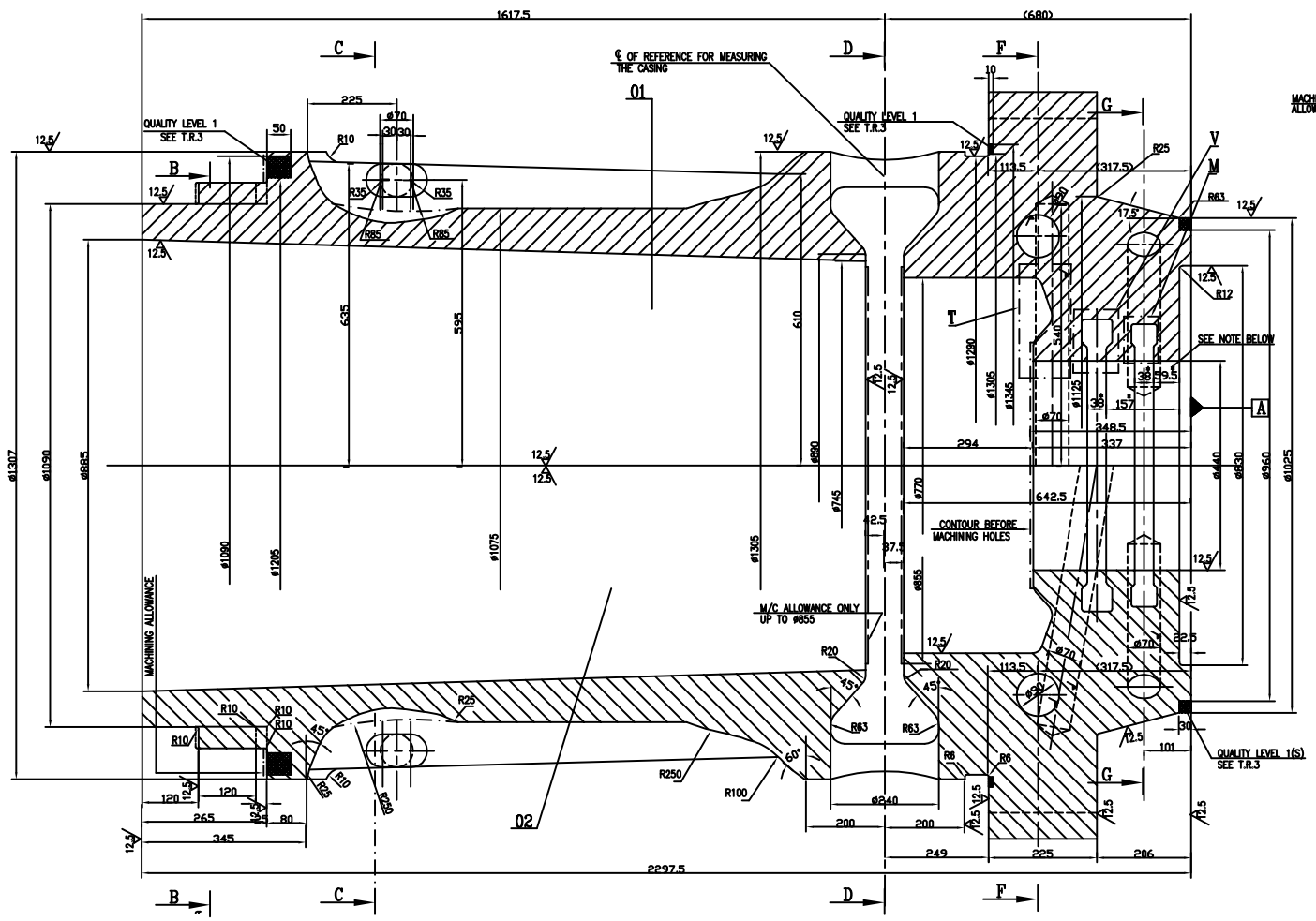
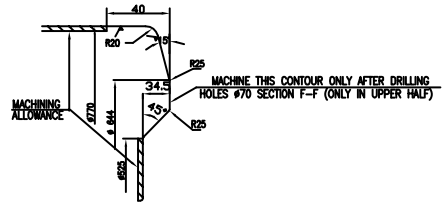
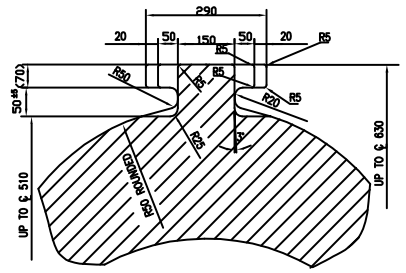
DRAWING NO. 0-10502-24901



SECTION A-A



DETAIL - T
SCALE N.T.S.



DETAIL - Z
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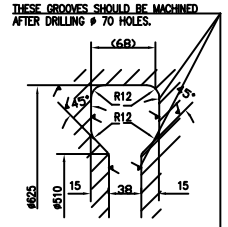

DETAIL - V
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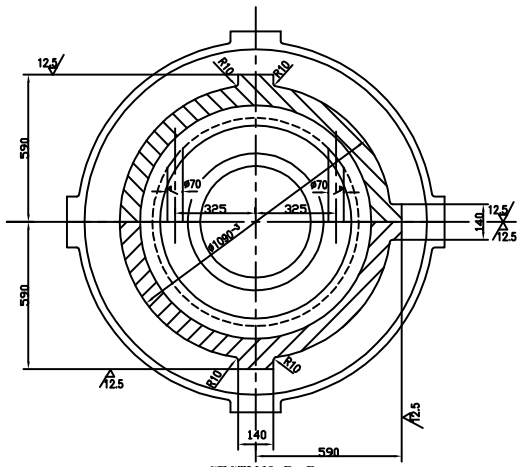
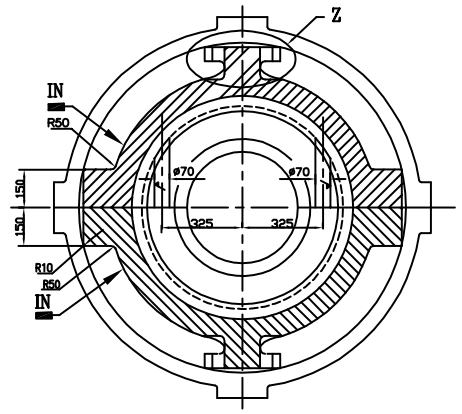
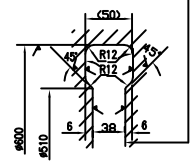


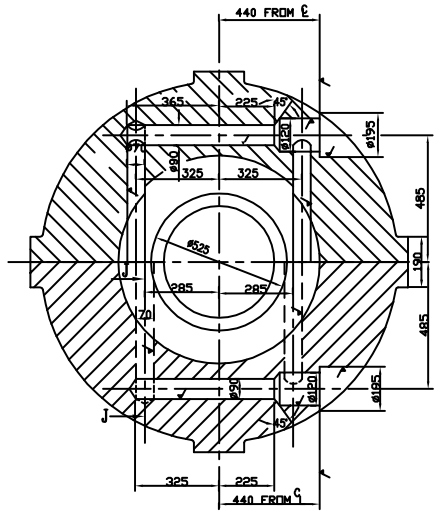
SECTION B-B



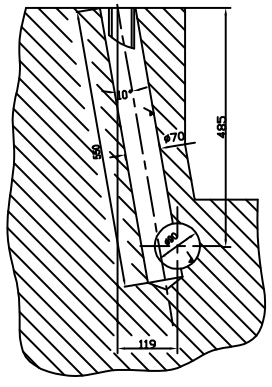
SECTION C-C



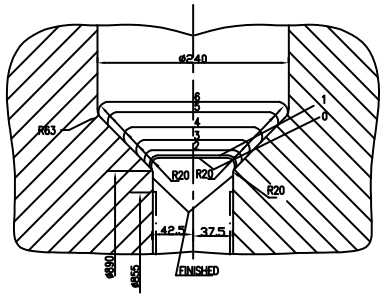
DETAIL - M
SCALE N.T.S.



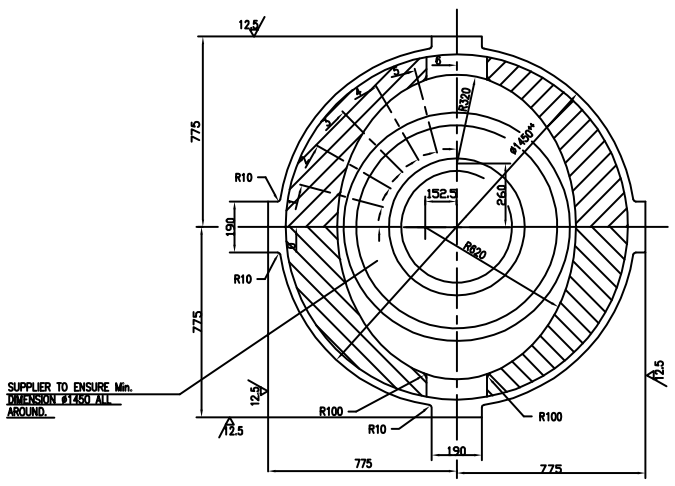
SECTION F-F



SECTION J-J



CORE SECTION 0-6(SCALE N.T.S.)



SECTION D-D

TECH. REQ. (FOR FINISH MACHINING AT SUPPLIER'S WORKS)

1. FINISH DIMENSIONS ARE TO BE MAINTAINED KEEPING IN VIEW THE ACTUAL ALLOWANCE ON REFERENCE FACES. THE ACTUAL ALLOWANCE ON REFERENCE AND THESE DIMENSION MUST BE INDICATED ON SUPPLIER'S INSPECTION SHEET.
2. ALL THE HOLES SHOULD BE THOROUGHLY CLEANED AND PLUGGED WITH POLYCARBONATE PLUGS.
3. FINISH MACHINED DIMENSIONS WHERE NO TOLERANCE HAS BEEN INDICATED SHOULD BE TAKEN AS MEDIUM GRADE AS PER DIN 7168.
4. ALL FINISH MACHINED SURFACES & HOLES ARE TO BE PROTECTED WITH TECTYL 858 (C) OR EQUIVALENT MATERIAL FOR PRESERVATION AGAINST CORROSION DURING TRANSPORT.

NOTE :

ACTUAL ALLOWANCE ON FACE ▶Ⓐ SHOULD BE TAKEN IN TO CONSIDERATION FOR MACHINING WHILE MAINTAINING THESE AXIAL DIMENSIONS MARKED.

THE ACTUAL ALLOWANCE ON FACE ▶Ⓐ SHOULD BE RECORDED IN INSPECTION SHEET IN ADDITION TO OTHER DIMENSIONS. SPECIAL CARE IS TO BE TAKEN THAT THESE GROOVES COINCIDE ON BOTH HALVES (THESE GROOVES ARE TO BE MACHINED OFTER DRILLING HOLES)

SPECIAL NOTE :-

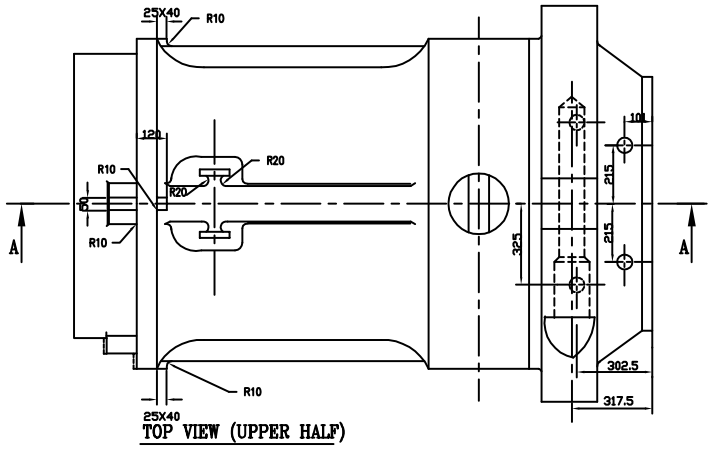
CASTING TO BE SUPPLIED IN ROUGH MACHINED CONDITION BUT HOLES/SURFACE MARKED ✓ SHALL BE SUPPLIED IN FINISH MACHINED CONDITION BY CASTING SUPPLIER.

TECHNICAL REQUIREMENTS :-

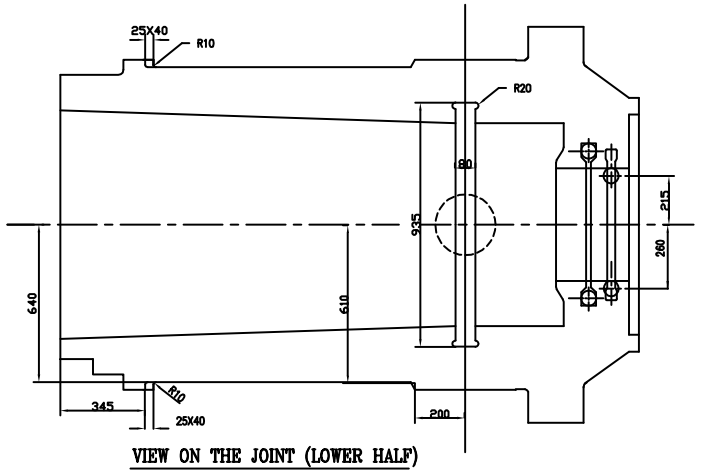
1. THE CASTING SHALL BE SUPPLIED IN ROUGH MACHINED CONDITION WITH 3±1mm. ALLOWANCE ON ALL SURFACE MARKED WITH MACHINING SYMBOL 12.5✓
2. THE CASTING SHALL BE SUPPLIED IN CONFORMITY WITH THE PURCHASING SPECIFICATION SPECIFIED ON THE ORDERING DOCUMENT.
3. UNLESS OTHERWISE SPECIFIED ANY WHERE ON THE DRAWING THE CASTING SHALL CONFORM TO QUALITY LEVEL 2.
4. NO SHRINKAGE SHALL OPEN OUT DURING MACHINING OF BLADE GROOVES ONLY FLAWS FOR RIM ZONE AS PER HW0980830 ARE PERMISSIBLE.
5. THE DIMENSIONS WITHIN (----) ARE FOR REFERENCE ONLY.
6. CONTOUR '____' TO BE MACHINED WITH ALLOWANCE AS PER T.R. 1 FOR FINISHING AT BHEL.
7. IDENTIFICATION NUMBER SHALL BE CAST ON AT THE LOCATION SHOWN IN . SUPPLIER'S EMBLEM AND DRAWING NO. SHALL BE CAST ON AT THE LOCATION SHOWN.■

SYMBOL :-

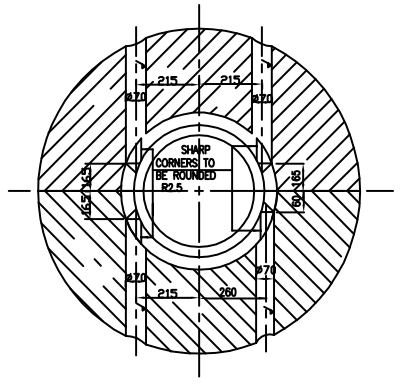
1. ✓ FINISHED MACHINED.12.5✓
2. ■ SEALING SURFACES QUALITY LEVEL 1.



TOP VIEW (UPPER HALF)



VIEW ON THE JOINT (LOWER HALF)



SECTION G-G

		02	LOWER HALF	0-10502-24901	W92310502162	CNC	5800.00
					HW19581		
		01	UPPER HALF	0-10502-24901	W92310502154	CNC	5800.00
					HW19581		
VAR.00	REMARKS	ITEM NO	DESCRIPTION	STD	DRAWING NO	VAR	MATERIAL CODE / MATERIAL SPECN	CAT	UNIT WEIGHT	QTY	ZONE

GRADE OF UNTOL.DIM	STT	D.G.B	SD/- 9.12.92
M/CG.-C/M/F AA0230208	STE	B.K.K	SD/- 14.12.92
WELDING-K/B/E/B AA0621104			
GAS CUTTING-T3 AA0621101			

-BMG-No./ C.B.O.M 0-10502-24000 — STATUS OF DRG ✓

REV	DATE	ALTERED	APPROVED	NAME	SIGN	DATE
T3	09.01.96	RAJPAL sd/-	CHECKED	P.NATH	sd/-	
4.16 4.11 A2		CHANGE IN DIM. DIM.ø885 WAS ø890 DIM.ø745 WAS ø750 WEIGTH 11600kg WAS 11400kg C/ADVICE NO.- MTE-06-F0114				
11	25.03.02	ALTERED	CHECKED	ASHOK / P.NATH	SD/- / SD/-	
12	14.08.06	RAJPAL sd/-	CHECKED	P.NATH	SD/-	

LOCATION OF INDENTIFICATION CHANGE C/ADVICE NO.- MTE-06-F0082

SUPERSEDES THE OLD DRAWING UNDER THE SAME NUMBER VIDE C/A NO: MTE-03-F1011

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT: STEAM TURBINE

BHARAT HEAVY ELECTRICALS LTD. RANIPUR, HARDWAR

	NAME	SIGN	DATE
DRN	A. RAWAT	SD/-	3.4.03
CHD	P.NATH	SD/-	5.4.03
APPD	P.NATH	SD/-	7.4.03

DEPT STE | CODE 4011 | SCALE N.T.S. | WEIGHT (KG) 11600.00 | REF. TO ASSY. DRG. | ITEM No. | NO. OF ITEMS

TITLE : CASTING FOR HP INNER CASING (ROUGH MACHINED)

CARD CODE | DRAWING NO. 0-10502-24901 | SHEET No. 01 | No. OF SHEETS 01

A0 SIZE

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