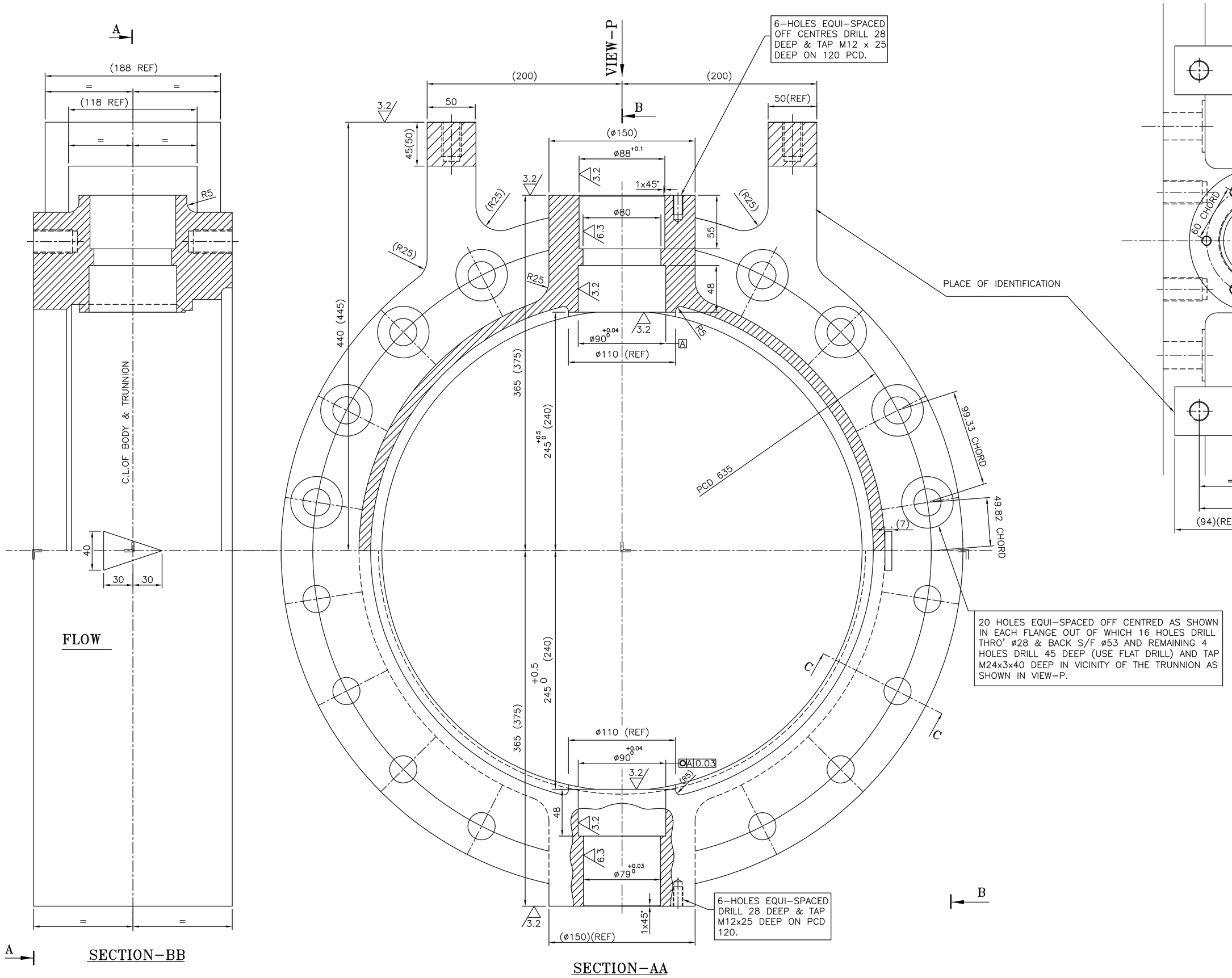
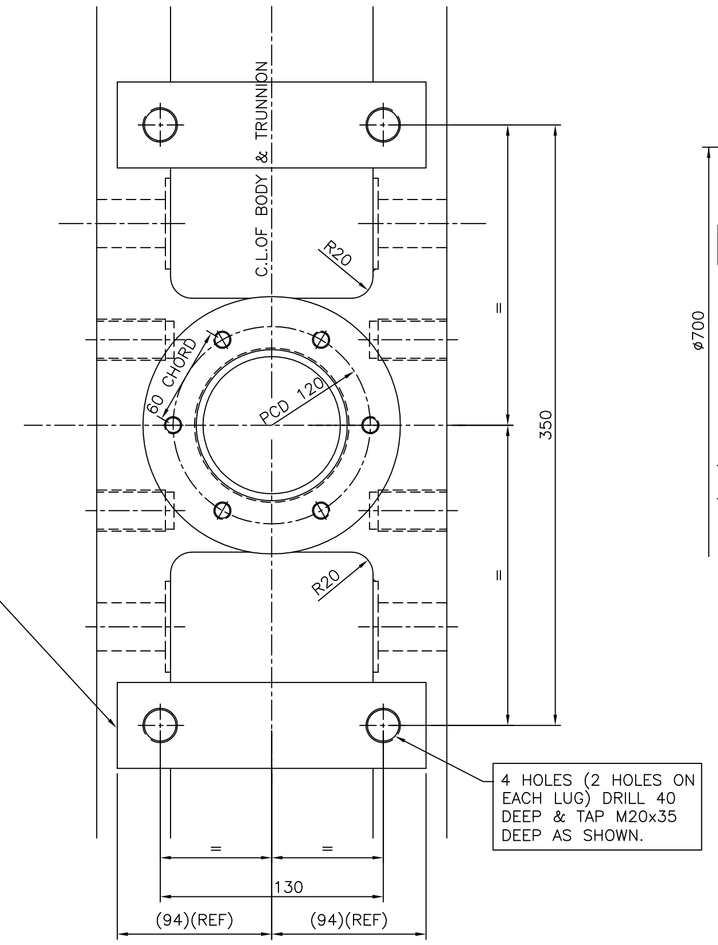
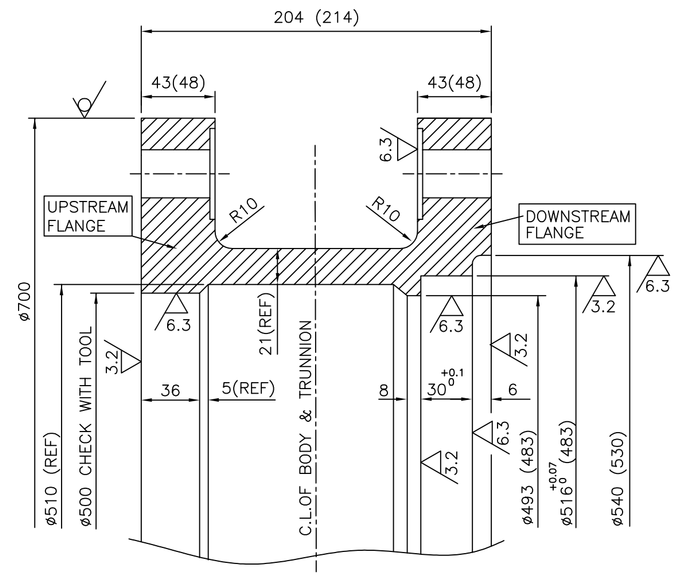
FIRST ANGLE PROJECTION

(ALL DIMENSIOMS ARE IN mm)

DRG. NO.1 951 38 00040







TECHNICAL REQUIREMENTS

1. MATERIAL: AUSTENITIC DUCTILE IRON CASTING TO ASTM A–439 TYPE D–2.

CHEMICAL COMPOSITION		MECHANICAL PROPERTIES	
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 %		

2. 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.
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 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 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. AA0850132.
10. NON COAXIALITY OF BORES OF BOTH TRUNNION BLOCKS NOT TO BE MORE THAN 0.03mm.
11. WELD REPAIR OF THE CASTINGS, IN ANY CASE, IS NOT ALLOWED.
12. PERMISSIBLE VARIATION FOR UNTOL. DIMENSIONS TO BE AS PER DRG. 3–200–00–49014.

VAR00	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.NO. / VAR.	MATL. CODE / MATL. SPCN.	A-C	UNIT	UNIT WT. / QTY.	GS	ZONE
28 —— CARD TYPE-3				28 —— CARD TYPE-1				28 —— CARD TYPE-2					

ADDITIONAL INFORMATION
CAST WT. 200 Kg.
STATUS OF DRAWING

DISTRIBUTION OF PRINTS
PSE – 2 TGX – 1
STM – 5 FYM – 5

उत्पाद का प्रकार या ग्राहक/परियोजना का नाम
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT

B.F. VALVE STANDARD

भारत हेवी इलेक्ट्रिकल्स लिमिटेड
भोपाल
BHARAT HEAVY ELECTRICALS LTD.
BHOPAL

	नाम/ NAME	हस्ता./ SIGN	दिनांक/DATE	पे.नं. सैंख्या NO. OF VAR.
बनाया DRN.	H.K.LAWANSH	लवंशी	26.02.08	–
जाँचा CKD.	P.M.S.BISHT	बिष्टमोहन	26.02.08	–
अनुमोदित APPD.	V.K.JAIN	वि.जैन	26.02.08	–

विभाग DEPT. PSE | उन.टल. नाप की श्रेणी UNTOL. DIMS. GR. C/M/F | कोड CODE 412 | पैमाना SCALE 1:2 | भार (कि.ग्रा.) WEIGHT (K.G.) 170 | उसे. ड्रॉइंग का संदर्भ REF. TO ASSY. DRG. – | मद क्र. ITEM NO. – | मद संख्या NO. OF ITEM –

शीर्षक/ TITLE: ø 500 B.F. VALVE BODY (FOR SEA WATER)

ड्रॉइंग क्र./DRAWING NO. 1 951 38 00040 | सुधार/REV. 02

पृष्ठ क्र./SHT. NO. 01 | पृष्ठों की संख्या/NO. OF SHT. 01

REV.	DATE	ALTERED / CHECKED / APPROVED	ZONE
02	12.01.2010	HKL / MJ / PMSB — CHORD & PCD CORRECTED TO 60 AND 120 RESPECTIVELY IN VIEW–P	8–8/9
01	03.03.09	HKL / MJ / PMSB — DIMENSION 6 WAS 11.	8-11/12

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REF. DRG. NO. | SIGN. & DATE | MASTOP NO.

A1