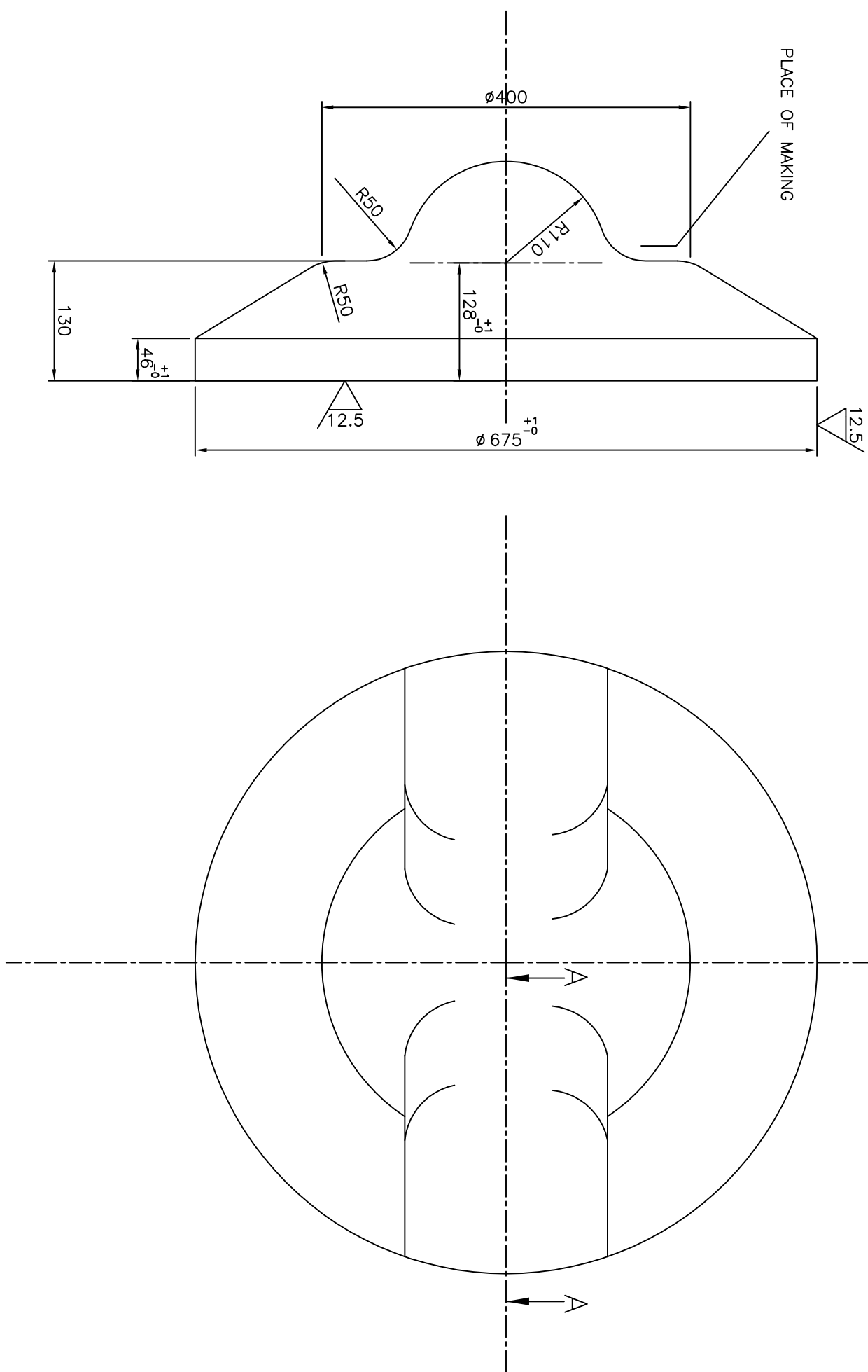
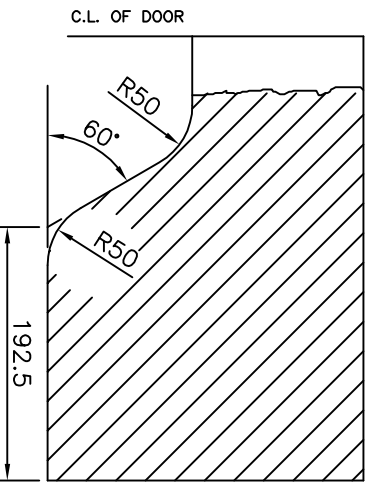


FIRST ANGLE PROJECTION				(ALL DIMENSIONS ARE IN mm)			
2		3		4		5	
6		7		8			
DRG. NO.1 951 38 00046							



TECHNICAL REQUIREMENTS

- | 1. MATERIAL: AUSTENITIC DUCTILE IRON CASTING TO ASTM A-439 TYPE D-2A. | |
|--|-----------------------|
| CHEMICAL COMPOSITION | MECHANICAL PROPERTIES |
| 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 % |
| 2. THE TEST PIECES OF SUITABLE SIZES SHOULD BE CAST SEPARATELY FROM THE SAME MELT AS THE CASTINGS THEY REPRESENT. | |
| 3. CASTINGS SHOULD BE SUPPLIED IN ROUGH MACHINE CONDITION. THE DRG. SHOWS THE DIMENSIONS OF THE ROUGH MACHINED DOOR. FOUNDER TO CARRY OUT THE MACHINING AT PLACES MARKED THUS | |
| 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. WELD REPAIR OF THE CASTINGS, IN ANY CASE, IS NOT ALLOWED. | |
| 11. FOR 'Ø700 B.F.V. DOOR (MACHINING)' REFER DRG. NO. 19513800047. | |

[illegible]

DRAWING REVIEW			TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT
DEPT.	NAME	SIGN.	
ADDITIONAL INFORMATION			
DRAWING OF PRODUCT			B.F. VALVE STANDARD

		STATUS OF DRAWING				
		DISTRIBUTION OF PRINTS				
		PSE - 2 TGX - 1				
		STM - 5 FYM - 5				
 BHARAT HEAVY ELECTRICALS LTD. BHOPAL						
			NAME	SIGN	DATE	NO. OF
		DRN	H.K.LAWANSHI	हस्ताक्षर	30.07.08	VAR.
		CRO	P.M.S.BISHT	प्रमाणित	30.07.08	
		APPD	V.K.JAIN	दिनांक	30.07.08	

REV.	DATE	ALTERED	DEPT.	UNTOL. DIMS. GR.		SCALE 1:5	WEIGHT(K.G.) 320	REF. TO ASSY.DRG.	ITEM NO.	NO. OF ITEM
		CHECKED	P.S.E.							
		APPD.	CODE							
ZONE	ZONE	TITLE Ø 700 B.F. VALVE DOOR (CASTING) (FOR SEA WATER)								
				DRAWING NO.		1 951 38 00046		REV.		00
				SHT. NO.		NO. OF SHT.				

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