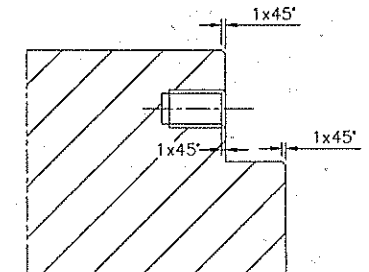


32 HOLES EQUISPACED OFF CTRS
DRILL 18 DEEP & TAP M10x15
DEEP AS SHOWN.(CHORD PITCH=52.73)
(USE FLAT DRILL)

4 HOLES DRILL .32 DEEP & TAP M16x30 DEEP
ON PCD 340 EQUISPACED OFF CTRS AS SHOWN.
FOR LIFTING PURPOSE IN FACE A.

DETAIL-D.



DETAIL-D.
SCALE-1:1

CHEMICAL COMPOSITION		MECHANICAL PROPERTIES	
CARBON	3.00 % (MAX)	TENSILE STRENGTH (MIN)	4000 Kg/sq cm
SILICON	1.5 TO 3.0 %	YIELD STRENGTH	2070 Kg/sq cm
MANGANESE	0.70 TO 1.25 %	ELONGATION IN 50mm	8.0% (MIN)
PHOSPHOROUS	0.08 % (MAX)	BRINELL HARDNESS (3000 Kg)	139-202
NICKEL	18.00 TO 22.00 %		
CHROMIUM	1.75 TO 2.75 %		

- THE DRG. SHOWS THE DOOR 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 EXCEPT FACE A.
- 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 SHOTS 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.
- NON-COAXIALITY OF $\phi 85^{+0.04}_{-0}$ BORES IN BOTH THE TRUNNION BLOCKS TO BE LESS THAN 0.04mm.
- NON-PERPENDICULARITY OF TRUNNION AXIS WRT TO AXIS OF $\phi 511^{+0.1}_{-0}$ TO BE LESS THAN 0.1mm.

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