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FOUNDRY DIVISION

Ref: FYM/TDC/SF/01 - Rev 01

Date : 12/12/2018

TDC FOR STATOR FRAME CASTING TO DRG NO. 04027140171 AND PATTERN NO 1241226

1. Casting specification : Grey Iron Casting - Gr. FG 200 as per AA19702 Rev no. 06.
2. Condition of delivery : Proof machined and primer coated. Refer casting Drg. 04027140171 Rev.01. Dimensions as shown in section A-A eg. Dia.540mm (at DE side End-shield bore) and Dia. 530 (NDE side End-shield bore) must be concentric and maintained in proof machining. Also after facing operation at both ends of stator frame (in order to obtain perpendicularity during proof machining) vendor must obtain height 1245 with positive tolerance. The end faces should be parallel to each other. All other dimensions shall be maintained according to casting drg.
3. Dimensions and Tolerances : As per CI 5.0 of AA19702 Rev. no. 06.
4. Heat Treatment: Stress Reliving as per Cl. 7.0 of AA19702 rev. no. 06.
5. Test samples: As per clause 11.0 of AA19702 rev. no. 06.
6. Mechanical Properties : Tensile and Hardness as per Cl.12.0 of AA 19702 rev. no. 06.
7. Inspection : As per Clause 16.0 of AA 19702 rev. no. 06. BHEL reserves the right to see the manufacturing of casting at any stage and at any time at vender's works.
8. Test Certificate : As per Cl. 17.0 of AA 19702 Rev no 06.
9. Packing and Marking : As per Cl. 18.0 of AA 19702 rev. no. 06.
10. Cable channel areas should be casting burr & dust free.
11. If any defect is observed during final machining at BHEL Bhopal. BHEL reserves the right to reject the casting.

Note : a) Pattern equipment will be issued / supplied by BHEL. Vendor shall visit BHEL Bhopal for assessing the technical aspects like gating system, riser location etc. and condition of Pattern.

b) In case of any supply of casting (against a particular drawing) for which no supply has been done earlier by vendor to BHEL, inspection of first casting shall be done by BHEL, Bhopal representative. Only after clearance/Approval by BHEL, the vendor shall take up bulk manufacturing.


12/12/18

DGM (FOUNDRY)


29/09/19