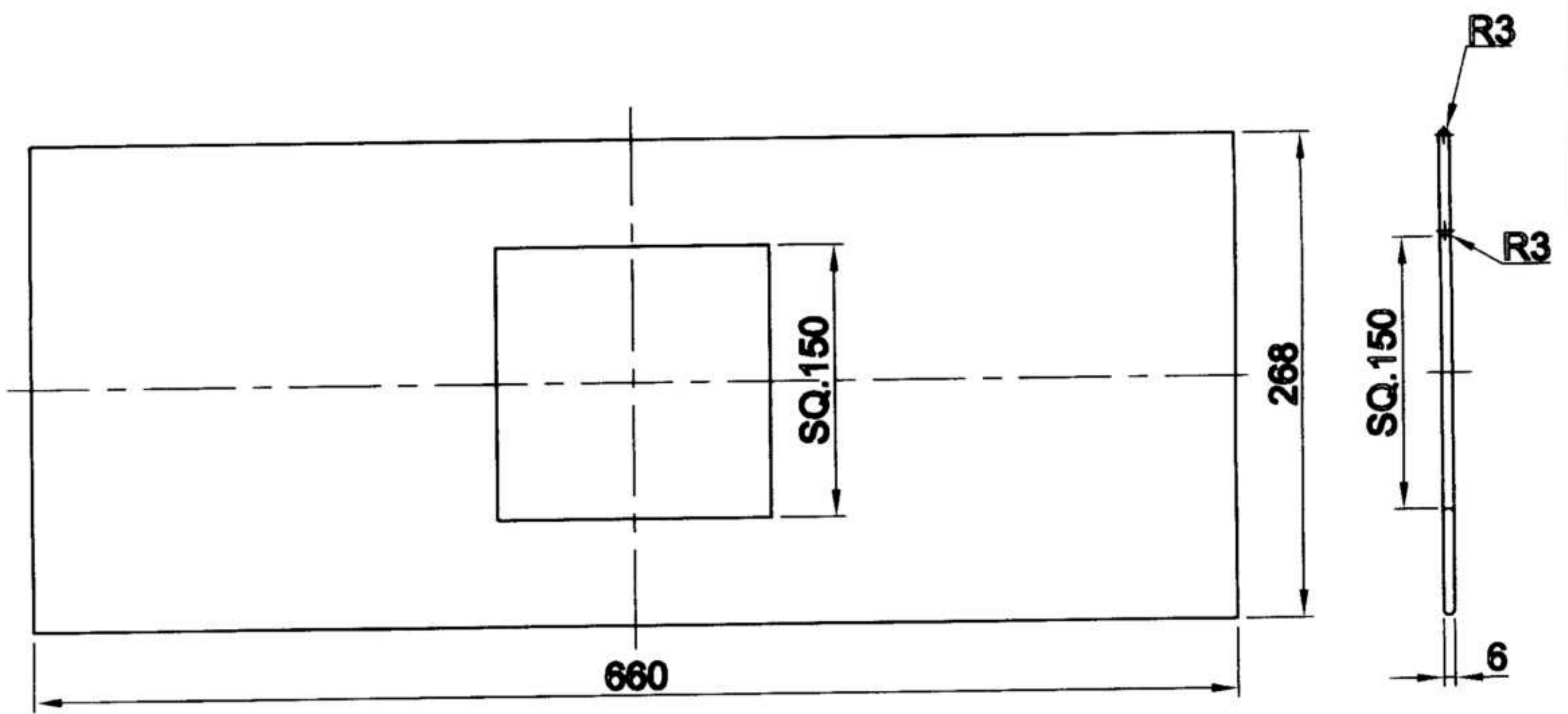


ALL DIMENSIONS ARE IN MM


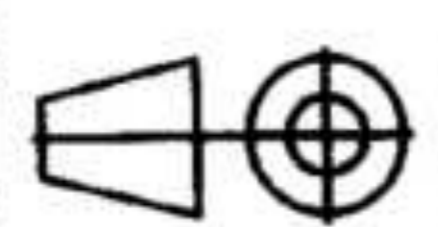

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IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANYWAY DETERMINANT TO INTEREST OF THE COMPANY

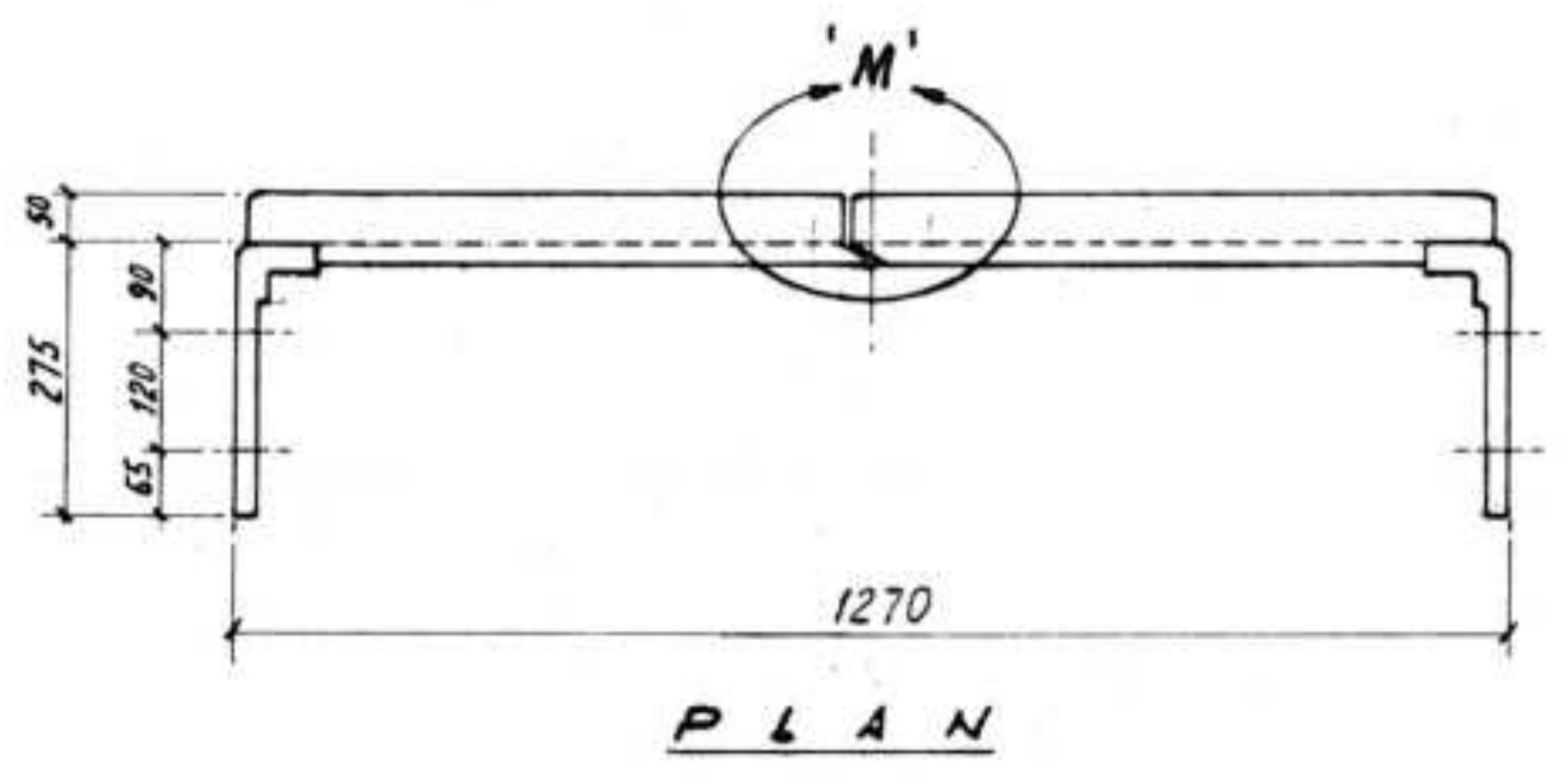
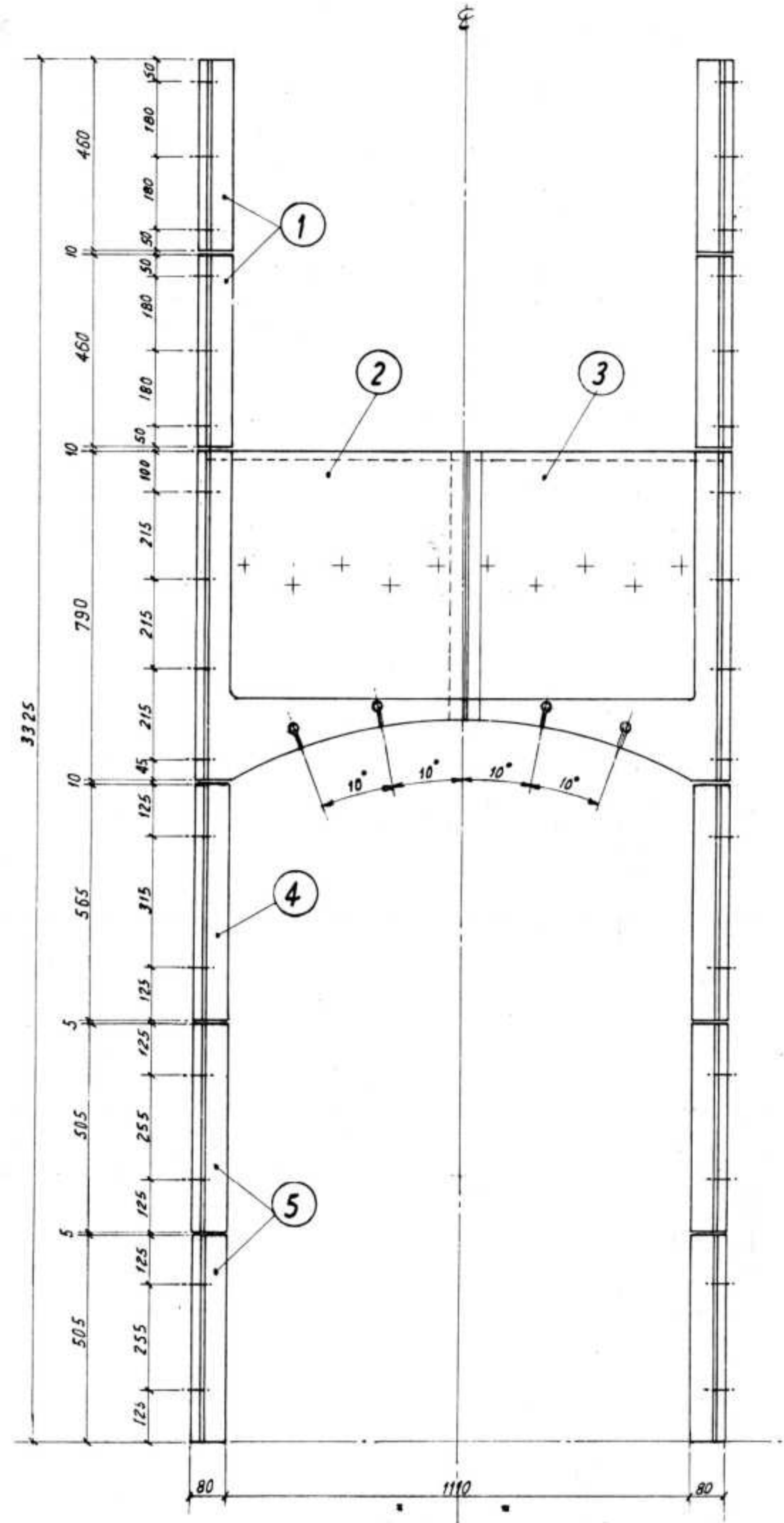
REV 01	DATE	ALTERED
		CHECKED
		APPROVED



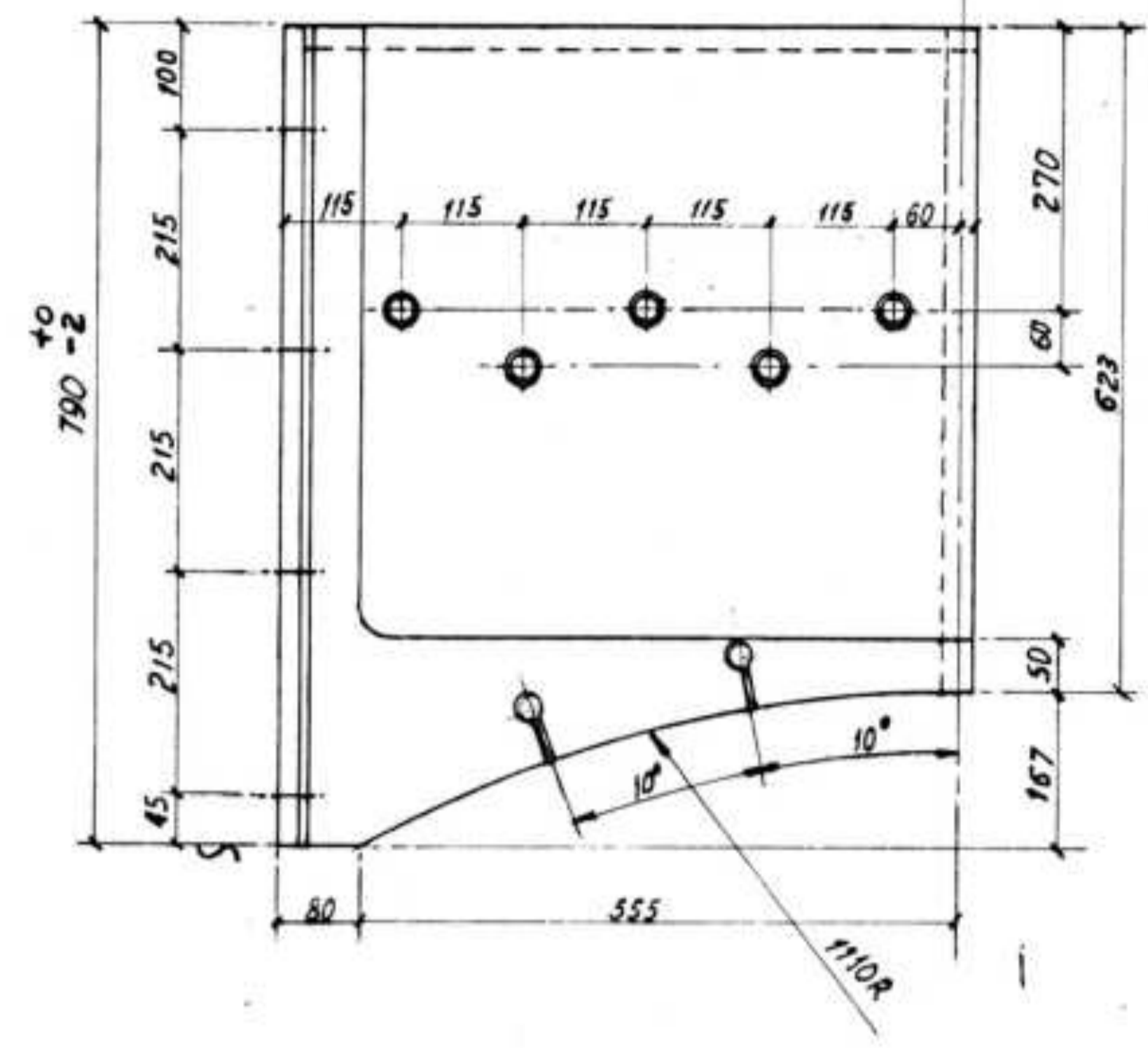
NOTES:-

1. ALL SHARP CORNERS ARE TO BE ROUNDED R3.WHERE NOT SPECIFIED WHERE NOT SPECIFIED
2. WEIGHT VARIATION ±5%
3. WARPAGE NOT TO EXCEED 3 TO 5mm IN ANY DIRECTION.

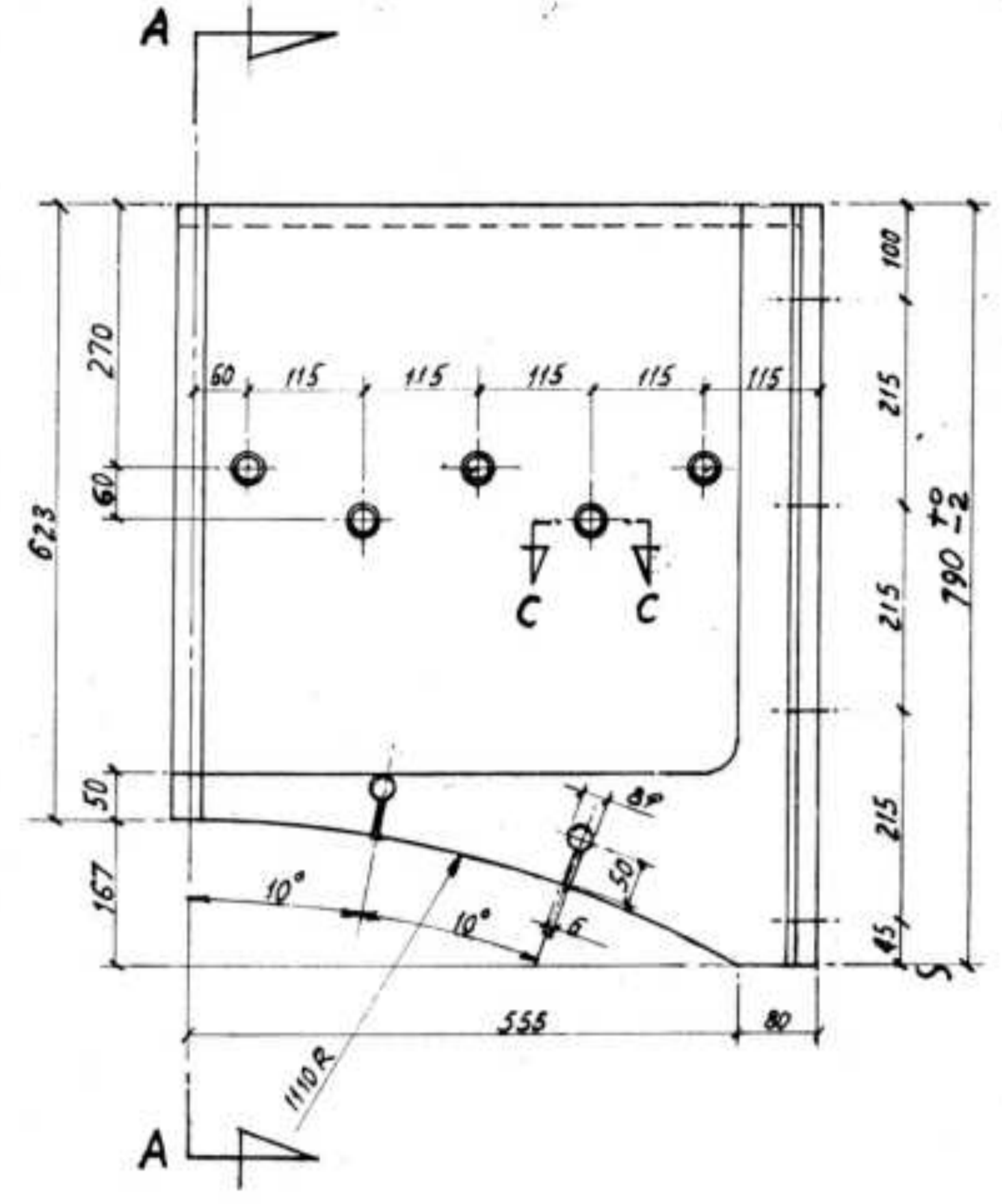
				HN Alloy (Grade-11 IS-4522)		
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE		UNIT WT	
			MATL SPEC		QTY	
EQPT: WALKING BEAM FURNACE						
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME SSN.KUMAR	SIGNATURE <i>S.S.N. Kumar</i>	DATE 15.12.04	
		CHD				
		APPD	S.SHANMUGASUNDARAM	<i>S. Shanmugasundaram</i>	16/12/06	
DEPT MPG	GRADE OF UNTOL. DIM <i>Q/M/P</i>		SCALE 1:5	WEIGHT (Kg) 8.3	REF TO ASSY DRG	ITEM NO
CODE					REF TO OLD DRG FA-0428-9A	
TITLE HEARTH TOP SEAL CASTING				CARD CODE U 01	DRAWING NO : 4-7-1150-02-06290	REV 00



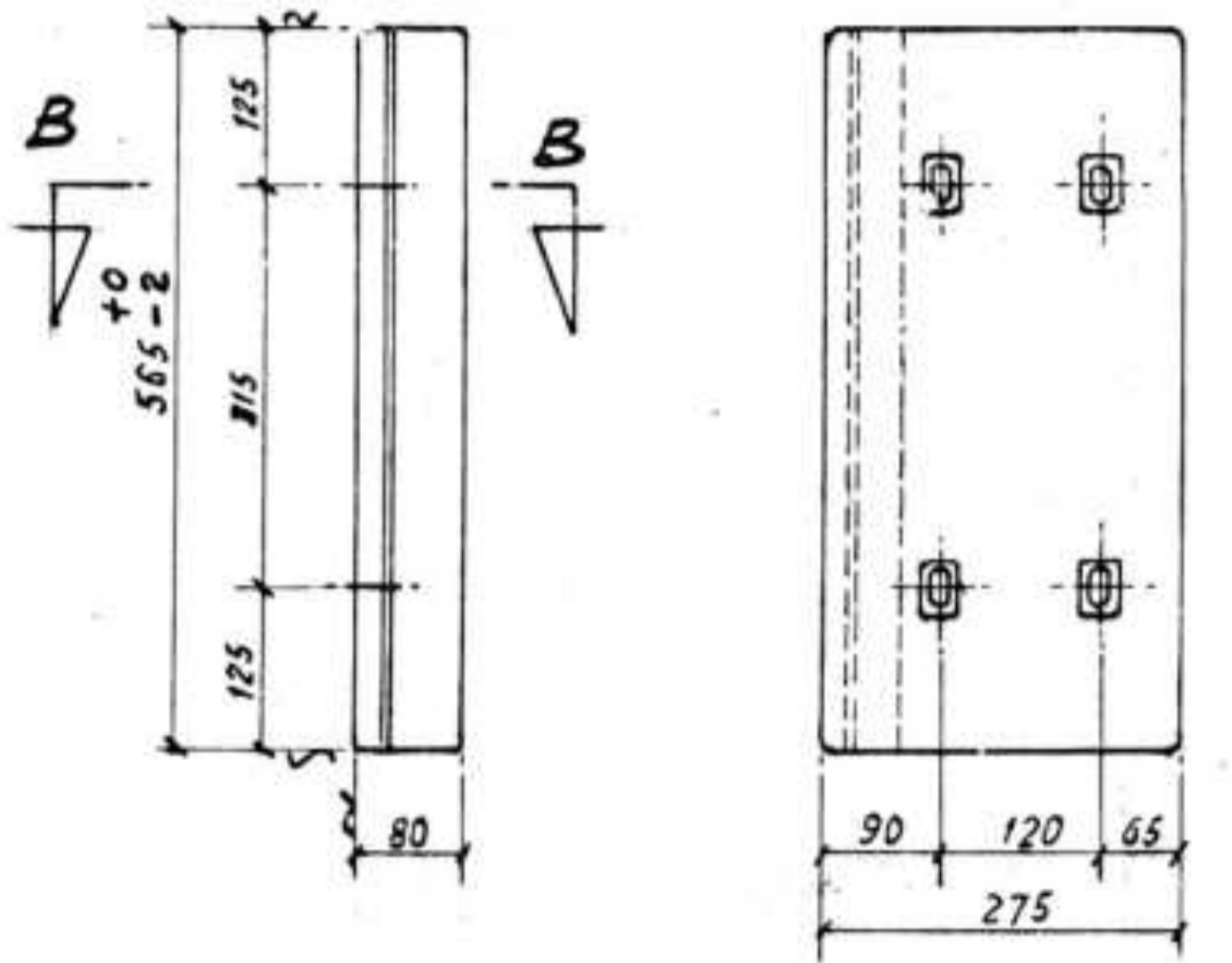
ASSEMBLY FOR CHARGE & DISCH. DOOR FRONT PLATE
2 SETS REQUIRED



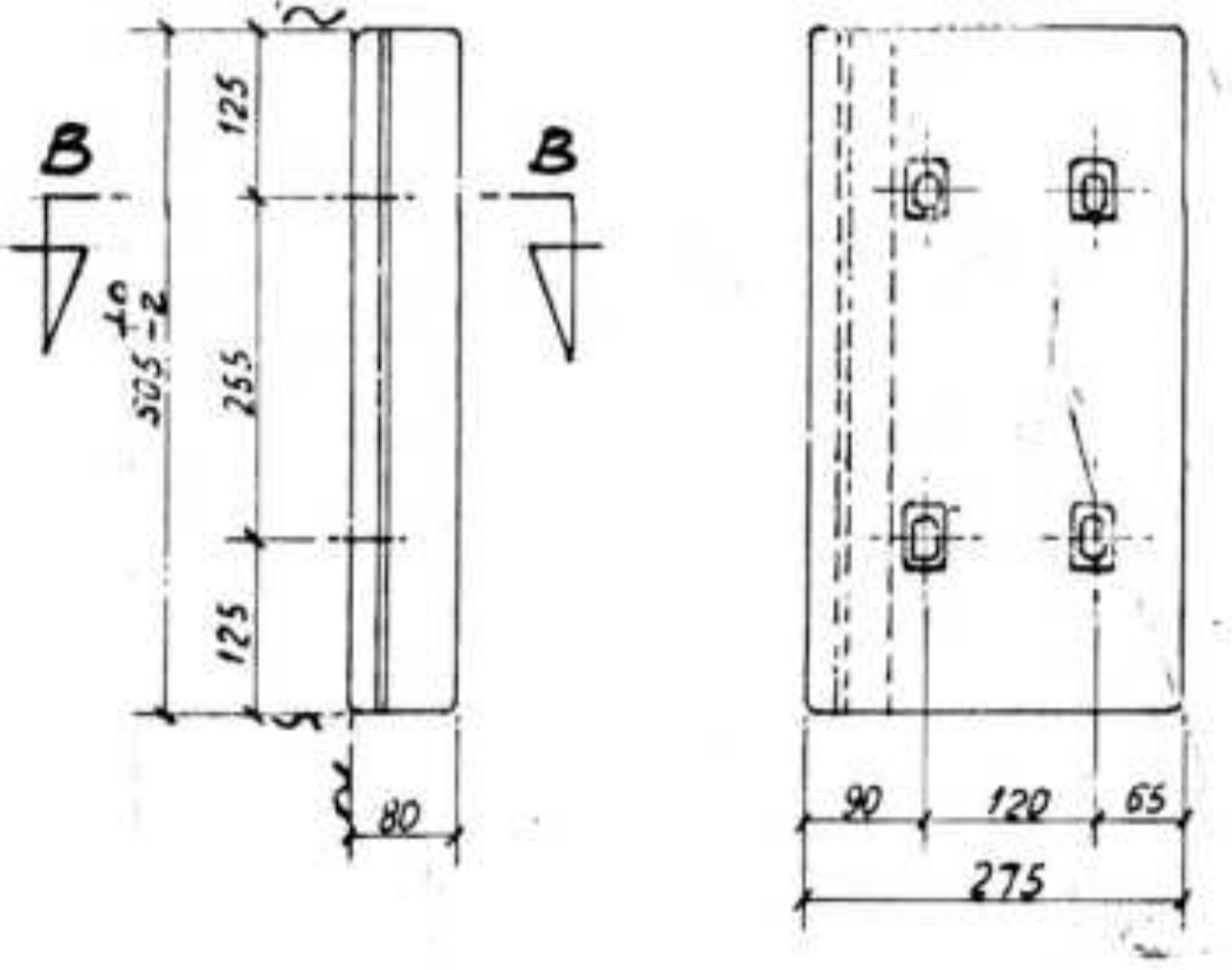
2 DOOR FRONT PLATE CASTING
Matl-HN Alloy(grade-11 IS-4522)
QTY. - 2 Nos.



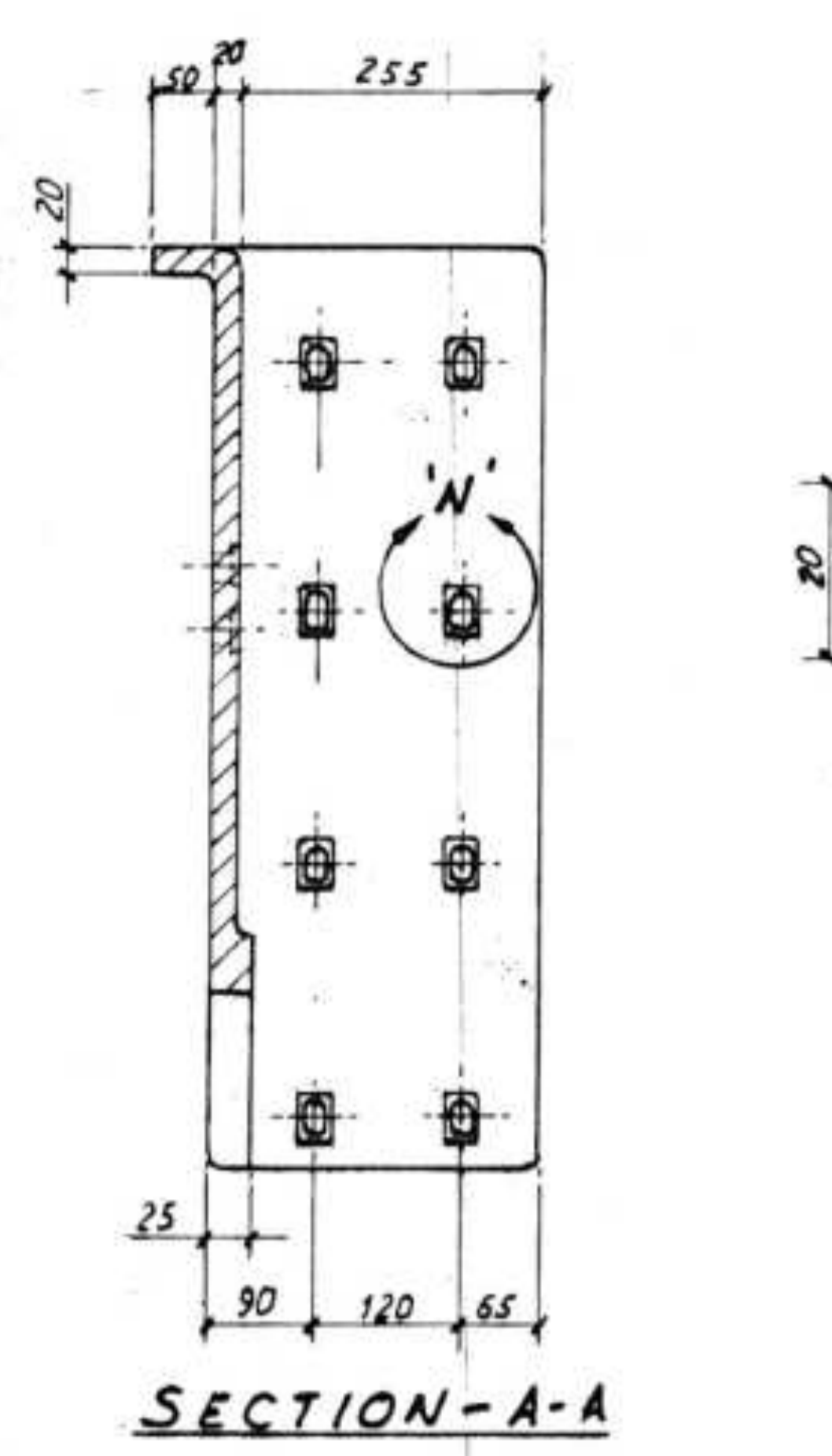
3 DOOR FRONT PLATE CASTING
Matl-HN Alloy(grade-11 IS-4522)
QTY. - 2 Nos.



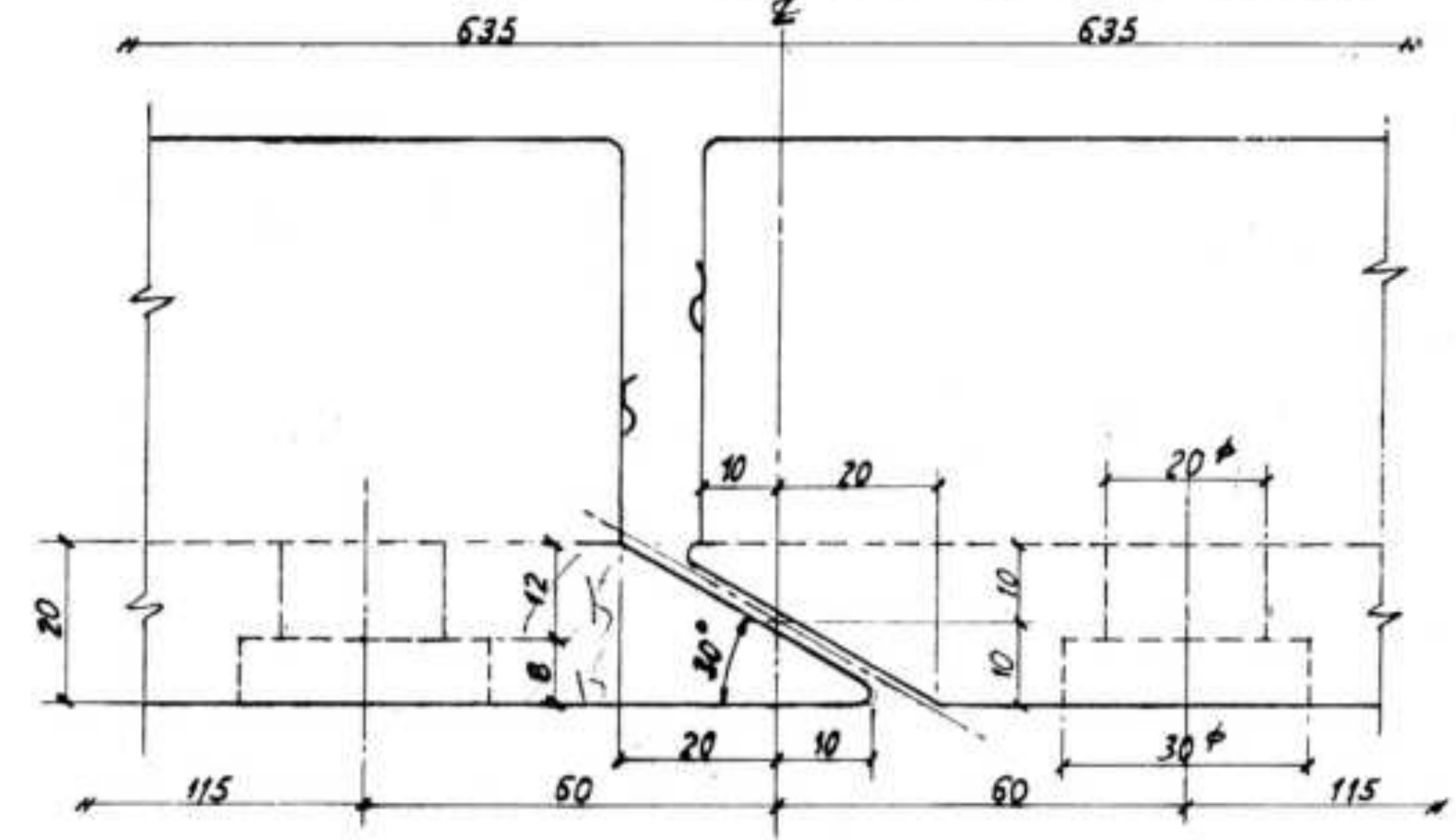
4 DOOR FRONT PLATE CASTING
MATL. - HK ALLOY (25% Cr. 20% Ni)
WT./PIECE = 27.4 KG.
QTY. - 4 Nos.



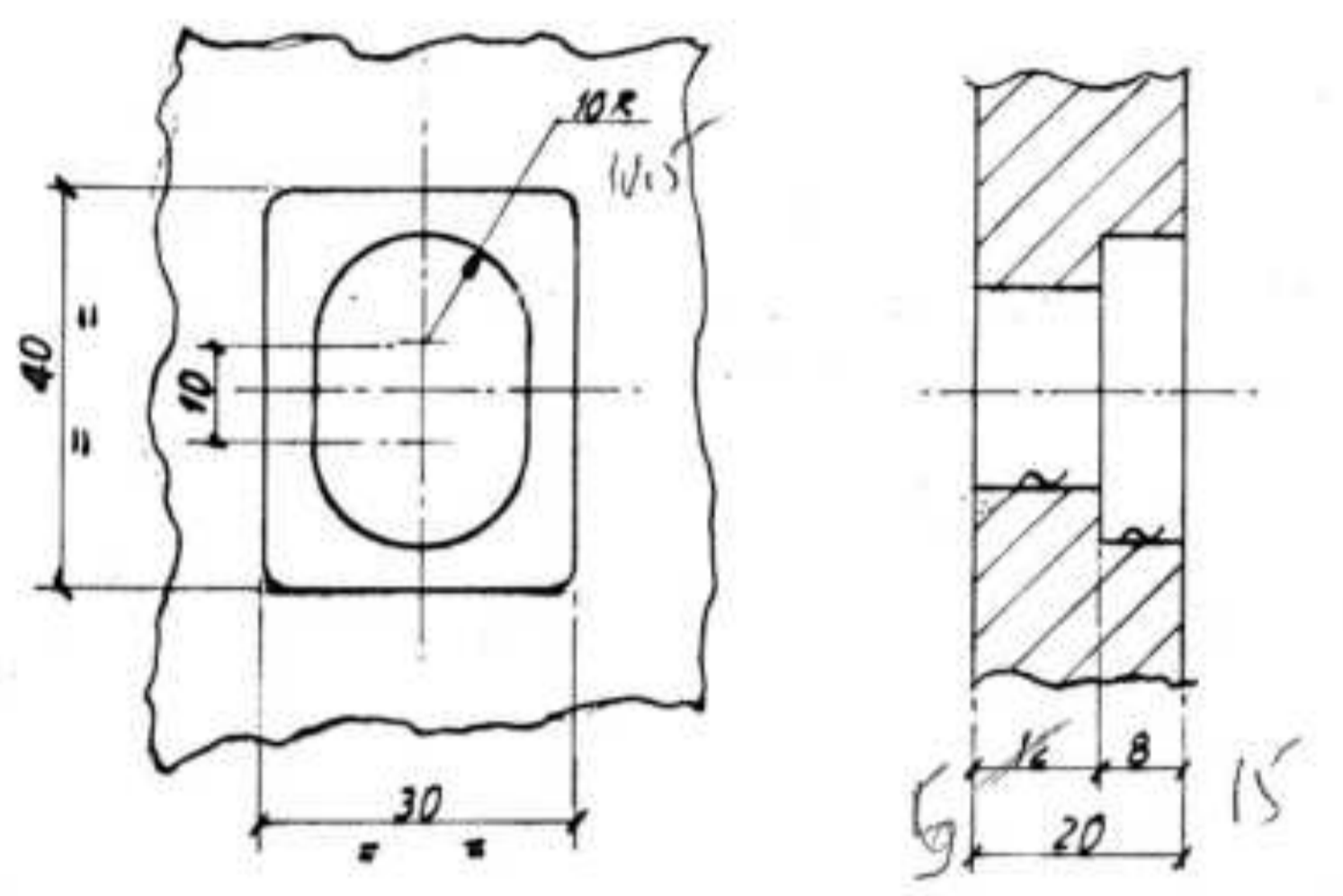
5 DOOR FRONT PLATE CASTING
MATL. - HK ALLOY (25% Cr. 20% Ni)
WT./PIECE = 30.7 KG.
QTY. - 8 Nos.



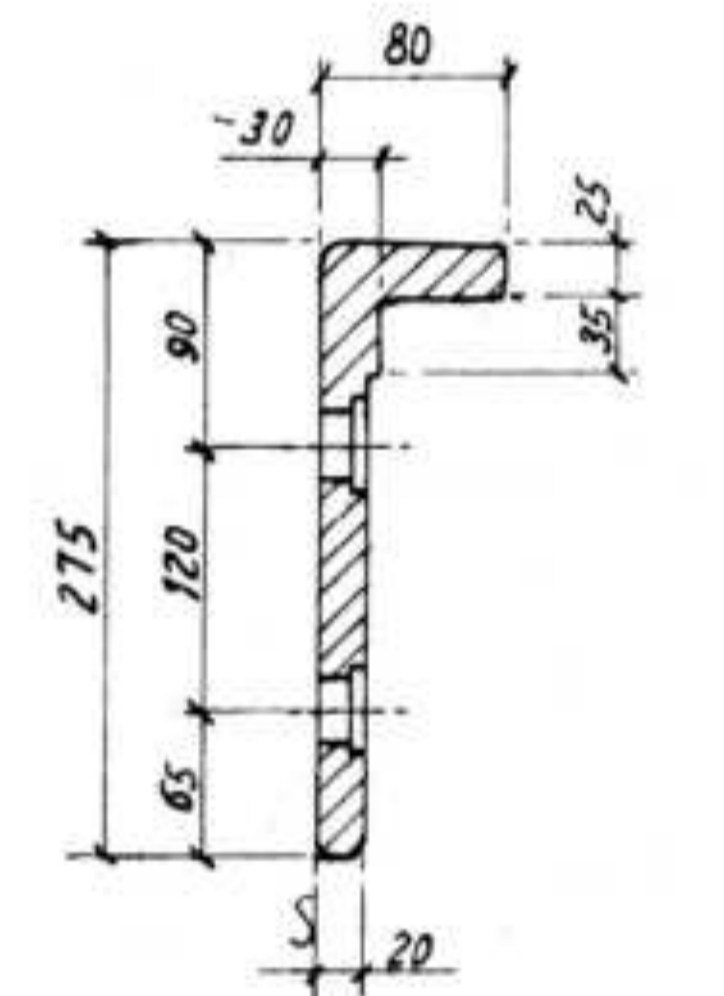
ENLGD. SECTION - C-C
(TYPICAL)



ENLGD. DETAIL - 'M'



ENLGD. DETAIL - 'N'
(TYPICAL)



ENLGD. SECTION - B-B

- NOTES:-
- CASTINGS TO BE MADE STRAIGHT, SMOOTH, TRUE TO DIMENSIONS AND FREE FROM FINS, SCABS, BLOWHOLES & COLD SHOTS.
 - SURFACES TO BE FINISHED SMOOTH BY SHOT BLASTING OR GRINDING
 - ALL CORNERS TO BE 5MM RADII UNLESS STATED OTHERWISE.
 - DENOTES GRINDING ~

REV	DATE	ALTY	CHK	ID

EQPT: ROTARY HEARTH FURNACE

SHARAT HEAVY ELECTRICALS LIMITED,
SEAMLESS STEEL TUBE PLANT- TIRUCHIRAPALLI-620 014

DPT. CODE: S5TP 456 SCALE: 1:10 WEIGHT (Kg): REF TO: FA-0427-9

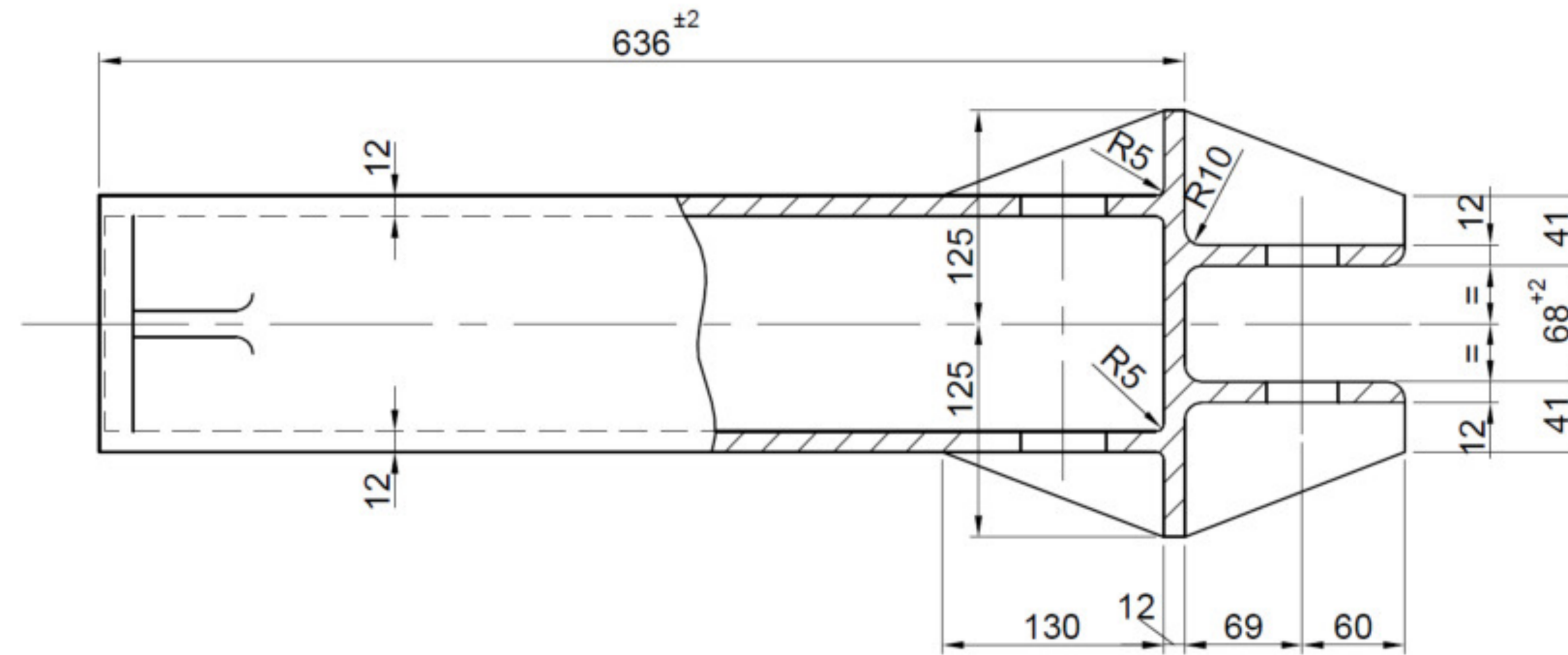
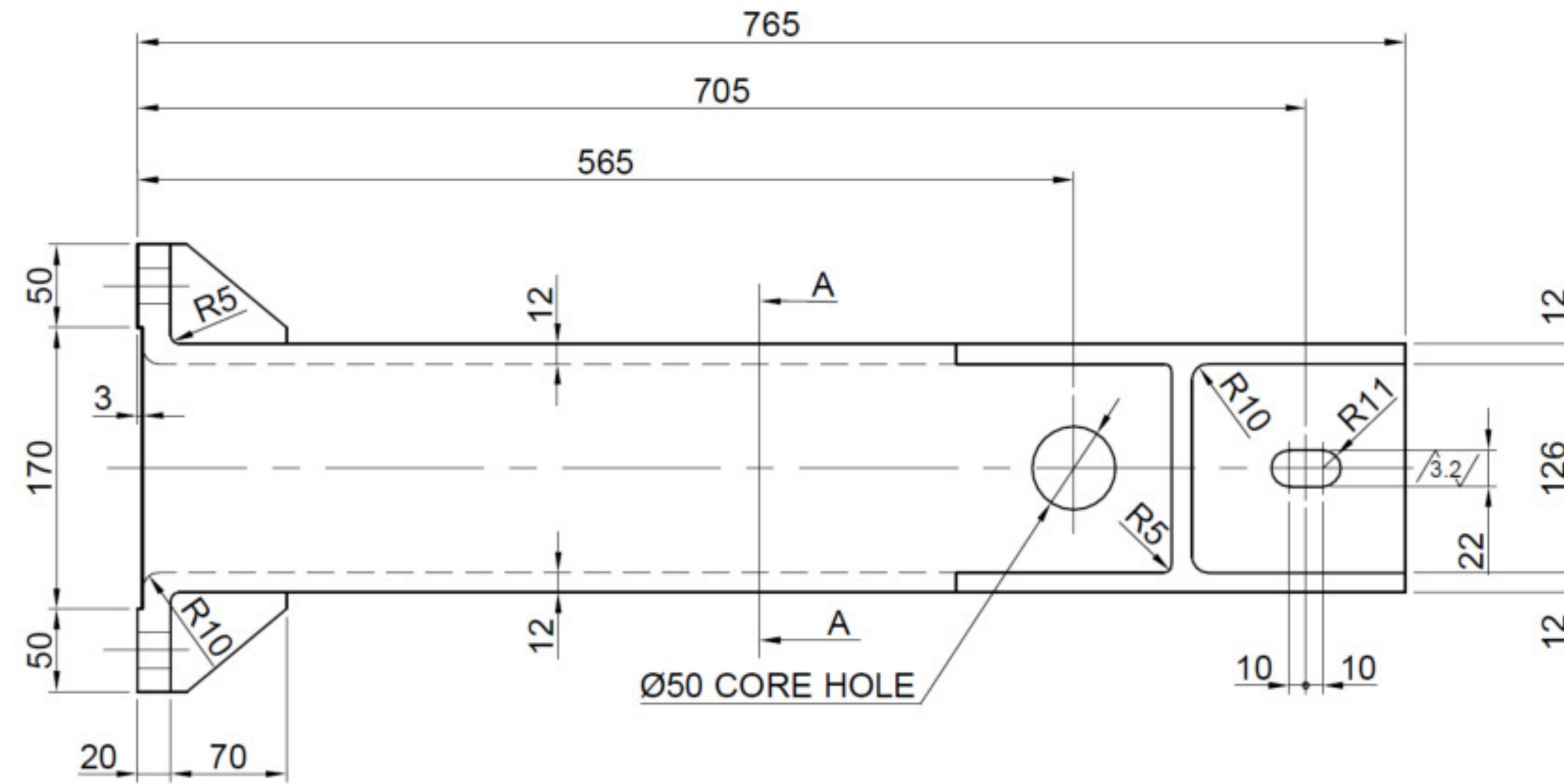
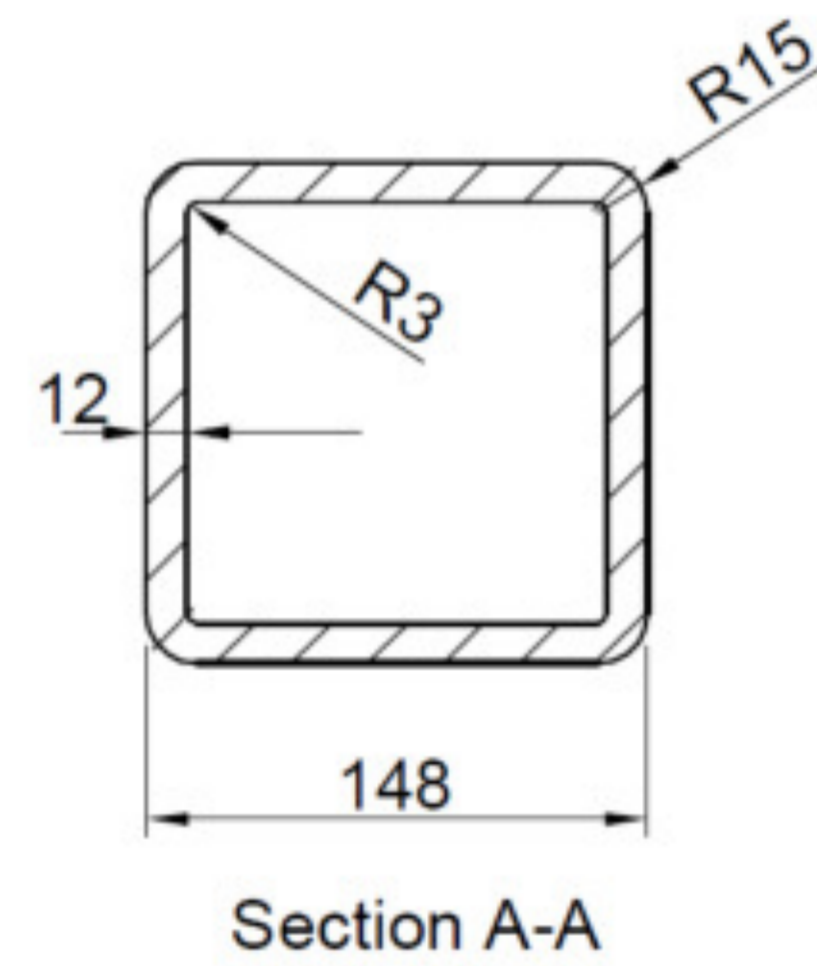
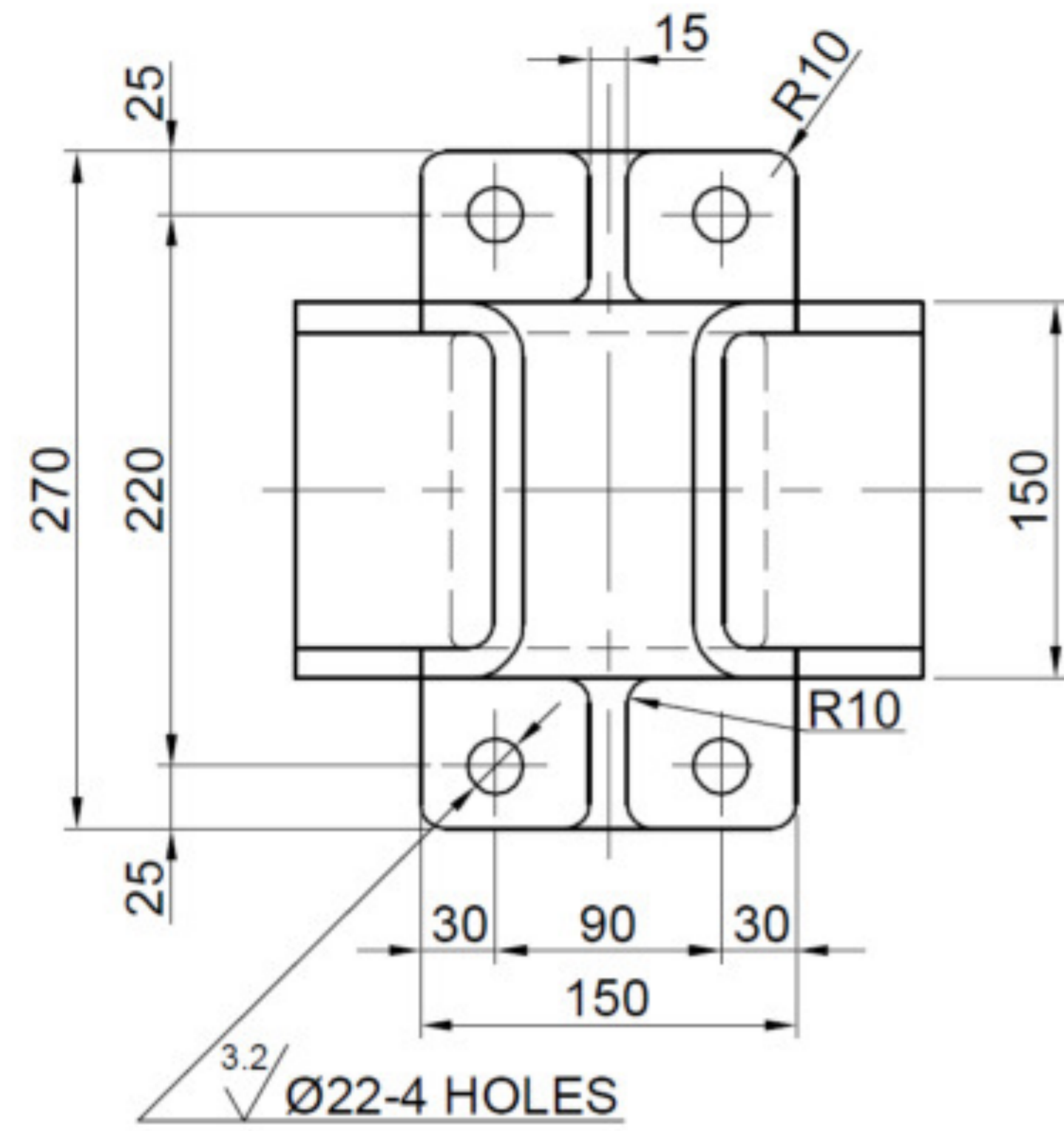
TITLE: CHARGE & DISCHARGE DOOR FRONT PLATE CASTING ARRGT. & DETAILS

DIMENSIONS TO BE CONTROLLED WITHIN LIMITS AS SHOWN. MACHINING TOLERANCE: 0.25MM UNLESS OTHERWISE SHOWN. NON-MACHINING TOLERANCE: 0.5MM

DRAWING No: 1-7-1101-07-01699

SHEET No: 60

APPROVED: R.R. Prabhakar



NOTES:

- 1.WEIGHT VARIATION 5%
- 2.WARPAGE NOT TO EXCEED 3mm IN LENGTH
- 3.ALL SHARP CORNERS TO ROUNDED BY R3 UNLESS OTHERWISE STATED
- 4.FOR ORIGINAL DESIGN REF DRG No.3-7-1150-05-01362

REV 02	DATE 01.02.12	ALTERED	<i>P. Mathavan</i>
		CHECKED	<i>S.S.V. Kumar</i>
		APPROVED	<i>R. Raghavver</i>

REV 01	DATE 08.12.89	ALTERED	
		CHECKED	
		APPROVED	

SECTION AA added showing Radius
 125,130 WERE 150 AND 200 RESPECTIVELY IN THE RIB.

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ITEM NO		DESCRIPTION		DRAWING NO		HN Alloy(Grade-11 IS-4522)	
						ALLOY STEEL CASTING	
						MATL CODE UNIT WT	
						MATL SPEC QTY	
EQPT: WALKING BEAM FURNACE.							
Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014				DRN	NAME	SIGNATURE	DATE
				CHD	B.ASHOKKUMAR		23.05.02
				APPD	SSN.KUMAR		
				SHANMUGASUNDARAM.S			
DEPT	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO		ITEM	
SSTP	Ø/M/F	1:5		REF TO OLD DWG NO			
456	IS: 2102			7621 / 409-3			
TITLE				CARD CODE	DRAWING NO :		REV
WBF - FIXED BEAM SUPPORT				U 01	3-7-1150-05-02845		02

