

SECTION BB

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

ALL DIMENSIONS ARE IN MILLIMETRES

NOTE:

- 1.NECESSARY MACHINING ALLOWANCES HAVE BEEN ADDED ON ALL MACHINABLE SURFACES.
- 2. ⊗ SURFACES TO BE MACHINED
- 3.UNSPECIFIED CASTING RADII R3-R5
- 4.  $\frac{100}{\sqrt{\text{R}}}$  CASTING SURFACES MUST BE HIGH QUALITY WITHOUT SURFACE UNEVENNESS
- 5.FINISH MACHINED DIMENSIONS ARE INDICATED WITHIN BRACKETS
- 6.CASTING SHALL MEET THE REQUIREMENTS OF TDC (WITH LATEST REVISION)
- 7.RISER REMAINS ARE TO BE COMPLETELY REMOVED SUITABLY
- 8.HEIGHT OF THE CASTING LETTERS 20mm

SPECIAL NOTE

CAST PUNCH DETAILS TO BE MADE WITHIN THE AREA OF THE CIRCLE Ø80mm SHOWN.

SECTION AA

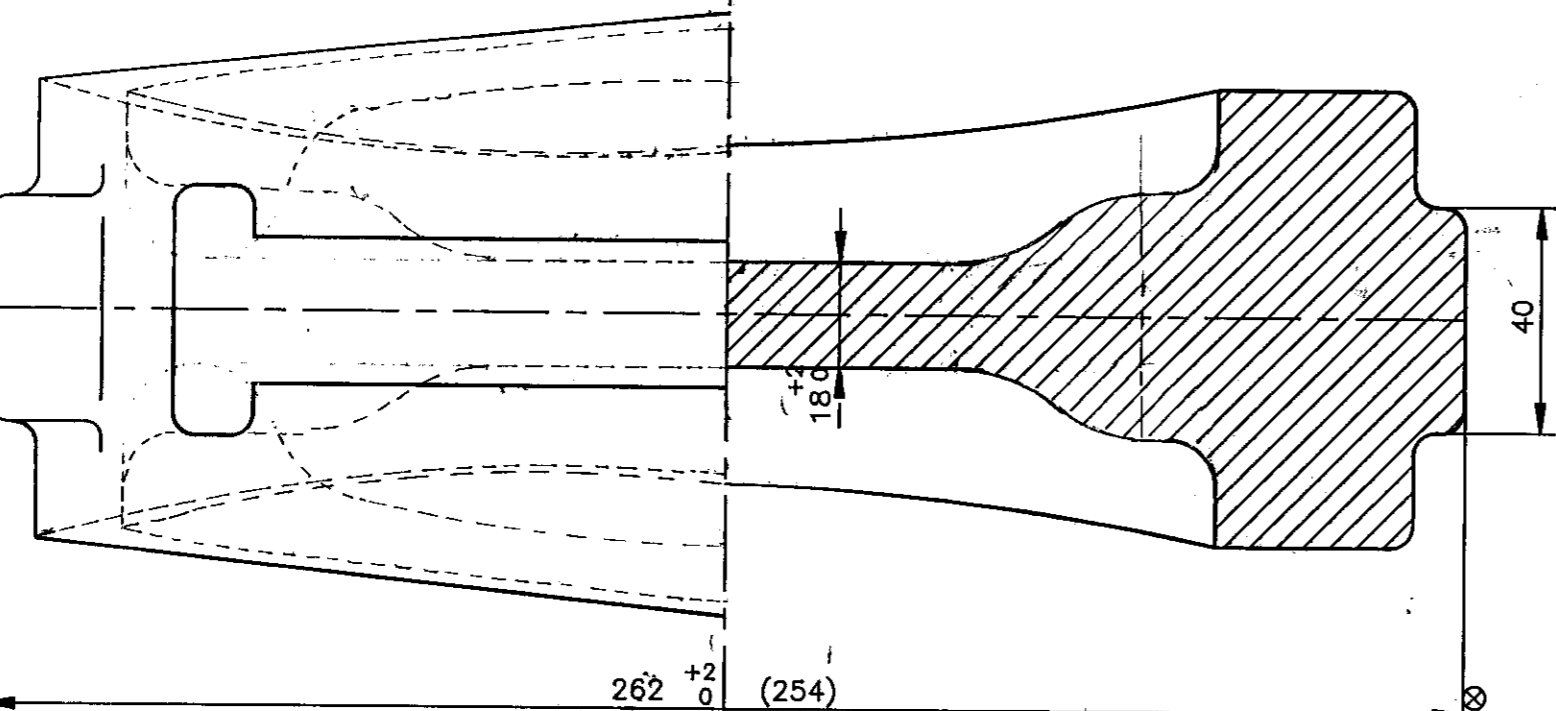
CAST 8"-300  
MATL.MARK  
MELT NO  
INSPECTION SEAL  
SUPPLIERS CODE

07	2-V-N498-03417R	92 201 155	A351-CF8M, SH, CERTIFY	CF8M	N498
06	2-V-M662-03417R/02	92 201 118	A217-C5 NT, CERTIFY	C5	M662
05	2-V-N245-03417R/02	92 201 117	A216 WCB NR CERTIFY	A216 WCB	N245
04	2-V-N247-03417R/02	92 201 116	ASTM A217 WCB N&T CERTIFY	A217 WCB	N247
03	2-V-N230-03417R/02	92 201 115	ASTM A217 WCB N & T	A217 WCB	N230
02	2-V-M359-03417R/02	92 201 114	ASTM A351 CF8 30L HEATTREATED	A351 CF8	M359
01	2-V-N089-03417R/02	92 201 113	ASTM A216 WCB NORMALISED	A216 WCB	N089
SL NO.	CASTING DRG NO	MATL.CODE	MATL.SPECN	MATL. MARK TO BE CAST	TYPE NO.

REV 04	DATE 20.11.95	ALTERED: T.L.C. CHD&APPD: [Signature]	SL NO. 05 INCLUDED.
REV 03	DATE 11-10-95	ALTERED: N.D. PAL CHD&APPD: [Signature]	1. SL NO. 4 IS INCLUDED.
REV 02	DATE 12-01-95	ALTERED: N.D. PAL CHD&APPD: [Signature]	1. SL NO. 3 IS INCLUDED.
REV 01	DATE 17-9-94	ALTERED: T.L.C. CHECKED: [Signature]	SL NO. 02 INCLUDED.

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		BHARAT HEAVY ELECTRICALS LTD.		NAME	SIGN	DATE	NO. OF VAR.
		UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPPALLI-620014.		DRN	J. PRABAKAR	010690	
				CHD	N. DHANAPAL	0106-90	
				APPD	P. LOGANATHAN	9.6.90	
DEPT	VL	GRADE OF UNTO DIM	SCALE	WEIGHT (KG)	REF. TO ASSY/OLD DRG.		
CODE	320	M	NT.S	18.5	ITEM NO. NO. OF TEST		
TITLE				CARD CODE	DRAWING NO.		
WEDGE (8"-300)				U 01	2-V-0000-03417R/08		



REV 08	DATE 5.7.99	ALTERED: T.L.C. CHD&APPD: [Signature]	SL NO. 07 INCLUDED.	REV 06	DATE 28.2.97	ALTERED: T.L.C. CHD&APPD: [Signature]	NOTES UPDATED REFER DCN-CS: 0662	REV 05	DATE 26.11.96	ALTERED: T.L.C. CHD&APPD: [Signature]	SL NO. 06 ADDED
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