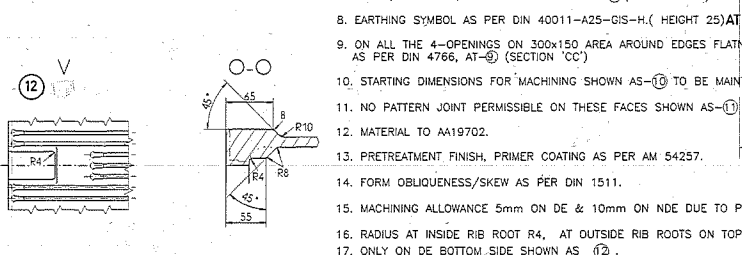
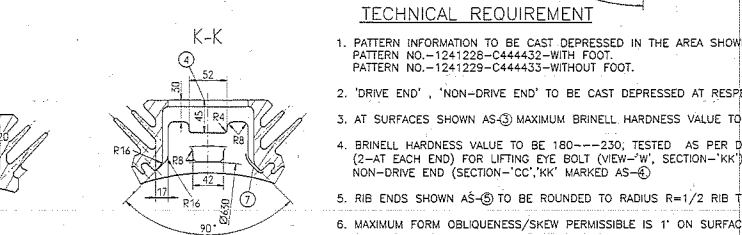
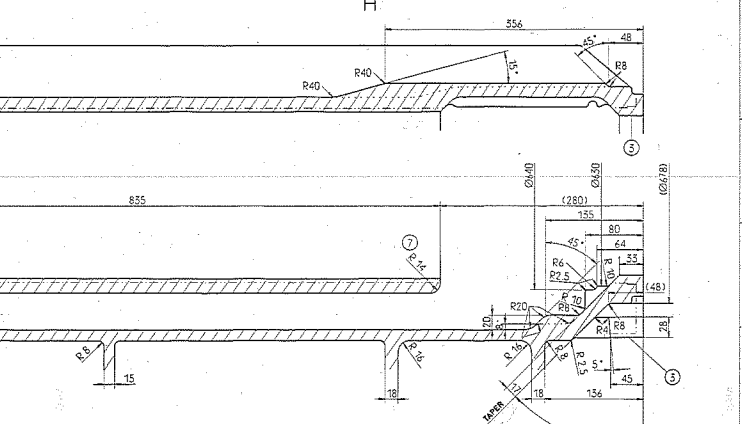
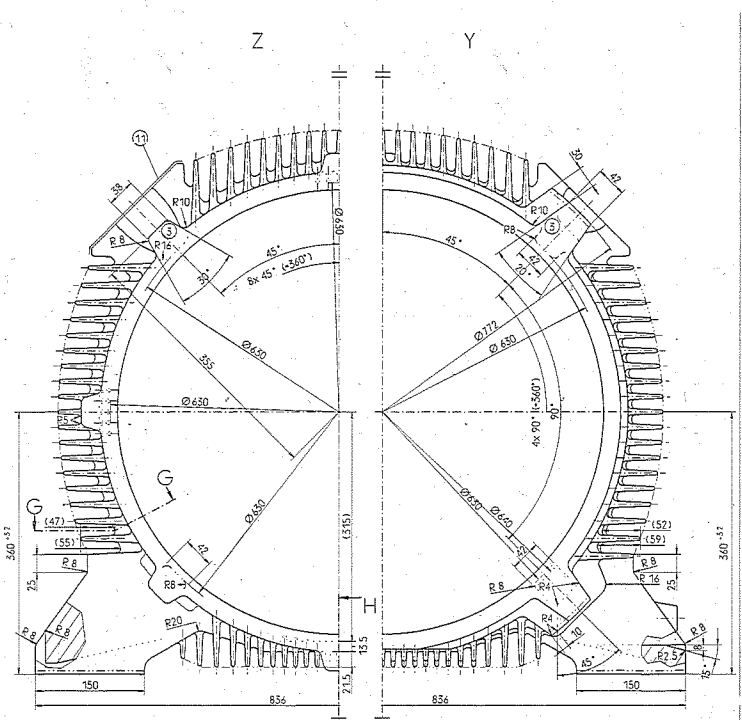
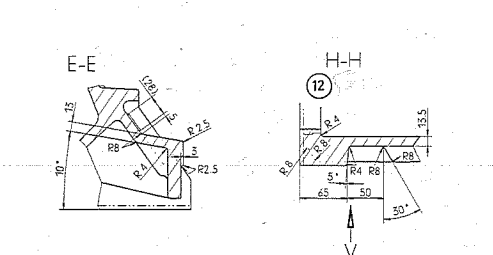
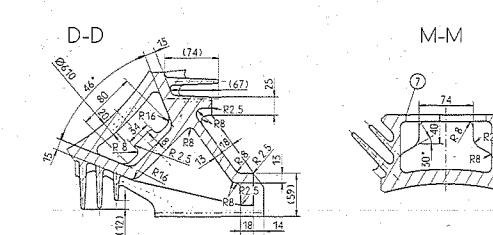
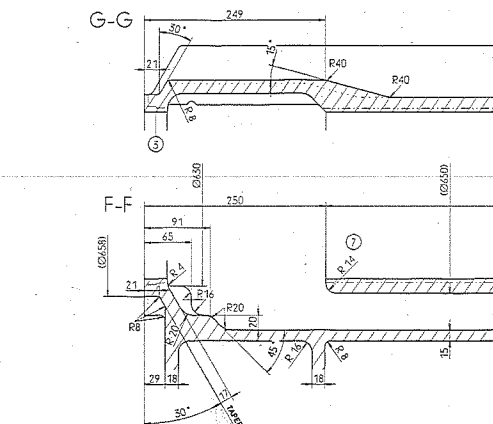
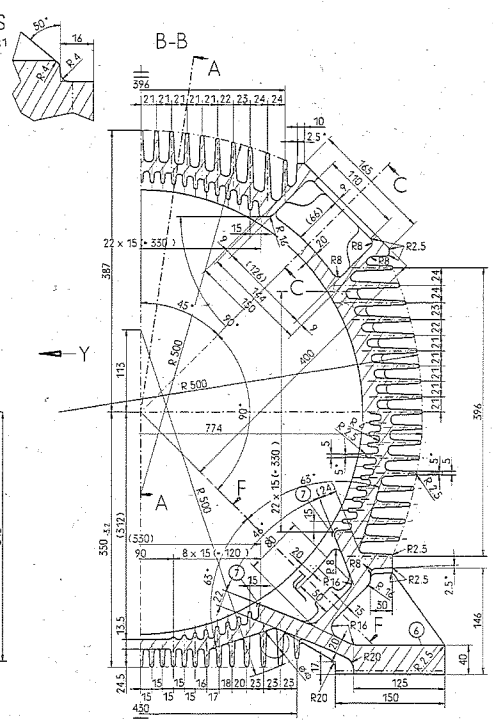
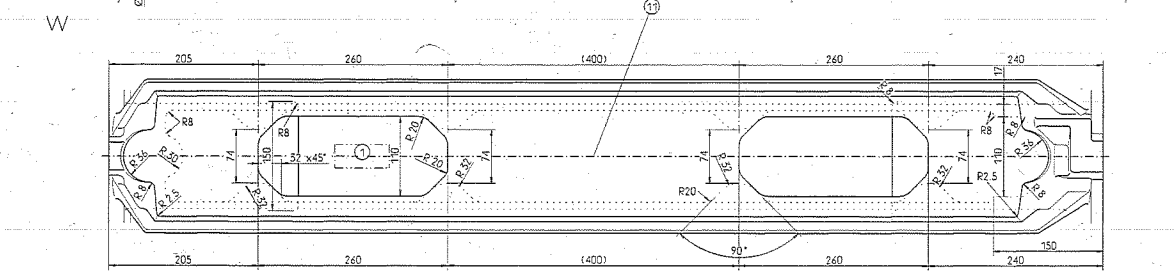
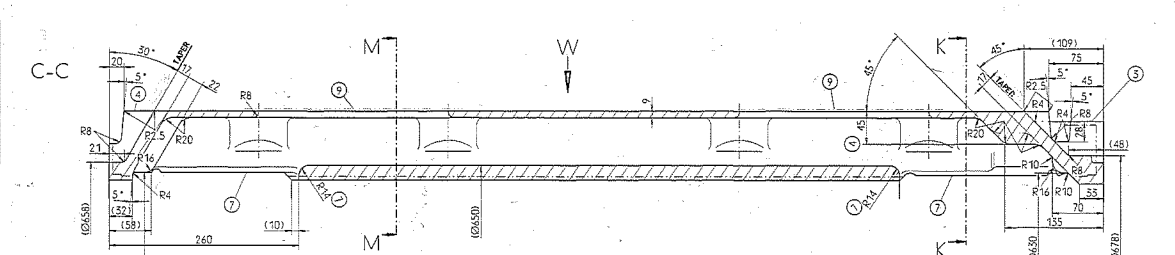
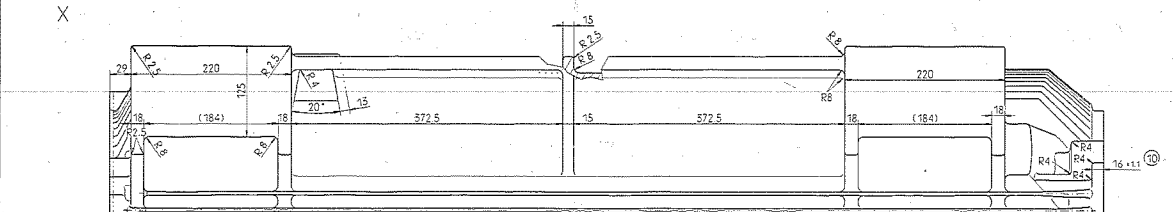
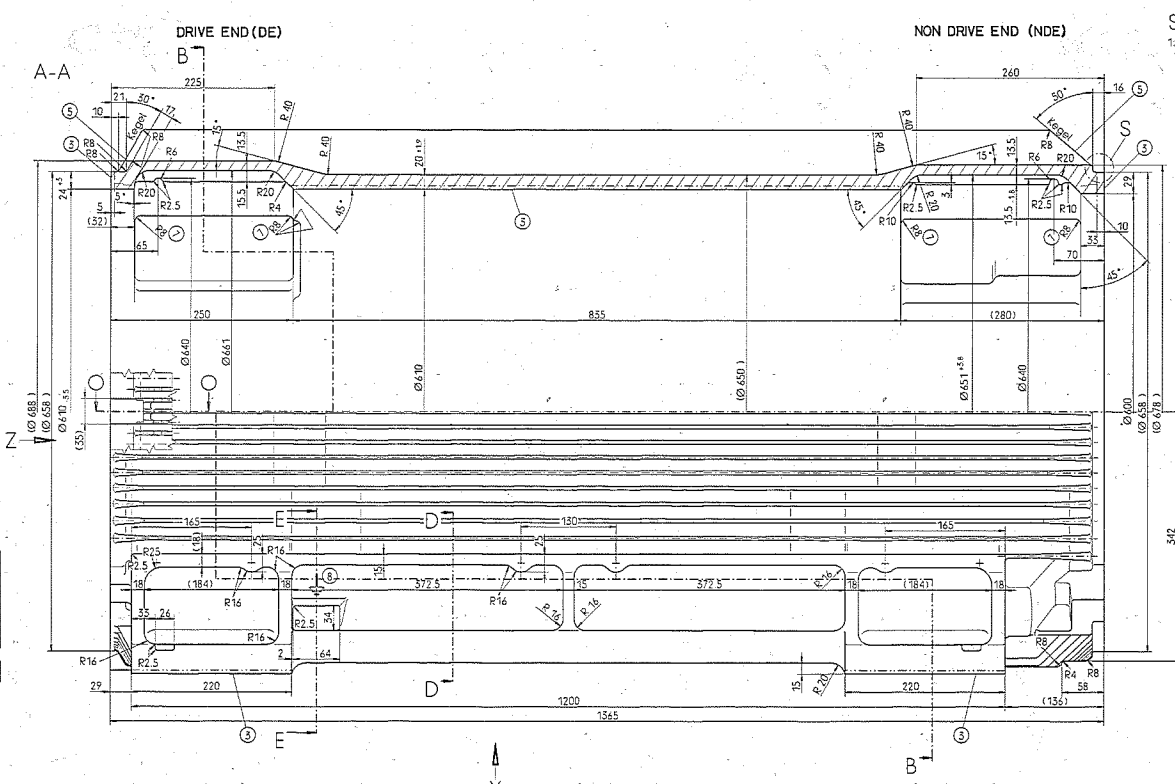


PROPERTY OF THE COMPANY
IT MUST NOT BE USED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF THE COMPANY



- TECHNICAL REQUIREMENT**
- PATTERN INFORMATION TO BE CAST DERESSED IN THE AREA SHOWN AS-①
PATTERN NO.-1241228-C444432-WITH FOOT
PATTERN NO.-1241229-C444433-WITHOUT FOOT.
 - 'DRIVE END' - 'NON-DRIVE END' TO BE CAST DERESSED AT RESPECTIVE END, IN THE AREA SHOWN AS-②
 - AT SURFACES SHOWN AS-③ MAXIMUM BRINELL HARDNESS VALUE TO BE 230, TESTED AS PER DIN 50351-HBS 10/30/10.
 - BRINELL HARDNESS VALUE TO BE 180---230, TESTED AS PER DIN 50351-HBS 10/30/10, ON ALL FOUR R36 PADS (2-AT EACH END FOR LIFTING EYE BOLT (VIEW-'W', SECTION-'KK') AND ON 45 MM RANGE BELOW BOTH 'PADS ON NON-DRIVE END (SECTION-'CC', 'KK' MARKED AS-④)
 - RIB ENDS SHOWN AS-⑤ TO BE ROUNDED TO RADIUS R=1/2 RIB THICKNESS.
 - MAXIMUM FORM OBLOQUENESS/SKEW PERMISSIBLE IS 1° ON SURFACES SHOWN AS-⑥ ON MOTOR FEET.
 - EDGES, SURFACES, RADIUS R14 SHOWN AS-⑦ (SECTION-'CC') MUST BE BURR FREE & WITHOUT ANY SHARP EDGES.
 - EARTHING SYMBOL AS PER DIN 40011-A25-GIS-H.(HEIGHT 25)AT ⑧
 - ON ALL THE 4-OPENINGS ON 300x150 AREA AROUND EDGES FLATNESS WITHIN 0.5 & FINISH R_z 250 MICRONS AS CAST AS PER DIN 4766, AT-⑨ (SECTION 'CC')
 - STARTING DIMENSIONS FOR MACHINING SHOWN AS-⑩ TO BE MAINTAINED ON NON-DRIVE END.
 - NO PATTERN JOINT PERMISSIBLE ON THESE FACES SHOWN AS-⑪ (VIEW-'W') ON BOTH SIDE.
 - MATERIAL TO AA19702.
 - PRETREATMENT FINISH, PRIMER COATING AS PER AM 54257.
 - FORM OBLOQUENESS/SKEW AS PER DIN 1511.
 - MACHINING ALLOWANCE 5mm ON DE & 10mm ON NDE DUE TO POURS/FOAMING.
 - RADIUS AT INSIDE RIB ROOT R4, AT OUTSIDE RIB ROOTS ON TOP & SIDES R5, AND FOR THOSE AT BOTTOM OUTSIDE R4.
 - ONLY ON DE BOTTOM SIDE SHOWN AS ⑫
 - FOR SOAKING TIME IN HEAT TREATMENT CYCLE, REFER PLANT STANDARD BP0640295.

ST. NO. BP9104037235

REV. DATE		ALTD. Y.M		REV. DATE		ALTD. DIPTI	
03 06.06.19		APPD. AKM		02 10.05.16		APPD. M.K.M.	
WEIGHT 960 WAS 900. REVISED AS PER IMM PLANNING.				NOTE 18 ADDED DRG. REVISED.			
ADDITIONAL INFORMATION				TYPE OF PRODUCT			
STATUS OF DRAWING				NAME OF CUSTOMER/PROJECT			
DISTRIBUTION OF PRINTS				1L44 35 B3			
AMC - 1				BHPAL			
MIM - 1				NAME			
FTM - 5				SIGN			
REV. DATE				DATE			
01 04.06.19				25/2/25			
02 10.05.16				25/2/25			
03 06.06.19				25/2/25			
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