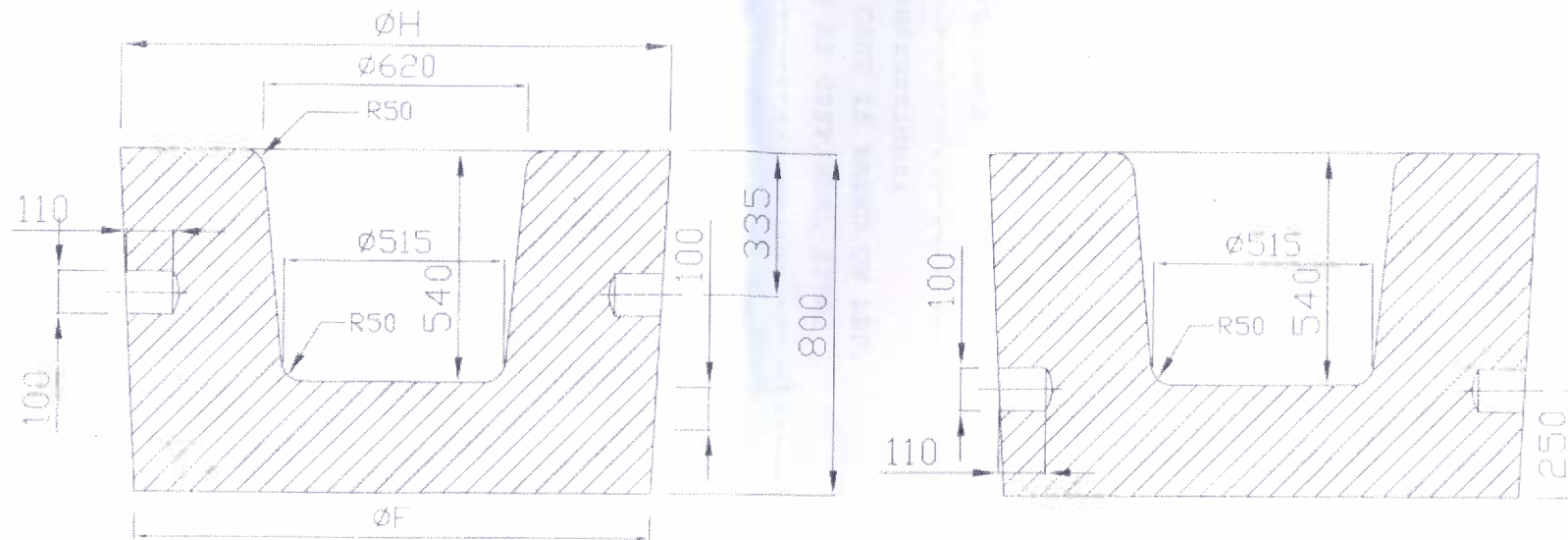


FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN MM.)



NOTE:

- DIMENSIONAL TOLERANCE = $\pm 2\text{MM}$
- COMPOSITION OF C.I. FALSE BOTTOM
 - TOTAL CARBON 3.6-4.0%
 - SILICON 1.5-2.0%
 - MANGANESE 0.5-0.7%
 - SULPHUR $\leq 0.08\%$
 - PHOSPHOROUS $\leq 0.08\%$
 - TIN $\leq 0.005\%$
 - NICKEL $\leq 0.2\%$
 - CHROMIUM $\leq 0.04\%$

-HEAT TREATMENT:

STRESS RELIEVING BY HEATING
UP TO $700-750^{\circ}\text{C}$ AND SOAKING FOR
MIN. 20 HOURS AND COOLING SLOWLY
BY 40°C PER HOUR TILL TEMPERATURE
OF 250°C IS ATTAINED

FALSE BOTTOM FOR INGOT MOULDS

SIZE	ØH	ØF	WT(Approx)
1700	1490	1410	9000Kg
1500/1400	1290	1210	6422Kg
1300	1110	1030	4426Kg
1200	1030	950	3640Kg
1050	895	815	2451Kg

REV	DATE	BY	CHKD
01	13/02/13	R50 RILET RADIUS AND NOTE ADDED	
02		ENDS OF Ø100MM HOLES ADDED	

BHARAT HEAVY ELECTRICALS. LTD.
CENTRAL FOUNDRY FORCE PLANT
RAIPUR HARDWARE

FALSE BOTTOMS FOR INGOT MOULDS

02-154 Rev:02

SHEET NO. 1 OF 1