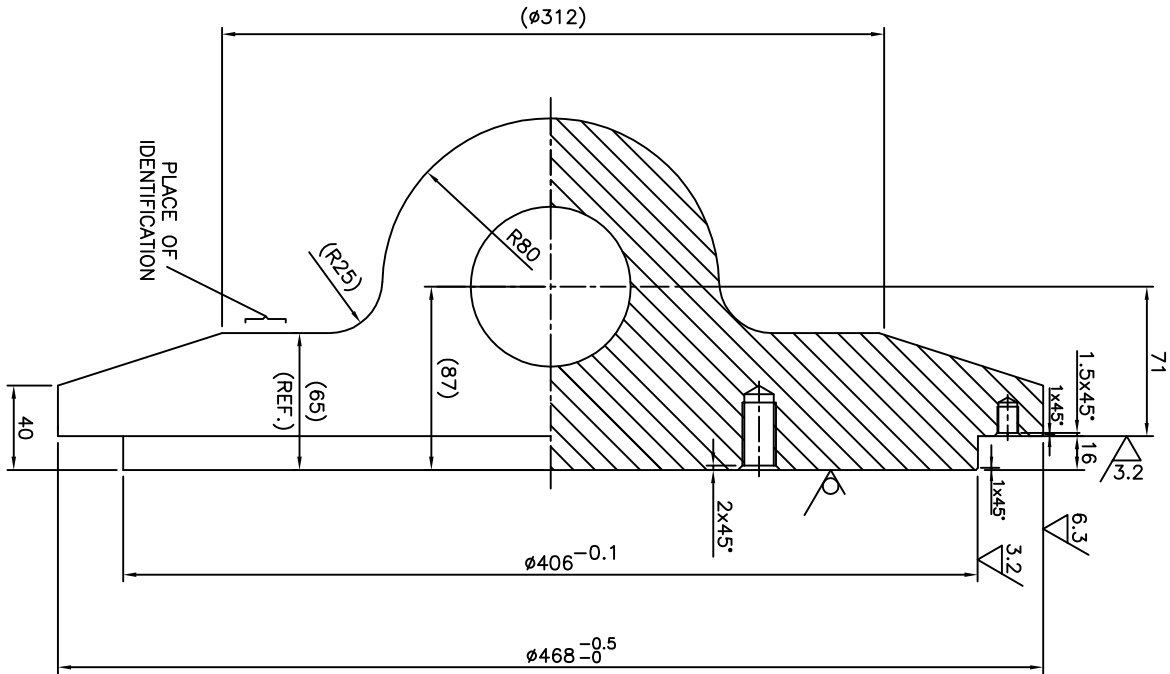
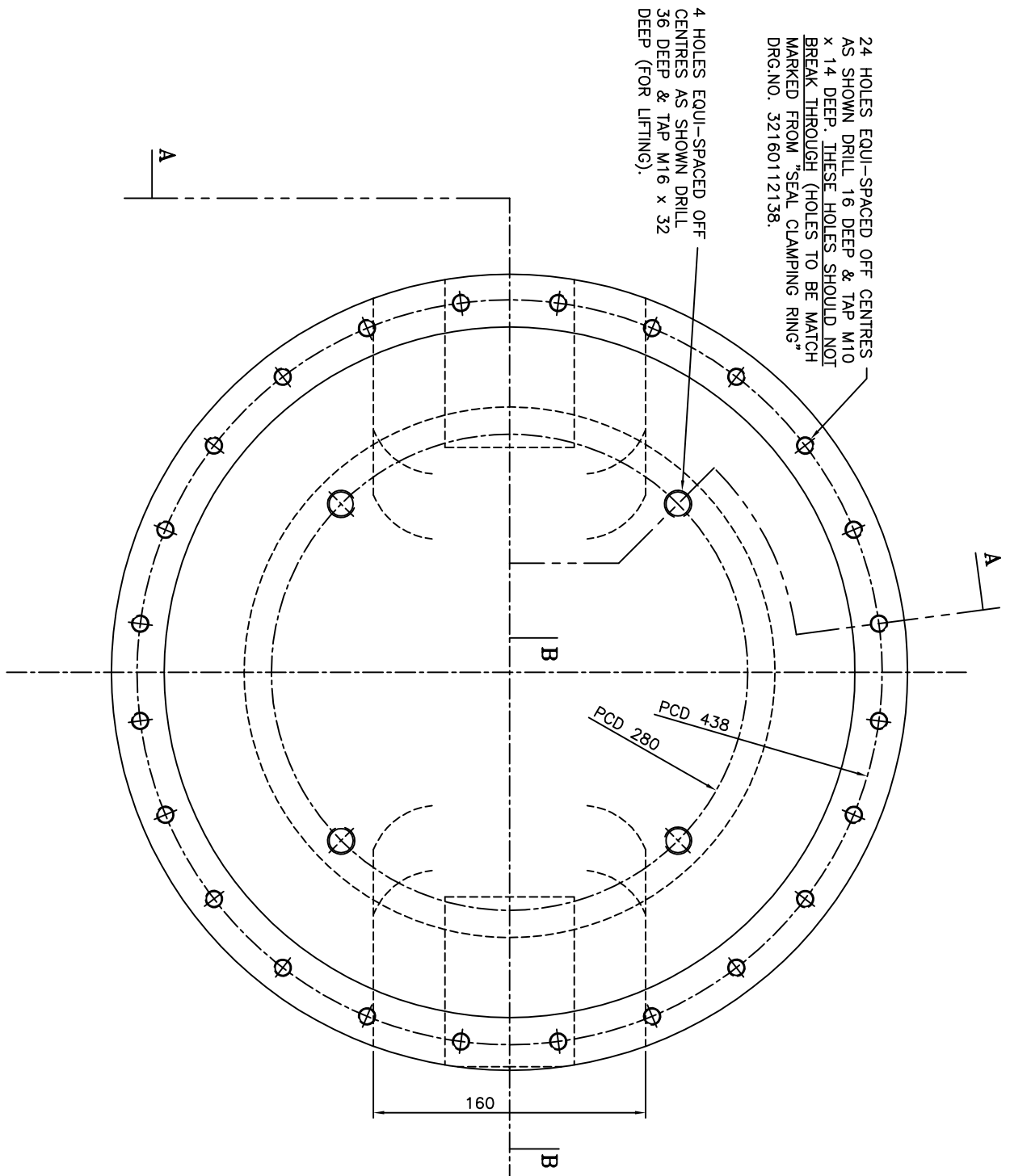
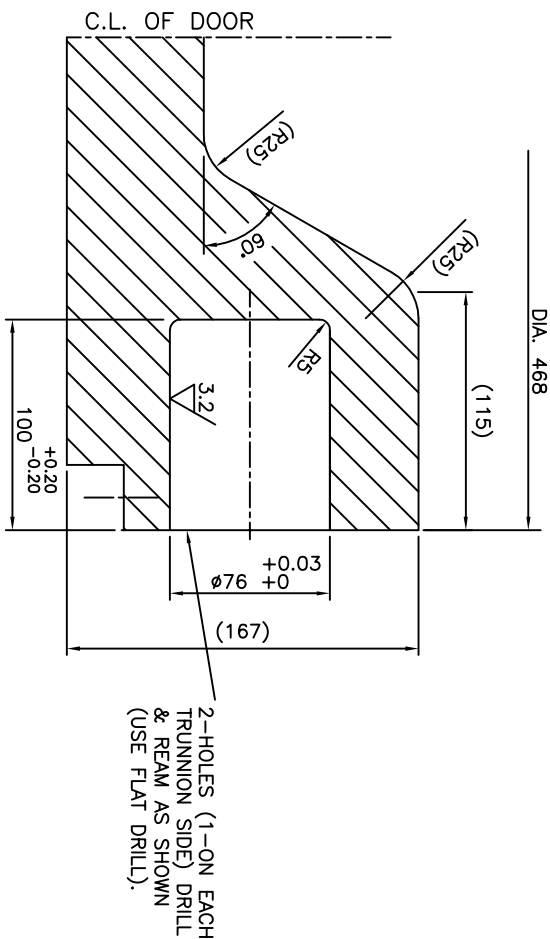


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SECTION-AA



SECTION-BB

REV.	DATE	ALTERED	
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- ## TECHNICAL REQUIREMENTS
1. MATERIAL: AUSTENITIC DUCTILE IRON CASTING TO ASTM A-439 TYPE D-2A.
- | MECHANICAL COMPOSITION | | MECHANICAL PROPERTIES | |
|------------------------|------------------|----------------------------|------------------------|
| CARBON | 3.00 % (MAX) | TENSILE STRENGTH (MIN) | 4000 Kg/sq cm |
| SILICON | 1.5 TO 3.0 % | YIELD STRENGTH (MIN) | 2070 Kg/sq cm |
| PHOSPHORUS | 0.08 % (MAX) | ELEVATION 50mm | 610 Kg/cm ² |
| NICKEL | 18.00 TO 22.00 % | BREINELL HARDNESS (3000kg) | 139-202 |
| CHROMIUM | 1.75 TO 2.75 % | | |
2. 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.
3. THE TEST PIECES OF SUITABLE SIZES SHOULD BE CAST SEPARATELY FROM THE SAME MELT AS THE CASTINGS THEY REPRESENT.
4. ALL UNSPECIFIED RADII TO BE 6mm.
5. CASTING SHOULD BE SOUND & FREE FROM BLOW HOLES, CRACKS, HOT TEARS, COLD SHOTS ETC. FOUNDER TO NOTE THAT THE CASTING SHALL BE SUBJECTED TO HYDRAULIC PRESSURE TEST AT BHEL AT 14 kg/sq.cm. FOR 10 MINUTES.
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 CONDITION AS PER ASTM A-439. TEST BARS SHALL ALSO BE HEAT TREATED ALONG WITH THE CASTINGS THEY REPRESENT.
9. ROUGH M/CED SURFACES TO BE SUBJECTED TO 100% DP TEST AS PER BHEL CORP. STD. AA0650132.
10. NON COAXIALITY OF BORES OF BOTH RUNNING BLOCKS NOT TO BE MORE THAN 0.03mm.
11. WELD REPAIR OF THE CASTINGS, IN ANY CASE, IS NOT ALLOWED.
12. PERMISSIBLE VARIATION FOR UNTOOL DIMENSIONS TO BE MORE THAN 0.03mm.
13. WELD REPAIR OF THE CASTINGS, IN ANY CASE, IS NOT ALLOWED.
14. PERMISSIBLE VARIATION FOR UNTOOL DIMENSIONS TO BE MORE THAN 0.03mm.