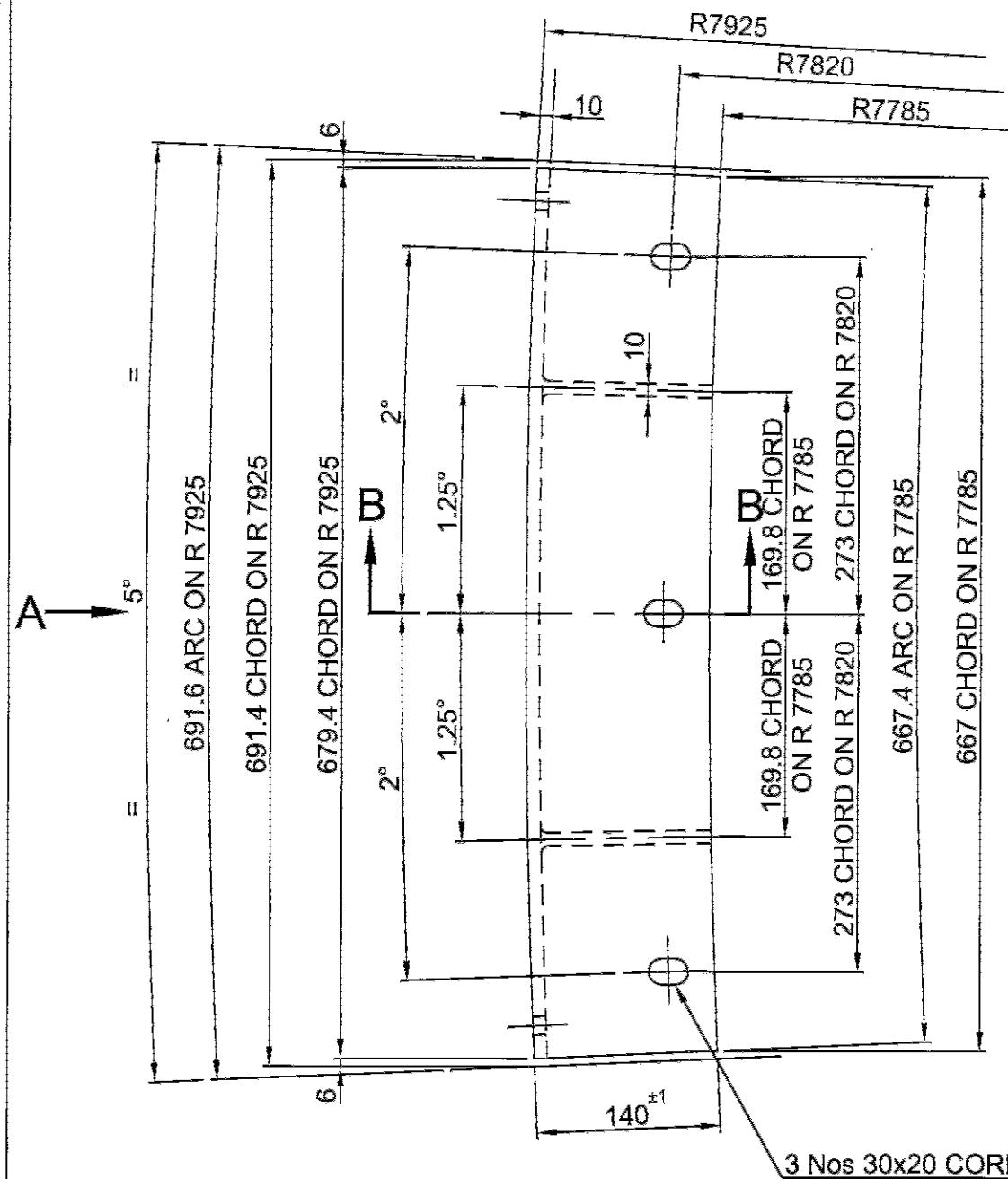
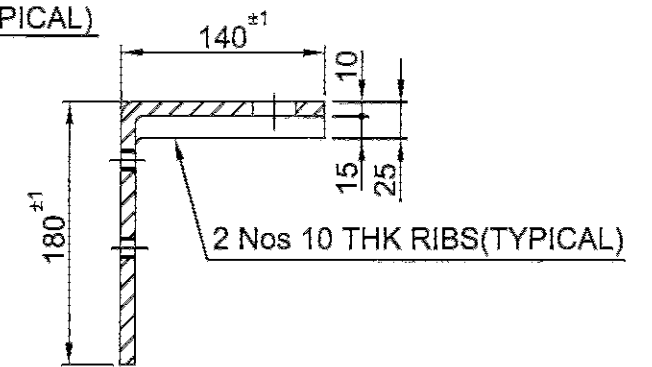
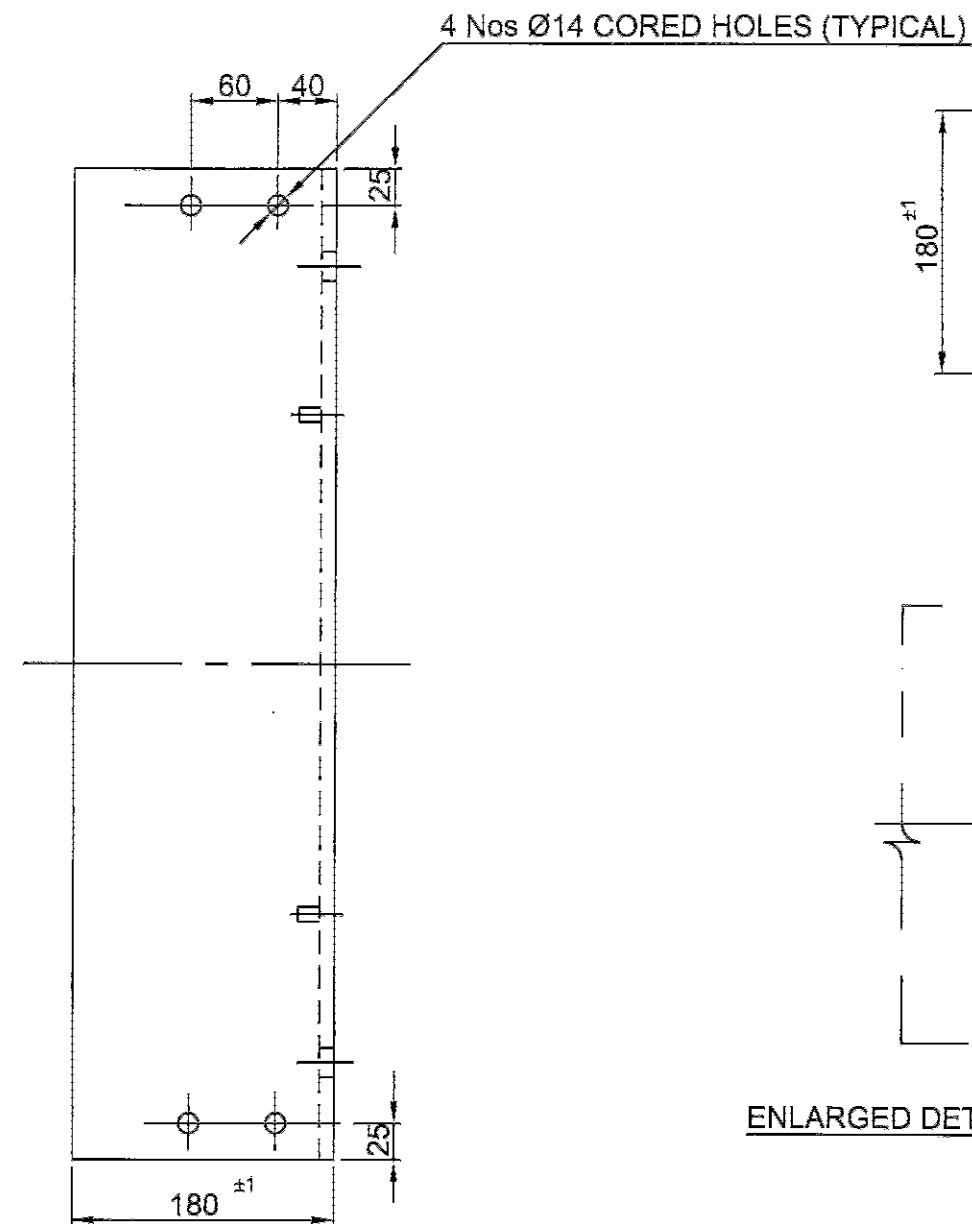


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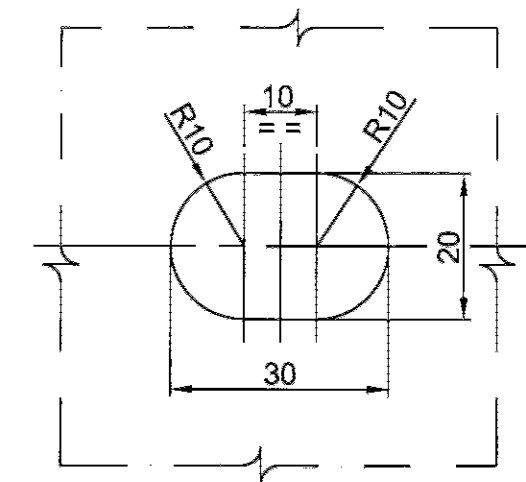
ALL DIMENSIONS ARE IN MILLIMETERS



3 Nos 30x20 CORED HOLES. VIEW-A



SECTION-BB



ENLARGED DETAILS OF CORED HOLES (TYPICAL)

FOR ORIGINAL DESIGN REFER DRG.No.1-7-1101-13-00212 TYPE V OUTER MOVABLE

MATERIAL: HEAT RESISTANT CAST IRON Gr I TYPE E OF IS:3355  
CHEMICAL COMPOSITION C=3.5% MIN, S=0.15% MAX, P=0.4 MAX.  
Cr1.21-1.40% CARBON EQUIVALENT 3.8 TO 4.4

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

| REV | DATE     | ALTERED : |
|-----|----------|-----------|
| 03  |          | APPROVED  |
| 02  | 05.02.09 | APPROVED  |

DIMN. 180 WAS 230

| REV | DATE     | ALTERED :             |
|-----|----------|-----------------------|
| 01  | 25.01.98 | CHECKED :<br>APPROVED |
| 02  |          |                       |

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<br>SEAMLESS STEEL TUBE PLANT<br>TIRUCHIRAPALLI - 620014 |                                 | DRN                   | NAME<br>B.ASHOKKUMAR | SIGNATURE                         |
|                                                                                      |                                 | CHD                   | SSN.KUMAR            | DATE<br>03.05.02                  |
|                                                                                      |                                 | APPD                  | S.SHANMUGASUNDARAM   |                                   |
| DEPT                                                                                 | GRADE OF<br>UNTOL. DIM<br>C/M/F | SCALE<br>1:5<br>(1:1) | WEIGHT(kg)<br>13     | REF TO ASSY DWG NO                |
| CODE                                                                                 |                                 |                       |                      | REF TO OLD DWG NO                 |
| TITLE<br>DIPPER PLATE CASTING<br>(OUTER MOVABLE TYPE V)                              |                                 |                       | CARD<br>CODE<br>U 01 | DRAWING NO :<br>3-7-1101-13-02458 |
|                                                                                      |                                 |                       |                      | REV<br>02                         |