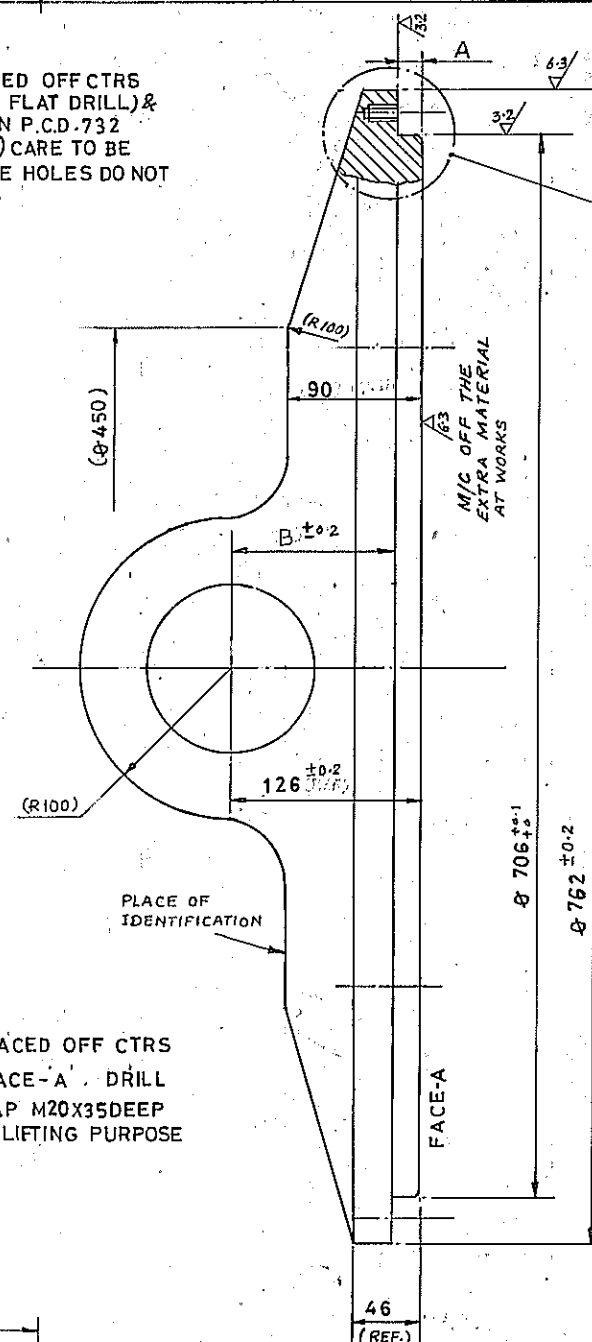
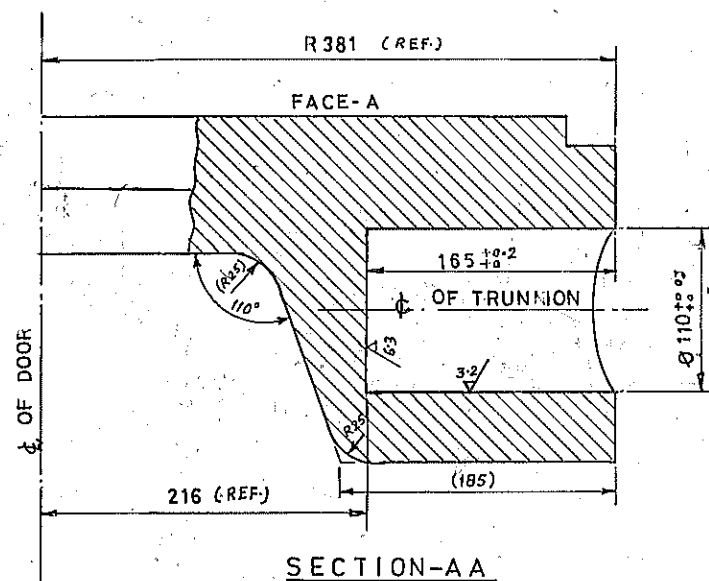


011210-912-1
ORG. NO. 1-216-01-1110

40 HOLES EQUISPACED OFF CTRS
DRILL 18 DEEP (USE FLAT DRILL) &
TAP M10 X 16 DEEP ON P.C.D. 732
(CHORD PITCH = 57.43) CARE TO BE
TAKEN THAT THESE HOLES DO NOT
BREAK THROUGH.

4 HOLES EQUISPACED OFF CTRS
AS SHOWN IN FACE-A. DRILL
40 DEEP AND TAP M20 X 35 DEEP
ON P.C.D. 600 FOR LIFTING PURPOSE

VAR	PROJECT	A	B
01	SIMHADRI - 1, 2	16	110
02	SIMHADRI - 3, 4	18	108



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. c.m.
YIELD STRENGTH 2070 kg/sq. c.m.
ELONGATION IN 50 m.m. 8.0% (MIN.)
BRINELL HARDNESS (3000kg) 139-202
- THE DRG. SHOWS THE DOOR IN FINISH M/C'D CONDITION. THE DIMENSIONS SHOWN IN C. J. ARE AS CAST DIMENSIONS. THE CASTING IS TO BE SUPPLIED IN ROUGH M/C'D CONDITION WITH M/C'ING ALLOWANCE OF 5 mm. 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 6 mm.
- 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. AFTER FINAL M/C'ING.
- TOLERANCES ON AS CAST DIMENSIONS TO BE AS PER BHEL CORP. STD. DAA0230402 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 CASTING THEY REPRESENT.
- ROUGH M/C'D SURFACES TO BE SUBJECTED TO 100% DP TESTED AS PER BHEL CORP. STD. AA0850132.
- FOR PAINTING REQUIREMENTS REFER THE ASSY. DRG.
- PERMISSIBLE VARIATION FOR UNTOL. DIMENSIONS TO BE AS PER DRG-3-200-00-49014.
- NON-COAXIALITY OF $\phi 110 \pm 0.03$ BORES IN BOTH THE TRUNNION BLOCKS TO BE LESS THAN 0.04 mm.
- NON-PERPENDICULARITY OF TRUNNION AXIS WRT TO AXIS OF $\phi 706 \pm 0.2$ TO BE LESS THAN 0.1 mm.

VAR	REMARK	VAR NO	ITEM NO	DESCRIPTION	DRG. NO	17 NO	MATL CODE	UNIT WT	ZONE

DRAWING REVIEW		ADDITIONAL INFORMATION		BFV-STANDARD	
DEPT.	NAME	DATE	TYPE OF PRODUCT OR NAME OF CUSTOMER / PROJECT	DATE	NO. OF
THX	CGB	13-8-77	AS CAST 360 KG.	10-8-77	VAR.
STATUS OF DRAWING			DISTRIBUTION OF PRINTS		
			HTE 2 THX 1		
			WTM 5		
REV. DATE ALTERED			REV. DATE ALTERED		
01 7.6.08 CHECKED HJ			01 7.6.08 CHECKED HJ		
APPROVED PHB			APPROVED PHB		
VAR. 02 INTRODUCED			VAR. 02 INTRODUCED		
& DRG. WAS FOR VAR 01			& DRG. WAS FOR VAR 01		
TR 11 DELETED.			TR 11 DELETED.		
TITLE			TITLE		
800 B.F. VALVE DOOR			800 B.F. VALVE DOOR		
(FOR SEA WATER)			(FOR SEA WATER)		
SHT. NO. 01			SHT. NO. 01		
NO. OF SHT. 01			NO. OF SHT. 01		