

DRG. NO. 1-216-01-12097

SECTION-BB

TOOL LIST

SL. No.	DESCRIPTION	TOOL No.
1	BLANK FLANGES TO SUIT 6 HOLES M12 ON 140 PCD AT A PRESSURE OF 13 kg/sq cm 2 OFF.	

SECTION-AA

SECTION-CC

SCALE 1:2.5

VIEW-Z

SCALE 1:2.5

TECHNICAL REQUIREMENTS

- MATERIAL: AUSTENITIC DUCTILE IRON CASTING TO ASTM A-439 TYPE D-2
CHEMICAL COMPOSITION
CARBON 3.00 % (MAX)
SILICON 1.5 TO 3.0 %
MANGANESE 0.70 TO 1.25 %
PHOSPHOROUS 0.08 % (MAX)
NICKEL 18.00 TO 22.00 %
CHROMIUM 1.75 TO 2.75 %
MECHANICAL PROPERTIES
TENSILE STRENGTH (MIN) 4000 Kg/sq cm
YIELD STRENGTH 2070 Kg/sq cm
ELONGATION IN 50mm 8.0% (MIN)
BRINELL HARDNESS (3000 Kg) 139-202
- THE DRG. SHOWS THE BODY IN FINISH M/CED CONDITION. THE DIMENSIONS SHOWN IN () ARE AS CAST DIMENSIONS. THE CASTING IS TO BE SUPPLIED IN ROUGH M/CED CONDITION WITH M/CING ALLOWANCE OF 5mm AT TOOL POINT AT ALL PLACES WHERE FINISH MACHINING IS TO BE CARRIED OUT.
- THE TEST PIECES OF SUITABLE SIZES SHOULD BE CAST SEPARATELY FROM THE SAME MELT AS THE CASTINGS THEY REPRESENT.
- ALL UNSPECIFIED RADII TO BE OF 6mm.
- CASTING SHOULD BE SOUND & FREE FROM BLOW HOLES, CRACKS, HOT TEARS, COLD SHUTS ETC. FOUNDER TO NOTE THAT THE CASTING SHALL BE SUBJECTED TO HYDRAULIC PRESSURE TEST AT BHFL AT 14 kg/sq cm. FOR 10 MINUTES.
- TOLERANCES ON AS CAST DIMENSIONS TO BE AS PER BHFL CORP. STD. AA 0230402 CLASS-5.
- CASTING SHALL BE MARKED WITH A IDENTIFICATION NO. (AT PLACE AS SHOWN) FROM WHICH IT CAN BE TRACED TO THE MELT & THE BATCH OF HEAT TREATMENT.
- CASTING TO BE SUPPLIED IN HEAT TREATED CONDITION. TEST BARS SHALL ALSO BE HEAT TREATED ALONG WITH THE CASTINGS THEY REPRESENT.
- ROUGH M/CED SURFACES TO BE SUBJECTED TO 100% DP TESTED AS PER BHFL CORP. STD. AA 0850132.
- FOR PAINTING REQUIREMENTS REFER THE ASSY. DRG.
- PERMISSIBLE VARIATION FOR UNTOL. DIMENSIONS TO BE AS PER DRG. 3-200-00-49014.

VAR.00	REMARKS	VAR.01	ITEM NO.	DESCRIPTION	STD.	DRAWING NO.	28 - CARD TYPE-3	28 - CARD TYPE-1	28 - CARD TYPE-2
DRAWING REVIEW									
DEPT.	NAME	SIGN.	DATE	ADDITIONAL INFORMATION					
WMT				AS CAST 280 kg.					
THX				STATUS OF DRAWING					
DISTRIBUTION OF PRINTS				TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT					
HTE ---2				BFV STANDARD					
WMT ---5 THX ---1				BHARAT HEAVY ELECTRICALS LTD. BHOPAL					
REV. DATE				DRN SRS					
01 7.6.08				JSH					
APPR. P.150				JSH					
REV. DATE				UNTO. DIMS. GR.					
01 7.6.08				SCALE 1:2.5					
APPR. P.150				WEIGHT (K.G.) 230					
REV. DATE				REF. TO ASSY. DRG.					
01 7.6.08				ITEM NO. 01					
APPR. P.150				NO. OF SHT. 1					
REV. DATE				DRAWING NO. 1-216-01-12097					
01 7.6.08				REV. 01					
APPR. P.150				SHT. NO. 1					
REV. DATE				NO. OF SHT. 1					
01 7.6.08				A1 SIZE					