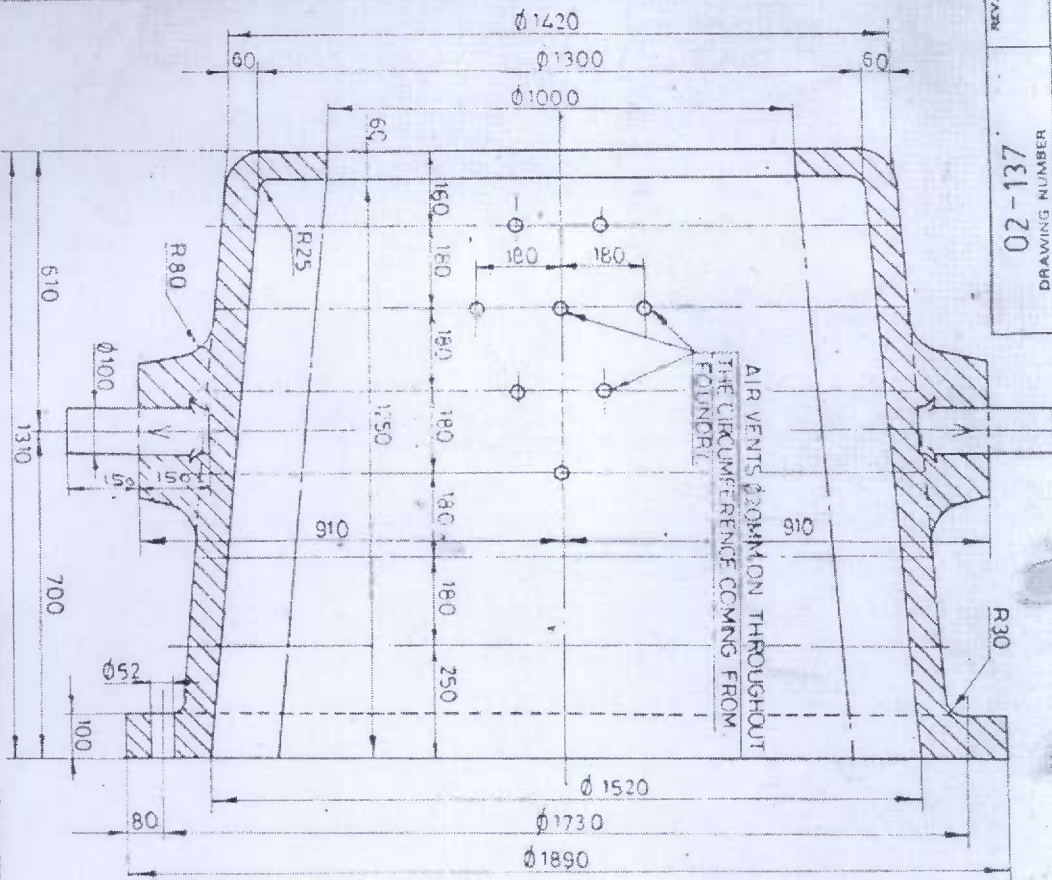


2

Inventory No.	Sign. & Date	Ref. Org. No.	The information on this document is the property of BHARAT HEAVY ELECTRICALS LIMITED. It must not be used directly or indirectly in anyway detrimental to the interest of the company.
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REV. 02-137
DRAWING NUMBER



CI WITH COMPOSITION
AS FOLLOWS
REF: CL/BHEL/53

1. TOTAL C	3.0 TO 4.7
2. SILICON	1.4 TO 2.7
3. MANGANESE	0.4 TO 0.57
4. SULPHUR	≤ 0.0507
5. PHOSPHORUS	≤ 0.0207
6. TIN	≤ 0.0507
7. NICKLE	≤ 0.0507
8. CHROMIUM	≤ 0.0507

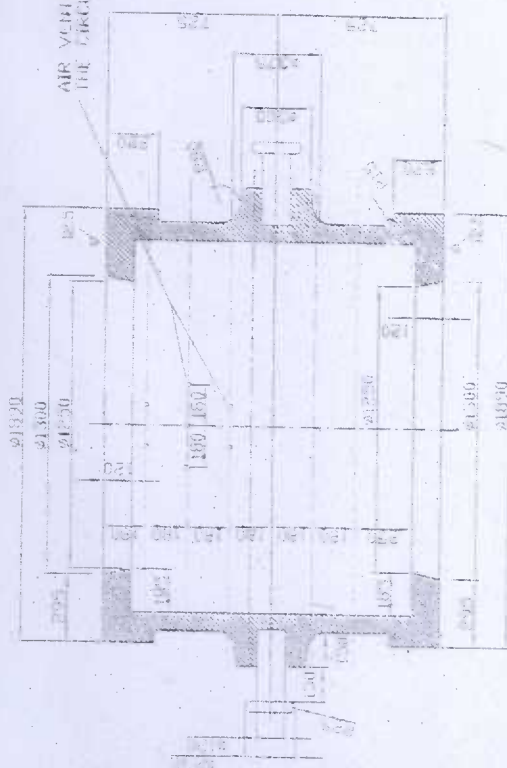
4-52 HOLES
EQU SPACED
AT 1730 P.C.D.
REF: CL DRG. NO. 272 BIS/HOT-
TOP

BHARAT HEAVY ELECTRICALS LTD.
UNIT: C.F.P. HARDWARE

DEPT. F.E.	CODE 1.10	SCALE 1:10	WEIGHT (KG) 3500 TONS	REF TO ASSY. DRG.	ITEM NO.
HOT TOP FOR 1300R INGOT MOULDS					
Dimensions to be Controlled Within Limits as Shown Machining Tolerance ± 25 mm Unless Otherwise Shown, Non Machining Tolerance ±					
CARGO CODE	DRAWING NO. 02-137		SHEET NO. 01		
APPROVED			SIGN. DATE		

SIZE A3

515/101 (12/100/S)



FORCED THROUGH SHOULD BE EMBEDDED IN THE CASTING BEFORE POURING AND IT SHOULD BE INTEGRAL PART OF THE CASTING AFTER POURING.
KUDCH MACHINED THROUGH SHOULD BE ULTRASONICALLY TESTED AS PER BHQ CORPORATE STANDARD HQ. AA-0050110 (LATEST REVISION) LEVEL-2
MATERIAL FOR THROUGH = C40
DIMENSIONAL TOLERANCE = ±2MM

[Signature]		Bharat Heavy Electricals, Ltd. SHE. CENTRAL FOUNDRY FORCE PLANT		Bharat Heavy Electricals, Ltd. SHE. CENTRAL FOUNDRY FORCE PLANT	
UNIT	SMS	DATE	TIME	DATE	TIME
		11/11/78	11:15	11/11/78	11:15
TITLE		HOT TOP FOR TUBER		HOT TOP FOR TUBER	
		TUBER SADDLES		TUBER SADDLES	
		DESIGNS TO BE SUBMITTED		DESIGNS TO BE SUBMITTED	
		WITHIN LIMITS AS SHOWN REGARDING		WITHIN LIMITS AS SHOWN REGARDING	
		TOLERANCE, USED OR UNLESS		TOLERANCE, USED OR UNLESS	
		OTHERWISE SHOWN		OTHERWISE SHOWN	