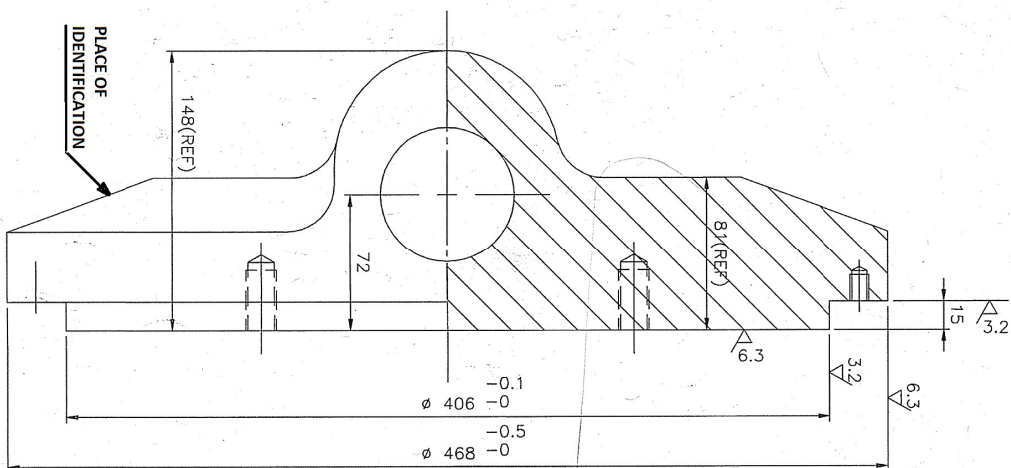
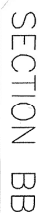




15. BOLTING HOLE TO BE MADE USING CNC PROGRAMME AND TO BE CHECKED USING CNC TEMPLATE.

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 SHALL BE INTEGRAL PART WHILE CASTING. SAME REQUIRED TO BE REMOVED AFTER HEAT TREATMENT.
4. ALL UNSPECIFIED RADII TO BE OF 6mm.
5. CASTING SHOULD BE SOUND & FREE FROM BLOW HOLES, CRACKS, HOT TEARS, COLD SHUTS ETC. FINISHED CASTING SHOULD BE HYDRAULICALLY TESTED AT A PRESSURE OF 20 KG/SQ.CM (G) FOR A DURATION OF 30 MIN (MINIMUM).
6. TOLERANCES ON AS CAST DIMENSIONS TO BE AS PER BH&L 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 BH&L CORP. STD. AA0850132. LEVEL -1.
10. PERMISSIBLE VARIATION FOR UNTOOL. DIMENSIONS TO BE AS PER DRG. 3-200-00-49014.
11. REPAIR OF CASTING SHALL NOT BE CARRIED OUT WITHOUT PIRON PERMISSION OF BH&L
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.19513800093
14. ALL SHARP EDGES & CORNERS TO BE REMOVED.
15. BOLTING HOLE TO BE MADE USING CNC PROGRAMME AND TO BE CHECKED USING CNC TEMPLATE.

[illegible]