

04. CONDITIONS OF THE SUPPLY:

The forging shall be supplied with Charpy V-Notch impact toughness requirement as per IS: 8500 grade 570 B and the carbon equivalent shall also be maintained as per the above specification. All materials before final machining shall be normalized and NDE should be performed as per the requirement.

05. DIMENSIONS AND TOLERANCES:

Dimensions and tolerance shall be met as per the drg and wherever tolerance are not specified: medium class per IS 2102 shall be m

06. INSPECTION AND TESTING:

Test piece of raw material shall be offered for BHEL's verification before proceeding for final machining. Sample size should be per IS; 1608

Forged material should be per machined and normalized one. At this condition only mechanical testing, impact testing, UT as per E 388 and MPI as per E 709 should be carried out in the presence of BHEL representative. After getting clearance from BHEL representative only, final machining shall be carried out.

should not be any warp age in the raw material before final machining.

All machining shall be carried out only in the plano- miller with digital output and controls.

The cumulative errors should be within the limit given in drg.

Parallelism of the slots to be maintained and inspection through go-no-go gage shall be carried out

Slots at random shall be tested with die- penetrant test (20%)

M24 tapped hole at the bottom of the segments to be provided with hele-coil inserts to ensure vibration free joints at assembly at side.