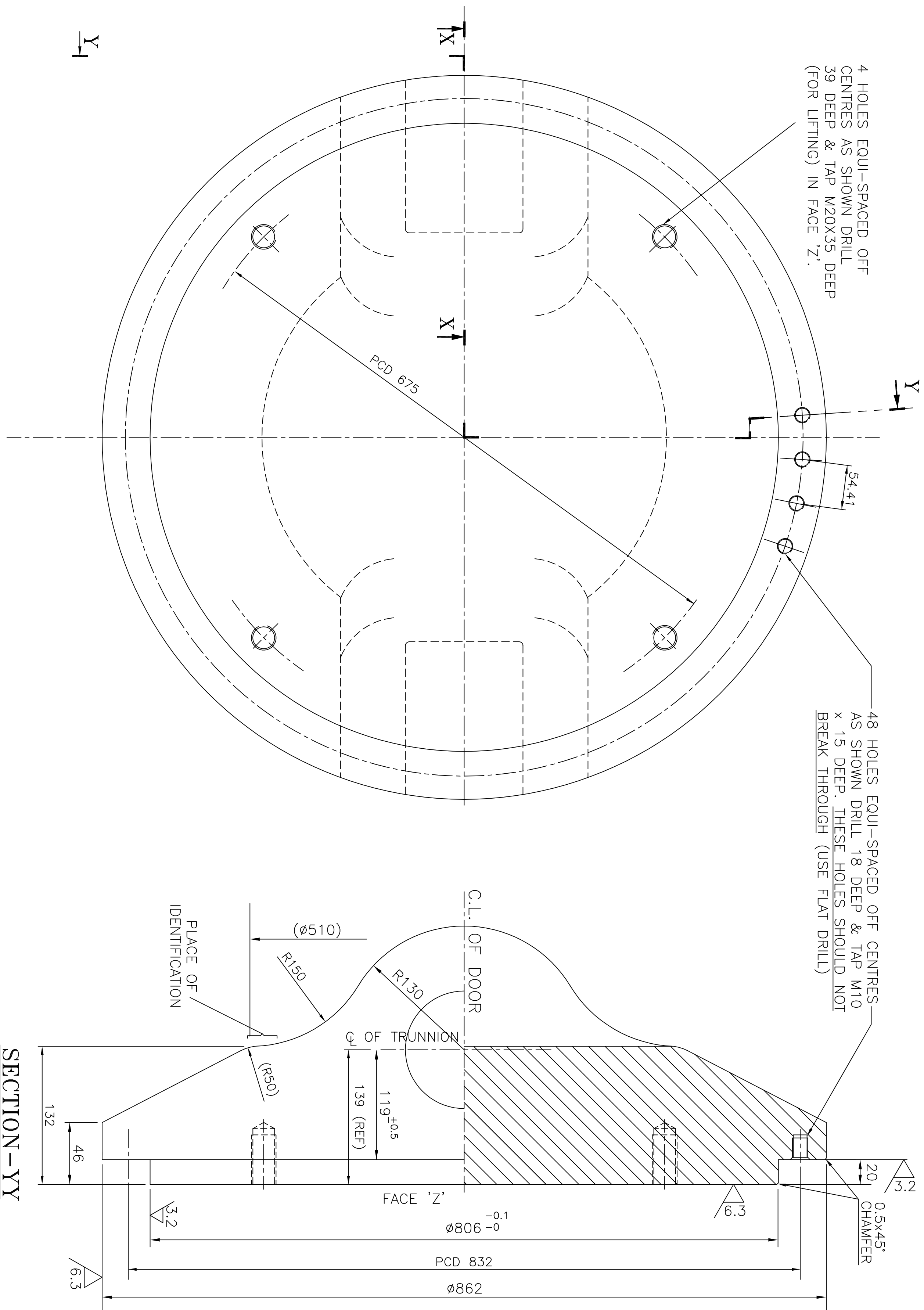


DRG. NO. 19513800011



TECHNICAL REQUIREMENTS

- | | |
|--|------------------|
| 1. MATERIAL: AUSTENITIC DUCTILE IRON CASTING TO ASTM A-439 TYPE D-2. | |
| <u>CHEMICAL COMPOSITION</u> | |
| CARBON | 3.00 % (MAX) |
| SILICON | 1.5 TO 3.0 % |
| MANGANESE | 0.70 TO 1.25 % |
| PHOSPHOROUS | 0.08 % (MAX) |
| NICKEL | 18.00 TO 22.00 % |
| CHROMIUM | 1.75 TO 2.75 % |
| <u>MECHANICAL PROPERTIES</u> | |
| TENSILE STRENGTH (MIN) | 4000 Kg/sq cm |
| YIELD STRENGTH | 2070 Kg/sq cm |
| ELONGATION IN 50mm | 8.0 % (MIN) |
| BRINELL HARDNESS (3000kg) | 139-202 |
- 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 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 BHFL AT 15 kg/sq.cm. FOR 10 MINUTES.
 - TOLERANCES ON AS CAST DIMENSIONS TO BE AS PER BHFL 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 AS PER ASTM A-439. 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 BHFL CORP. STD. AA0850132.
 - NON COAXIALITY OF BORES OF BOTH TRUNNION BLOCKS NOT TO BE MORE THAN 0.03mm.
 - WELD REPAIR OF THE CASTINGS, IN ANY CASE, IS NOT ALLOWED.
 - 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.
 - WEIGHT OF THE CASTING IN ROUGH M/CED CONDITION = 560 kg.

INVENTORY NO.	SIGN. & DATE	REF. DRG. NO.
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SECTION-XX

ADDITIONAL INFORMATION		3. ગાંધી નામક ટાંકા નામક નો ઉપયોગ કરી માલિક ના નામ પરથી માલિક ના ઉપરથી માલિક ના ઉપરથી	
STATUS OF DRAWING		B.F. VALVE STANDARD	
DISTRIBUTION OF FINISH		૧. ગાંધી નામક ટાંકા માલિક ના ઉપરથી માલિક ના ઉપરથી માલિક ના ઉપરથી	
SPM = 2 TOL = 1		૨. ગાંધી નામક ટાંકા માલિક ના ઉપરથી માલિક ના ઉપરથી માલિક ના ઉપરથી	
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