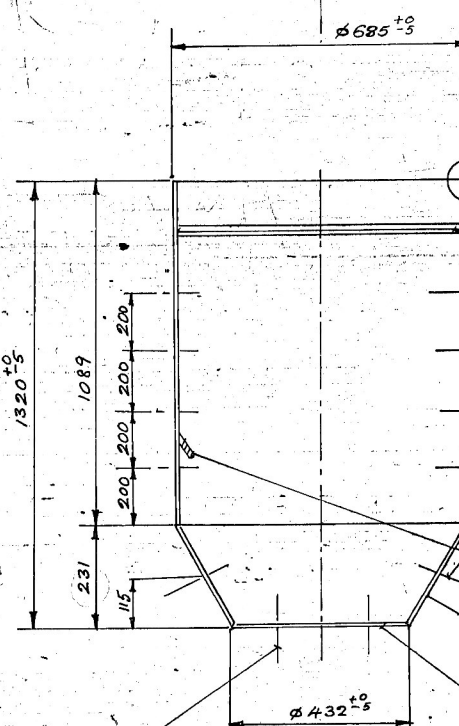
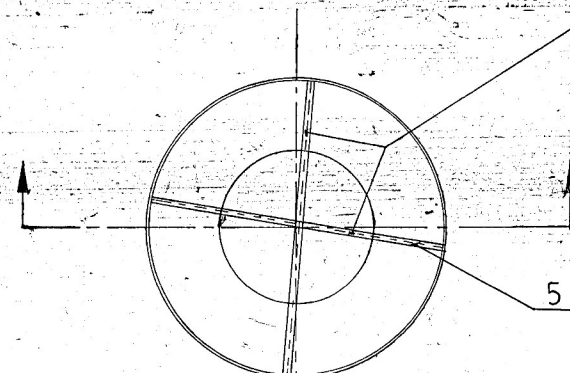


20X20X3 ANGLES 2 Nos TO BE
WELDED TO MAINTAIN ROUNDNESS



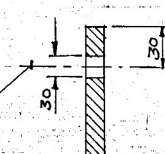
6 HOLES OF Ø30
Ø 200 EQUALLY SPACED.

4 HOLES OF Ø30
EQUALLY SPACED

5 ROWS OF Ø3 VENT HOLES
EQUALLY SPACED 16 HOLES
IN EACH ROW.

2 CONE TO BE FABRICATED
FROM TWO HALF CONES.

DETAIL 'X'



810 MM X 50MM ROD
TO BE WELDED AT
45° AT 500 HEIGHT
FROM THE BOTTOM

WELD JOINT

Note:-

1. SIDE WELD JOINTS MUST BE CONTINUOUS AND GROUND SMOOTHLY ON OUTSIDE.
2. OUTSIDE SURFACE OF FORM SHOULD BE IN ONE LEVEL AND WELDS SHOULD BE GROUND TO THE LEVEL OF FORM.

GROSS WT: 160.33 KGS.

NET WT: 137.33 KGS.

ITEM NO.	DESCRIPTION	SIZE	STD.	QTY.	UNIT WT.
5	ANGLE	ANGLE ISA : 2020 20X20X3 X 673 LONG	HY 10125 08609 IS 226	1.2	kg
4	SHELL	PLATE 2130X1089 X6	AA 10118 08030 IS 226	110.3	kg
3	ROD	ROD Ø10 X 50	HY 10102 99069 IS 1570:1528	0.031	kg
2	CONE (HALF SEGMENT)	Ø 685 / Ø 432 X 6 231 H6 CONE	AA 10118 08030 IS 226	20.9	kg
1	BASE	PLATE Ø 432 X 6	AA 10118 08030 IS 226	6.9	kg

SAP DRAWING No.

2-39999-40119

REV No.

04

ADDITIONAL INFORMATION

STATUS OF DRAWING

DISTRIBUTION OF PRINTS

TYPE OF PRODUCT

OR

NAME OF CUSTOMER/PROJECT

MATERIAL CODE:

HY 9614082003



BHARAT HEAVY ELECTRICALS LTD
HYDERABAD

DRN	NAME	SIGN	DATE	73
CHD	M.N.A		18-7-86	VAR.
APD	S.V.R.		18-7-86	VAR.

DEPT.

GRADE OF

UNTL. DIA.

C/M/F

SCALE

WEIGHT (KG)

REF. TO ASSY. DRG.

NO. OF

TEMS

TITLE

LINING FORM FOR

25T. INDUCTION FURNACE.

DRAWING NO.

2-04-119

SHEET NO.

NO. OF SHEETS

REV 04 DATE 28-3-2004

Raw Material Size and wt added. Gross & Net wts shown.

REV 03 DATE 22-3-99

Material Code altered.

REV 02 DATE 23-6-93

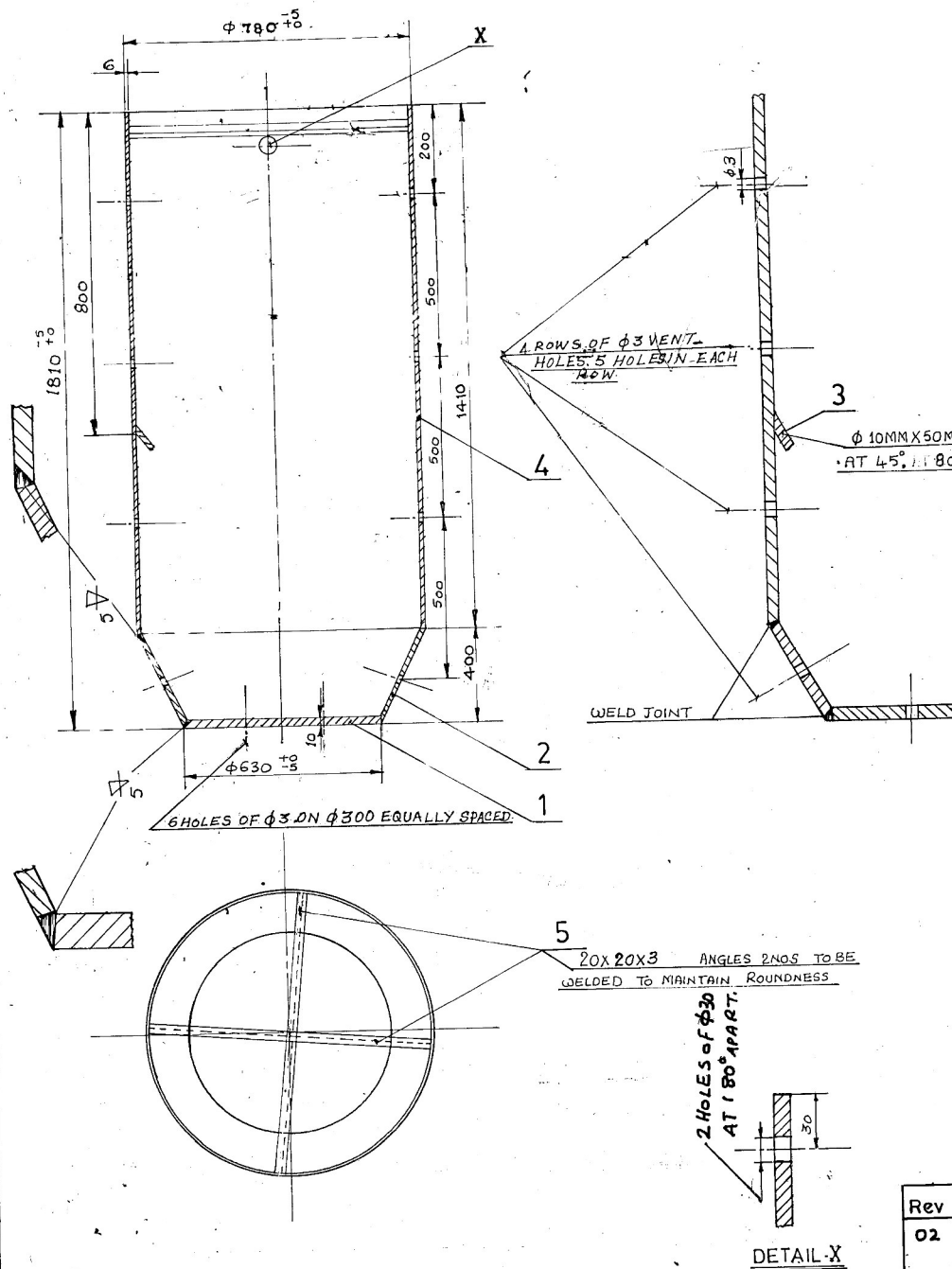
Single cone converted to assembly of two half cones.

ALT. 01 DATE 13-7-86

Code 448 add.

REV 01 DATE 13-7-86

Code 448 add.



NOTE:-

1. SIDE WELD JOINTS MUST BE CONTINUOUS AND GROUND SMOOTHLY ON OUTSIDE.
2. OUTSIDE SURFACE OF FORM SHOULD BE IN ONE LEVEL AND WELDS SHOULD BE GROUND TO THE LEVEL OF FORM.

SAP DRAWING No.

2-39999-40577

Rev No.

02

ITEM NO.	DESCRIPTION	QTY.	UNIT	REMARKS
5	ANGLE ISA : 2020 20x20x3x768 LONG	HY1012508608 IS 226	0.70	2
4	SHELL 2450X1410X6	AA1011808030 IS 226	162	1
3	ROD $\phi 10 \times 50$	HY1010299069 IS 1570 : 15C8	0.01	1
2	CONE 1250X500X6	AA1011808030 IS 226	29.43	2
1	BASE $\phi 630 \times 10$	AA1011808072 IS 226	2.5 Kgs	1

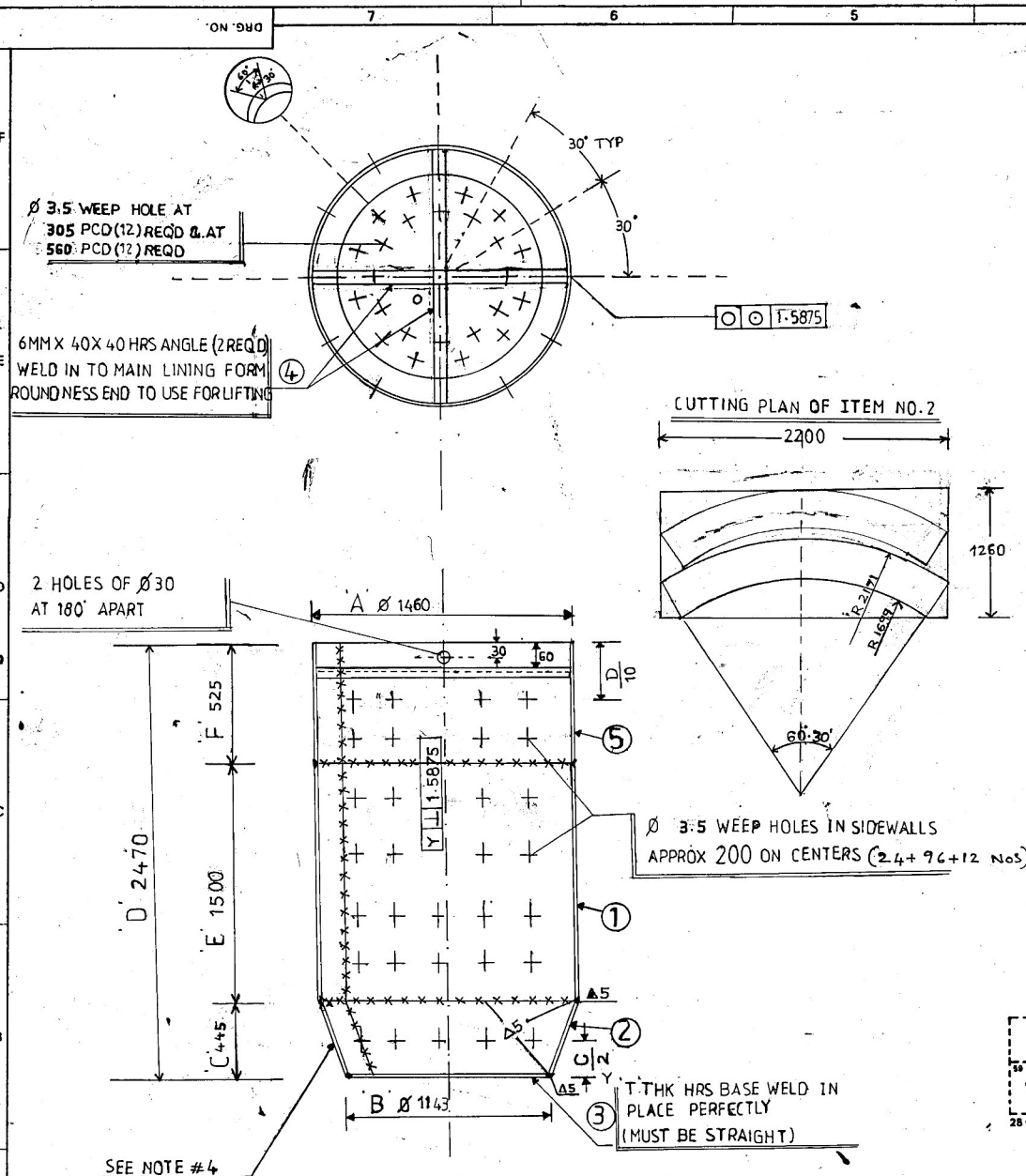
VAR. NO.	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	DRAWING NO.	VAR. NO.	ITEM NO.	DESCRIPTION	UNIT	QTY.	REMARKS
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ADDITIONAL INFORMATION		TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT																	
STATUS OF DRAWING		BHARAT HEAVY ELECTRICALS LTD. HYDERABAD																	
DISTRIBUTION OF PRINTS		<table border="1"> <tr> <th>DRN.</th> <th>NAME</th> <th>SIGN.</th> <th>DATE</th> </tr> <tr> <td>CHD.</td> <td>U. A. T. Raja</td> <td>U. A. T. Raja</td> <td>30-3-97</td> </tr> <tr> <td>APPD.</td> <td>S. C. Rao</td> <td>S. C. Rao</td> <td>31-3-97</td> </tr> </table>		DRN.	NAME	SIGN.	DATE	CHD.	U. A. T. Raja	U. A. T. Raja	30-3-97	APPD.	S. C. Rao	S. C. Rao	31-3-97				
DRN.	NAME	SIGN.	DATE																
CHD.	U. A. T. Raja	U. A. T. Raja	30-3-97																
APPD.	S. C. Rao	S. C. Rao	31-3-97																
ANGLE 25° DELETED		<table border="1"> <tr> <th>DEPT.</th> <th>GRADE OF UNTOOL. DIM.</th> <th>SCALE</th> <th>WEIGHT (KG)</th> </tr> <tr> <td>CODE</td> <td>C/M/F</td> <td>N.T.S.</td> <td>247.3</td> </tr> </table>		DEPT.	GRADE OF UNTOOL. DIM.	SCALE	WEIGHT (KG)	CODE	C/M/F	N.T.S.	247.3								
DEPT.	GRADE OF UNTOOL. DIM.	SCALE	WEIGHT (KG)																
CODE	C/M/F	N.T.S.	247.3																
<table border="1"> <tr> <th>Rev</th> <th>Date</th> <th>Altered</th> <th>Checked</th> </tr> <tr> <td>02</td> <td>11-5-96</td> <td>View X-300 holes 1/2x at 180° apart</td> <td>247.3</td> </tr> </table>		Rev	Date	Altered	Checked	02	11-5-96	View X-300 holes 1/2x at 180° apart	247.3	<table border="1"> <tr> <th>Rev</th> <th>Date</th> <th>Altered</th> <th>Checked</th> </tr> <tr> <td>01</td> <td>24-5-97</td> <td>247.3 WAS 248.0 1410 WAS 1584 400 WAS 226 234.4 KGS WAS 248.5</td> <td>247.3</td> </tr> </table>		Rev	Date	Altered	Checked	01	24-5-97	247.3 WAS 248.0 1410 WAS 1584 400 WAS 226 234.4 KGS WAS 248.5	247.3
Rev	Date	Altered	Checked																
02	11-5-96	View X-300 holes 1/2x at 180° apart	247.3																
Rev	Date	Altered	Checked																
01	24-5-97	247.3 WAS 248.0 1410 WAS 1584 400 WAS 226 234.4 KGS WAS 248.5	247.3																
DRAWING NO. 2-04-577		SHEET NO. 2 OF 2																	

THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

SIGN. & DATE	REF. DRG. NO.
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INVENTORY NO.



S.NO	IIP NO	CAPACITY	AØ	BØ	C	D	E	F	T
1.	FSAA 6002	20 TONS (BHFL)	00 1460	00 1143	445	2470	1500	525	8

NOTE :

1. SIDE WELDS MUST BE CONTINUOUS AND GROUND SMOOTH ON OUTSIDES AND INSIDE.
2. BEND OR BREAK AND WELD SECTIONS AS REQUIRED TO OBTAIN CONICAL FORM.
3. APPLY ONLY RED OXIDE PAINT.
4. MIN 175 HRS

GENERAL TOLERANCES UNLESS OTHERWISE STATED

UPTO 304.8 $\pm$ 1.5875

ABOVE 304.8 $\pm$ 3.175:

DECIMAL ± 1.5875

ANGULAR $\pm 1^\circ$

MACHINING DENOTED 

SAP DRAWING NO	REV NO
2-39999-40852	03

4	ANGLE IRON	ANGLE 40 X 40 X 5 X 1401 LONG	AA1012508030 IS 226/AA10108	4.34	4.38
3	SHELL BOTTOM	PL 8 x Ø1143	AA1011808056 IS 226/AA10108	64.4	64.4
2	SHELL CONE	PL 8 x 1260 x 2200	AA1011808056 IS 226/AA10108	121.22	174
5	SHELL VERTICAL (F)	PL 8 X 525 X 4589	AA1011808056	151.5	152
1	SHELL VERTICAL (E)	PL 8 X 1500 X 4589	IS 226/AA10108	432.5	433
ITEM NO	DESCRIPTION	SIZE	MATL CODE MATL SPEN	NET WT	GROSS WT
				QTY	

NET WT : 780 Kg
GROSS WT : 835 Kg

[illegible]

ADDITIONAL INFORMATION				TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT										DRN		TS NAME		SIGN		DATE		73							
STATUS OF DRAWING				BHARAT HEAVY ELECTRICALS LTD.										CHD		SVB		10-01-01		10-01-01		10-01-01							
DISTRIBUTION OF PRINTS				HYDERABAD										APPD		SCMRAO		10-02-01		10-02-01		10-02-01							
REV. 01		DATE 15-10-00		ALTERED TS		CHECKED SCR		DIP		GRADE OF TOL. DIM. C/M/F		SCALE		WEIGHT (Kg)		REF. TO ASSY. DRG. C-9-674-L		ITEM NO.		75									
ZONE D2		Material dimensions change due to poor availability of S. & B. W.T. corrected.		CODE 204		C/M/F		~		780		INDUCTOTHERM (1) LTD		-		-		-		-									
TITLE 20T STL										DRAWING NO. 2-04-852										SHEET NO.		NO. OF SHEETS		03					
MELTOUT LINING FORM										CARD CODE																			

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY

COMPUTER FILE NAME

REF. DRG. NO.

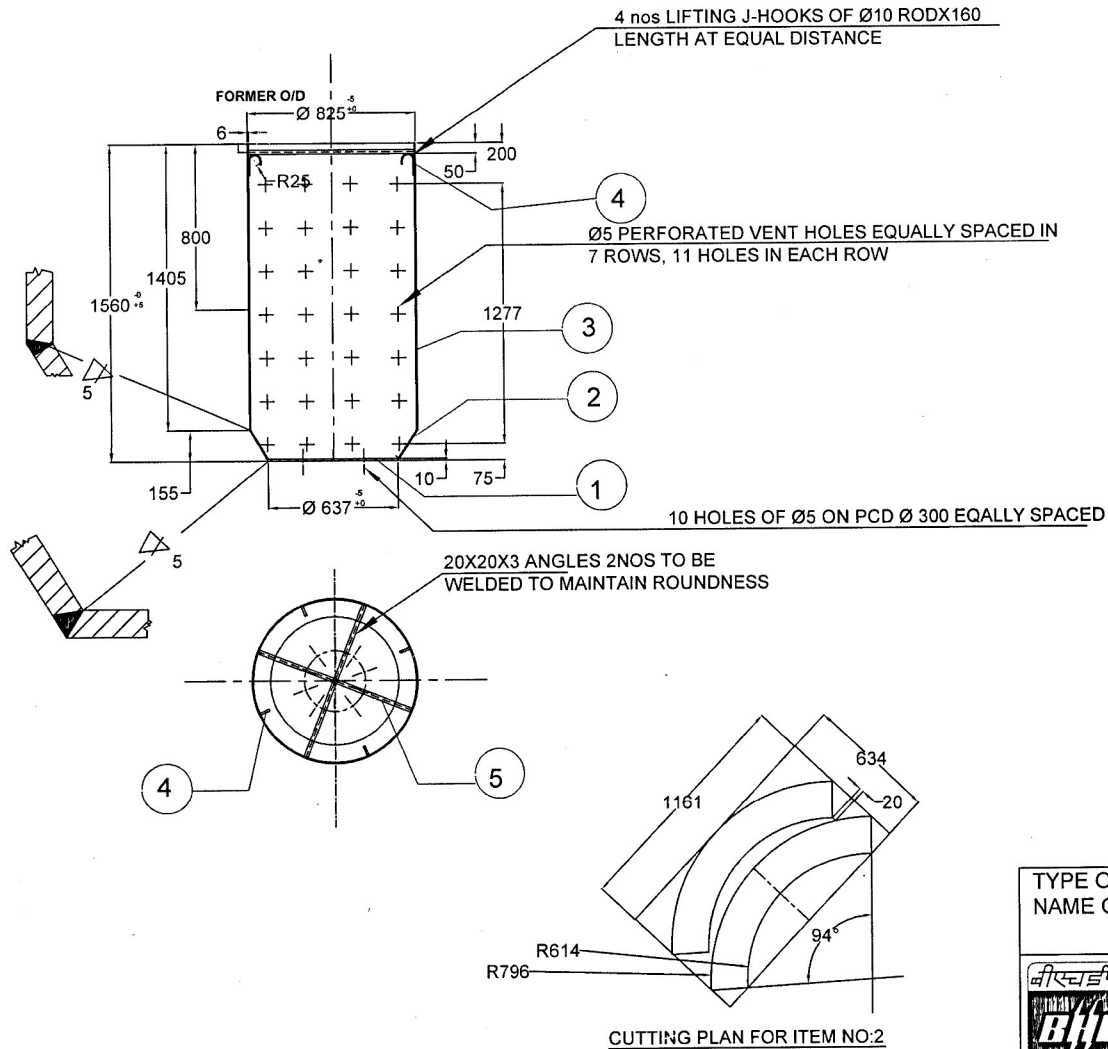
SIGN. AND DATE

INVENTORY NO

DRG. NO.

SH. 1 OF 1

GENERAL DIMENSIONAL LIMITS, FITS & TOLERANCES AS PER HY0230261



SAP DRAWING NO

REV NO

3-39999-40896

00

NOTE:

- SIDE WELDS MUST BE CONTINUOUS AND GROUND SMOOTH ON OUTSIDE AND INSIDE.
- BEND OR BREAK AND WELD SECTIONS AS REQUIRED TO OBTAIN CONICAL FORM.
- APPLY ONLY RED OXIDE ON FORMER.

5	ANGLE	20X20X3X825	HY 101 25 08 609	0.75	1.5
			AA 101 08		2
4	LIFTING LUG	Ø 10X165	HY 101 02 99 069	0.13	0.52
			HY 101 99		4
3	SHELL	2610X1420X6	AA 101 18 08 030	174.6	174.6
			AA 101 08		1
2	CONE	1180X650	AA 101 18 08 030	36.7	36.7
			AA 101 08		1
1	BASE	Ø 655X10	AA 101 18 19 074	26.6	26.6
			AA 101 19		1
ITEM.NO	DESCRIPTION	SIZE	MATL.CODE	NET.WT	GROSS.WT
			MATL.SPCN		QTY

RAW MATERIAL GROSS WT: 240 KG

NET.WT: 210 KG

TYPE OF PRODUCT OR
NAME OF CUSTOMER/PROJECTBHARAT HEAVY ELECTRICALS LTD.
HYDERABAD

	NAME	SIGN.	DATE	NO.OF VAR.
DRN.	ARPANA.K		03.08.11	
CHD.	V.L.NATH		03.08.11	-NA-
APPD.	M.N.A		03.08.11	

DEPT. F&P CODE 204A	UNTOL. DIMS. GR. /C/M/F/ 	SCALE N.T.S	WEIGHT (KG)	REF. TO ASSY. DRG. -NA-	ITEM NO. -NA-	NO.OF ITEMS -NA-
TITLE LINING FORMER FOR 5T MEGATHERM INDUCTION MELTING FURNACE				CARD CODE -NA-	DRAWING NO. 3-04-896	REV. 00
				SHT. No	1	NO. OF SHT. 1