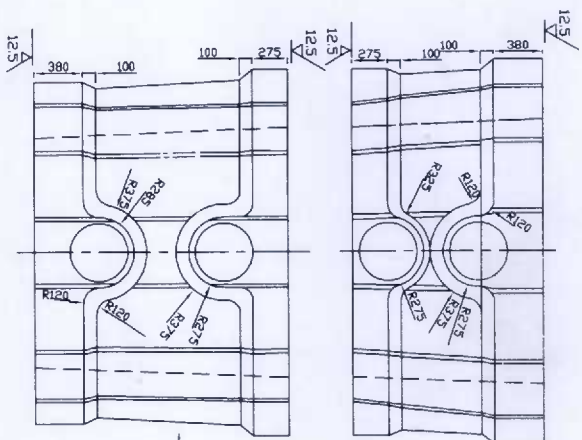
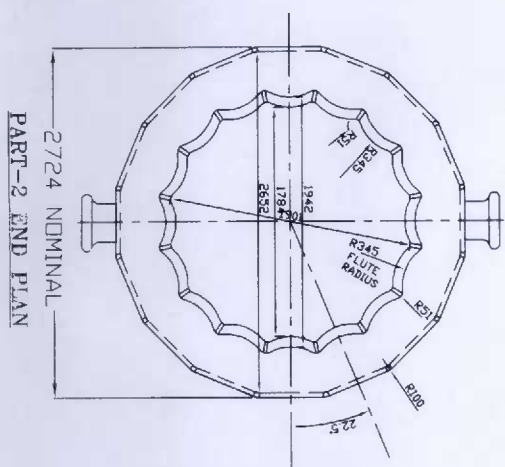
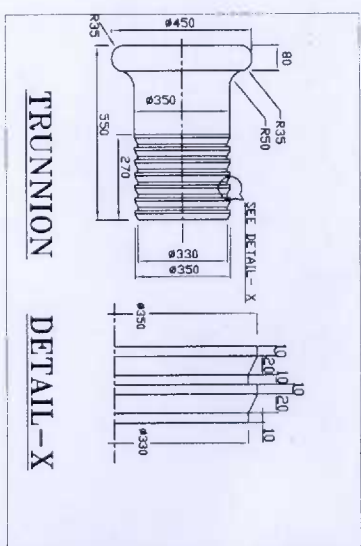




PART-2
APP.WT=40T



—2724 NOMINAL—
PART-2 END PLAN

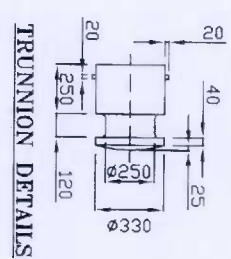
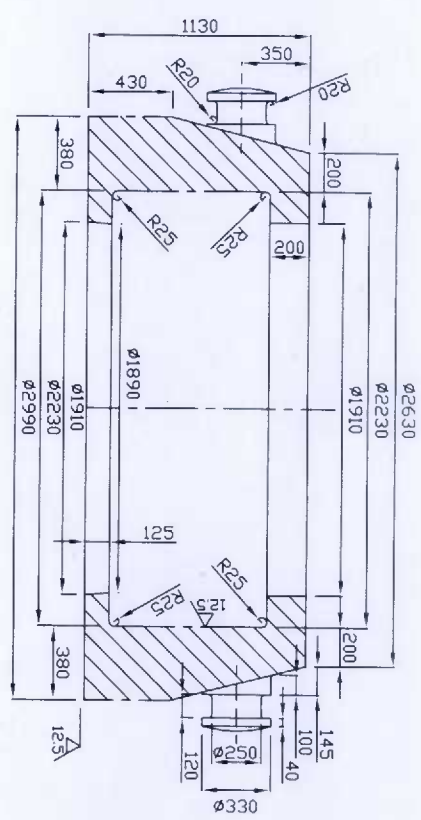


TRUNNION DETAIL-X

1) DIMENSIONAL TOLERANCE = $\pm 2\text{MM}$

- 2) ID NO SHALL BE SUPPLIER'S UNIQUE IDENTIFICATION NO
- 3) TRUNNION
 - a. MATERIAL : C40
 - b. IT SHOULD BE FORGED IN SINGLE PIECE AND MACHINED TO SIZE.
 - c. ROUGH MACHINED TRUNNION SHOULD BE ULTRASONICALLY TESTED AS PER BHEL CORPORATE STANDARD NO. AA-0860118 Rev'01.
- d. DIMENSIONAL TOLERANCE : +1/-1

		BHARAT HEAVY ELECTRICALS, LTD. CENTRAL FOUNDRY FORCE PLANT RANIPUR HARDWAR			
DEPT.	SMS			WEIGHT	
TITLE	2030 mm DIA INGOT MOULD (16 SIDED)			NAME	SIGN
				VKD SUNIL KUMAR	
				CKD P. K. ROY	
				APD VK.RAIZADA	
DEPARTMENT	SMS	DRG NO.	SMS/INGOT MOULD/2030/16SS		
REF. NO.	APB/969	REV.0			



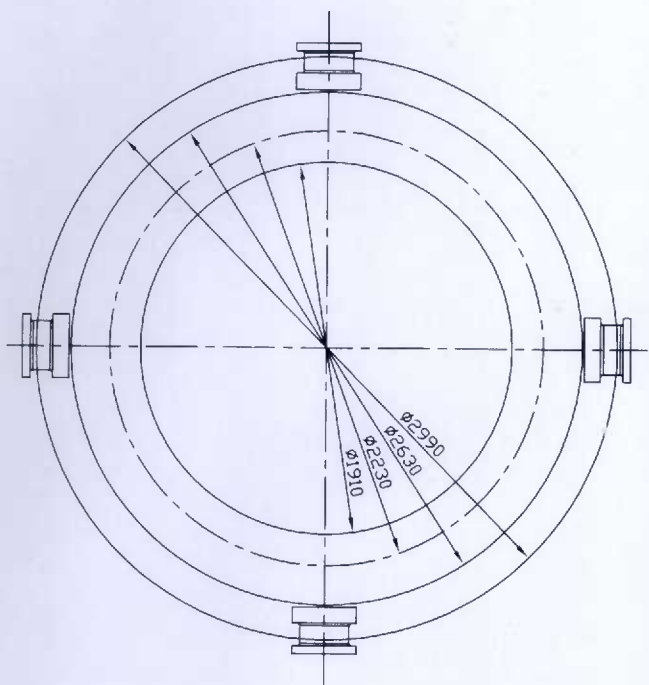
TRUNNION DETAILS

NOTE:

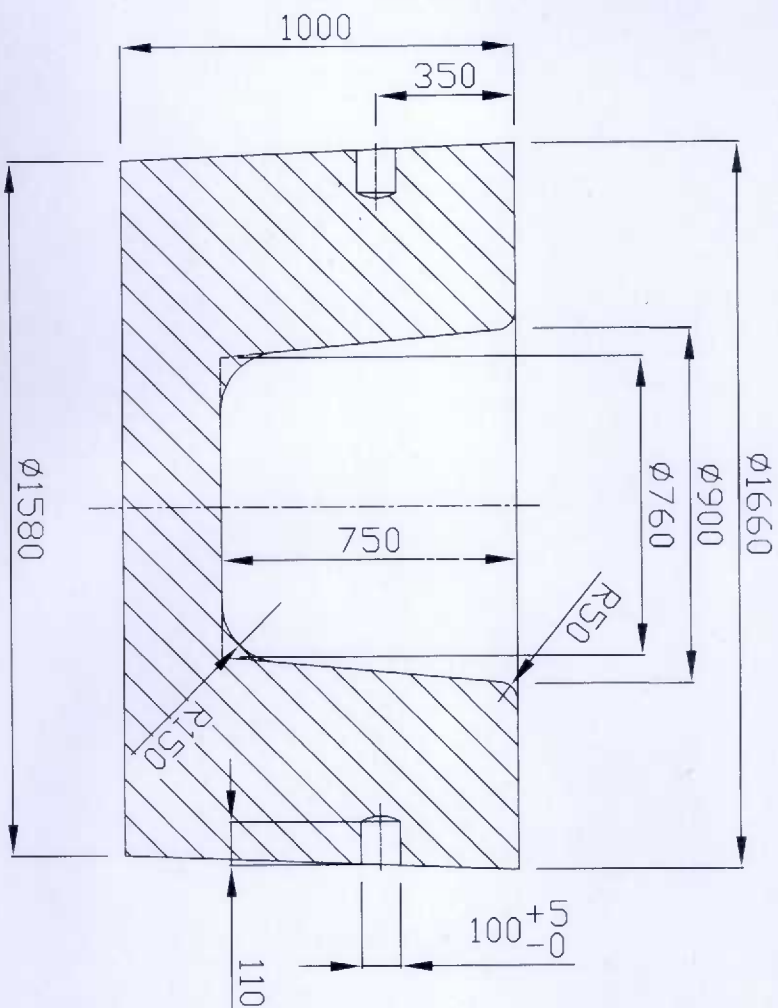
-DIMENSIONAL TOLERANCE = $\pm 2\text{MM}$

-TRUNNIONS

- MATERIAL : C40
- IT SHOULD BE FORGED IN SINGLE PIECE AND MACHINED TO SIZE.
- ROUGH MACHINED TRUNNION SHOULD BE ULTRASONICALLY TESTED AS PER BHEL CORPORATE STANDARD NO. AA-0850118 Rev01.
- DIMENSIONAL TOLERANCE : $+1/-1$



		BHARAT HEAVY ELECTRICALS. LTD. CENTRAL FOUNDRY FORCE PLANT RANIPUR HARDYAR	
DEPT.	SMS	WEIGHT	APR. 24000
TITLE	HOT TOP (DIA 2030 INGOT MOULD)	DRN	SUNIL KUMAR
DEPARTMENT	SMS	CHKD	P. K. ROY
		APD	V.K. RAJZADA
DEPARTMENT SMS		DRG NO. SMS/HOT TOP/2030	SIGN
Rev.00 Ref: APB BANKS/959		Rev.00 SHEET NO- 1	NO OF SHEETS-1

**NOTE:**- DIMENSIONAL TOLERANCE = $\pm 2\text{MM}$

- COMPOSITION OF C.I. FALSE BOTTOM

TOTAL CARBON	3.6-4.0%
SILICON	1.5-2.0%
MANGANESE	0.5-0.7%
SULPHUR	$\leq 0.08\%$
PHOSPHOROUS	$\leq 0.08\%$
TIN	$\leq 0.005\%$
NICKEL	$\leq 0.2\%$
CHROMIUM	$\leq 0.04\%$

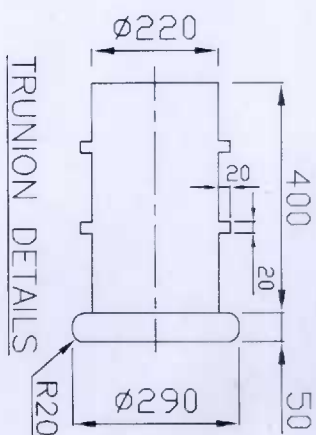
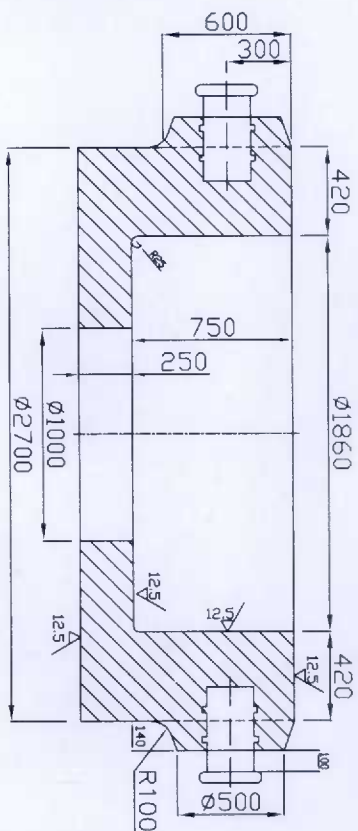
- HEAT TREATMENT:

STRESS RELIEVING BY HEATING
UPTO 700-750°C AND SOAKING FOR
MIN. 20 HOURS AND COOLING SLOWLY
BY 40°C PER HOUR TILL TEMPERATURE
OF 250°C IS ATTAINED

BHARAT HEAVY ELECTRICALS. LTD.	
CENTRAL FOUNDRY FORCE PLANT	
RANIPUR HARDWAR	
TITLE	WEIGHT
FALSE BOTTOM	APR. 12000
(DIA 2030 INGOT MOULD)	DRN SUNIL KUMAR
DEPARTMENT SMS	CHKD P. K. ROY
DRG. NO.	APD V.K. RAJZADA
SMS/FAISE BOTTOM/2030	Rev:00

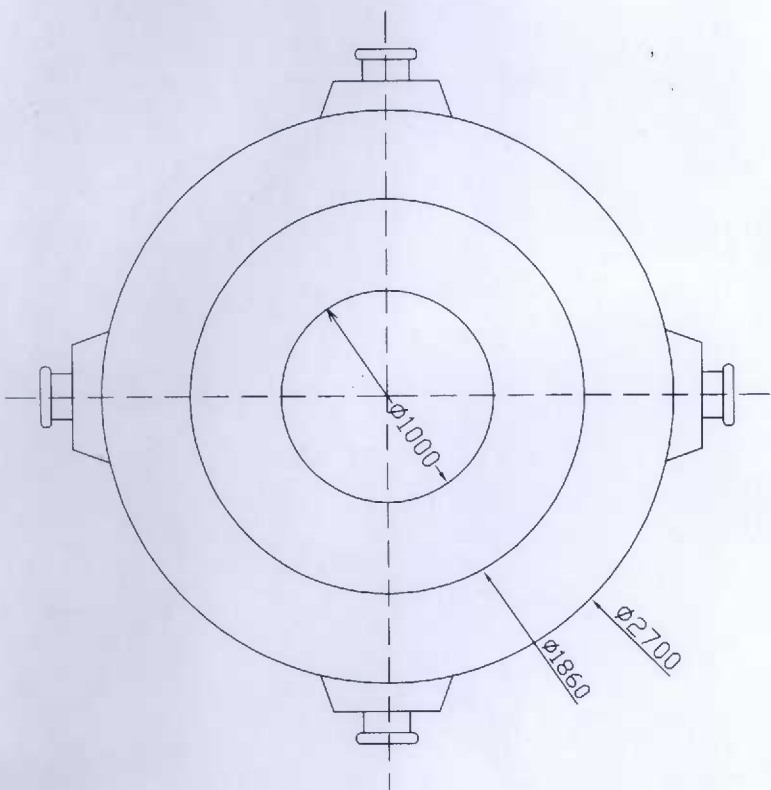
FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN M.M.)

DRAWING NUMBER



NOTE:

- FORGED TRUNION SHOULD BE EMBEDDED IN THE CASTING BEFORE POURING AND IT SHOULD BE INTEGRAL PART OF THE CASTING AFTER POURING.
- MATERIAL FOR TRUNION = C40
- DIMENSIONAL TOLERANCE = $\pm 2\text{MM}$



		BHARAT HEAVY ELECTRICALS. LTD. CENTRAL FOUNDRY FORCE PLANT RAIPUR HARDWARE	
DEPTT.	SMS	SCALE	WEIGHT
		N.T.S.	APR. 2000
TITLE		DRN	NAME
SUPPORT FOR DIA 2030		OKD	P. K. ROY
FALSE BOTTOM		APD	V.K. RAIZADA
DEPARTMENT		DRG. NO.	SIGN
SMS		SMS/SUPPORT FOR FB/2030	DATE

Rev. 00