



THIS IS A FINISH MACHINED DRAWING

1. NO HOT TEARS & CRACK INSERTS ARE ACCEPTABLE.
2. ULTRASONIC EXAMINATION SHALL BE CARRIED OUT IN ACCORDANCE WITH BHEL STD HYQC:NDE:037
3. NO VISIBLE DEFECTS OR CRACKS ARE ACCEPTABLE ON PROOF MACHINED

MANDATORY REQUIREMENTS:

** 1. SULPHUR AND PHOSPHORUS CONTENT SHALL NOT BE MORE THAN 0.025%



TECHNICAL REQUIREMENTS:-

1. SURFACE FINISH OF SPOTFACING TO BE $\sqrt{32}$
2. ROUND OFF ALL SHARP CORNERS
3. DIMENSIONS MARKED * THUS TO BE CONCENTRIC
4. ALL PITCH CIRCLES TO BE CONCENTRIC
5. THOROUGHLY CLEAN ALL INNER ROUGH SURFACES & PAINT WITH OIL PROOF PAINT AS PER DRG.NO:3-65--0021
6. THIS IS A FINISH MACHINED DRAWING.
UNLESS OTHERWISE SPECIFIED ALL RADII TO BE 12MM
CAST FILET.
7. CASTING TO BE SUPPLIED IN ROUGH MACHINED CONDITION
IF ORDERED ON MATERIAL CODE: 0E9216406020.
8. CARRY OUT THE MPI TEST AS PER THE BHEL STANDARD
HYGC:NDE:035 AFTER FINAL MACHINING.
9. ATTEST MATERIAL

FULLY MACHINED CODE :- OE9717740038

1 HOUSING CAP				0E9216406020	185.00		
				0E51396	1		
ITEM NO.	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	MATERIAL CODE	NET WT.	GROSS WT.
					MATERIAL SPECN.	QUANTITY	
THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED...				TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		PC 425 SWIVEL	
1. REF. TO HYD0230261 FOR UNUS. TOLERANCES.				  भारत भारी औद्योगिक मशीन लिमिटेड भारत भारी औद्योगिक मशीन लिमिटेड SHARAT HEAVY ELECTRICALS LTD. HYDERABAD		DRN. NAME DATE PCC/BSRC 06.07.04 CHD. S.C.JHA 08.07.04 APPD. M.R.K. 12.07.04	
2. CHAMFER M/CD SHARP EDGES 1 TO 1.0 AT 45°.						OF NO. 02 OF NO. 02	
3. INTERNAL M/CD CORNER RADIUS 1 TO 0.7.				DEPT. OFF. ENGG. SCALE WEIGHT (KG) CODE 4430 NTS 185.00		REF. TO ASSY DRG. ITEM NO. OF TMS. 0-96660-3-0056 8 INV.	
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.				TITLE HOUSING CAP		DRAWING NO. 0-96660-3-0058 08 SHEET NO. 01 OF NO. OF SHEETS 01	