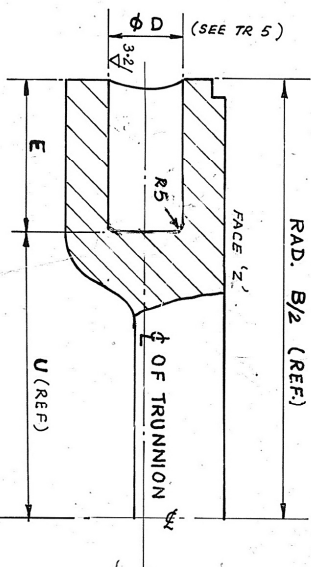
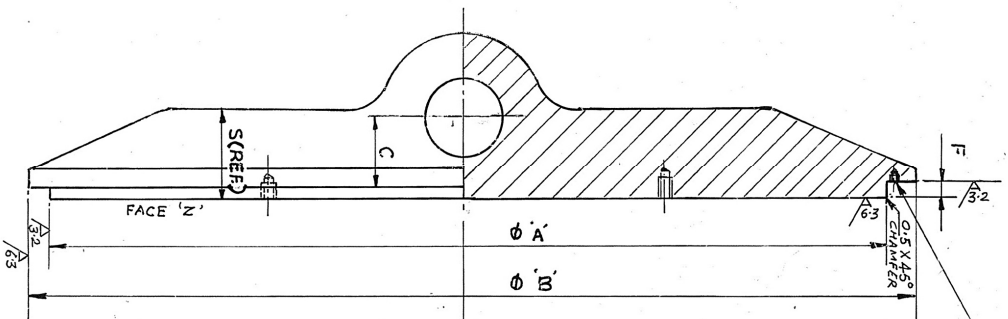
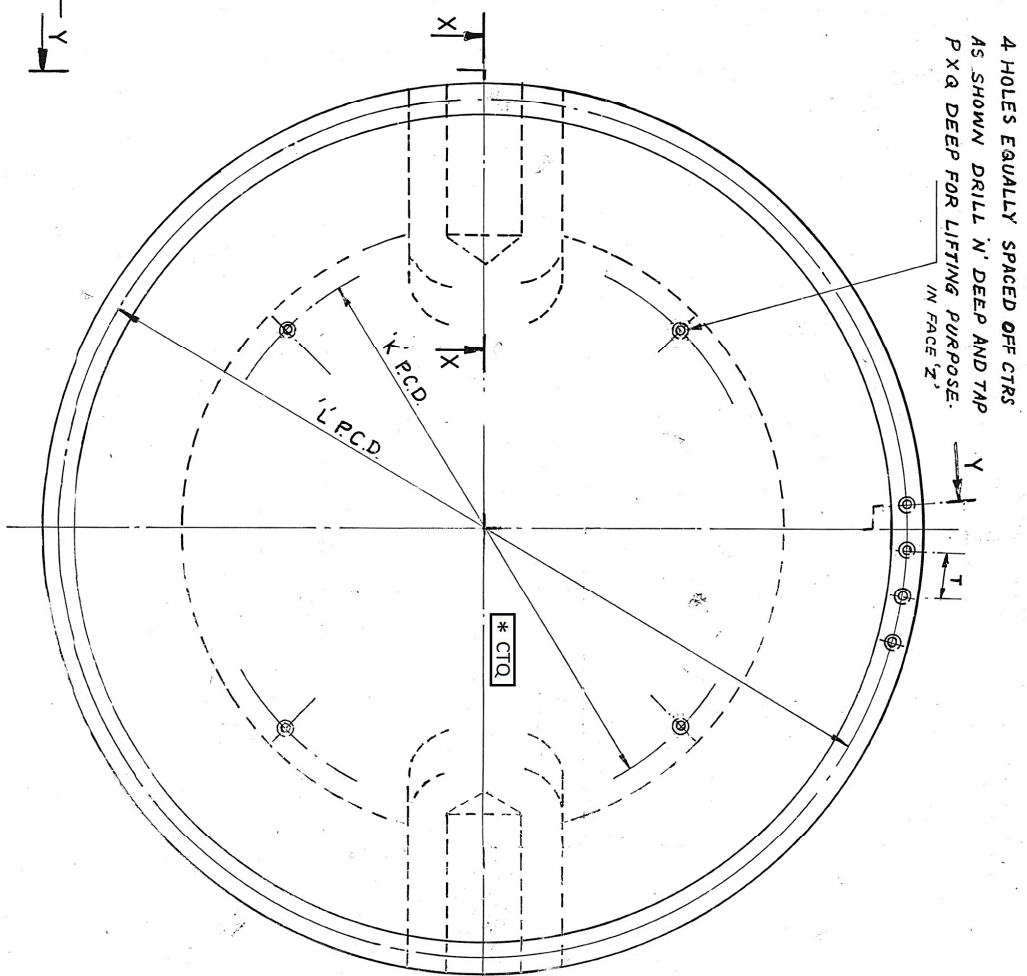


98000861561 ON STD



TECHNICAL REQUIREMENTS

1. MATERIAL: DUPLEX SS TO ASTM A-995 GR. 4A
2. TEST PIECES OF SUITABLE SIZES SHOULD BE AN INTEGRAL PART WHILE CASTING. SAME REQUIRED TO BE REMOVED AFTER HEAT TREATMENT.
3. ALL UNSPECIFIED RADII TO BE OF 6mm.
4. FINISHED CASTING SHOULD BE SOUND & FREE FROM BLOW HOLES, CRACKS, HOT TEARS, COLD SHUTS ETC. FOR A DURATION OF 30 MIN (MINIMUM).
5. FOUNDER TO NOTE THAT THE CASTING SHALL BE SUBJECTED TO HYDRAULIC PRESSURE AT BHEL WORKS PRESSURE GIVEN IN ASSY. DRAWING.
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. TEST BARS SHALL ALSO BE HEAT TREATED ALONG WITH THE CASTINGS THEY REPRESENT.
9. AFTER HEAT TREATMENT AND BEFORE GRIT BLASTING ALL SURFACE TO BE SUBJECTED TO 100% DP TEST AS PER BHEL CORP. STD. AA0850132, LEVEL-1
10. PERMISSIBLE VARIATION FOR UNTOI. DIMENSIONS TO BE AS PER DRG. 3-200-00-49014.
11. REPAIR OF CASTING SHALL NOT BE CARRIED OUT WITHOUT PRIOR PERMISSION OF BHEL.
12. COMPLETE ITEM TO BE GRIT BLASTED FOLLOWED BY PASSIVATION. MACHINED SURFACE AND IDENTIFICATION AREA NEEDS TO SUITABLY PROTECTED WHILE GRIT BLASTING.
13. FOR 'B.F. VALVE DOOR' (CASTING) REFER DRG. NO. 19513800092.
14. BOLTING HOLES TO BE MADE USING CNC PROGRAM AND TO CHECKED USING CNC MAKE TEMPLATE.

* UTMOST CARE TO BE TAKEN WHILE MACHINING TO MAINTAIN THE CONCENTRICITY OF BOTH SIDE TRUNNION HOLES.

VAR. NO.	DESCRIPTION	MATERIAL	DIMENSIONS																			APPROX WEIGHT IN KGS.
			A	B	C	D	E	F	G	H	J	K	L (Tee)	M	N	P	Q	S	T	U		
1.	φ 400 B.F. VALVE DOOR	SEE TR 1	311 ^{+0.4} _{-0.1}	370	60 ^{+0.5} _{-0.1}	50 ^{+0.03} _{-0.03}	75 ^{+0.2} _{-0.2}	16	18	M 10	15	180	338	20	26	M 12	24	58	52.8	110	47	
2.	φ 450 B.F. VALVE DOOR	SEE TR 1	361 ^{+0.4} _{-0.1}	420	60 ^{+0.5} _{-0.1}	56 ^{+0.03} _{-0.03}	84 ^{+0.2} _{-0.2}	16	18	M 10	15	240	388	24	26	M 12	24	70	50.6	126	65	
3.	φ 600 B.F. VALVE DOOR	SEE TR 1	511 ^{+0.4} _{-0.1}	570	63 ^{+0.5} _{-0.1}	71 ^{+0.03} _{-0.03}	105 ^{+0.2} _{-0.2}	16	18	M 10	15	340	538	32	32	M 16	30	100	52.7	180	164	
4.	φ 600 B.F. VALVE DOOR (10 ATA)	SEE TR 1	511 ^{+0.4} _{-0.1}	570	63 ^{+0.5} _{-0.1}	71 ^{+0.03} _{-0.03}	105 ^{+0.2} _{-0.2}	16	18	M 10	15	340	538	32	32	M 16	30	110	52.7	180	171	
5.	φ 800 B.F. VALVE DOOR (VALVE)	SEE TR 1	706 ^{+0.4} _{-0.1}	762	109 ^{+0.5} _{-0.1}	92 ^{+0.04} _{-0.04}	140 ^{+0.2} _{-0.2}	20	18	M 10	15	600	732	40	39	M 20	35	120	57.4	241	365	
6.	φ 1200 B.F. VALVE DOOR (VALVE)	SEE TR 1	1096 ^{+0.4} _{-0.1}	1156	139.5 ^{+0.5} _{-0.1}	130 ^{+0.04} _{-0.04}	195 ^{+0.2} _{-0.2}	20	18	M 10	15	850	1124	60	39	M 20	35	170	58.8	383	1050	
7	φ 400 B.F. VALVE (16 ATA)	SEE TR 1	311 ^{+0.4} _{-0.1}	370	69 ^{+0.5} _{-0.1}	62 ^{+0.03} _{-0.03}	93 ^{+0.2} _{-0.2}	18	18	M 10	15	180	338	20	26	M 12	24	75	52.8	92	57	

DRAWING REVIEW		SIGNATURE		DATE	
DEPT.	NAME	SIGN	DATE		
STATUS OF DRAWING					
DISTRIBUTION OF PRINTS					
CODE	2	1	2	3	4
STM	5				
DATE	ALTERED	DATE	ALTERED	DATE	ALTERED
CHECKED	CHECKED	CHECKED	CHECKED	CHECKED	CHECKED
APPROVED	APPROVED	APPROVED	APPROVED	APPROVED	APPROVED
ZONE					
DRAWING REVISION AND REVISION					
B.F. VALVE DOOR (MACHINING)					
19513800086					
01					