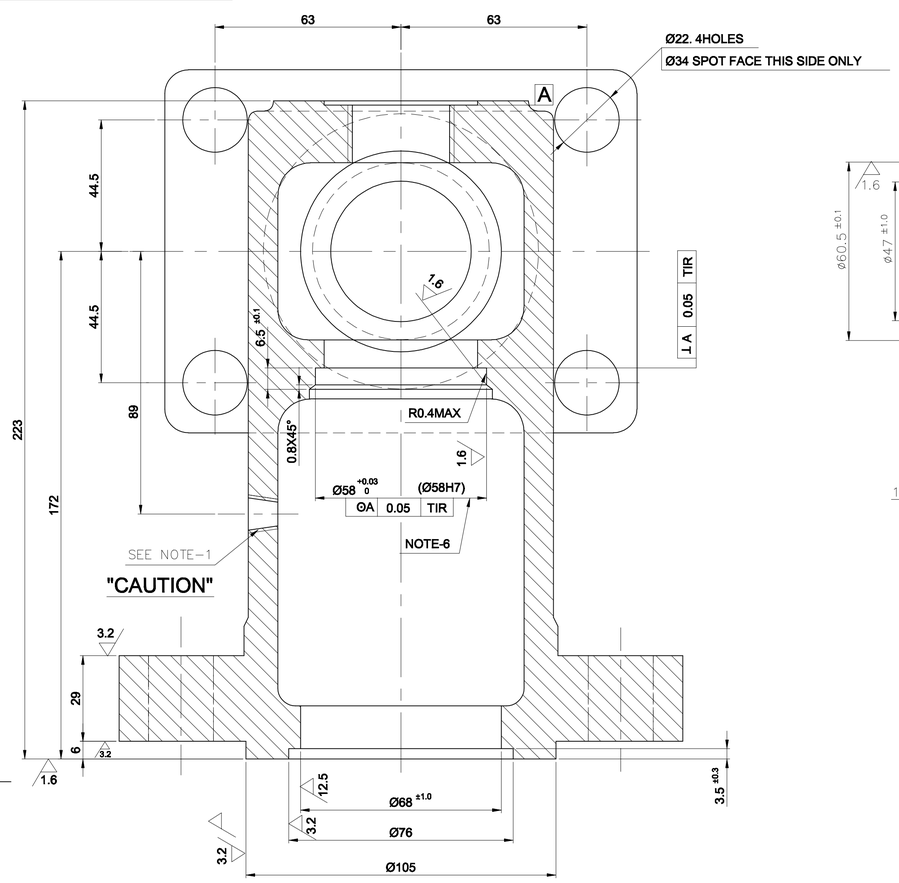
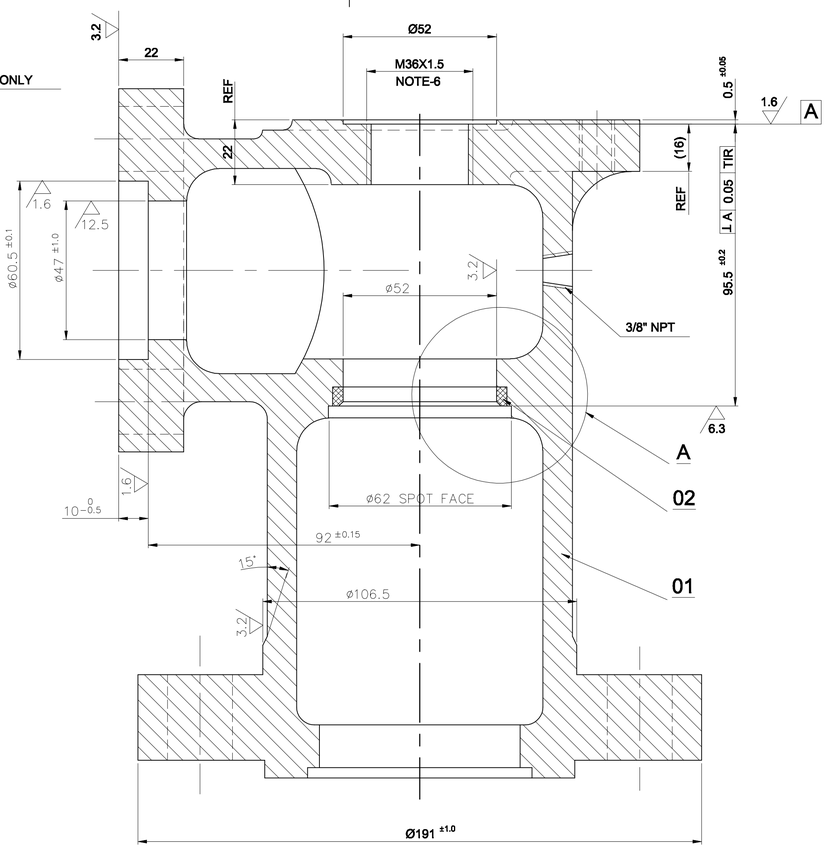
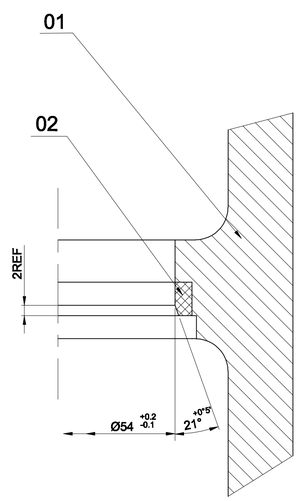
DRAWING NO. 1-20-001-00010

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



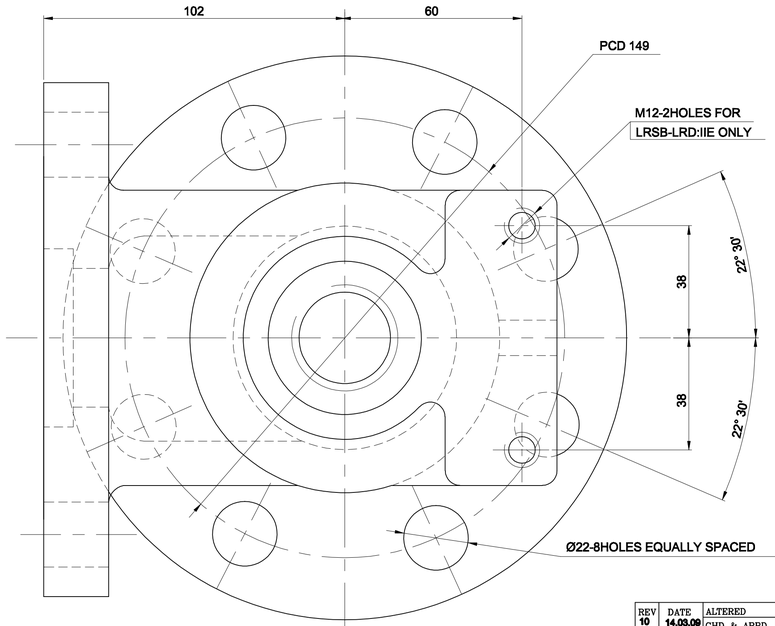
STELLITE SEAT INSERT (ITEM 02) OMITTED IN THIS VIEW





DETAIL-'A'

MACHINING OF STELLITE SEAT INSERT



NOTES:-

1. 3/8" NPT THREADED HOLE SHOULD NOT BE MADE UNLESS OTHERWISE SPECIFICALLY CALLED FOR.
2. MINIMUM WALL THICKNESS 11MM. IS TO BE MAINTAINED.
3. FOLLOW THE PROCEDURE FOR PRESS. FITTING THE SEAT INSERT IN TO BODY.
4. SEE ASSEMBLY INSTRUTION (DRG. NO. 4-20-201-02065 & 4-20-201-02064).
5. THE INLET OF VALVE BODY SHOULD BE HYDRAULICALLY TESTED AT 90KG/CM² FOR WCB CASTING AND WC6 CASTINGS.
6. Ø58H7 & M36X1.5 ARE TO BE MACHINED IN ONE SETTING AND THE CONCENTRICITY SHOULD BE WITHIN 0.05MM.
7. IF THIS IS NOT CARRIED OUT IN ONE SETTING; METHODS SHOULD BE DEVELOPED TO ATTAIN THE CONCENTRICITY SPECIFIED.
8. INSPECTORS TO CHECK THIS ON ALL VALVE BODIES.

VARIANT NUMBER	ITEM NUMBER	DESCRIPTION	STD	DRAWING NUMBER	ITEM NO / VAR NO	MATERIAL CODE / MATERIAL SPECN	A/C/P	UNIT / QUANTITY	UNIT WEIGHT	GS	ZONE
	02	SEAT INSERT		4-20-201-00796		96-353-109			0.030		
						HAYNES STELLITE			1		
04	01	VALVE BODY		1-20-001-00190		92-013-181-01	A		16.00		
						ASTM A216WCB			1		
03	01	VALVE BODY		1-20-001-00190		92-024-387-01	A		16.00		
						ASTM A216WCB			1		
02	01	VALVE BODY		1-20-001-00190		92-013 -181	A		16.00		
						ASTM A217WC6			1		
01	01	VALVE BODY		1-20-001-00190		92-024-387	A		16.00		
						ASTM A216WCB			1		

REV	DATE	ALTERED	
10	14.03.09	CHD & APPD	J.S K.S

DRAWING REDRAWN & UPDATED.

DCN:SB: 800909 / 5009626

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.

TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT

BHARAT HEAVY ELECTRICALS LTD.
UNIT: HIGH PRESSURE BOILER PLANT.
TIRUCHIRAPALLI-620014.
365-119

	NAME	SIGN	DATE
DRN	J.SANKAR	J.S	14.03.09
CHD	K.SRIDHARAN	K.S	14.03.09
APPD	S.NATARAJAN	S.N	14.03.09

DEPT SB | CODE 330 | SCALE 1:1 | WEIGHT (KG). 16.030 | REFERENCE INFORMATIONS

TITLE: VALVE BODY
2 1/2" (NB 65MM)

CARD CODE: U 01

DRAWING NO. 1-20-001-00010

REV 10

Size A1