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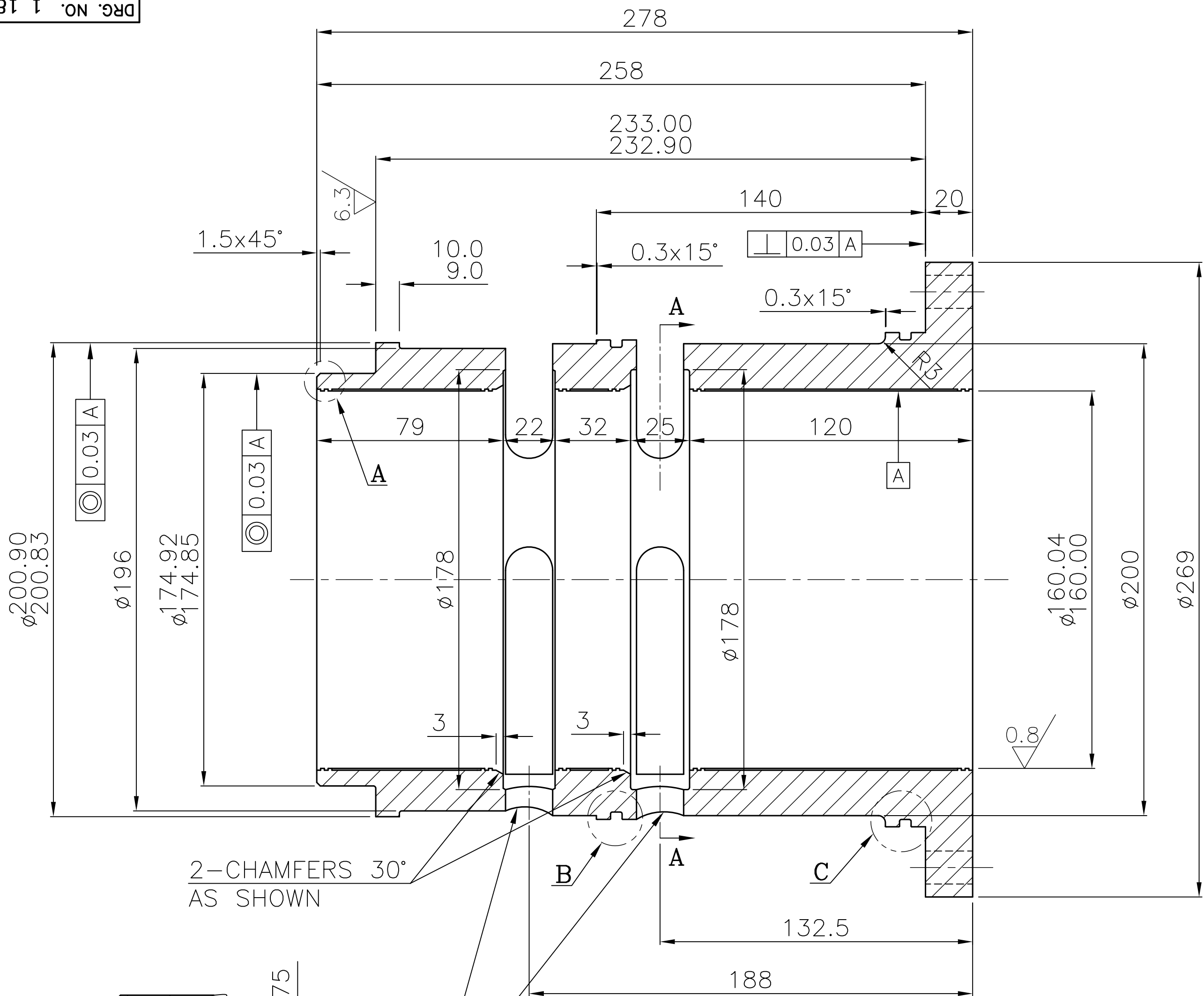
INVENTORY NO
SIGN. AND DATE
REF. DRG. NO.
C-A1-10415
COMPUTER FILE NAME :
11804313314-S00-R04

FIRST ANGLE PROJECTION

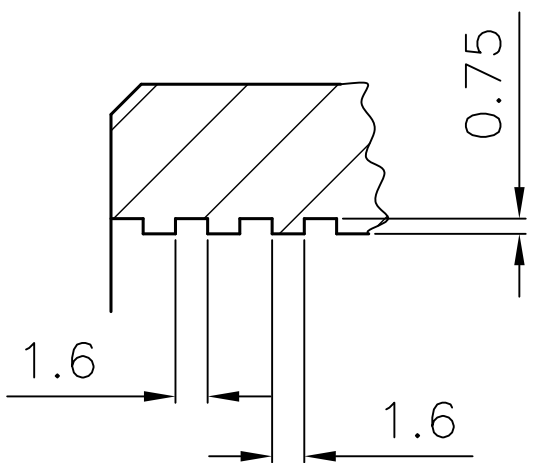
(ALL DIMENSIONS ARE IN mm)

DRG. NO. 1 180 43 1 3314

3.2//0.8//1.6//12.5//



2-CHAMFERS 30°
AS SHOWN

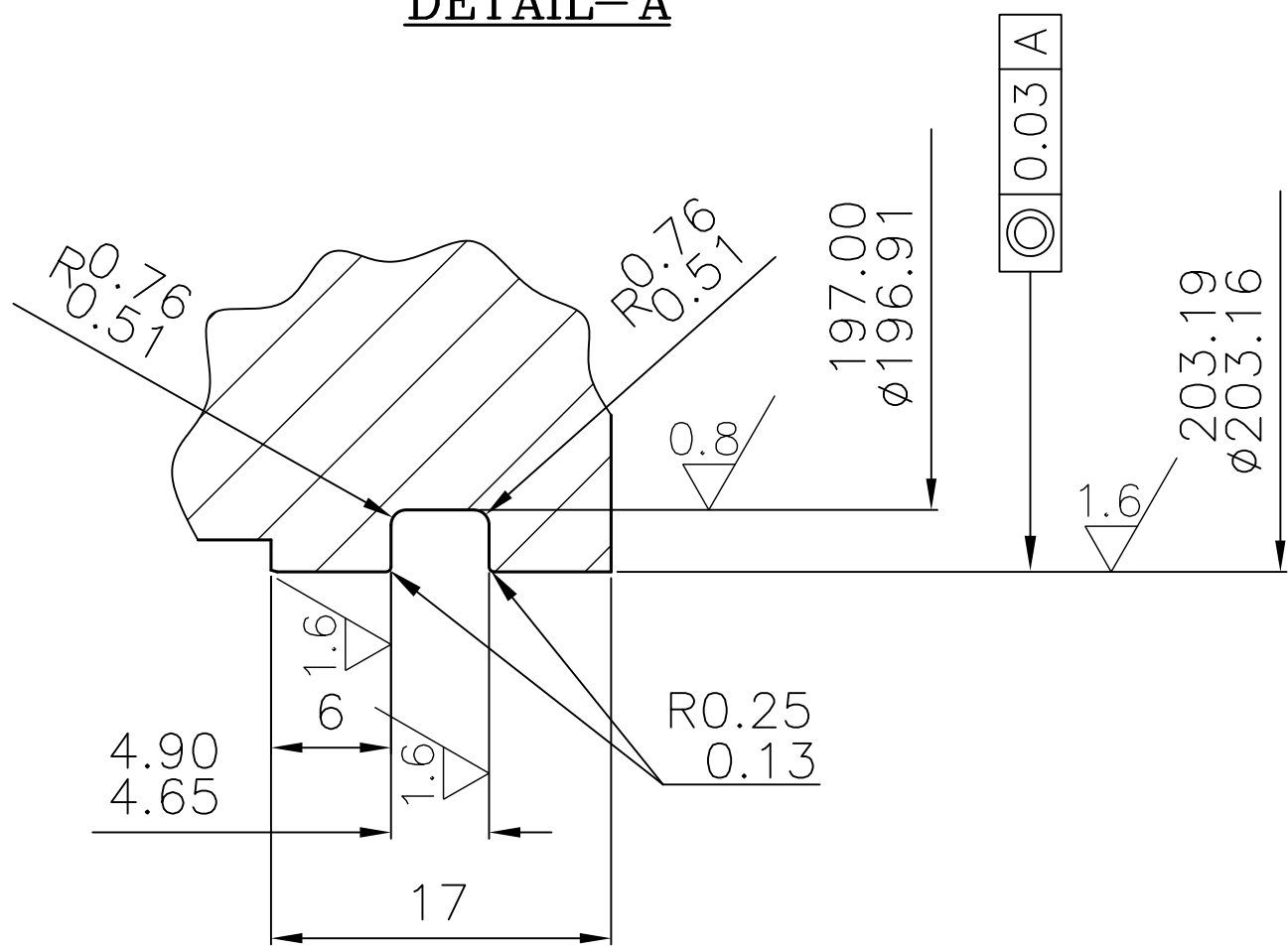


8 SERRATIONS/25mm x 0.75 DEEP

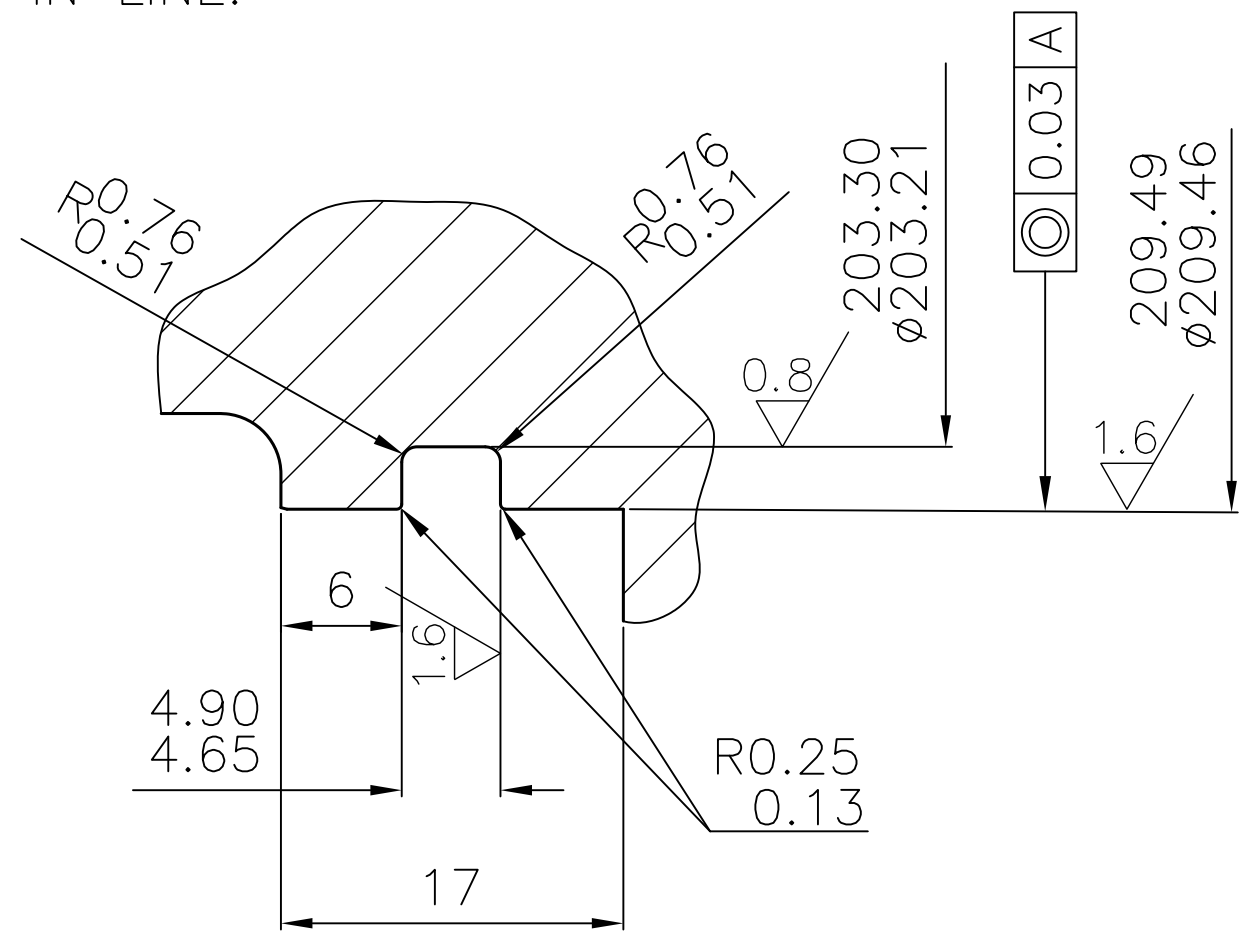
DETAIL-A

4-SLOTS 20mm WIDE EQUI
SPACED AS SHOWN

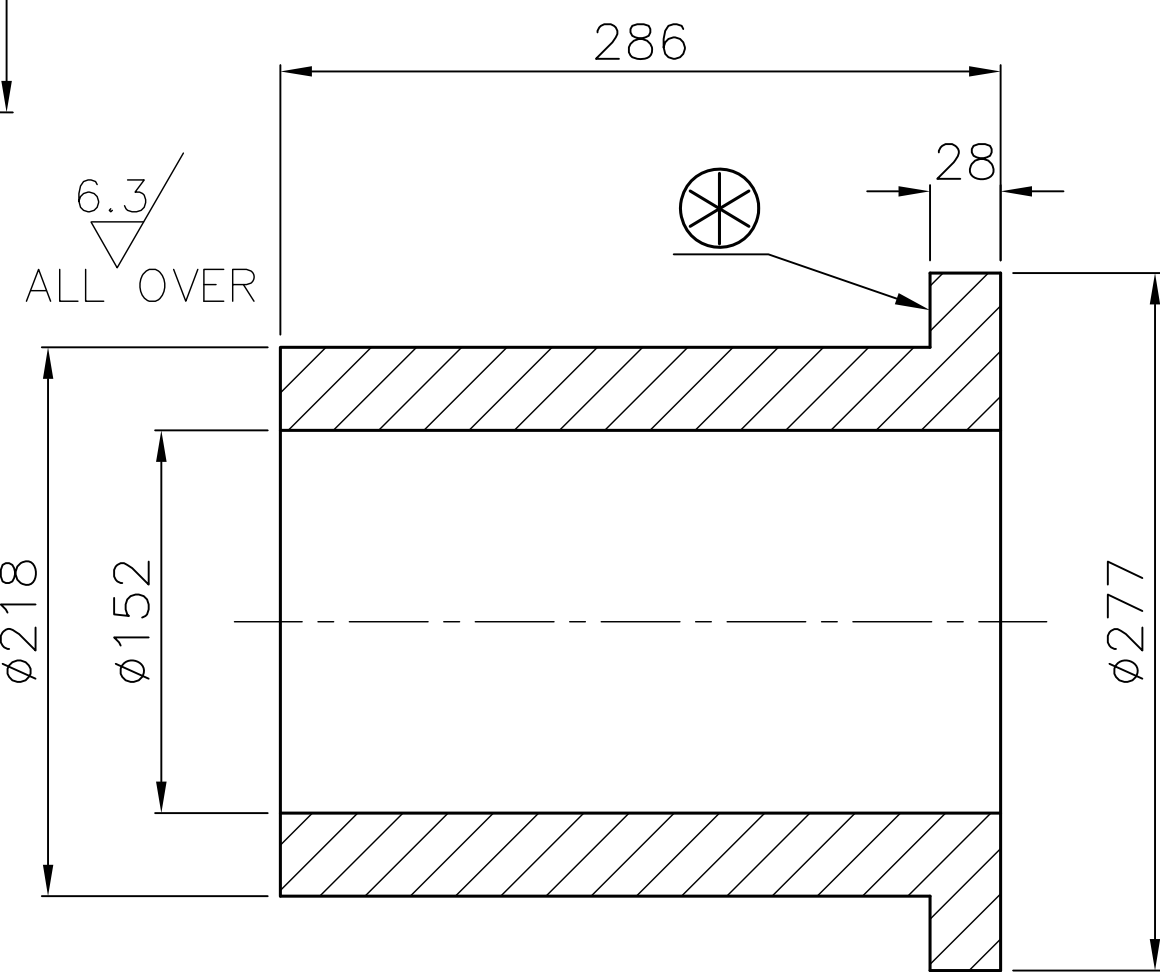
NOTE: BOTH SETS OF SLOTS
TO BE IN LINE.



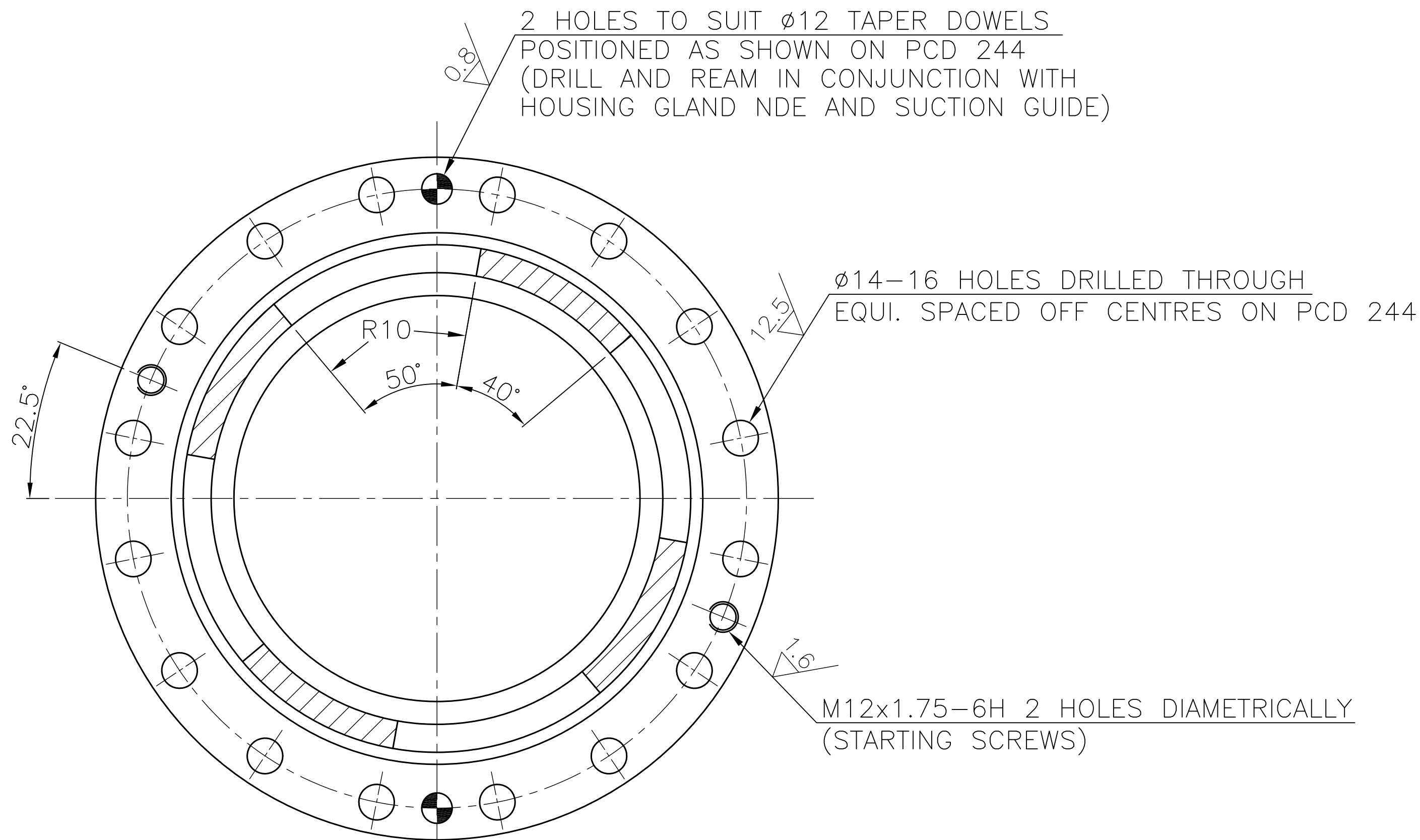
DETAIL-B



DETAIL-C



FORGING DETAIL



SECTION-AA

NOTE TO SUPPLIER:

1. MATERIAL SPECIFICATION AND TECHNICAL DELIVERY CONDITIONS SHALL BE AS PER AA19322.
2. MATERIAL SHALL BE SUPPLIED AS PER THE DIMENSIONS SHOWN IN THE FORGING DETAIL.
3. ULTRASONIC TEST SHALL BE DONE AS PER AA0850118 AND ACCEPTANCE NORM SHALL BE AA0850118, CATEGORY 2.
- ⊗ PLACE FOR HEAT NO./MELT NO.

NOTE TO MACHINE SHOP:

1. FORGINGS ARE SUPPLIED IN ROUGH MACHINED CONDITION AS PER AA19322.
2. FORGINGS SHALL BE HEAT TREATED TO ACHIEVE AN HARDNESS OF 360-405BHN.
3. FOR HEAT TREATMENT DETAILS, PLEASE REFER SPEC. FP50671
4. LPI TO BE DONE ON ALL MACHINED SURFACES AS PER AA0850131 AND ACCEPTANCE AS PER AA0850130.

ITEM NO.	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	MATERIAL CODE	NET WT.	GROSS WT.
					AA19322	25.7	48.1
					MATERIAL SPECN.	QUANTITY	

THE FOLLOWING CONDITIONS APPLY
EXCEPT OTHERWISE STATED
1. REF.TO HY0230261 FOR UN
TOLERANCES.
2. CHAMFER M/CD SHARP ED
1.2 TO 1.0 AT 45°.
3. INTERNAL M/CD CORNER RADI
1 TO 0.7.
4. THE SURFACE ROUGHNESS WHEREVER NOT SHOWN
SHALL BE TAKEN FROM THE SURFACE ROUGHNESS
SHOWN OUT SIDE BACK SLASHES GIVEN AT THE
TOP MOST RIGHT CORNER OF THE DRG.

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT				FK4E36 (CI SEALING)					
 भारत हीवी इलेक्ट्रिकल्स लिमिटेड हय्दराबाद BHARAT HEAVY ELECTRICALS LTD. HYDERABAD				NAME		SIGN.	DATE	NO.OF VAR.	
				DRN.	J.NAGAMANJUR		31.08.17		
				CHD.	M.S.RAM		31.08.17		
				APPD.	M.S.RAM		31.08.17		
DEPT. PUMPS		SCALE		WEIGHT (KG)		REF. TO ASSY DRG.		ITEM NO.	NO.OF ITEMS
CODE 410				NTS		NA		NA	NA
TITLE						DRAWING NO.			REV.
LABYRINTH BUSH						1 180 43 1 3314			04
SHEET NO.						NO OF SHEETS			