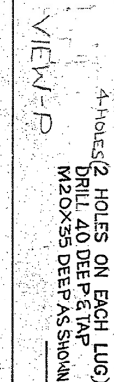
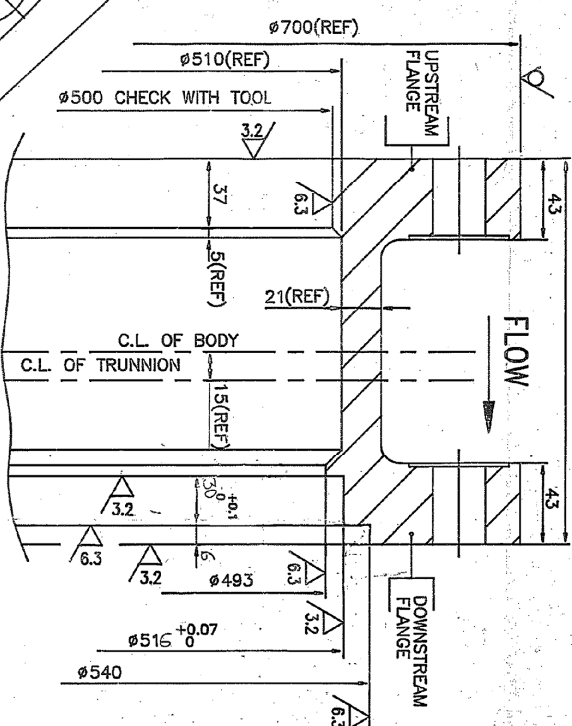


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TECHNICAL REQUIREMENTS :----

1. MATERIAL : DUPLEX SS TO ASTM
2. THE DRG. SHOWS THE BODY IN FINI
3. TEST PIECE OF SUITABLE SIZE SHO

1. MATERIAL : DUPLEX SS TO ASTM A-995 GR. 4A AS PER GA DRAWING.
2. THE DRG. SHOWS THE BODY IN FINISH M/ CED CONDITION.
3. TEST PIECE OF SUITABLE SIZE SHOULD BE AN INTEGRAL PART WHILE CASTING. SAME REQUIRED TO BE REMOVED AFTER HEAT TREATMENT.
4. ALL UNSPECIFIED RADI TO BE OF 6mm.
5. CASTING SHOULD BE SOUND & FREE FROM BLOW HOLES, CRACKS, HOT TEARS, COLD SHUTS ETC.
6. FINISHED CASTING SHOULD BE HYDRAULICALLY TESTED AT A PRESSURE OF 20 KG/SQ CM (G) FOR A DURATION OF 30 MINUTES (MINIMUM).
7. TOLERANCES ON AS CAST DIMENSIONS TO BE AS PER BHSL CORP. STD. AA 0230402 CLASS-5.
8. 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.
9. CASTING TO BE SUPPLIED IN HEAT TREATED CONDTION.. TEST BARS SHALL ALSO BE HEAT TREATED ALONG WITH THE CASTINGS THEY REPRESENT.
10. AFTER HEAT TREATMENT AND BEFORE GRIT BLASTING ALL SURFACE TO BE SUBJECTED TO 100% DP TEST AS PER BHSL CORP. STD. AA0850132.
11. PERMISSIBLE VARIATION FOR UNTOL. DIMENSIONS TO BE AS PER DRG. 3-200-00-49014.
12. REPAIR OF CASTINGS SHALL NOT BE CARRIED OUT WITHOUT PRIOR PERMISSION OF BHSL
13. COMPLETE ITEM TO BE GRIT BLASTED FOLLOWED BY PASSIVATION MACHINED SURFACE AND IDENTIFICATION AREA NEEDS TO SUITABLY PROTECTED WHILE GRIT BLASTING.
14. FOR B.F. VALVE BODY (CASTING) REFER DRG.NO. 19513800090
15. ALL SHARP EDGES & CORNERS TO BE REMOVED.
16. BOLTING HOLES TO BE MADE USING CNC PROGRAMME AND TO BE CHECKED USING CNC MAKE TEMPLATE.

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

SECTION-AA

SNO	TOOL NO	DESCRIPTION
1	15B58932	BLANK FLANGE TO SUIT G-HEAD M2 ON ITS PCD AT A PRESSURE OF 10.5 Kpsi/cm ² .
2	15B5893	TEST FLANGE TO SUIT G-HEAD M10 ON ITS PCD FOR 10.5 Kpsi/cm ² PRESSURE

[illegible]