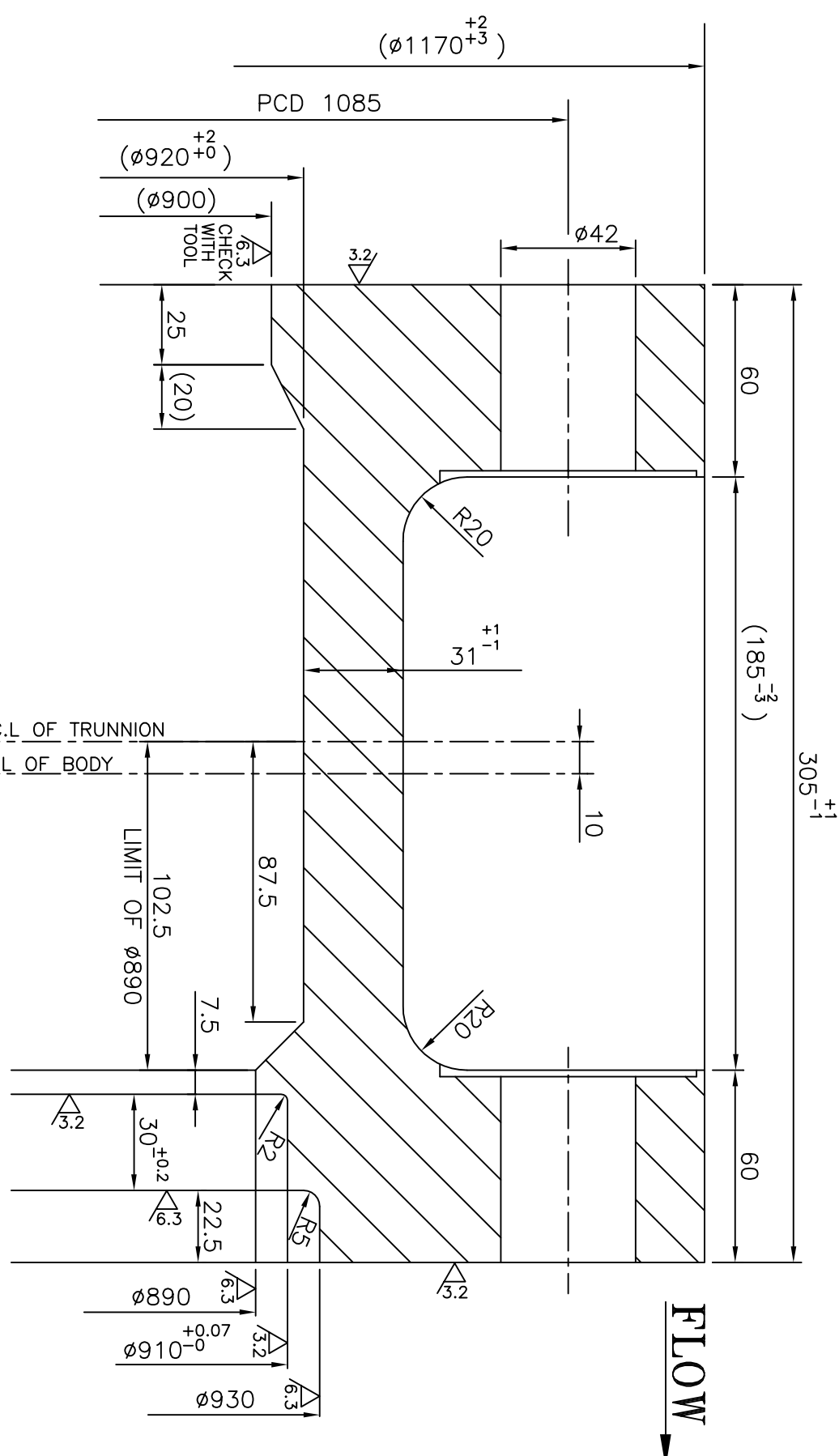
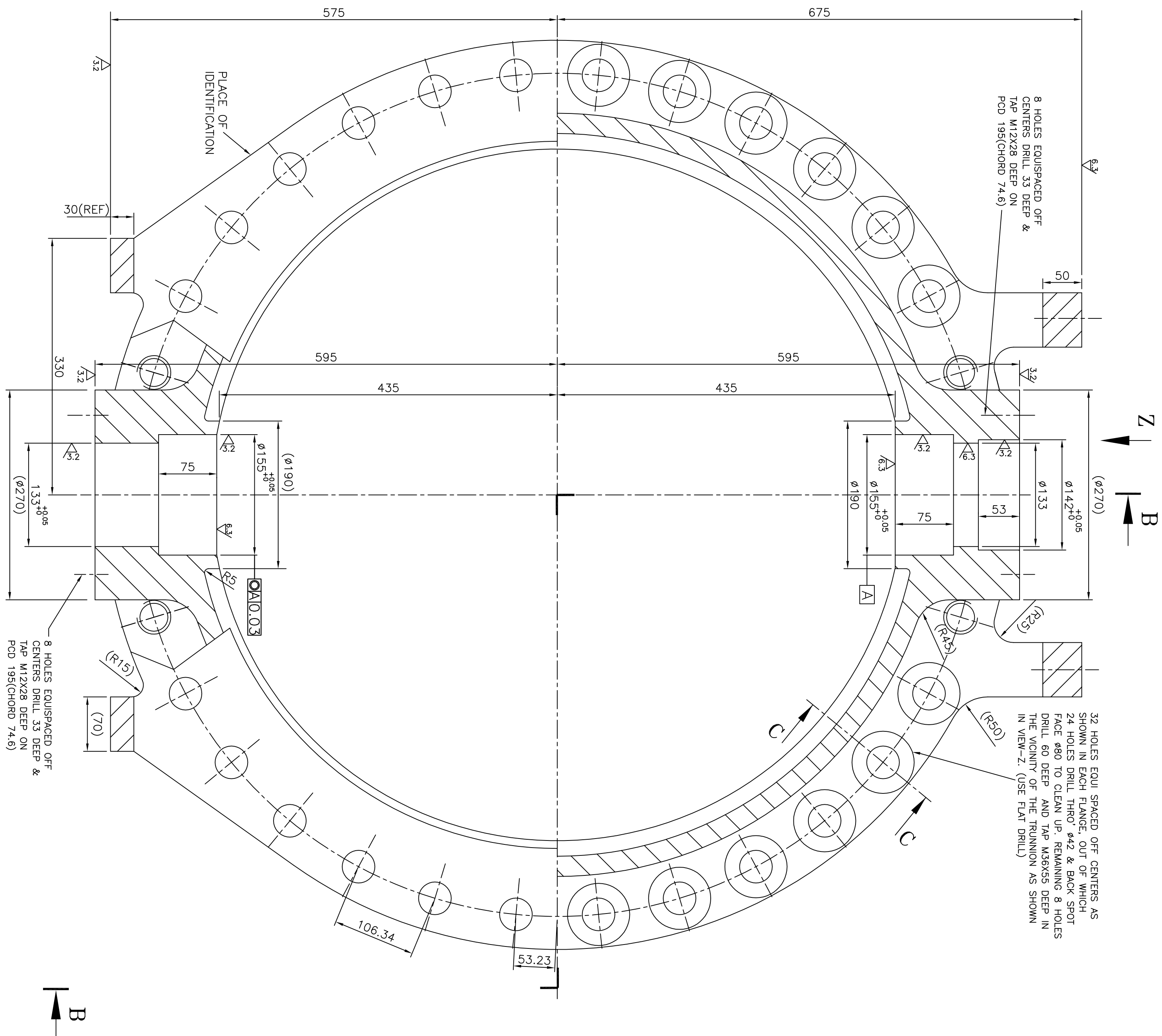
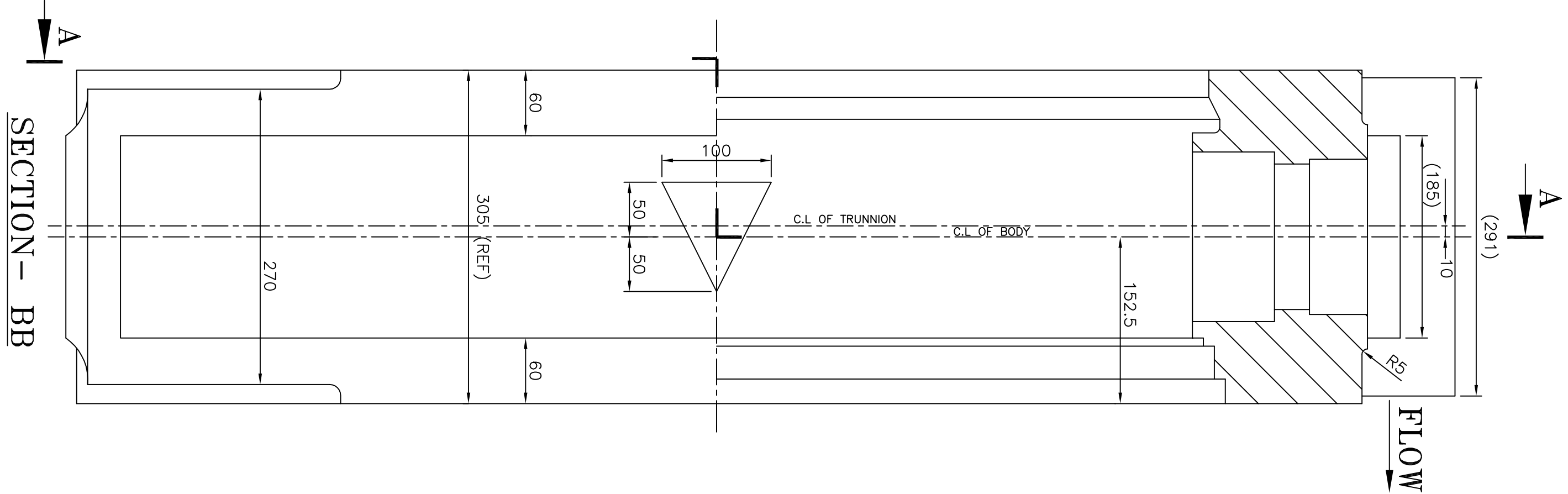


DRG. NO. 19513800010



SECTION - CC

(SCALE-1:2.5)

TECHNICAL REQUIREMENTS

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

CARBON	3.00 % (MAX)	4000	Kg/sq cm
SILICON	1.5 TO 3.0 %	2070	Kg/sq cm
MANGANESE	0.70 TO 1.25 %	8.0%	(MIN)
PHOSPHORUS	0.08 % (MAX)		
NICKEL	18.00 TO 22.00 %	BRINELL	HARDNESS (3000kg)
CHROMIUM	1.75 TO 2.75 %		139-202
2. THE DRG. SHOWS THE BODY IN FINISH M/CED CONDN. THE DIMENSIONS SHOWN IN () ARE AS CAST DIMENSIONS. THE CASTING IS TO BE SUPPLIED IN ROUGH M/CED CONDN WITH M/CING ALLOWANCE OF 5mm AT TOOL POINT AT PLACES WHERE FINISH MACHINING IS TO BE CARRIED OUT.
3. THE TEST PIECES OF SUITABLE SIZES SHOULD BE CAST SEPARATELY FROM THE SAME AS THE CASTINGS THEY REPRESENT.
4. ALL UNSPECIFIED RADI TO BE OF 6mm.
5. 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 15 kg/sq cm. FOR 10 MIN.
6. TOLERANCES ON AS CAST DIMENSIONS TO BE AS PER BHEL CORP. STD. AA 0230402 CLASS-5.
7. 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.
8. CASTING TO BE SUPPLIED IN HEAT TREATED CONDN. TEST BARS SHALL ALSO BE HEAT TREATED ALONG WITH THE CASTINGS THEY REPRESENT.
9. CASTING SURFACES TO BE SUBJECTED TO 100% DP TEST AS PER BHEL CORP. STD. AA0650132.
10. PERMISSIBLE VARIATION FOR UNTOOL. DIMENSIONS TO BE AS PER DRG. 3-200--00-49014.
11. COMPLETE TESTING/INSPECTION REQUIREMENTS, SHALL BE AS PER OUR ENQUIRY/P.O. SPECIFICATIONS.
12. WELD REPAIR OF CASTINGS IN ANY CASE IS NOT ALLOWED.
13. WEIGHT OF THE CASTING IN ROUGH M/CED CONDITION = 520 kg.
14. NON COAXIALITY OF BORES OF BOTH RUNNION BLOCKS NOT TO BE MORE THAN 0.03mm.

INVENTORY NO.	SIGN. & DATE	REF. DRG. NO.
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