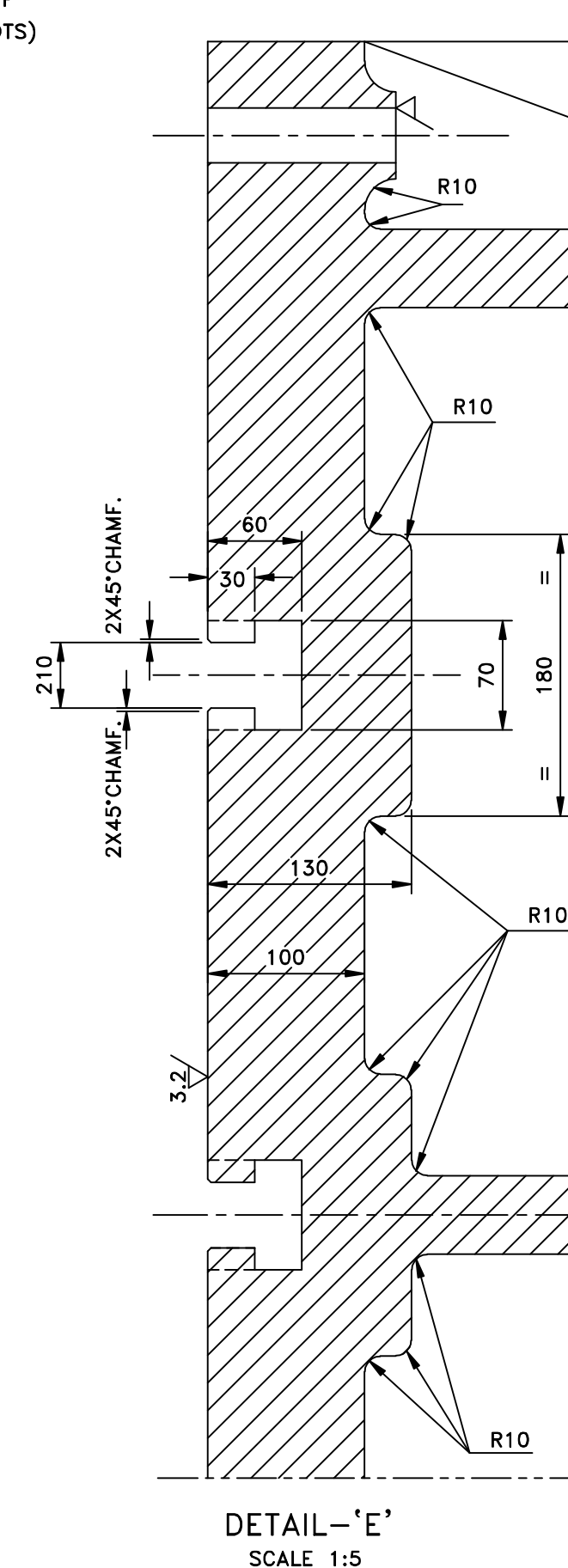
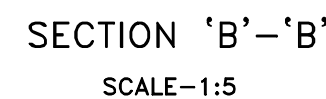




INVENTORY NO.



B. TEE SLOTS TO BE MACHINED FROM SOLID.
NO CORING REQUIRED ON CASTING FOR THE
TEE SLOTS.

1. PLACE CASTING IN THE FURNACE AT NOT GREATER THAN 300°C.
2. RAISE TEMPERATURE AT A RATE NOT GREATER THAN 100°C PER HOUR TO 530±10°C IT IS ESSENTIAL THAT THIS TEMPERATURE IS NOT EXCEEDED.
3. "SOAK" AT THE ABOVE TEMPERATURE IS FOR (X+1) HOURS WHERE X STANDS FOR MAXIMUM THICKNESS OF CASTING Eg. IF THICKNESS IS 2" THE SOAKING PERIOD WILL BE 3 HOURS.
4. FURNACE COOL TO 200°C, THE COOLING RATE SHOULD NOT BE GREATER THAN 50°C PER HOUR.
5. ALLOW THE TEMPERATURE TO DROP TO 100°C BEFORE REMOVING THE CASTINGS FROM THE FURNACE.
6. PERPENDICURITY OF SURFACE Y w.r.t. X
X SHOULD NOT BE MORE THAN 0.05 mm.

[illegible]

TYPE-3		28 — CARD TYPE-1		28 — CARD TYPE-2	
ADDITIONAL INFORMATION			TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		
			SARDAR SAROVAR CANAL		
STATUS OF DRAWING					
DISTRIBUTION OF PRINTS					
 BHARAT HEAVY ELECTRICALS LTD. BHOPAL			DRN	NAME	DATE
			CKD	SB	09/12/99
			APPD	SLK	14/02/99
				RVR	15/02/99
REV.	DATE	ALTERED CHECKED	DEPT.	UNTOOL DIMS. GR.	SCALE
01	16/6/94	SLK Sd	W.T.M.	TGST 110M	1:20 1:5
ZONE		APPROVED YRR Sd	CODE		WEIGHT(K.G.)
			202	—	REF. TO ASSY.DRG.
					—
DETAIL 'F' ADDED. SLOT SIZE REDESIGN TO SUIT M30 STUD. NOTE(FINISH):— b & c DELETED.			TITLE C.I. ANGLE PLATE (CLAMPING FIXTURE) 5000X2625X1500		DRAWING NO. F-1503302
					ITEM NO
					00
					NO. OF ITEM
					00
					REV.
					04
			SHT. NO. 1		NO. OF SHT. 1

TOTAL WEIGHT OF CASTING
AFTER M/C'ING - 18435 KG. APPROX.