

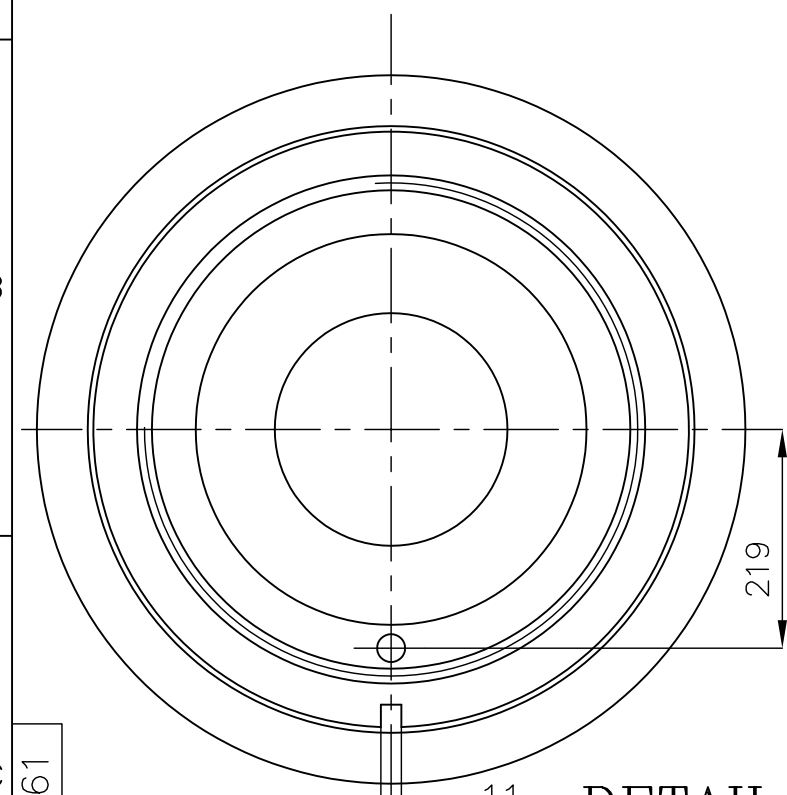
INVENTORY NO. _____ SIGN. AND DATE _____ REF. DRG. NO. _____ REV. _____ COMPUTER FILE NAME _____ THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY

FIRST ANGLE PROJECTION

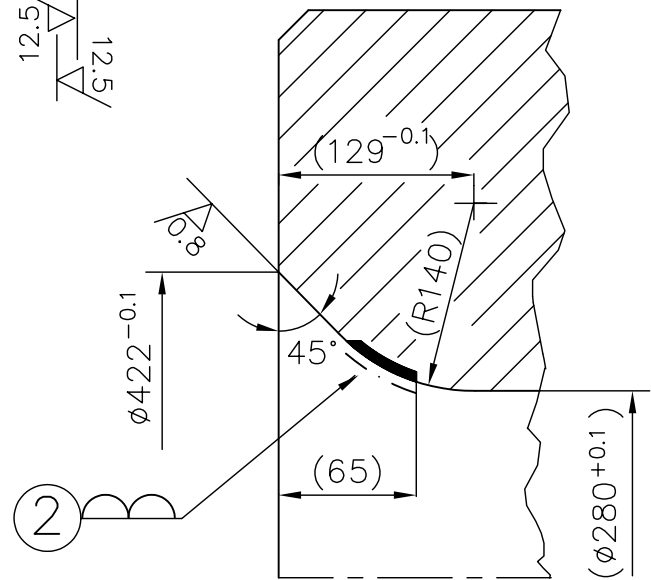
(ALL DIMENSIONS ARE IN mm)

DRG. NO. 2-113-21-62003

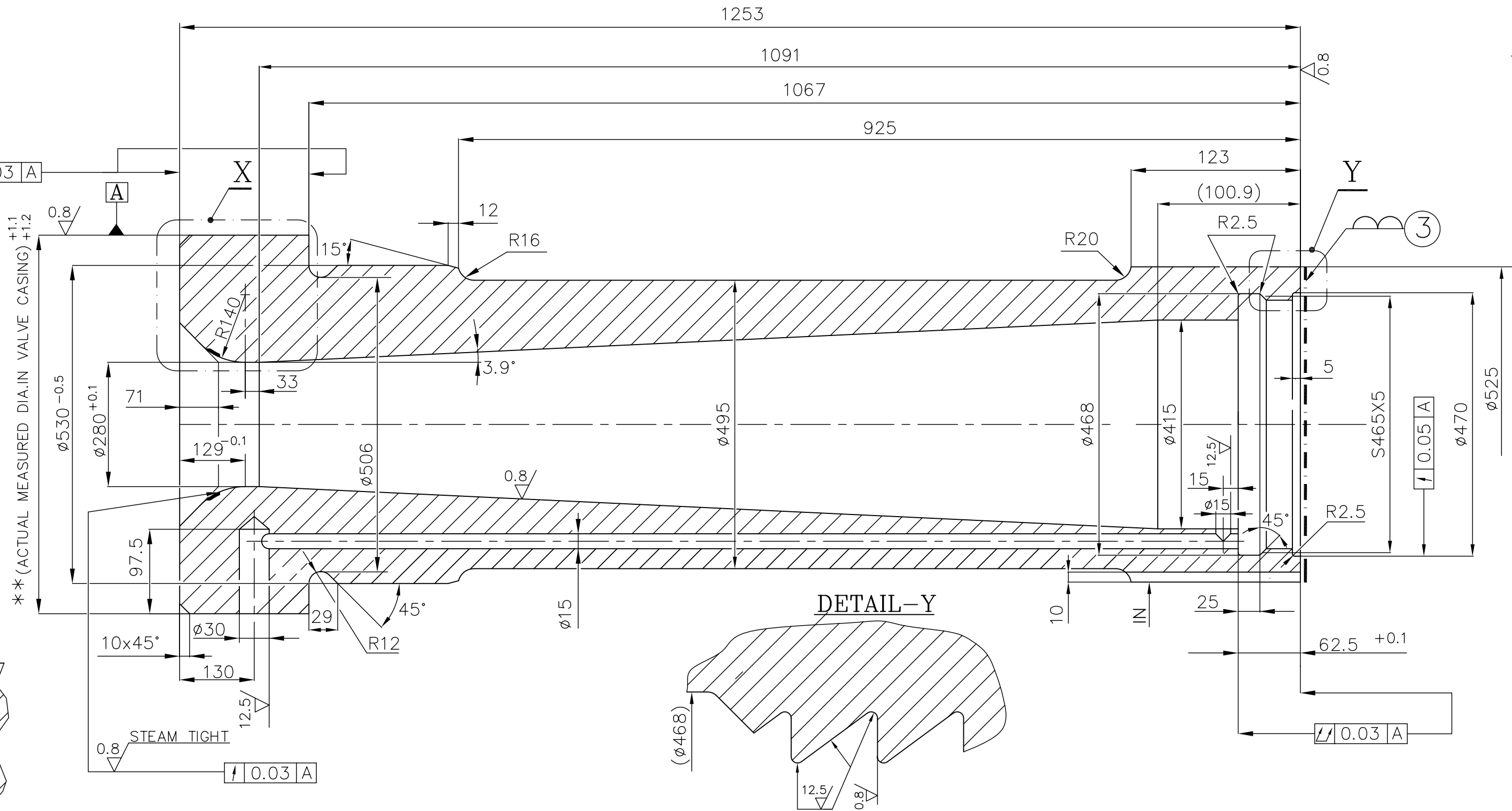
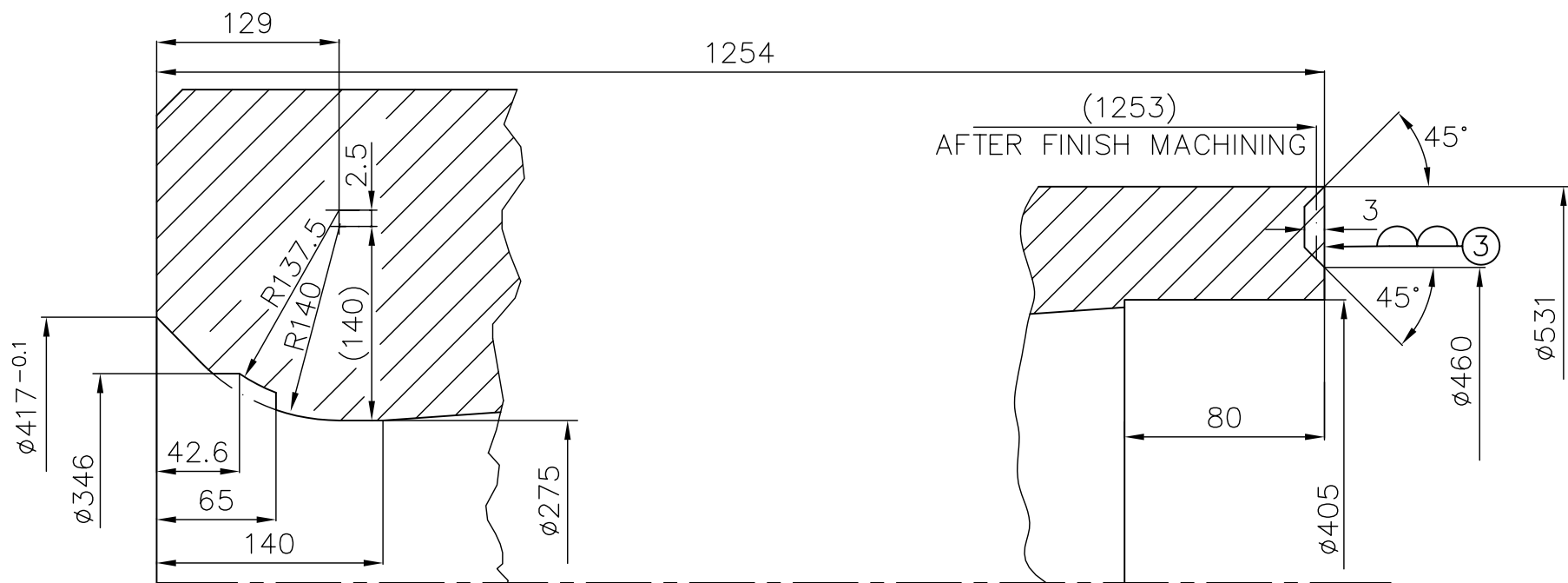
SH. 1 OF 1



DETAIL-X



PREMACHINING DETAIL BEFORE OVERLAY



DETAIL-Y

NOTES:

- DIMENSION MARKED ** TO BE FINISH MACHINED AFTER MEASURING THE FINISHED DIAMETER OF VALVE CASING. NOMINAL DIAMETER = (616.2)-0.03
- ALL UNDIMENSIONED EDGES TO BE CHAMFERED TO 0.5 x 45°.
- DEPOSITION TO BE DONE ON THE SURFACES SHOWN AS ② USING ELECTRODE ENiCr Fe-3 (NiCr082) AS PER W.P.S.No: WE116.
- STELLITE -6 TO BE DEPOSITED ON THE SURFACE SHOWN AS ③ TO A DEPTH OF 2MM +0.1mm. AS PER W.P.S.No: WE374
- 45° BUTRESS SCREW THREADS (S465X5) SHOULD BE AS PER DWG. 3-301-01-00304 VARIANT-04.
- ALL THE RADII SHOULD BE FINISHED TO 1.6/
- IDENTIFICION MARKING SHALL BE DONE AT PLACE MARKED AS IN
- SYMBOL 12.5/ DENOTES TOLERANCE OF COMBINED AXIAL AND RADIAL RUNOUT.
- MAT.CODE/MATL.SPEC. : ST9510809004/AA19308

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT



BHARAT HEAVY ELECTRICALS LTD. HYDERABAD

NAME	SIGN.	DATE	NO.OF VAR.
ANWAR		22-02-96	
N.S.N		22-02-96	
P.S.BABU		22-02-96	-N.A.-

DEPT. I.T.D. CODE 415	UNTOL. DIMS. GR. C/M/F	SCALE N.T.S.	WEIGHT (KG) 1075	REF. TO ASSY. DRG. -N.A.-	ITEM NO. -N.A.-	NO.OF ITEMS -N.A.-
TITLE				CARD CODE N.A.	DRAWING NO. 2-113-21-62003	REV. 02
				SHT. No 1	NO. OF SHT. 1	