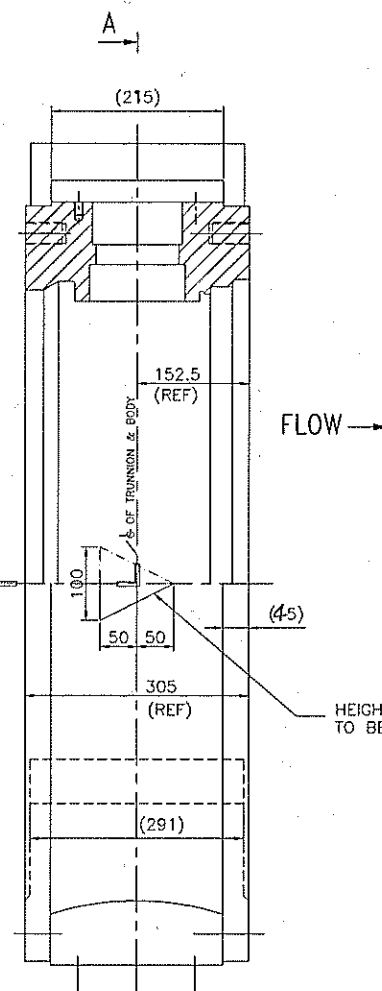
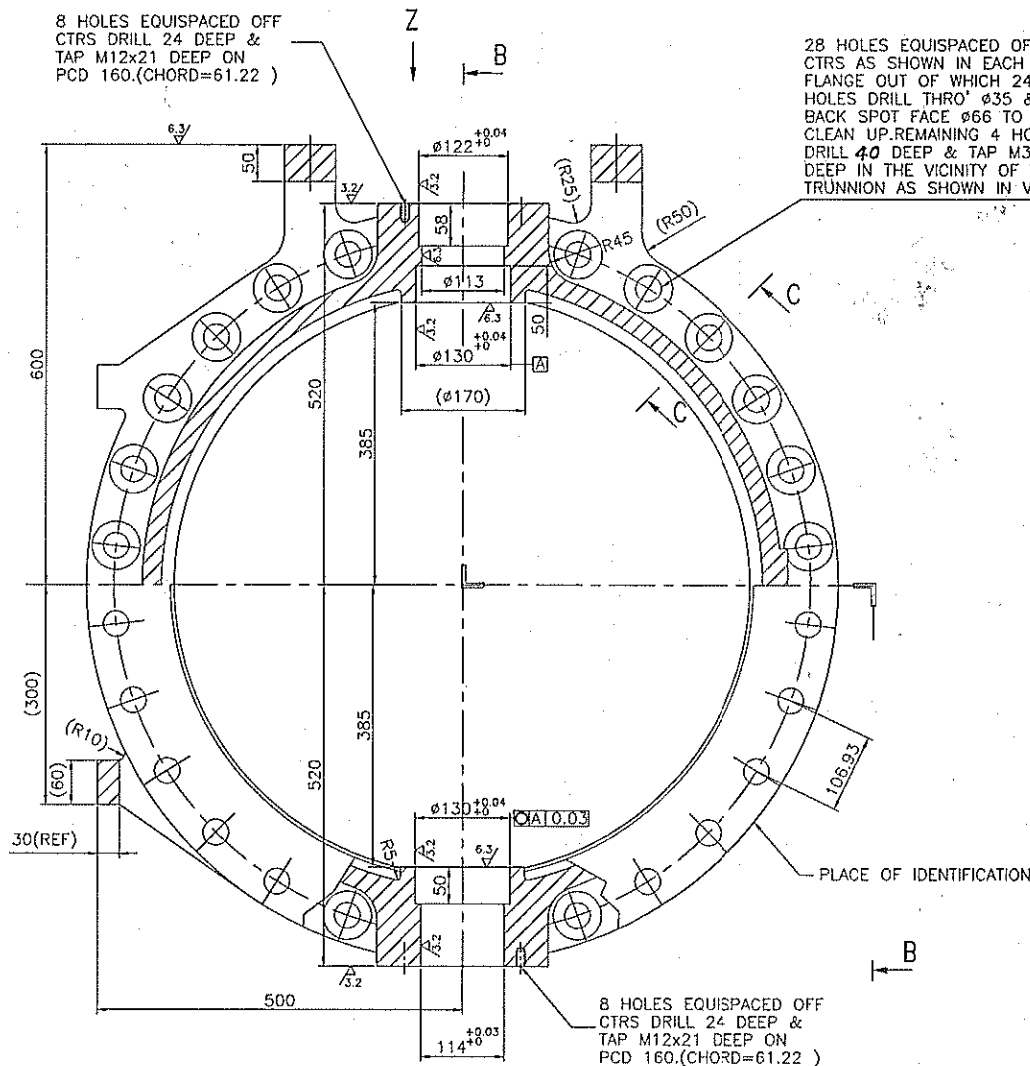


80121-01-12108

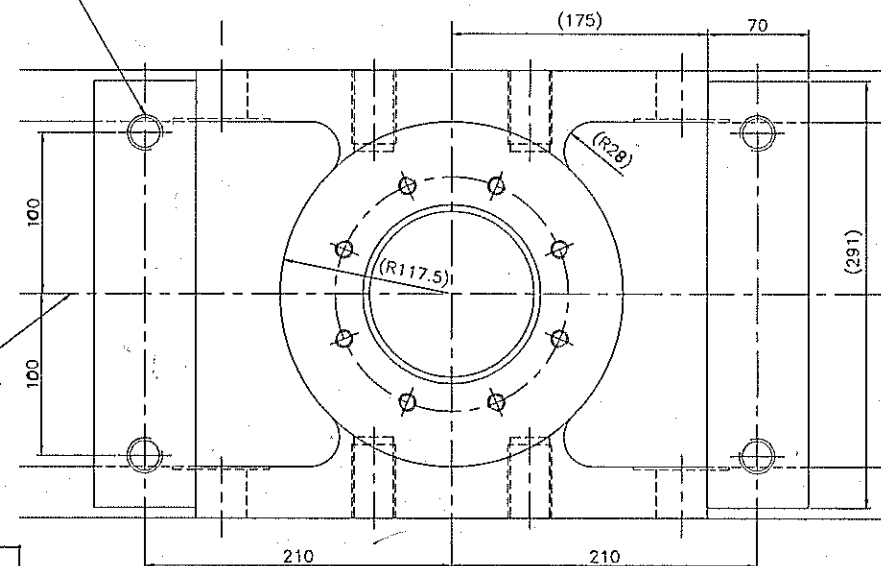


SECTION-BB



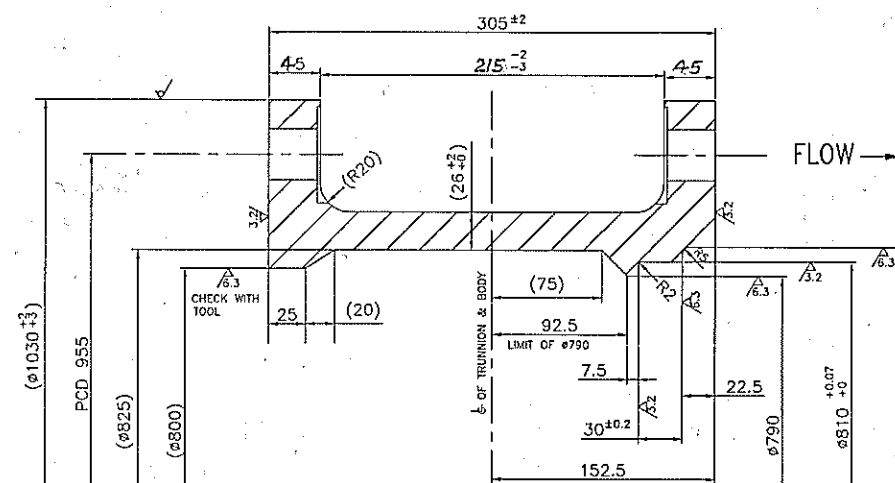
SECTION-AA

4 HOLES POSITIONED
AS SHOWN DRILL 45 DEEP
& TAP M24x40 DEEP.

VIEW - Z
SCALE 1:2.5

TOOL LIST

SL. No.	DESCRIPTION	TOOL NO.
1	BLANK FLANGES TO SUITE 8 HOLES M12 ON 160 PCD AT A PRESSURE OF 13 kg/cm ² 2 OFF	1586311

SECTION-CC
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 %
PHOSPHORUS 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 BHEL AT 14 kg/sq cm. FOR 10 MIN.
- TOLERANCES ON AS CAST DIMENSIONS TO BE AS PER BHEL 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 BHEL 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.

28 - CARD TYPE-3		28 - CARD TYPE-1		28 - CARD TYPE-2	
VAR.00	REMARKS	VAR.00	REMARKS	VAR.00	REMARKS
DRAWING REVIEW		ADDITIONAL INFORMATION		TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT	
DEPT.	NAME	DATE	DATE	BFV - STANDARD	
WTM	NAME	DATE	DATE	BHARAT HEAVY ELECTRICALS LTD. BHOPAL	
THX	NAME	DATE	DATE	NAME	
STATUS OF DRAWING		DISTRIBUTION OF PRINTS		SIGN	
PSE - 2		TGX - 1		DATE	
STM - 5		TAX - 1		NO. OF	
REV. DATE		REV. DATE		REV. DATE	
02 7.6.08		01 6.5.08		01 6.5.08	
03 23.7.08		02 7.6.08		03 23.7.08	
04 16.5.08		03 23.7.08		04 16.5.08	
05 16.5.08		04 16.5.08		05 16.5.08	
06 16.5.08		05 16.5.08		06 16.5.08	
07 16.5.08		06 16.5.08		07 16.5.08	
08 16.5.08		07 16.5.08		08 16.5.08	
09 16.5.08		08 16.5.08		09 16.5.08	
10 16.5.08		09 16.5.08		10 16.5.08	
11 16.5.08		10 16.5.08		11 16.5.08	
12 16.5.08		11 16.5.08		12 16.5.08	
13 16.5.08		12 16.5.08		13 16.5.08	
14 16.5.08		13 16.5.08		14 16.5.08	
15 16.5.08		14 16.5.08		15 16.5.08	
16 16.5.08		15 16.5.08		16 16.5.08	
17 16.5.08		16 16.5.08		17 16.5.08	
18 16.5.08		17 16.5.08		18 16.5.08	
19 16.5.08		18 16.5.08		19 16.5.08	
20 16.5.08		19 16.5.08		20 16.5.08	
21 16.5.08		20 16.5.08		21 16.5.08	
22 16.5.08		21 16.5.08		22 16.5.08	
23 16.5.08		22 16.5.08		23 16.5.08	
24 16.5.08		23 16.5.08		24 16.5.08	
25 16.5.08		24 16.5.08		25 16.5.08	
26 16.5.08		25 16.5.08		26 16.5.08	
27 16.5.08		26 16.5.08		27 16.5.08	
28 16.5.08		27 16.5.08		28 16.5.08	
29 16.5.08		28 16.5.08		29 16.5.08	
30 16.5.08		29 16.5.08		30 16.5.08	
31 16.5.08		30 16.5.08		31 16.5.08	
32 16.5.08		31 16.5.08		32 16.5.08	
33 16.5.08		32 16.5.08		33 16.5.08	
34 16.5.08		33 16.5.08		34 16.5.08	
35 16.5.08		34 16.5.08		35 16.5.08	
36 16.5.08		35 16.5.08		36 16.5.08	
37 16.5.08		36 16.5.08		37 16.5.08	
38 16.5.08		37 16.5.08		38 16.5.08	
39 16.5.08		38 16.5.08		39 16.5.08	
40 16.5.08		39 16.5.08		40 16.5.08	
41 16.5.08		40 16.5.08		41 16.5.08	
42 16.5.08		41 16.5.08		42 16.5.08	
43 16.5.08		42 16.5.08		43 16.5.08	
44 16.5.08		43 16.5.08		44 16.5.08	
45 16.5.08		44 16.5.08		45 16.5.08	
46 16.5.08		45 16.5.08		46 16.5.08	
47 16.5.08		46 16.5.08		47 16.5.08	
48 16.5.08		47 16.5.08		48 16.5.08	
49 16.5.08		48 16.5.08		49 16.5.08	
50 16.5.08		49 16.5.08		50 16.5.08	
51 16.5.08		50 16.5.08		51 16.5.08	
52 16.5.08		51 16.5.08		52 16.5.08	
53 16.5.08		52 16.5.08		53 16.5.08	
54 16.5.08		53 16.5.08		54 16.5.08	
55 16.5.08		54 16.5.08		55 16.5.08	
56 16.5.08		55 16.5.08		56 16.5.08	
57 16.5.08		56 16.5.08		57 16.5.08	
58 16.5.08		57 16.5.08		58 16.5.08	
59 16.5.08		58 16.5.08		59 16.5.08	
60 16.5.08		59 16.5.08		60 16.5.08	
61 16.5.08		60 16.5.08		61 16.5.08	
62 16.5.08		61 16.5.08		62 16.5.08	
63 16.5.08		62 16.5.08		63 16.5.08	
64 16.5.08		63 16.5.08		64 16.5.08	
65 16.5.08		64 16.5.08		65 16.5.08	
66 16.5.08		65 16.5.08		66 16.5.08	
67 16.5.08		66 16.5.08		67 16.5.08	
68 16.5.08		67 16.5.08		68 16.5.08	
69 16.5.08		68 16.5.08		69 16.5.08	
70 16.5.08		69 16.5.08		70 16.5.08	
71 16.5.08		70 16.5.08		71 16.5.08	
72 16.5.08		71 16.5.08		72 16.5.08	
73 16.5.08		72 16.5.08		73 16.5.08	
74 16.5.08		73 16.5.08		74 16.5.08	
75 16.5.08		74 16.5.08		75 16.5.08	
76 16.5.08		75 16.5.08		76 16.5.08	
77 16.5.08		76 16.5.08		77 16.5.08	
78 16.5.08		77 16.5.08		78 16.5.08	
79 16.5.08		78 16.5.08		79 16.5.08	
80 16.5.08		79 16.5.08		80 16.5.08	
81 16.5.08		80 16.5.08		81 16.5.08	
82 16.5.08		81 16.5.08		82 16.5.08	
83 16.5.08		82 16.5.08		83 16.5.08	
84 16.5.08		83 16.5.08		84 16.5.08	
85 16.5.08		84 16.5.08		85 16.5.08	
86 16.5.08		85 16.5.08		86 16.5.08	
87 16.5.08		86 16.5.08		87 16.5.08	
88 16.5.08		87 16.5.08		88 16.5.08	
89 16.5.08		88 16.5.08		89 16.5.08	
90 16.5.08		89 16.5.08		90 16.5.08	
91 16.5.08		90 16.5.08		91 16.5.08	
92 16.5.08		91 16.5.08		92 16.5.08	
93 16.5.08		92 16.5.08		93 16.5.08	
94 16.5.08		93 16.5.08		94 16.5.08	
95 16.5.08		94 16.5.08		95 16.5.08	
96 16.5.08		95 16.5.08		96 16.5.08	
97 16.5.08		96 16.5.08		97 16.5.08	
98 16.5.08		97 16.5.08		98 16.5.08	
99 16.5.08		98 16.5.08		99 16.5.08	
100 16.5.08		99 16.5.08		100 16.5.08	
101 16.5.08		100 16.5.08		101 16.5.08	
102 16.5.08		101 16.5.08		102 16.5.08	
103 16.5.08		102 16.5.08		103 16.5.08	
104 16.5.08		103 16.5.08		104 16.5.08	
105 16.5.08		104 16.5.08		105 16.5.08	
106 16.5.08		105 16.5.08		106 16.5.08	
107 16.5.08		106 16.5.08		107 16.5.08	
108 16.5.08		107 16.5.08		108 16.5.08	
109 16.5.08		108 16.5.08		109 16.5.08	
110 16.5.08		109 16.5.08		110 16.5.08	
111 16.5.08		110 16.5.08		111 16.5.08	
112 16.5.08		111 16.5.08		112 16.5.08	
113 16.5.08		112 16.5.08		113 16.5.08	
114 16.5.08		113 16.5.08		114 16.5.08	
115 16.5.08		114 16.5.08		115 16.5.08	
116 16.5.08		115 16.5.08		116 16.5.08	
117 16.5.08		116 16.5.08		117 16.5.08	
118 16.5.08		117 16.5.08		118 16.5.08	
119 16.5.08		118 16.5.08		119 16.5.08	
120 16.5.08		119 16.5.08		120 16.5.08	
121 16.5.08		120 16.5.08		121 16.5.08	
122 16.5.08		121 16.5.08		122 16.5.08	
123 16.5.08		122 16.5.08		123 16.5.08	
124 16.5.08		123 16.5.08		124 16.5.08	
125 16.5.08		124 16.5.08		125 16.5.08	
126 16.5.08		125 16.5.08		126 16.5.08	
127 16.5.08		126 16.5.08		127 16.5.08	
128 16.5.08		127 16.5.08		128 16.5.08	
129 16.5.08		128 16.5.08		129 16.5.08	
130 16.5.08		129 16.5.08		130 16.5.08	
131 16.5.08		130 16.5.08		131 16.5.08	
132 16.5.08		131 16.5.08		132 16.5.08	
133 16.5.08		132 16.5.08		133 16.5.08	
134 16.5.08		133 16.5.08		134 16.5.08	
135 16.5.08		134 16.5.08		135 16.5.08	
136 16.5.08		135 16.5.08		136 16.5.08	
137 16.5.08		136 16.5.08		137 16.5.08	
138 16.5.08		137 16.5.08		138 16.5.08	
139 16.5.08		138 16.5.08		139 16.5.08	
140 16.5.08		139 16.5.08		140 16.5.08	
141 16.5.08		140 16.5.08		141 16.5.08	
142 16.5.08		141 16.5.08		142 16.5.08	
143 16.5.08		142 16.5.08		143 16.5.08	
144 16.5.08		143 16.5.08		144 16.5.08	
145 16.5.08		144 16.5.08		145 16.5.08	
146 16.5.08		145 16.5.08		146 16.5.08	
147 16.5.08		146 16.5.08		147 16.5.08	
148 16.5.08		147 16.5.08		148 16.5.08	
149 16.5.08		148 16.5.08		149 16.5.08	
150 16.5.08		149 16.5.08		150 16.5.08	
151 16.5.08		150 16.5.08		151 16.5.08	
152 16.5.08		151 16.5.08		152 16.5.08	
153 16.5.08		152 16.5.08		153 16.5.08	
154 16.5.08		153 16.5.08		154 16.5.08	
155 16.5.08		154 16.5.08		155 16.5.08	
156 16.5.08		155 16.5.08		156 16.5.08	
157 16.5.08		156 16.5.08		157 16	