

FOUNDRY DIVISION

Ref: FYM/TDC/SF/02 - Rev 04.


Date: 03-05-2025

TDC FOR STATOR FRAME CASTING TO DRG NO. 04027140173 PATTERN NO 1241228

1. Casting specification: Grey Iron Casting – Gr. FG 200 as per AA19702 Rev no. 07.
2. Condition of delivery: Proof machined and primer coated. Refer casting Drg. 04027140173 Rev.04. Dimensions as shown in casting drawing 04027140173 Rev.04 in section A-A eg. Dia.610mm (at DE side End-shield bore) and Dia. 600 (NDE side End-shield bore) must be concentric. After facing operation at both ends of stator frame (in order to obtain perpendicularity during proof machining) vendor must obtain height 1365 with positive tolerance. The end faces should be parallel to each other. All other dimension shall be maintained according to casting deg
3. Dimensions and Tolerances: As per CI 5.0 of AA19702 Rev. no. 07.
4. Test samples: As per clause 11.0 of AA19702 rev. no. 07.
5. Mechanical Properties: Tensile and Hardness as per Cl.12.0 of AA 19702 rev. no. 07.
6. Inspection: As per Clause 16.0 of AA 19702 rev. no. 07. BHEL reserves the right to see the manufacturing of casting at any stage and at any time at vender's works.
7. Test Certificate: As per CI. 17.0 of AA 19702 Rev no 07.
8. Packing and Marking: As per Cl. 18.0 of AA 19702 rev. no. 07.
9. Cable channel areas of casting should be burr free.
10. If any defect is observed during final machining at BHEL Bhopal. BHEL reserves the right to reject the casting.

Note: a) Pattern equipment will be issued / supplied by BHEL. Vendor shall visit BHEL Bhopal for assessing the technical aspects like gating system, riser location etc. and condition of Pattern.

b) Inspection of first casting shall be done by BHEL, Bhopal representative. Only after clearance/Approval by BHEL, the vendor shall take up bulk manufacturing.
Not applicable for vendors, who have supplied such castings earlier to BHEL.


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FOUNDRY DIVISION

Ref: FYM/TDC/SF/01 – Rev 04


Date: 03/05/2025

TDC FOR STATOR FRAME CASTING TO DRG NO. 04027140171 PATTERN NO. 1241226

1. Casting specification: Grey Iron Casting – Gr. FG 200 as per AA19702 Rev no. 07.
2. Condition of delivery: Proof machined and primer coated. Refer casting Drg. 04027140171 Rev.05 Dimensions as shown in section A-A eg. Dia.540mm (at DE side End-shield bore) and Dia. 530 (NDE side End-shield bore) must be concentric and maintained in proof machining. Also after facing operation at both ends of stator frame (in order to obtain perpendicularity during proof machining) vendor must obtain height 1245 with positive tolerance. The end faces should be parallel to each other. All other dimensions shall be maintained according to casting drg.
3. Dimensions and Tolerances: As per CI 5.0 of AA19702 Rev. no. 07.
4. Test samples: As per clause 11.0 of AA19702 rev. no. 07.
5. Mechanical Properties: Tensile and Hardness as per Cl.12.0 of AA 19702 rev. no. 07.
6. Inspection: As per Clause 16.0 of AA 19702 rev. no. 07. BHEL reserves the right to see the manufacturing of casting at any stage and at any time at vender's works.
7. Test Certificate: As per CI. 17.0 of AA 19702 rev no 07.
8. Packing and Marking: As per Cl. 18.0 of AA 19702 rev. no. 07.
9. Cable channel areas of casting should be burr free.
- 10.If any defect is observed during final machining at BHEL Bhopal. BHEL reserves the right to reject the casting.

Note: a) Pattern equipment will be issued / supplied by BHEL. Vendor shall visit BHEL Bhopal for assessing the technical aspects like gating system, riser location etc. and condition of Pattern.

b) Inspection of first casting shall be done by BHEL, Bhopal representative. Only after clearance/Approval by BHEL, the vendor shall take up bulk manufacturing.
Not applicable for vendors, who have supplied such castings earlier to BHEL.


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