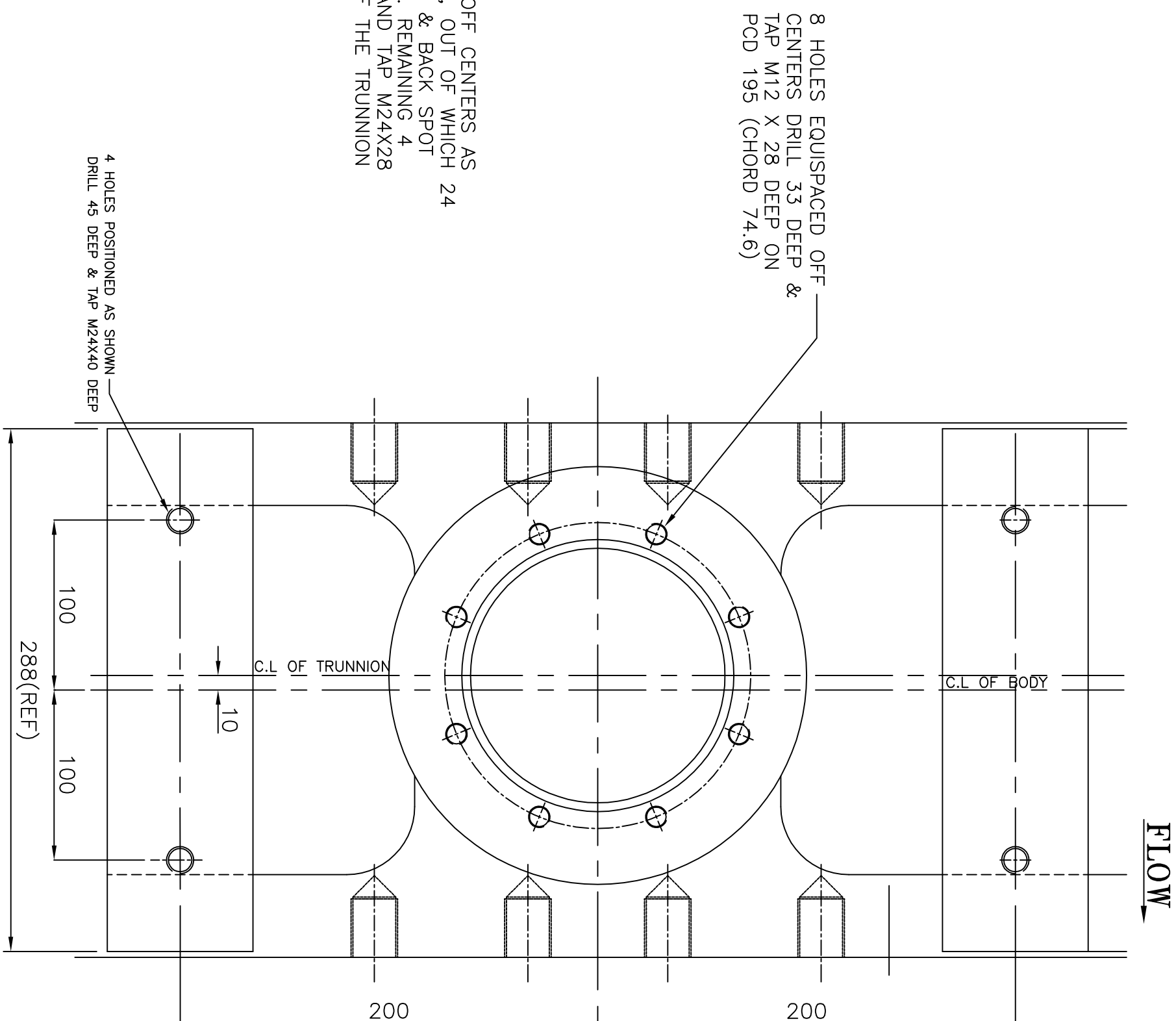
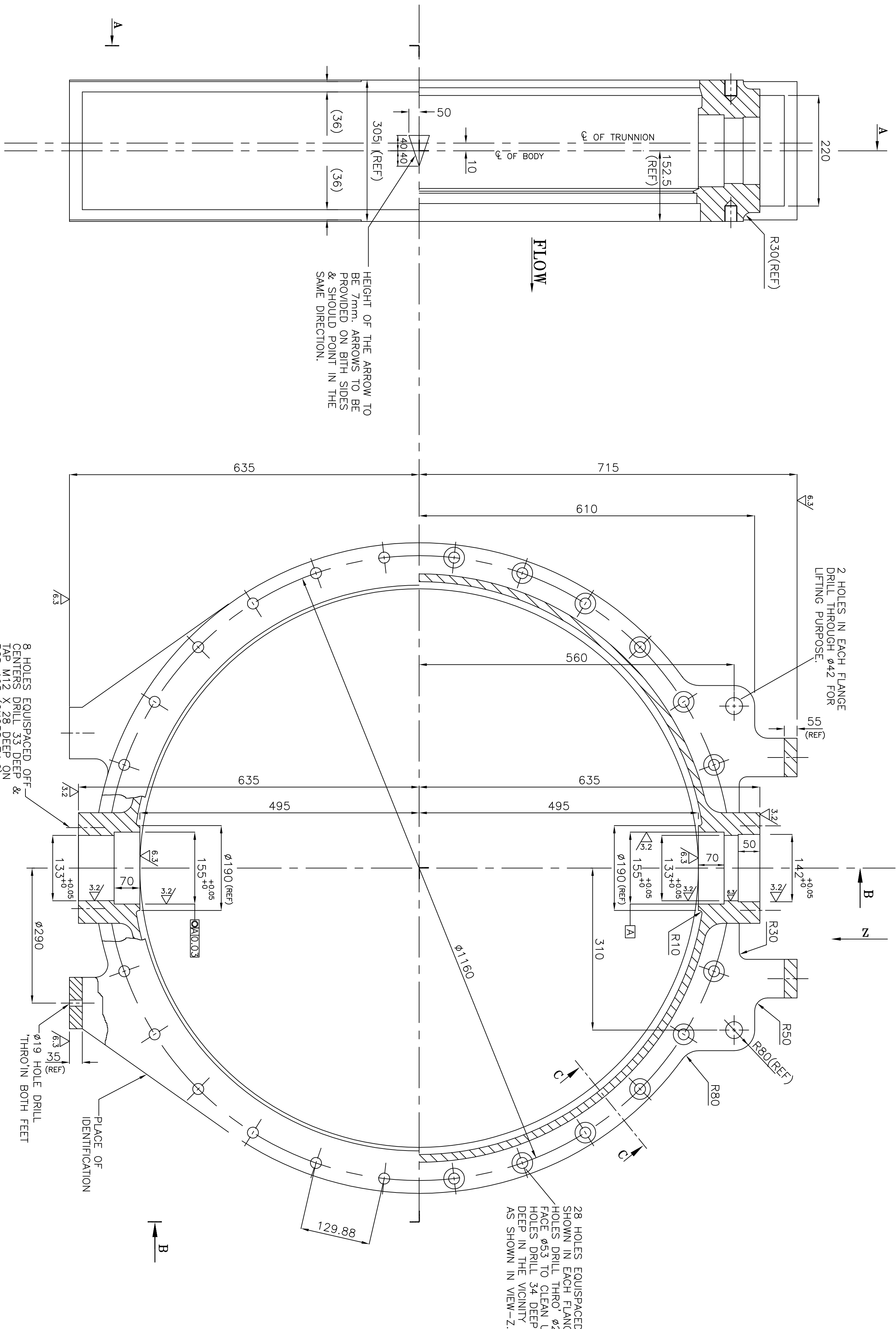


VIEW ON-Z
SCALE-1:5

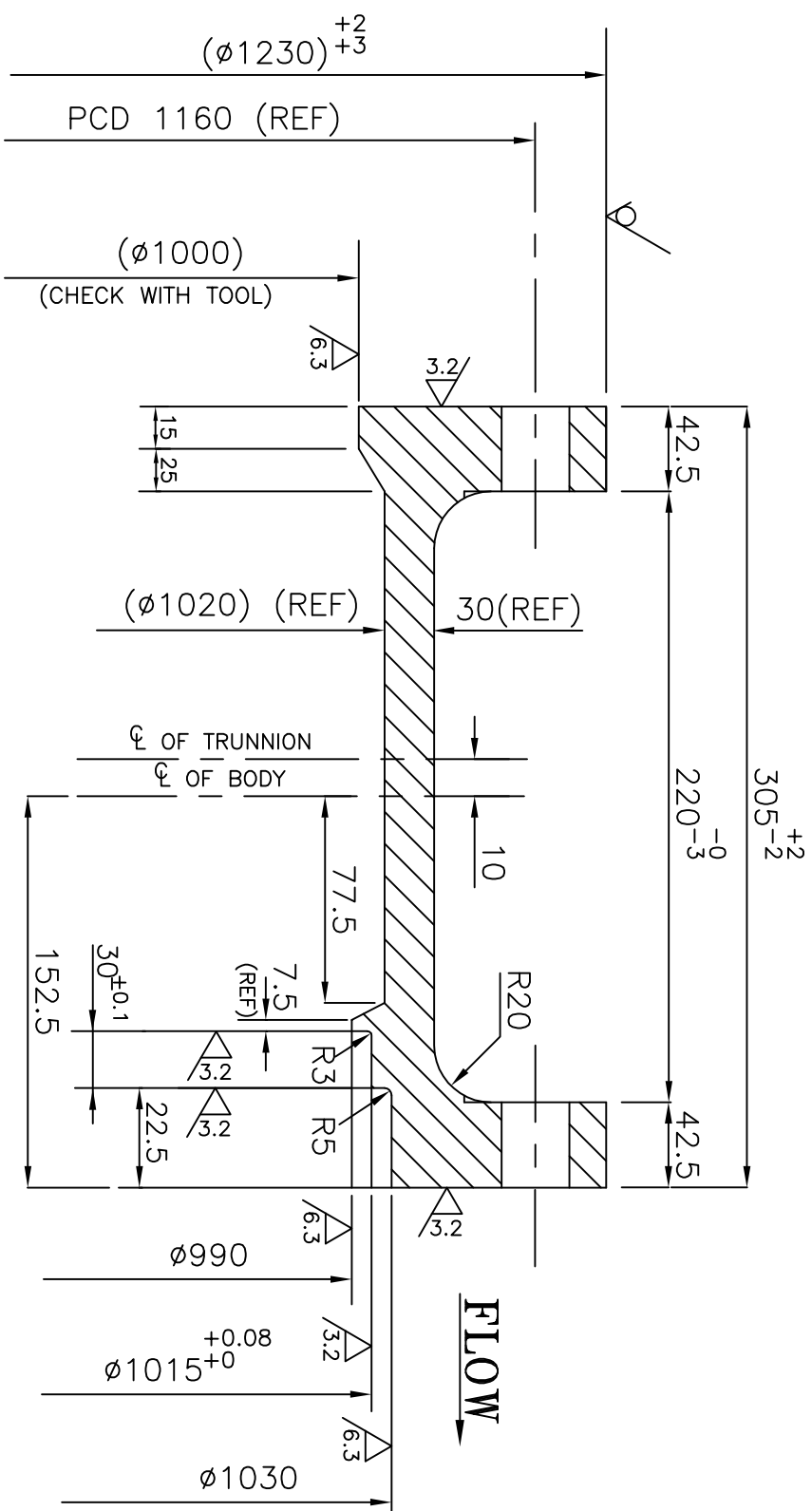
TECHNICAL REQUIREMENTS

- MATERIAL: AUSTENITIC DUCTILE IRON CASTING TO ASTM A-439 TYPE D-2
CHEMICAL COMPOSITION
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 (3000Kg) 139-202
NICKEL 18.00 TO 22.00 %
CHROMIUM 1.75 TO 2.75 %
- 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 PLACES WHERE FINISH MACHINING IS TO BE CARRIED OUT.
- THE TEST PIECES OF SUITABLE SIZES SHOULD BE CAST SEPARATELY FROM THE SAME 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 10 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 TEST AS PER BHEL CORP. STD. AA0850132.
- PERMISSIBLE VARIATION FOR UNTOL. DIMENSIONS TO BE AS PER DRG. 3-200-00-49014.
- COMPLETE TESTING/INSPECTION REQUIREMENTS, SHALL BE AS PER OUR ENQUIRY/P.O. SPECIFICATIONS.
- WELD REPAIR OF CASTINGS IN ANY CASE IS NOT ALLOWED.
- WEIGHT OF THE CASTING IN FINISHED M/CED CONDITION = 520 kg.

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IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

SECTION - BB

SECTION - AA



PRELIMINARY

ADDITIONAL INFORMATION				TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT				STANDARD			
STATUS OF DRAWING				NAME				SIGN			
DISTRIBUTION OF PRINTS				BHN H.K.LAMANH				25.10.08			
PSC-2				P.M.S.BISHI				25.10.08			
STM-5				V.K.JAIN				25.10.08			
TOX-1				APD				REF TO ASSY DRG.			
REV. DATE				UNTOOL. DWS. GR.				SCALE			
PSE				CODE				1:10			
APD				ZONE				TITLE			
4/12				Ø1000 B.F.V. BODY				(M/C ING)			
				DRAWING NO.				1 951 38 00008			
				REV.				00			