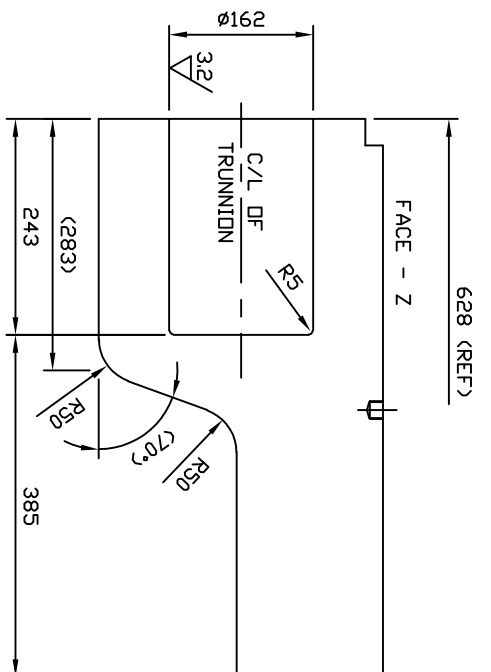
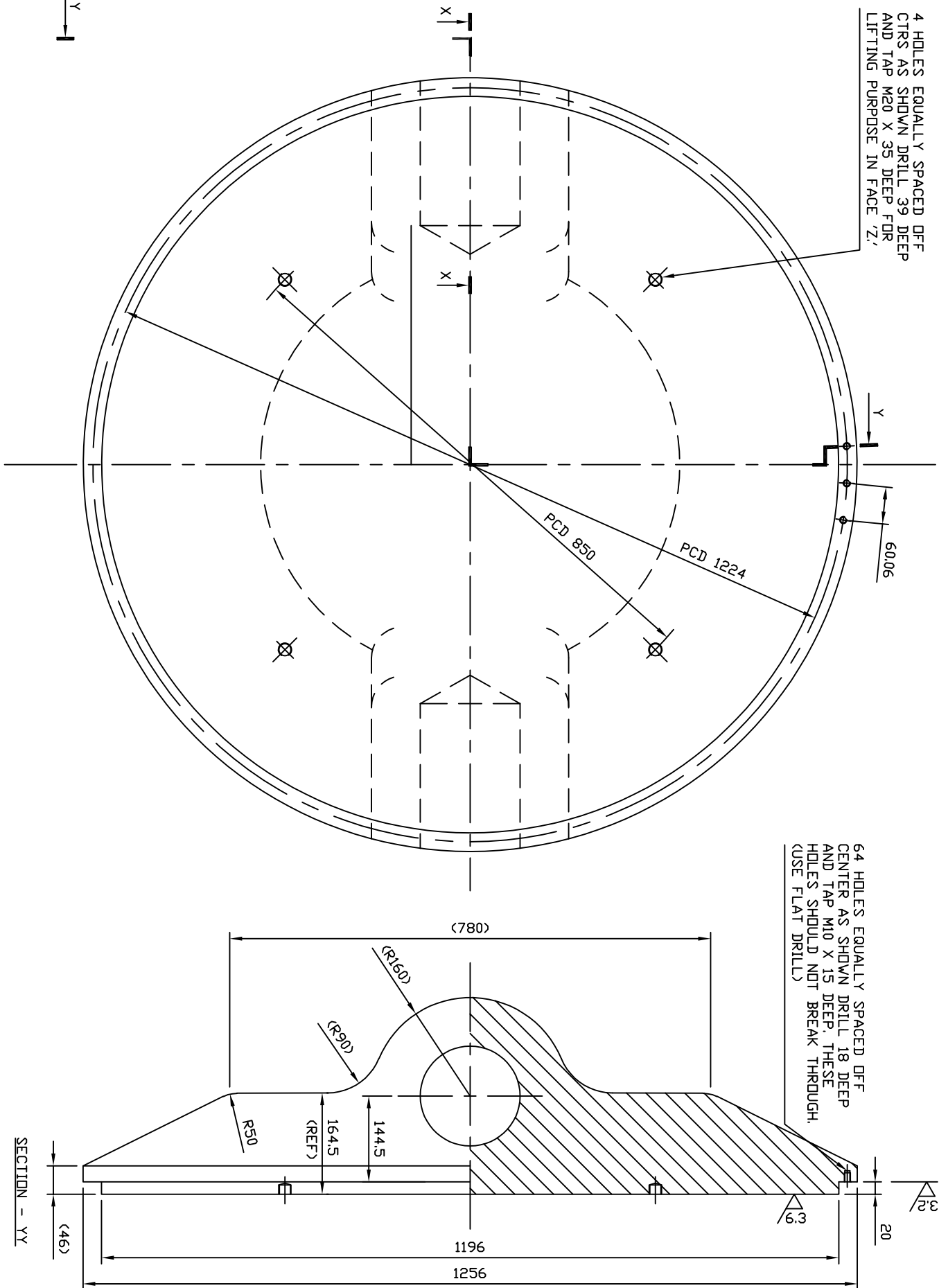




TECHNICAL REQUIREMENTS

1. MATERIAL, AUSTENITIC DUCTILE IRON CASTING TO ASTM A-439 TYPE D-2
- | CHEMICAL COMPOSITION | | MECHANICAL PROPERTIES | |
|----------------------|------------------|---------------------------|---------------|
| CARBON | 3.00 % (MAX) | TENSILE STRENGTH (MND) | 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 % (MND) |
| PHOSPHORUS | 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 DOOR IN FINISH M/CED CONDITION. THE DIMENSIONS SHOWN IN () ARE AS CAST DIMENSIONS.
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 SHOTS ETC. FOUNDER TO NOTE THAT THE CASTING SHALL BE SUBJECTED TO HYDRAULIC PRESSURE TEST AT BHIL AT 10 kg/sqcm FOR 10 MINUTES AFTER FINAL M/C ING.
- 5a. QUALITY OF UN-MACHINED SURFACE, LEVEL - II OF A-997
6. TOLERANCES ON AS CAST DIMENSIONS TO BE AS PER BHIL 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. TEST BARS SHALL ALSO BE HEAT TREATED ALONG WITH THE CASTINGS THEY REPRESENT.
9. M/CED SURFACES TO BE SUBJECTED TO 100% DP TEST AS PER BHIL CORP. STD. AA0850132, LEVEL - I
10. PERMISSIBLE VARIATION FOR UNTOL. DIMENSIONS TO BE AS PER DRG. 3-200-00-49014.
11. NON COAXIALITY OF $\phi 160^{+0.3}_{-0.0}$ IN BOTH TRUNNION BLOCKS TO BE LESS THAN 0.03mm.
12. NON PERPENDICULARITY OF TRUNNION AXIS WRT THE AXIS OF $\phi 1196^{+0.3}_{-0.0}$ TO BE LESS THAN 0.1 mm
13. COMPLETE TESTING/INSPECTION REQUIREMENTS, SHALL BE AS PER DUR ENDUURY/P.D. SPECIFICATIONS.
4. WELD REPAIR OF CASTINGS IN ANY CASE IS NOT ALLOWED.

ADDITIONAL INFORMATION WEIGHT OF CASTING - 1403 KG					
STATUS OF DRAWING					
DISTRIBUTION OF PRINTS CDE - 2 TGX - 1 STM - 5					
REV.	DATE	ALTERED			
		CHECKED			
		APPROVED			
भाग CODE			उप. प्र. भाग की संख्या UNITS/DWG. GR.		अनुपात SCALE
शीट CODE 411			-	1:1	श. क्रमांक WEIGHT (KGS) 1311
शीटों का शीर्षक ø1300 B.F. VALVE DOOR					
Bharat Heavy Electricals Ltd. भारत हेवी इलेक्ट्रिकल्स लिमिटेड कोयला BHOPAL					
ग्रा./नाम		एम्प्ल./सोन	दिनांक/DWG DATE		
संस्था अवकाशा		राजेश	24.01.2020		
संचालन कुमार महतो		सुनील	24.01.2020		
प्रो. के विवेकानंद		मुनील	24.01.2020		
उप. प्र. भाग की संख्या REF. TO ASSY. DWG.		श. क्रमांक ITEM NO.	श. क्र. की संख्या ITEM NO. OF THIS DWG.		
-		-	00		
कुटी का ड्रा./DRAWING NO. 1 951 38 00097					
पृष्ठ No./श्री. No. 01			पृष्ठों की संख्या/No. OF SH. 01		