









SECTION AA  
(D-9/16)



SECTION BB  
(G-13)

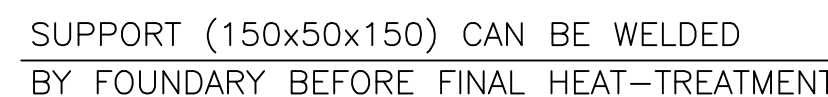


- TECHNICAL REQUIREMENTS:—

1. THE CASTING SHALL BE SUPPLIED IN ROUGH MACHINED CONDITION WITH 3, mm MACHINING ALLOWANCE ON ALL SURFACES MARKED WITH MACHINING SYMBOL  WITH SURFACE FINISH 12.5 UNLESS OTHERWISE SPECIFIED. SYMBOL  ARE REQUIRED AS PER DRG. DIMENSIONS.
2. THE CASTING SHALL BE SUPPLIED IN CONFORMITY WITH THE PURCHASING SPECIFICATION MENTIONED IN THE ORDERING DOCUMENT.
3. UNLESS OTHERWISE SPECIFIED ANY WHERE ON THE DRG. THE CASTING SHALL CONFORM TO QUALITY LEVEL 3.
4. PADS 25mm Sq. SHALL BE WELDED BY SUPPLIER IN ACCORDANCE WITH ST 29002 PAGE 6 TYPE-2.
5. DIMENSIONS WITHIN  ARE TO BE MAINTAINED BY SUPPLIER WITHOUT ANY EXTRA ALLOWANCE.
6. DIMENSIONS WITHIN  ARE FOR REFERENCE ONLY.
7. IDENTIFICATION NUMBER SHALL BE CAST ON AT THE LOCATION SHOWN AS IN SUPPLIER'S EMBLEM AND DRG NO. SHALL BE CAST ON THE LOCATION SHOWN .
8. REFERENCE LINE SHALL BE MARKED ON BOTH HALVES OF THE CASTING. AS CAST JOINT PLANE SHOULD BE MATCHED WITHIN 5mm ON FLANGE. DIMENSIONS MARKED WITHIN  ARE CRITICAL TO QUALITY.
9. DURING FINISH MACHINING, LUGS WILL BE CUT AND FACES WILL BE MACHINED. MINIMUM 10mm ALLOWANCE IS REQUIRED FOR MACHINING.

- NOTE:—

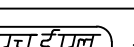

1. IRRESPECTIVE OF QUALITY LEVEL REQUIRED ON PARTING PLANE AND SEALING SURFACE, SUPPLIER SHALL ENSURE THAT NO DEFECTS SHALL OPEN UP DURING FINAL MACHINING.



VIEW U  
(M-13)

X  
(G-14,SH.2)

[illegible]

GMS NO./GR. SP. NO. 01060157000				STATUS OF OR		TYPE OF PRODUCT OR				STEAM TURBINE			
TWOED REF		NAME SIGN		DATE		NAME OF CUSTOMER/PROJECT							
STE		A.SHAH		-sd-		12.10.06							
STT		V.K.M.		-sd-		12.10.06							
04										BHARAT HEAVY ELECTRICALS LTD.		DRN NAME ASHOK SIGN -sd- DATE 26.04.06 No. 05 VAR	
101										RANIPUR, HARDWAR		APPD P.NATH SIGN -sd- DATE 26.04.06 No. 12 VAR	
REV		DATE		ALTERED		ASHOK -sd-		DEPT MTE		SCALE		WEIGHT (KG)	
-sd-		02.07.07		CHECKED		S.D.D.		CODE 4300				1:10 35300	
				SUPERSEDES		THE OLD DRG.							
				UNDER THE NAME				TITLE :		CARD CODE		DRAWING NO.	
								CASTING FOR I.P. OUTER CASING				0-10601-57901 72/93	
								(ROUGH MACHINED)				SHEET No. 01 No. of SHEETS 12	
												CA/NO.MTE-07-F0475	

REV 06	DATE 04.11.09	ALTERED ASHOK-sd- CHECKED SSG-sd-	REV 05	DATE 27.02.09	ALTERED ASHOK-sd- CHECKED SSG-sd-	REV 04	DATE 19.09.08	ALTERED ASHOK-sd- CHECKED SSG-sd-
DIMENSION 570 SHOWN AT ZONE L-12 & QUALITY LEVEL 2 ADDED IN SECTION AA (IN SHEET NO. 01 ONLY) CA/NO. MTE-09-F0117			CHANGE AS PER CHANGE ADVISE ADVISE (ZONE J-13) IN SHEET NO.02. CA/NO. MTE-09-F0040			DIMENSION 13100.5 IN PLACE OF 14100 DIMENSION 200.5 IN PLACE OF 200 AND R80 IN PLACE OF R32 IN SECC. CA/NO. MTE-08-F0214		

GRADE OF UNTOL.DIM
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M/CG.-C/M/F	AA0230208
WELDING-A/B/C/D	AA06211
GAS CUTTING-T3'	AA06211

REV	DATE	ALTERED	ASHOK -S
03	05.04.08	CHECKED	SSG -S
3 TECHNOLOGICAL SUPPORTS OF 150X50X150 ADDED IN VIEW U			
CA/NO.MTE-08-F0111			

NAME OF CUST



DEPT	MTE
CODE	4300
TITLE :	
CASTING F	
(R	

R/PROJECT

AT HEAVY  
RANIPU

I.P.O.U.  
H. MACHINE

STEAM TURBINE

NAME OF CUSTOMER/PROJECT



**BHARAT HEAVY**  
**RANIPUR**

DEPT MTE	
CODE 4300	
TITLE : CASTING FOR I.P.OU (ROUGH MACHINE	

ELECTRICALS LTD. BARDWAR	NAME	
	DRN	ASHOK
	CHD	S.S.GROTRA
	APPD	P.NATH

E 0	WEIGHT (KG) 35300	REF. TO _____
CASING		DRAWING 0-106 7

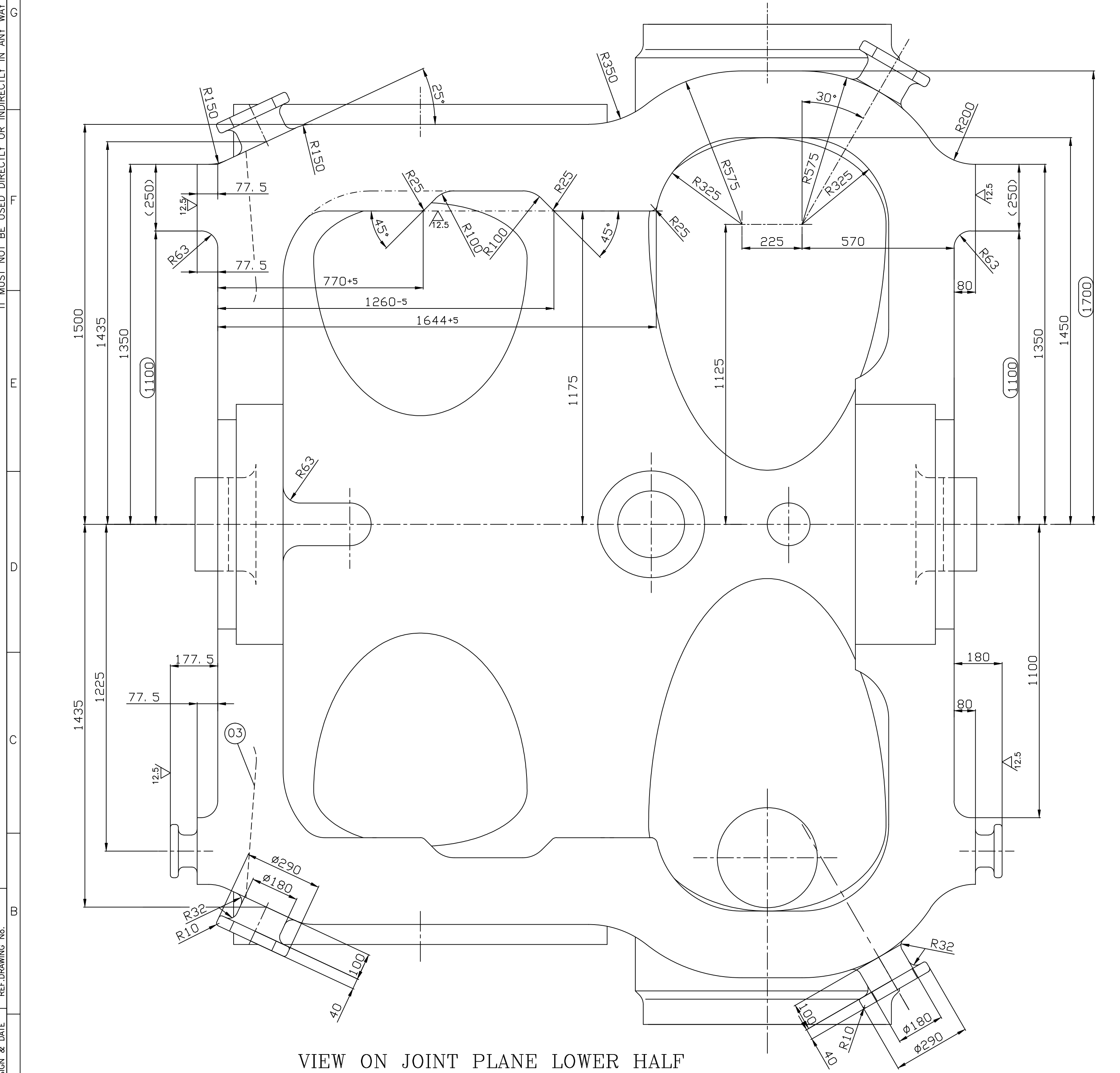
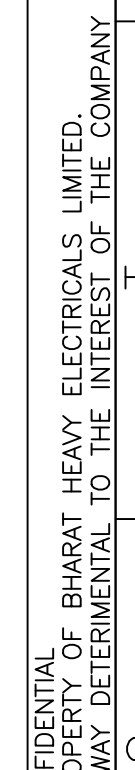
NAME	
ASHOK	
S.S.GROTRA	
P.NATH	

REF. TO	
DRAWING	
0-106	
7	

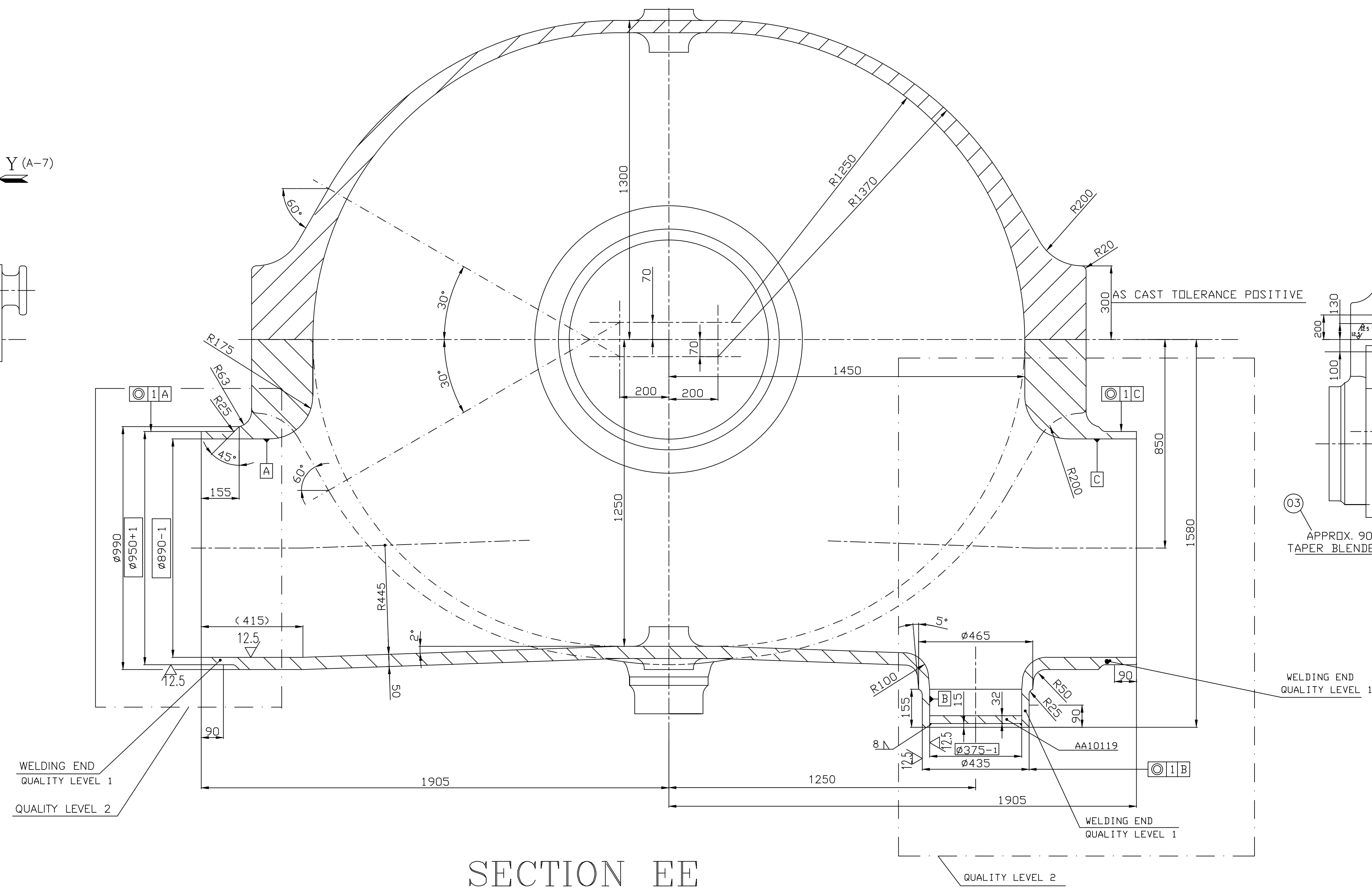
N	DATE	NO. C	VAR
d—	26.04.06		
d—	28.04.06		
d—	12.10.06	73	7

SY. DRG.	ITEM No.	NO. OF ITEMS
	—	75 7
—57901		
	22	23 2

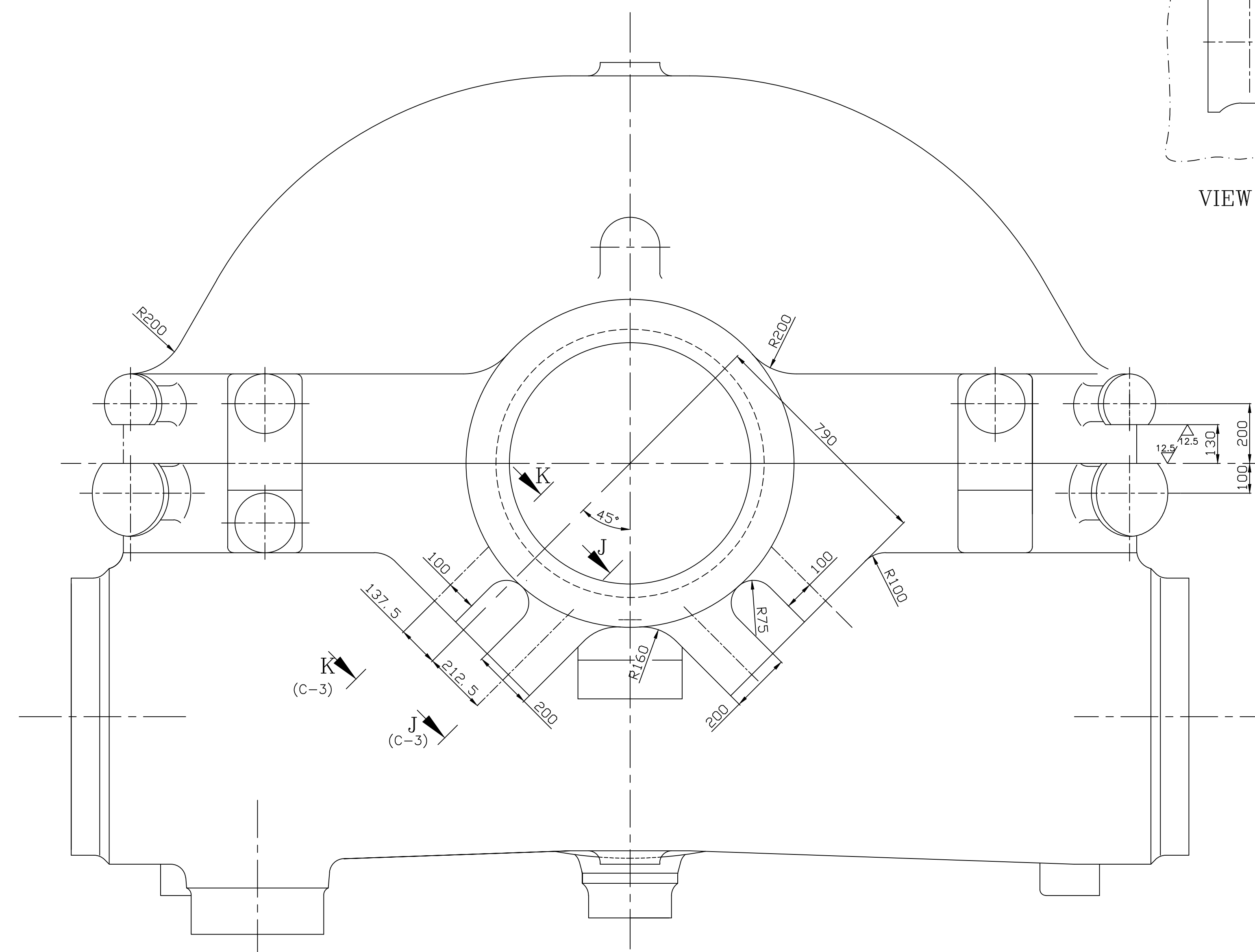
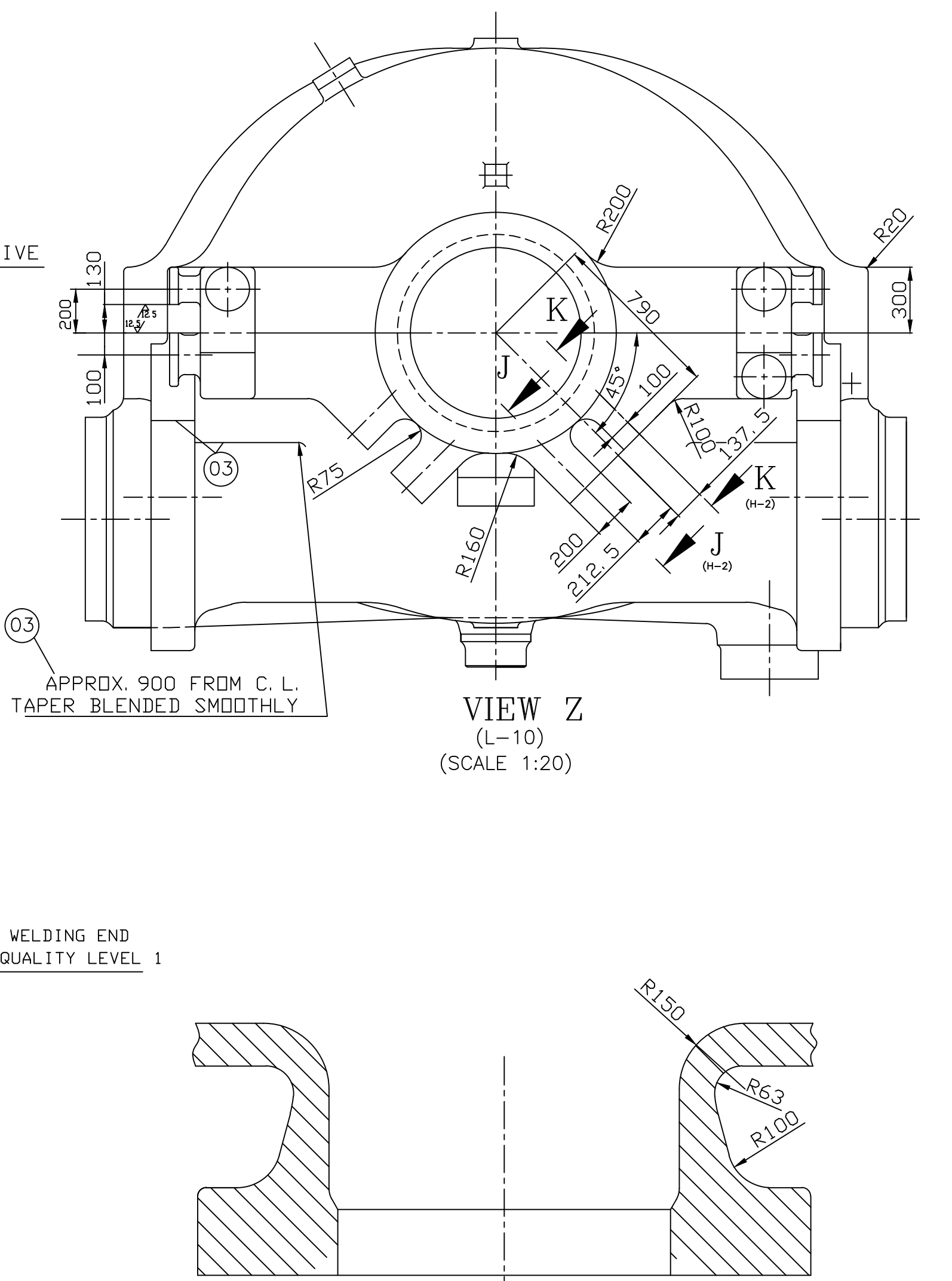
THE REST
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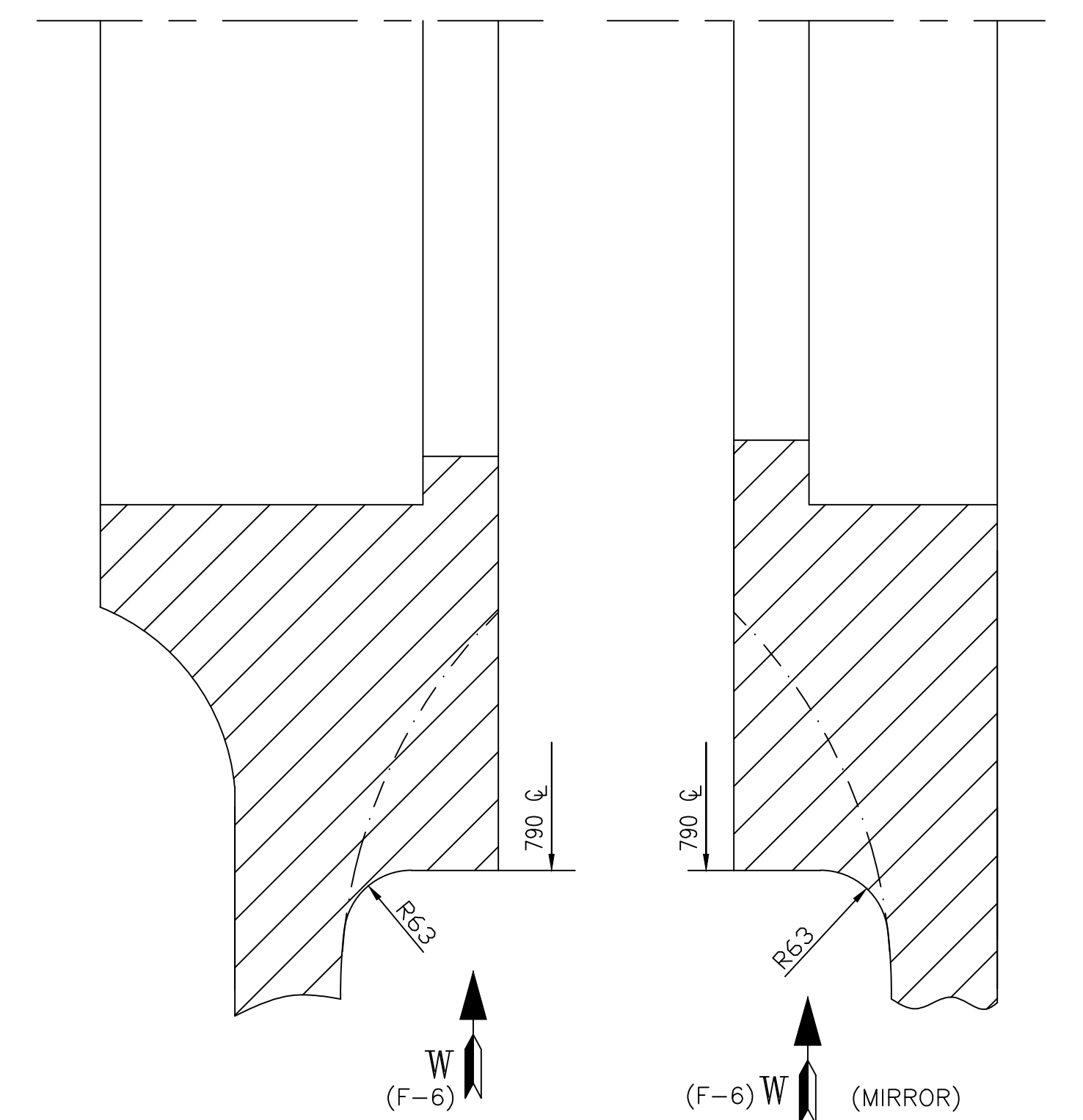
SECTION EE  
SCALE 1:10  
(G-13,SH.2)



SECTION GG (J-16)  
SCALE 1:20




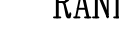
VIEW Y (L-11)



SECTION JJ (C-8)

SECTION KK  
(H-6)

		002	LOWER HALF	0-10601-57901	W92310601306 HW19578	CNO	20400 00		B3
		001	UPPER HALF	0-10601-57901	W92310601292 HW19578	CNO	14900 00		
VAR.00	REMARKS	ITEM NO	DESCRIPTION	DRAWING NO	VAR MATERIAL SPECN	MATERIAL CODE	UNIT WEIGHT	ZONE	

C.B.O.M. 01060157000		STATUS OF ORDER		TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT										STEAM TURBINE															
AGREED REF.		NAME SIGN		DATE												NAME SIGN		DATE		NO. OF VAR									
208 21104 21101		STE SIT		A.S.HSH VKM		-sd- -sd-		12.10.06 12.10.06		 BHARAT HEAVY ELECTRICALS LTD. RANIPUR, HARDWAR										DRN APPD		NAME S.S.G. GROTRA		SIGN -sd-		DATE 26.04.06		NO. OF VAR	
																						P.NATH		SIGN -sd-		DATE 26.04.06		NO. OF VAR	
										SCALE 1:10										WEIGHT (KG) 35300.00		REF. TO ASSY. DRG.		ITEM NO.		NO. OF ITEMS			
-sd- -sd-		DATE 02.07.06		ALTERED ASHOK SSG		-sd- -sd-		DEPT MTE CODE 4300												CARD CODE		DRAWING NO. 0-10601-57901		22		23			
DIM DED.				SUPERSEDES THE OLD DRG. UNDER THE SAME NO.						TITLE : CASTING FOR I.P. OUTER CASING (ROUGH MACHINED)												SHEET 7		NO. OF SHEETS 23		24			
								CA/NO.MTE-07-F0475																					

REV 06	DATE	ALTERED ASHOK - SSS	REV 05	DATE	ALTERED ASHOK - SSS	REV 04	DATE	ALTERED ASHOK - SSS	REV 03	DATE	ALTERED ASHOK - SSS
04.12.09		CHECKED SSG - SS	27.02.09		CHECKED SSG - SS	19.09.08		CHECKED SSG - SS	12.09.08		CHECKED SSG - SS
CHANGE IN SHEET NO. 01 ONLY.			CHANGE AS PER CHANGE ADVISE (IN ZONE U-13)			DIMENSION 605'S ADDED AND W/CING S/M ADDED IN VIEW X			DIM. 1400 CHANGED TO DIM 1300 AND DIM 605 ADDED.		
CA/NO. MTE-09-F0117			CA/NO. MTE-09-F0040			CA/NO. MTE-08-F0214					