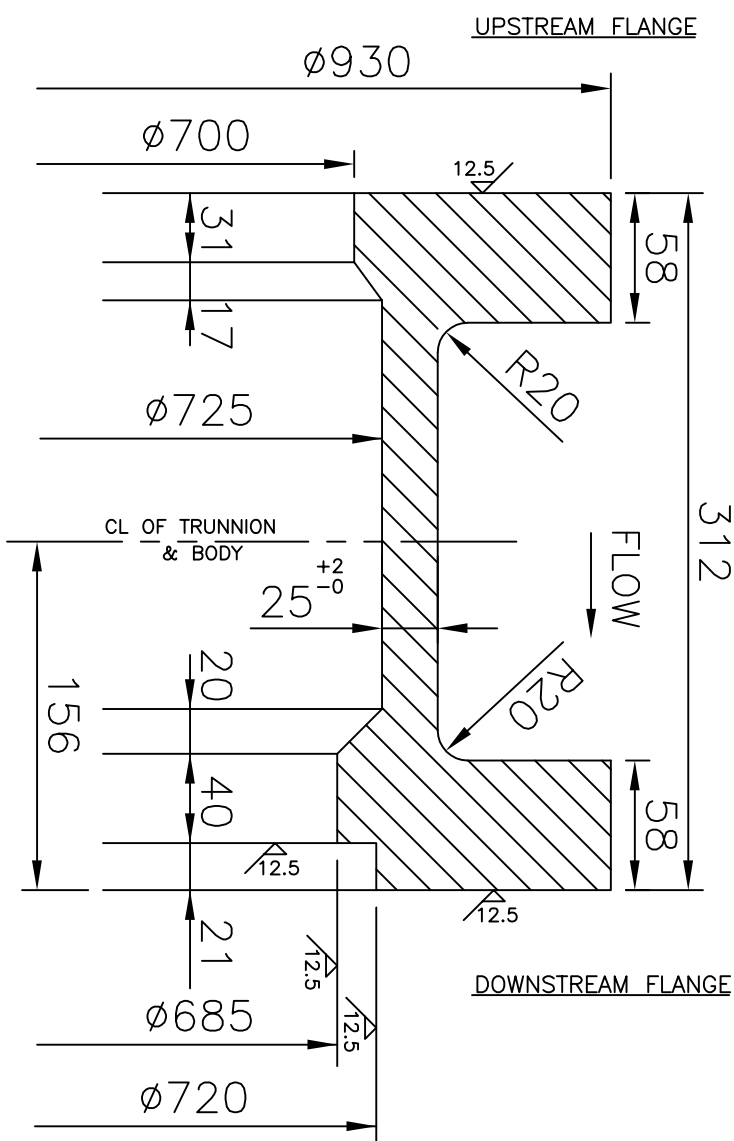
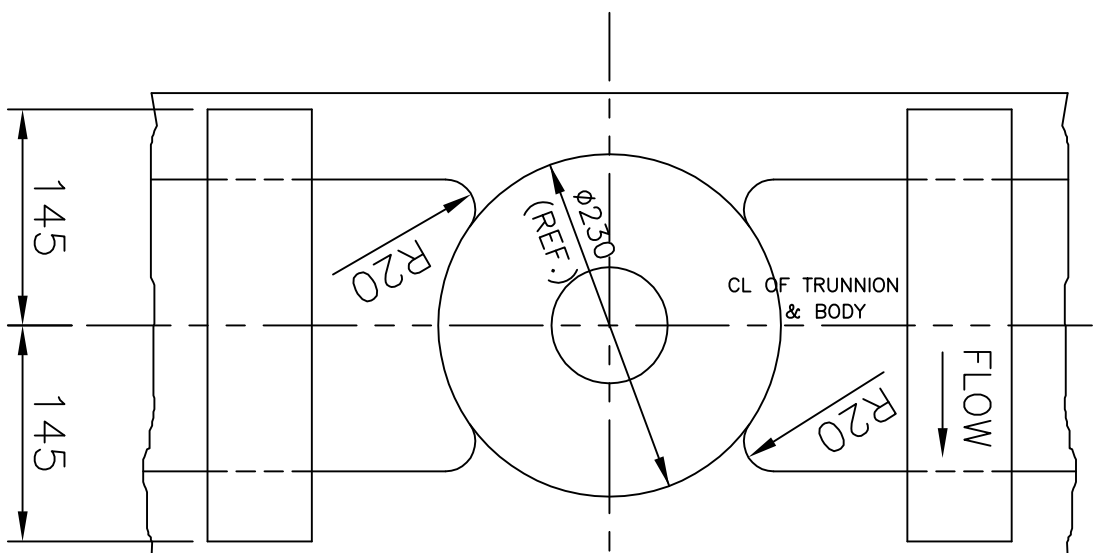
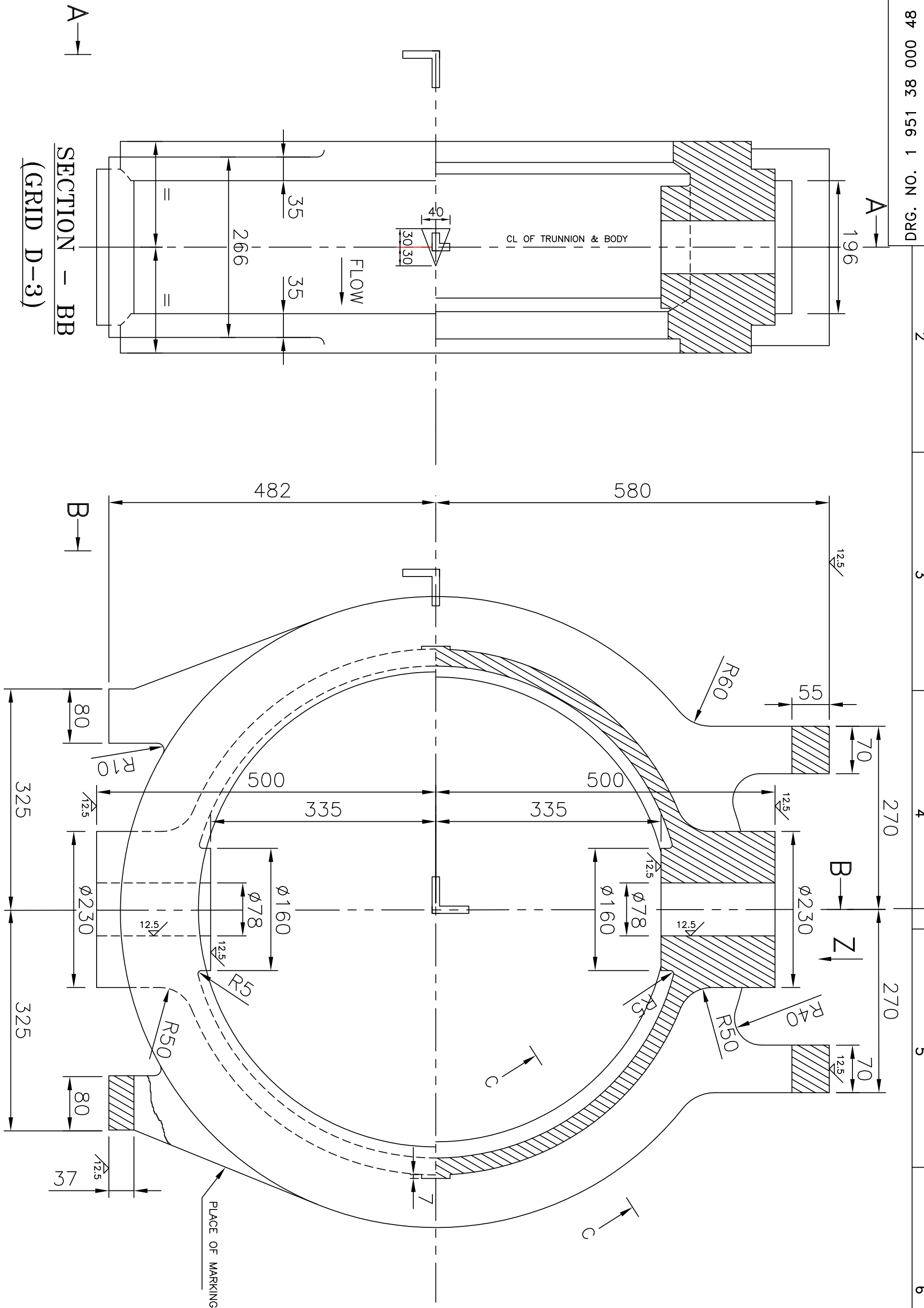




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SECTION - BB
(GRID D-3)

TECHNICAL REQUIREMENTS

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

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 POLICE MACHINE BODY. COINDED TO CARRY OUT THE MACHINEING AT PLACES MARKED THERE.

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. CASING 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.

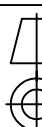
9. ROUGH M/CED SURFACES TO BE SUBJECTED TO 100% DP TEST AS PER BHEL CORP. STD. AA08501.32.

10. WELD REPAIR OF THE CASTINGS, IN ANY CASE, IS NOT ALLOWED.

11. FOR 'Ø700 B.F.V. BODY (MACHINING)' REFER DRG. NO. 19513800049.

INVENTORY NO.	SIGN. & DATE	REF. DRG. NO.
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[illegible][illegible]

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT										B.F. VALVE STANDARD									
BHARAT HEAVY ELECTRICALS LTD. BHOPAL										DRN		NAME		SIGN		DATE		NO. OF VAR.	
DEPT. P.S.E.		UNTOOL. DIMS. GR.				SCALE 1:5		WEIGHT(K.G.) 480		REF. TO ASSY.DRG.		ITEM NO.		NO.OF ITEM					
CODE 412										APRD		P.M.S.BISHT		प्र.प्र.सं.		25.10.08			
TITLE		ø700 BF VALVE BODY (CASTING) (FOR SEA WATER)																	
										DRAWING NO.		1 951 38 000 48		REV.		00			
										SHT. NO.		NO. OF SHT.		7		8			