

60000831561 .ON .DRG.

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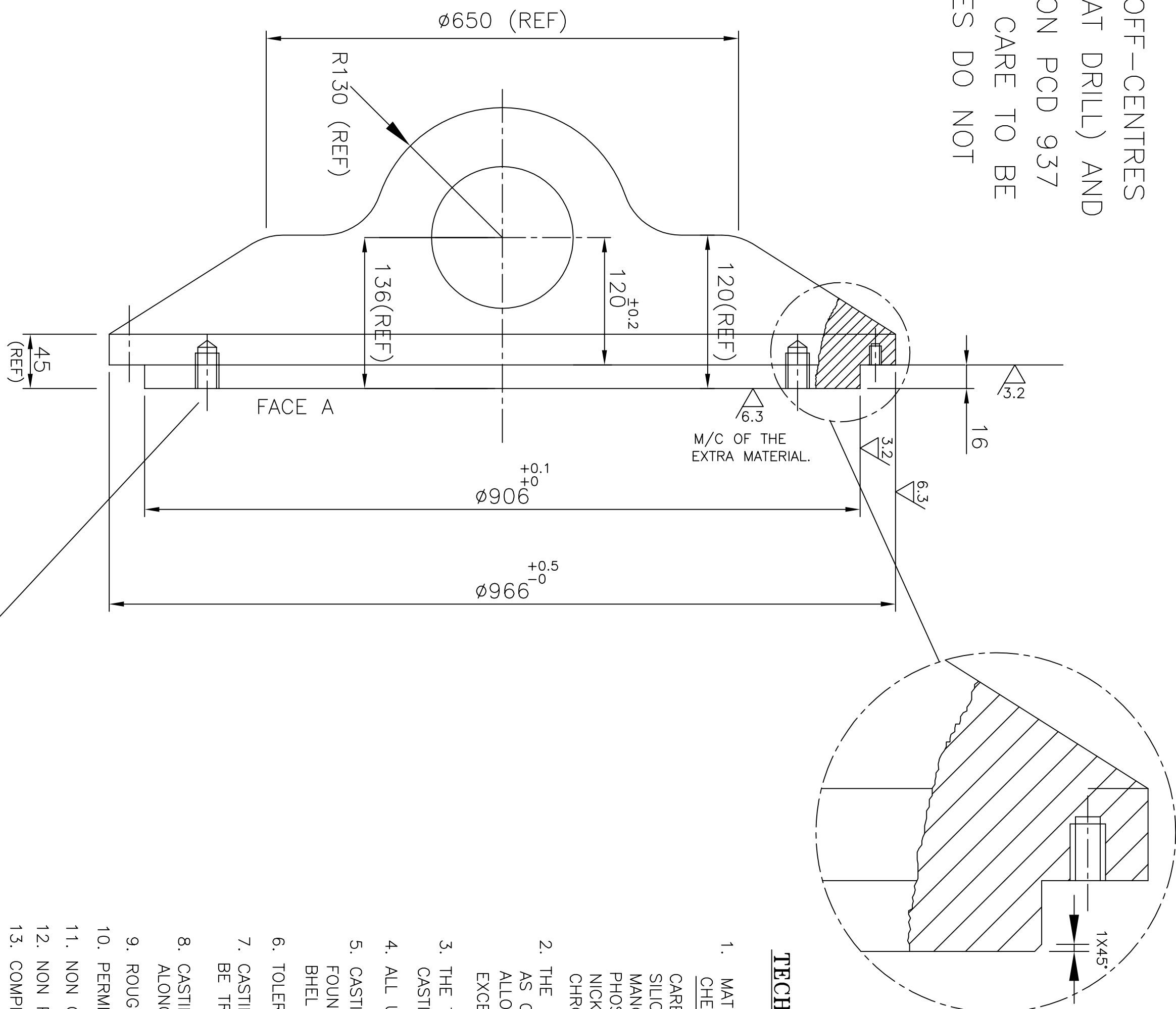
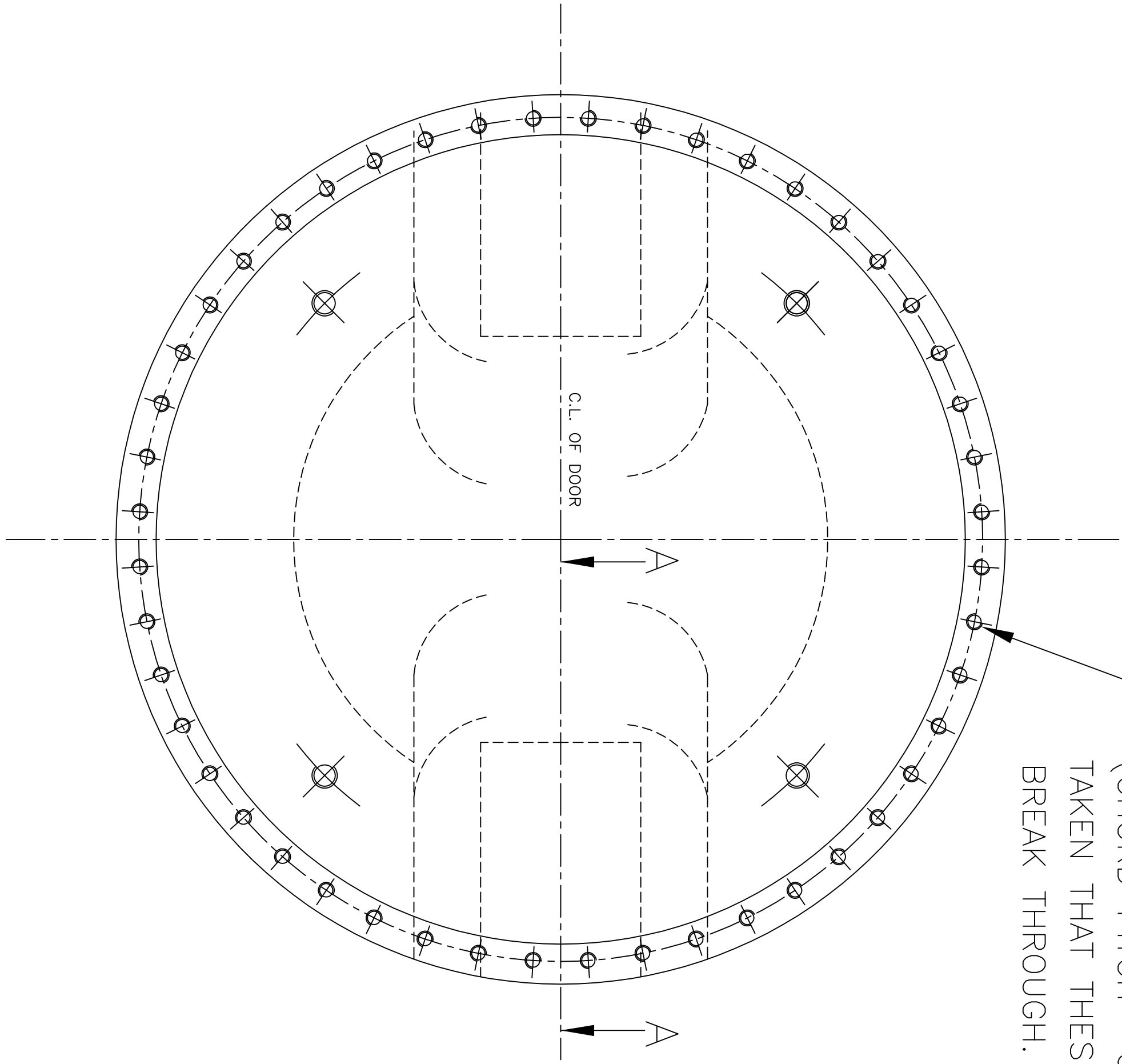
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48 HOLES EQUISPACED OFF-CENTRES
DRILL 18 DEEP (USE FLAT DRILL) AND
TAP M-10 X 16 DEEP ON PCD 937
(CHORD PITCH= 61.28). CARE TO BE
TAKEN THAT THESE HOLES DO NOT
BREAK THROUGH.



4 HOLES EQUISPACED
OFF CENTRES AS SHOWN
IN SIDE VIEW, DRILL 40 DEEP
AND TAP M20 X 36 DEEP
OF PCD 530 FOR LIFTING
PURPOSE.

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

SIDE VIEW

R 483(REF)

FACE A

C.L. OF DOOR

288 (REF)

195^{+0.5}₋₀

C.L. OF TRUNNION

Ø130^{+0.04}₊₀

SECTION-AA
GRID- C-2

TECHNICAL REQUIREMENTS

- MATERIAL: AUSTENITIC DUCTILE IRON CASTING TO ASTM A-439 TYPE D-2
CHEMICAL COMPOSITION

CARBON	3.00 % (MAX)	TENSILE STRENGTH (MN)	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	16.00 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 SHUTS ETC. FOUNDER TO NOTE THAT THE CASTING SHALL BE SUBJECTED TO HYDRAULIC PRESSURE TEST AT BHEL AT 10 kg/sq.cm. FOR 10 MINUTES AFTER FINAL M/C ING.
- 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.
- NON COAXIALITY OF Ø130^{+0.03} BORES IN BOTH TRUNNION BLOCKS TO BE LESS THAN 0.03mm.
- NON PERPENDICULARITY OF TRUNNION AXIS WRT THE AXIS OF Ø1650^{+0.2} TO BE LESS THAN 0.1 mm
- 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 = 660 kg.

ADDITIONAL INFORMATION				TYPE OF PRODUCT OR			
STATUS OF DRAWING				NAME OF CUSTOMER/PROJECT			
DISTRIBUTION OF PRINTS				B.F. VALVE STANDARD			
PSE - 2 TOX - 1				BHARAT HEAVY ELECTRICALS LTD. Bhopal			
STM - 5				BHN H.K.LAVANSHI			

REV.	DATE	ALTERED BY	CHKD BY	UNTOOL. DIMS. DRG.	SCALE	WEIGHTING	REF TO ASSY DRG.	ITEM NO.	NO. OF
01	22.04.11	APRD	P.S.BHIT	3.25	1:5	-	-	01	REV
ZONING OF HOLES CORRECTED TO 45°									
TITLE: Ø 1000 B.F. VALVE DOOR (W/C ING)									
(FOR SEA WATER)									
DRAWING NO. 19513800009 01									
SHT. NO. NO. OF SHT.									

INVENTORY NO.

SIGN. & DATE

REF. DRG. NO.

F

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D

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