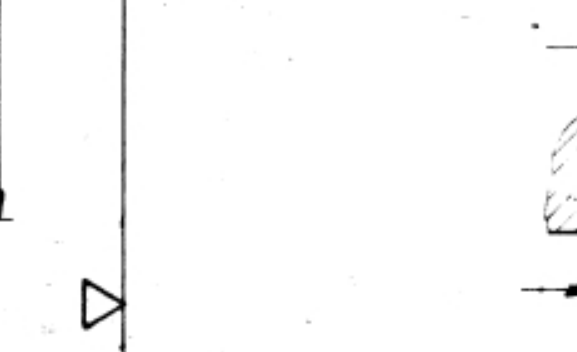
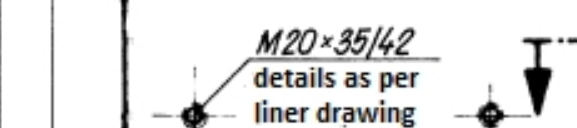
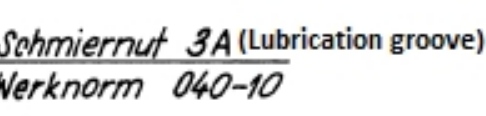
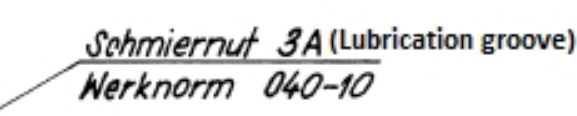
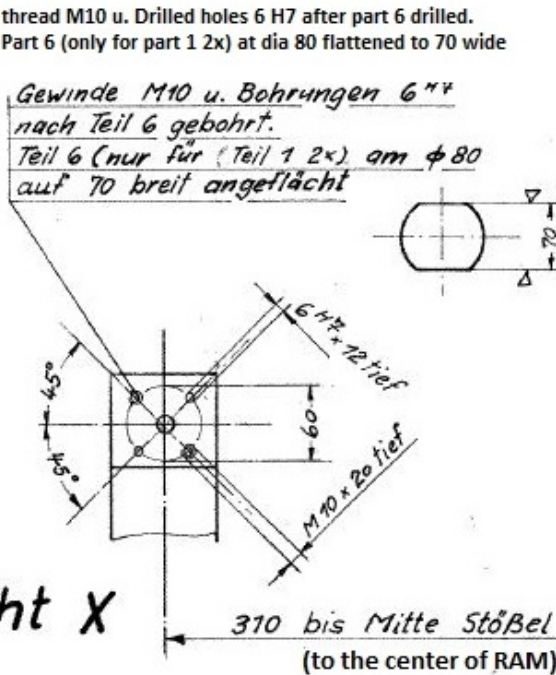
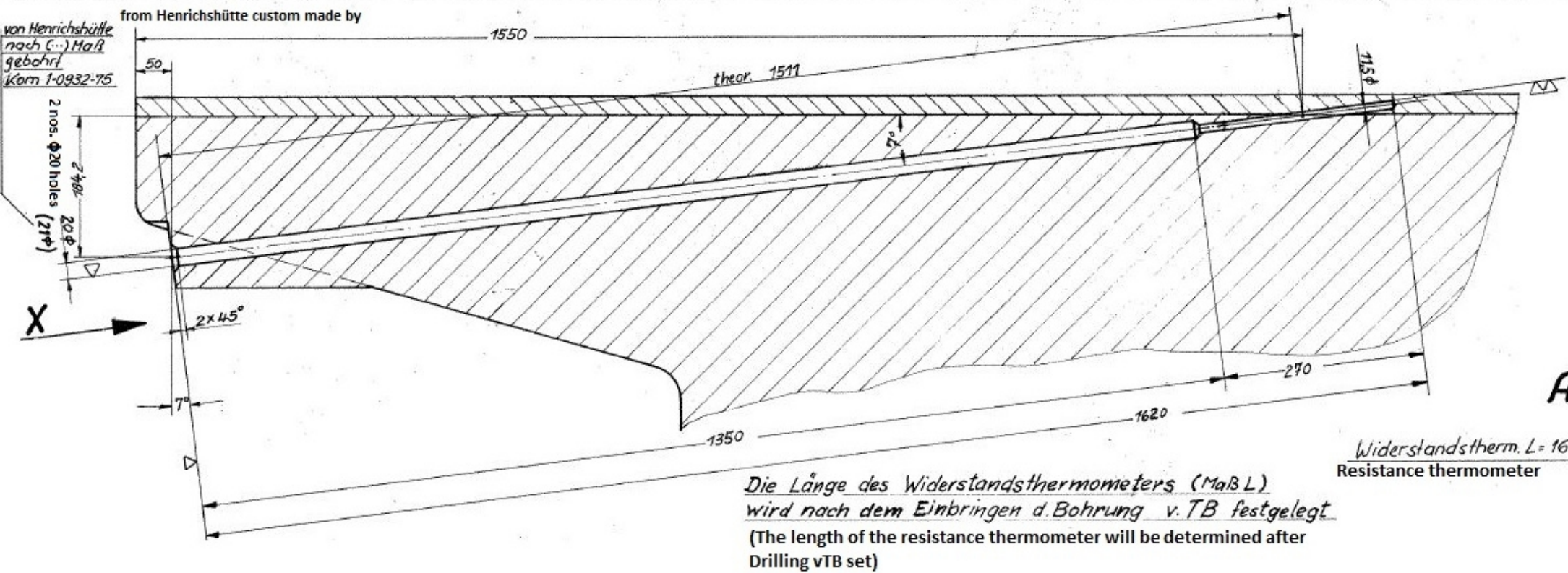
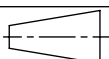


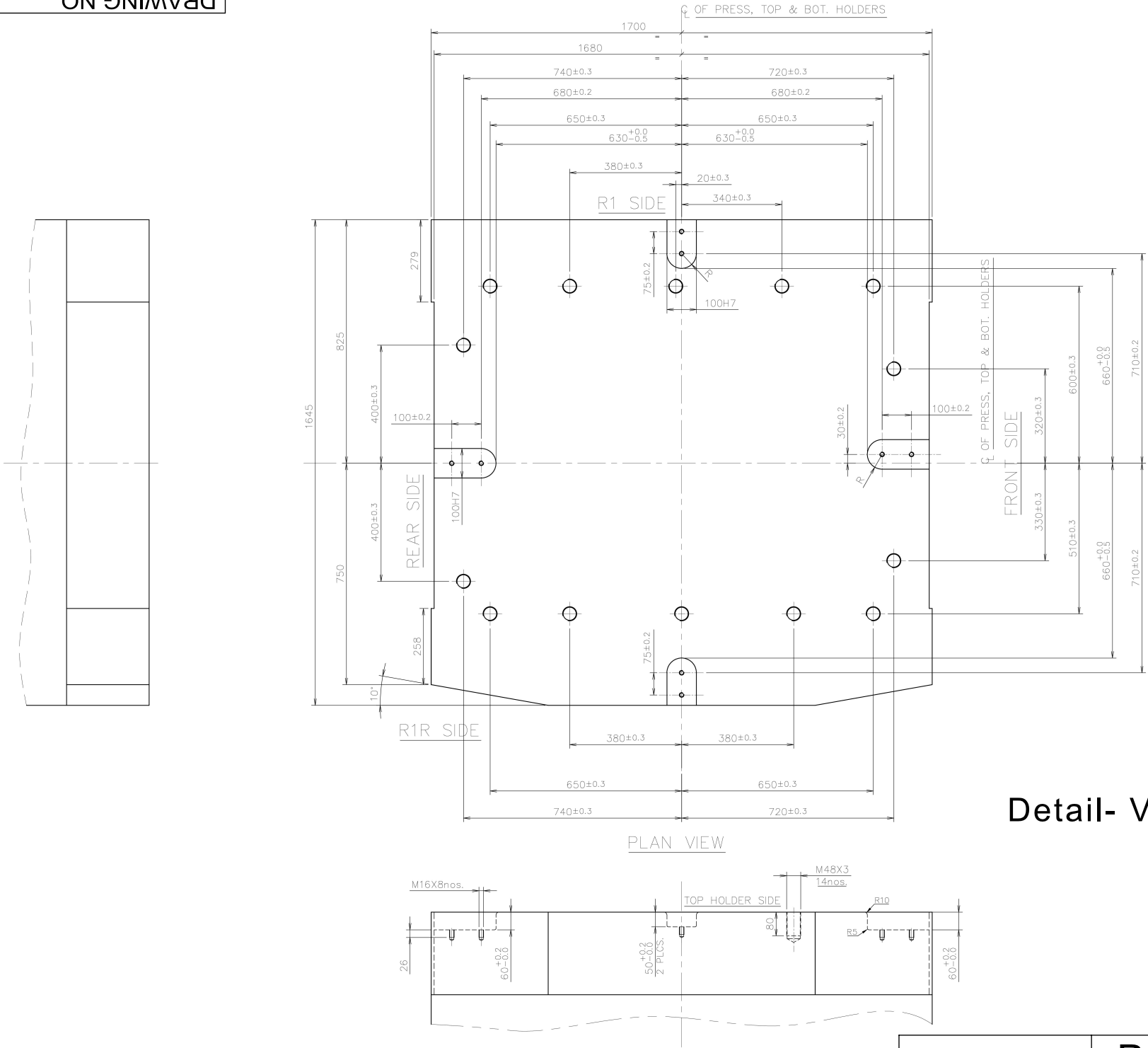
Operating Pressure 4 atm
Test Pressure 6 atm.

1. Casting is to be machined to the dimensions tolerances, accuracies and surface finish as shown in the drawing.
2. The drawing comprises of 3 sheets:
 - a. Sheet 1 of 3 gives details of overall castings.
 - b. Sheet 2 of 3 gives details of inclined holes to be drilled in the casting.
 - c. Sheet 3 of 3 gives details of 14 tapered holes of M48 on the bottom face and 4 keyways to be made by machining (Not shown in sheet 1 of 3).
3. Allowance of 5 to 7 mm will be available on tool point for carrying out finish machining.
4. 2 liners alongwith bolts shall be provided which is required to be fixed onto the ram casting as per Sheet 2 of 3 of drawing and a skin cut is to be taken on top of liner subsequently to remove undulations and achieve flatness.
5. The material of casting is G28M6 of EN10293.
6. Hydro test to be carried out at 6 atm. for holding time of 3 hrs.
7. All machined surfaces to be suitably protected, all threaded holes to be greased.
8. The casting to be packed in wooden box with proper protection of machined surfaces and lifting arrangement to be made.
9. Please refer drawing no . 159545 for Liner Details.
10. Weight of casting before finish machining will be: 22 T
11. Weight of casting after finish machining will be: 21.19 T

		BHARAT HEAVY ELECTRICALS. LTD. CENTRAL FOUNDRY FORGE PLANT RAMPUR HARDWAR						
DEPTT FDY. TECH.		 	SCALE N.T.S.	WEIGHT IN Kgs	NAME		SIGN	DATE
TITLE		DRN 58/5915/M2 WRD IN K GAURAV CHK R LAKRA APPD D DAVE						
RAM CASTING								
PROJECT AND CUSTOMER NAME			TECHNOLOGY NO		DRAWING NO			
SMS INDIA			59151		1-105-91-80100/M2			
					SHEET NO. NO. OF SHEETS			



										BHARAT HEAVY ELECTRICALS. LTD. CENTRAL FOUNDRY FORGE PLANT RANIPUR HARDWAR						
REV	DATE	ALTERED	REV	DATE	ALTERED	REV	DATE	ALTERED	DEPTT.- FDY. TECHY		SCALE	WEIGHT IN KG.	NAME		SIGN	DATE
		CHECKED			CHECKED			CHECKED								
									TITLE 							



NOTE: -
1. BLEND ALL SHARP CORNERS TO 2X45°
2. UNSPECIFIED RADII :1

UNSPECIFIED TOLERANCES

OVER	0.5	±0.1
UPTO	6	
OVER	6	±0.2
UPTO	30	
OVER	30	±0.3
UPTO	120	
OVER	120	±0.5
UPTO	400	
OVER	400	±0.8
UPTO	1000	
OVER	1000	±1.2
UPTO	1200	

Detail- V

REV	DATE	ALTERED	REV	DATE	ALTERED	REV	DATE	ALTERED
		CHECKED			CHECKED			CHECKED



BHARAT HEAVY ELECTRICALS. LTD.

CENTRAL FOUNDRY FORGE PLANT

RANIPUR HARDWAR

DEPTT.- FDY. TECHY

SCALE

WEIGHT IN KG.

TITLE

PROJECT AND CUSTOMER NAME

NAME

SIGN

DATE

TECHNOLOGY NO.

DRAWING NO.

SHEET NO.

DRN

WKD

CHD

APPD

59/59151M2

N K GAURAV

R LAKRA

T DAVE

59151

1-105-91-80100/M2

3

SMS INDIA

NO. OF SHEETS

3

