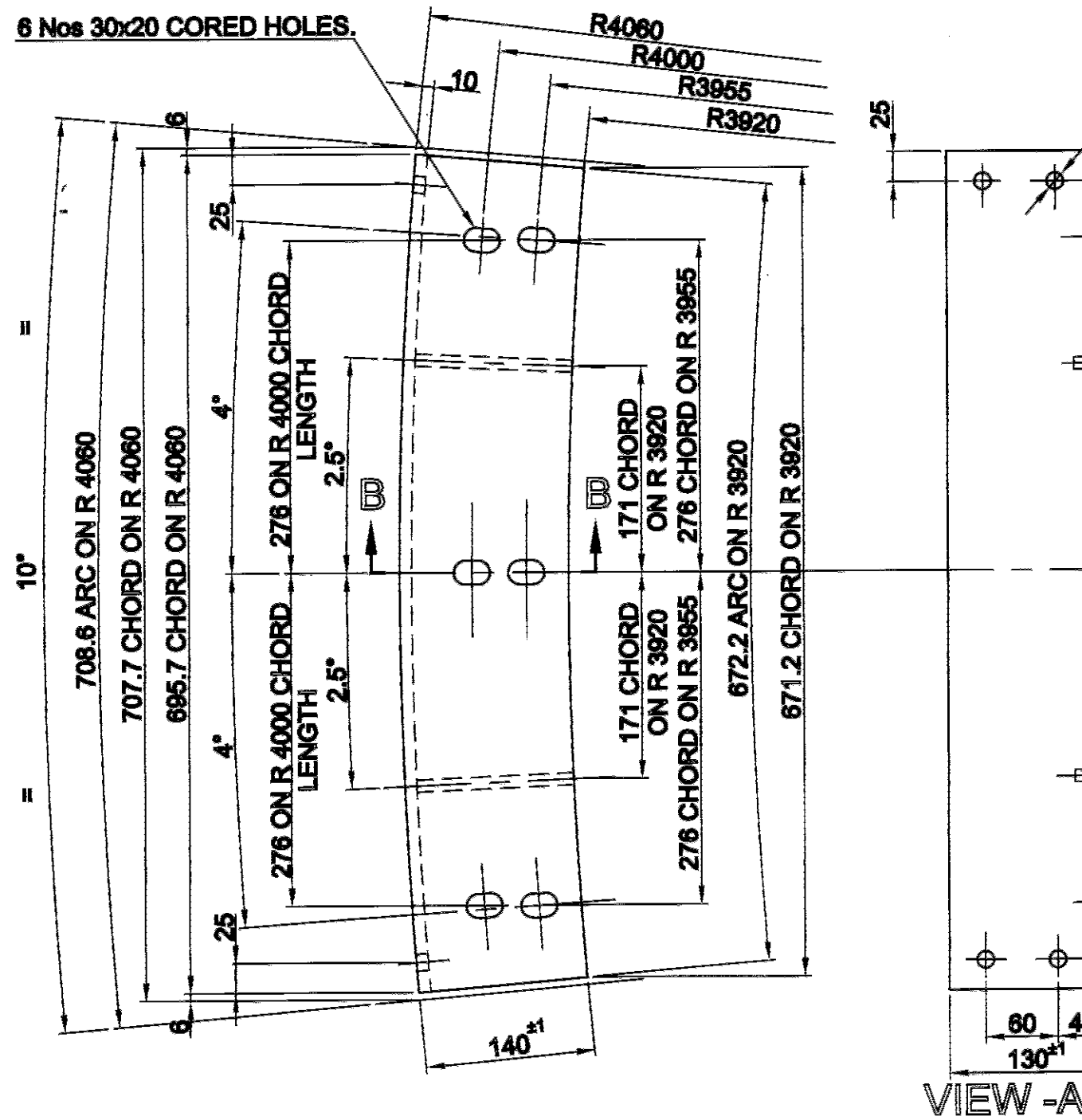
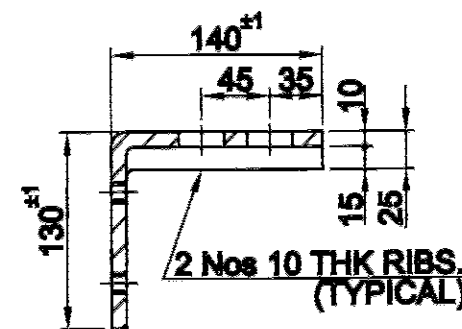


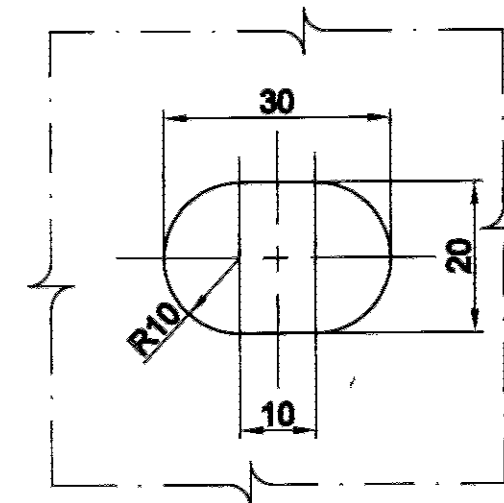
ALL DIMENSIONS ARE IN MILLIMETERS



4 Nos Ø14 CORED HOLES(TYPICAL)



SECTION-BB



ENLARGED DETAILS OF CORED HOLES (TYPICAL)

ALL CORNERS TO BE 3 mm. RADIUS UNLESS STATED OTHERWISE.

MATERIAL: HEAT RESISTANT CAST IRON Gr I TYPE E OF IS:3355
CHEMICAL COMPOSITION C=3.5% MIN, S=0.15%MAX,P=0.4MAX.
Cr=1.21-1.40% CARBON EQUIVALENT 3.8 TO 4.4

NOTE: PERMISSIBLE DEVIATIONS ON UNTOLERANCED DIMENSIONS SHOULD BE AS PER IS:5519 CLASS 2.

REV	DATE	ALTERED :	REV	DATE	ALTERED :
02	15.03.96	CHECKED :	01	24.01.96	CHECKED :
		APPROVED			APPROVED
ZONE	CORED HOLES 30x20 ON 4000 RADIUS ADDED AT 3 PLACES.		ZONE	CHEMICAL COMPOSITION C 3.5%MIN WAS C 3.81-4.40%. CARBON EQUIVALENT 3.8 TO 4.4 AND NOTE ADDED.	

ITEM NO	DESCRIPTION	DRAWING NO			MATL CODE		UNIT WT		
					MATL SPEC		QTY		
EQPT: ROTARY HEARTH FURNACE									
		Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014			DRN	NAME B.ASHOKKUMAR	SIGNATURE 	DATE 04.05.02	
					CHD	SSN.KUMAR		30.5.02	
					APPD	S.SHANMUGASUNDARAM		30.05.2002	
DEPT	GRADE OF TOL. DIM C/M/F			SCALE 1:5 (1:1)	WEIGHT(kg) 14.15	REF TO ASSY DWG NO			ITEM N
CODE						REF TO OLD DWG NO 355134 3/3 (TYPE IV)			
TITLE DIPPER PLATE CASTING (INNER FIXED)					CARD CODE U 01	DRAWING NO : 3-7-1101-13-02602			REV 02