350 BHN (MIN.) FOR SL. No. 01 to 11.
- SHARP CORNERS TO BE ROUNDED OFF.
- FOR SL.NO.12 AND 13 NO BUFFER LAYER ONLY 18/8 S.S IS DEPOSITED AS HARD FACING MATERIAL.
- SEAT HEIGHT 2.5 AND 1x45° CHAMFER SHALL BE 2.0 AND 0.5x45° AFTER FINE MACHINING DURING ASSY.



BEFORE FINAL LAYER



DETAIL-A

No OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
	TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT							CS	
								DRG.RETRACED WITH REV. 17 ON 25.05.98 (REFER DCN.CS:0753,0427,790)	
								BHARAT HEAVY ELECTRICALS LTD. UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI-620014.	
								DRN K.P.LEON SIGN N.DHANAPAL DATE 25.05.98	
								CHD K.S.RAMAN DATE 25.05.98	
								APPD K.S.RAMAN DATE 25.05.98	
								REFERENCE INFORMATION CAD:C203306	
								DRAWING NO. 2-V-0000-03306	
								REV 17	

CAUTION: The information on this document is the property of BHARAT HEAVY ELECTRICALS LTD. It must not be used directly or indirectly in any way detrimental to the interest of the company.

REV	DATE	ALTERED
17	25.05.98	CHD & APPD
IN SL.Nos.6 & 11 TOLERANCE GIVEN FOR DIMN.Ød.		
REFER DCN CS:0865		