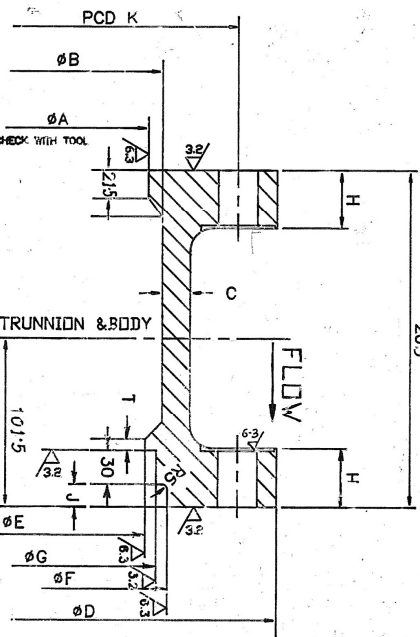
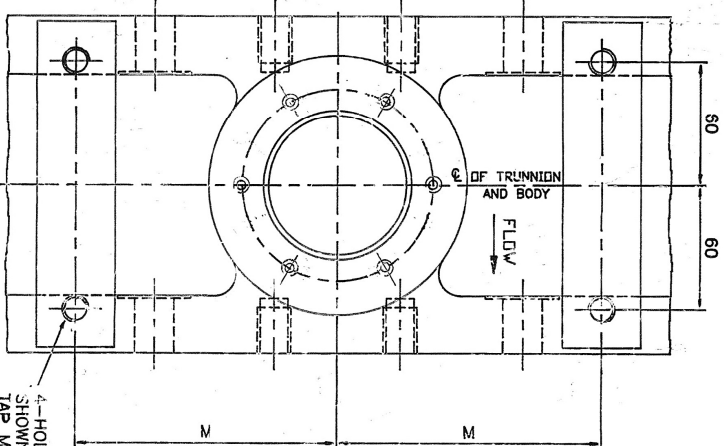


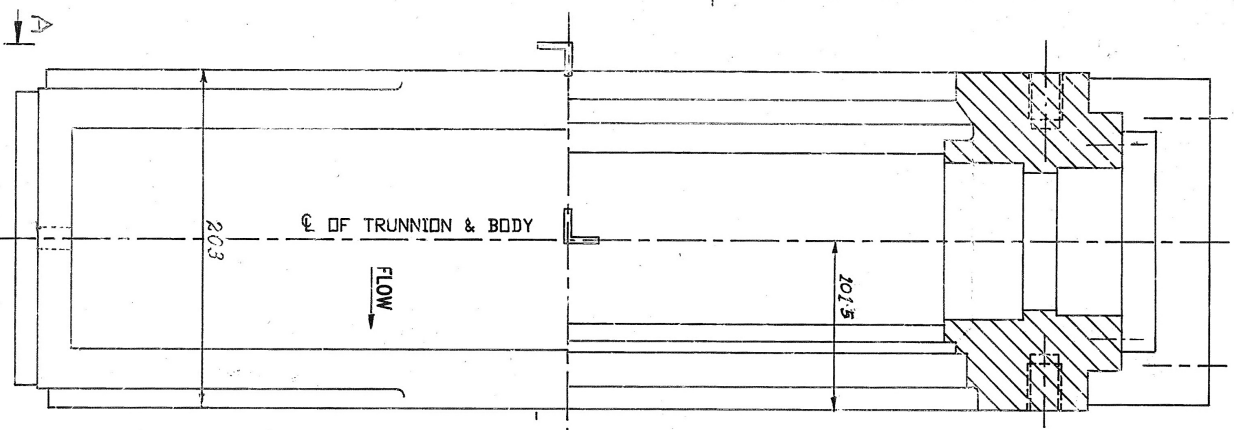
VAR. NO.	SIZE	DIMENSIONS																											WT (kg)													
		ØA	ØB	C	ØD	ØE	ØF	ØG	H	J	PCD K	ØL	M	N	ØO	P	Q	R	S	T	ØU	ØV	W	X	Y	Z	AA	BB		CC	DD	PCD EE	FF	GG	HH	JJ	KK	LL	MM	NN		
1	ø400. BFV BODY	400	415	17	600	394	435	415 ^{+10⁻⁰⁶}	37.5	21.5	540	62 ^{+10⁻⁰³}	125	45	80	195	305	375	35	7.5	65 ^{+10⁻⁰³}	53 ^{+10⁻⁰³}	—	—	—	53	23	M10	19	95	47.5	16	12	28	53	40	M24	35	105.3	130		
2	ø450BFV BODY	450	455	20	635	444	485	465 ^{+10⁻⁰⁶}	32.0	21.5	575	68 ^{+10⁻⁰³}	125	45	85	222	323	393	40	7.5	71 ^{+10⁻⁰³}	59 ^{+10⁻⁰³}	—	—	—	59	23	M10	18	95	47.5	20	16	28	53	40	M24	35	85.9	142		
3	ø600 BFV BODY	600	615	23	815	594	635	615 ^{+10⁻⁰⁷}	49.5	18.5	745	83 ^{+10⁻⁰³}	140	50	106	297	415	495	50	7.5	66 ^{+10⁻⁰³}	74 ^{+10⁻⁰³}	400	240	25	74	24	M12	21	115	57.5	20	16	35	66	40	M30	35	116.5	245		
4	ø400 BFV BODY (LITERATA)	400	415	18	610	354	435	415 ^{+10⁻⁰⁶}	40	11.5	540	74 ^{+10⁻⁰³}	125	45	90	195	305	375	40	7.5	77 ^{+10⁻⁰³}	65 ^{+10⁻⁰³}	—	—	—	65	25	M12	21	105	52.5	16	12	35	66	40	M30	35	105.3	149		



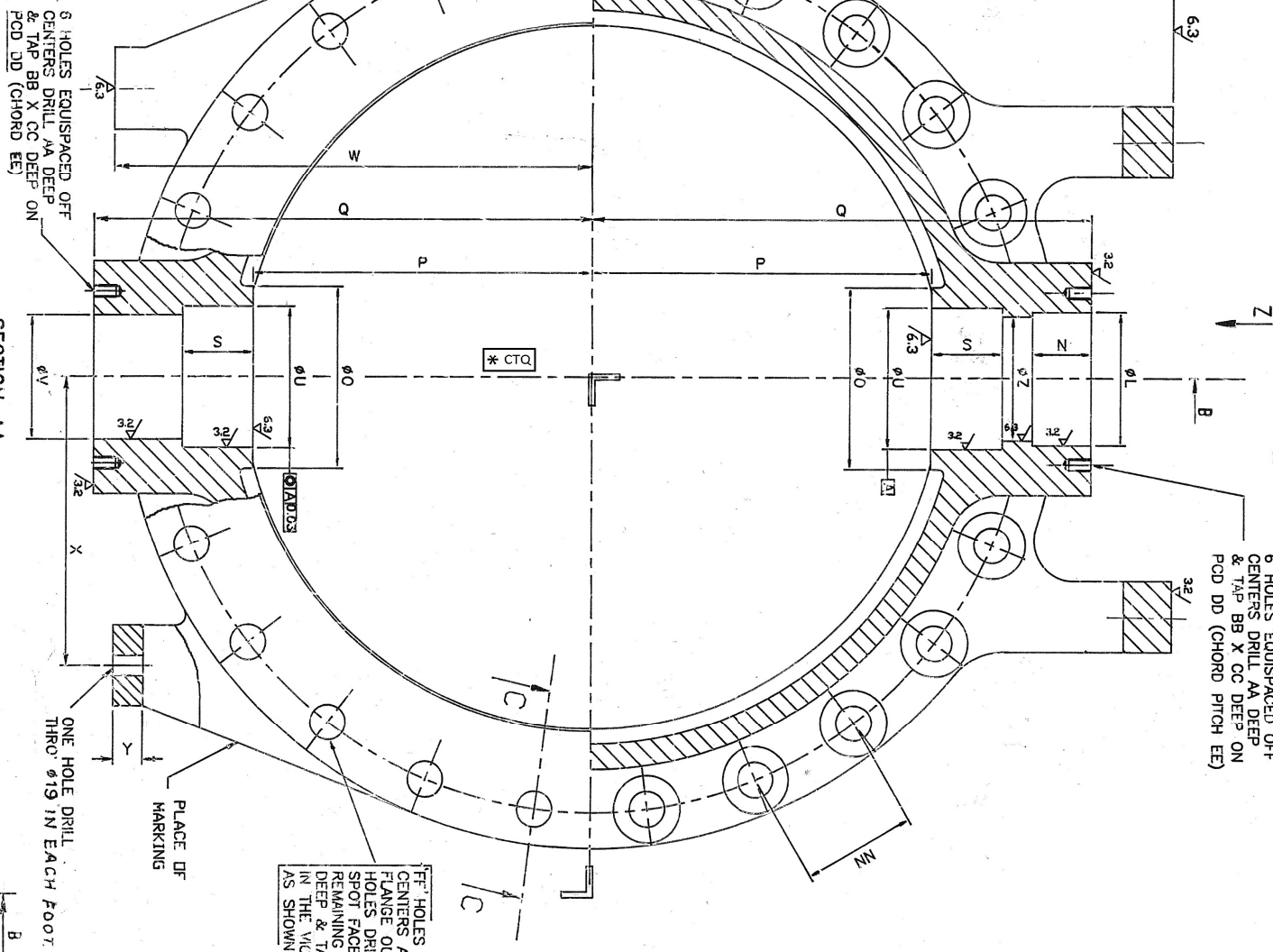
SECTION-CO
(GRID E-7)



VIEW ON-Z
(GRID-B-5)



SECTION--BB
(GRID--H-7)



SECTION--AA
(GRID-G-1)

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

FEET HOLES EQUISPACED OFF CENTERS AS SHOWN IN EACH FLANGE OUT OF WHICH 6" HOLES DRILL THRU. 4" & BACK SPOT FACE IN TO CLEAN UP. REMAINING 4 HOLES DRILL 1/2" DEEP & TAP 1/2" X 1/4" DEEP IN THE VICINITY OF THE TRUNNION AS SHOWN IN VIEW-2

4-HOLES POSITIONED AS SHOWN DRILL 40 DEEP & TAP M. 16 x .35 DEEP

1. MATERIAL: DUPLEX SS TO ASTM A-305, GR. 4A.
2. TEST PIECES OF SUITABLE SIZES SHOULD BE AN INTERNAL PART WHILE CASTING, SAME REQUIRED TO BE REMOVED AFTER HEAT TREATMENT.
3. ALL UNSPECIFIED RADI TO BE OF 5mm.
4. CASTING SHOULD BE SOUND & FREE FROM BLOW HOLES, CRACKS, HOT TEARS, COLD SHOTS ETC. FINISHED CASTING SHOULD BE HYDRAULICALLY TESTED AT A PRESSURE OF 20 KG/ SQ CM (G) FOR A DURATION OF 30 MIN (MINIMUM).
5. TOLERANCES ON AS CAST DIMENSIONS TO BE AS PER BH&L CORP. STD. A 0230402 CLASS-5.
6. 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.
7. CASTING TO BE SUPPLIED IN HEAT TREATED CONDITION. TEST BARS SHALL ALSO BE HEAT TREATED ALONG WITH THE CASTINGS THEY REPRESENT.
8. AFTER HEAT TREATMENT AND BEFORE GRT BLASTING ALL SURFACE TO BE SUBJECTED TO 100% DP TEST AS PER BH&L CORP. STD. A0680132, LEVEL-1.
9. PERMISSIBLE TOLERANCE FOR JOURNAL DIMENSIONS TO BE AS PER DRG. 3-200-00-49014.
10. FINISHED CASTING SHALL BE SUPPLIED WITH A MINIMUM OF 10% OVER PENETRATION OF DBH&L TO COMPLETE IT TO BE GRT BLASTED FOLLOWED BY PASSIVATION. MACHINED SURFACE AND IDENTIFICATION AREA NEEDS TO SUITABLY PROTECTED WHILE GRT BLASTING.
12. GEOMETRICAL VARIATIONS, OR UNIFORM, FINISHED DIMENSIONS TO BE AS PER DRG. NO. 3-200-00-49014.
13. FOR "B.V.F DDDY CASTING" REFER DRG. NO. 19513800091.
14. BOLLING HOLES TO BE MADE USING CNC PROGRAMME AND TO BE CHECKED USING CNC MAKE TEST PIECE.

[illegible]

DRAWING REVIEW		ADDITIONAL INFORMATION		BREV STANDARD
DEPT.	NAME	SIGN	DATE	
STATUS OF DRAWING U				
STAMP AND SIGNATURE OF APPROVING AUTHORITY				
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT				

[illegible]