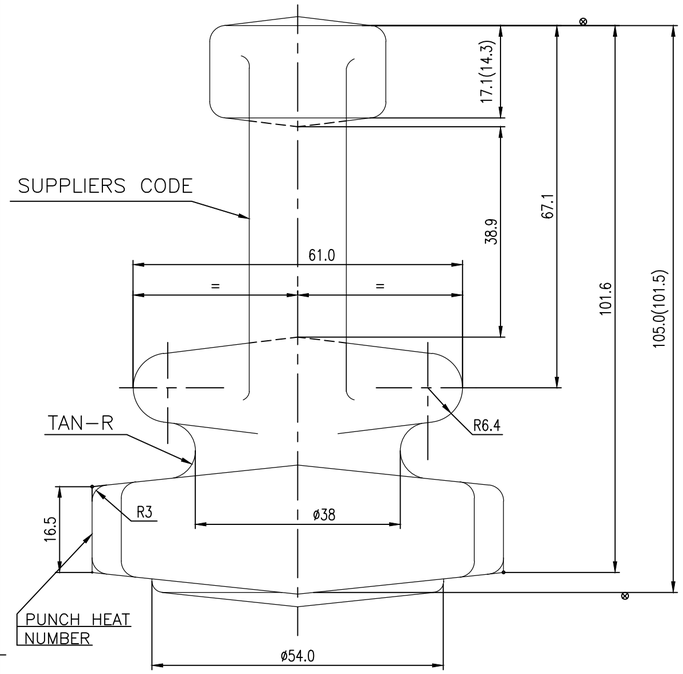
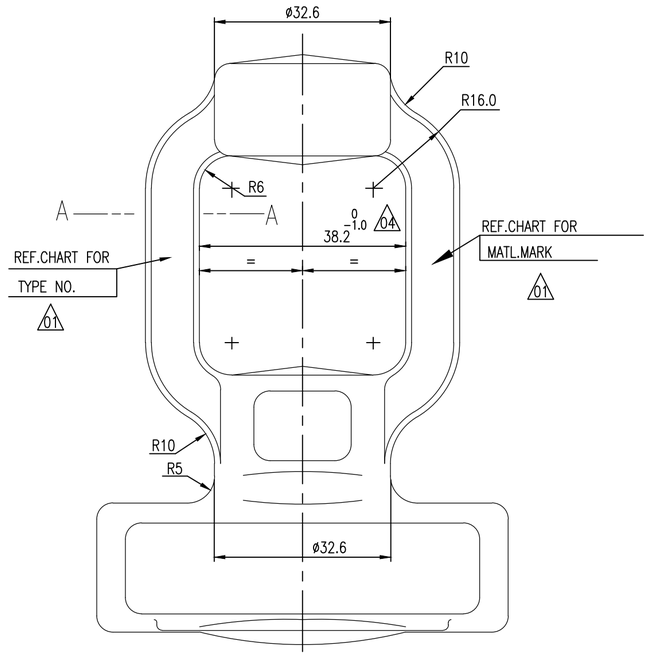
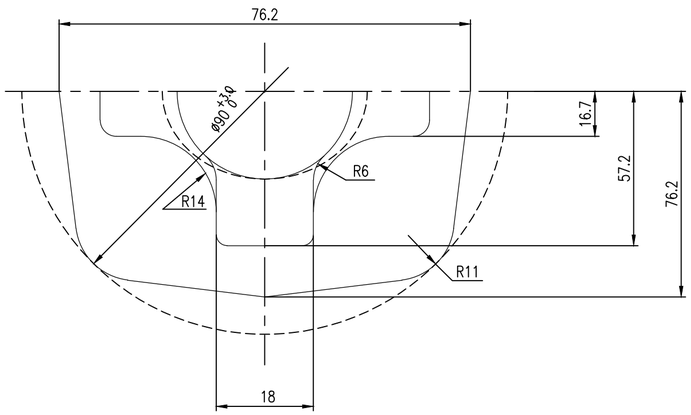
DRAWING NO. 2-V-0000-02508F

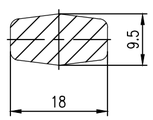
ALL DIMENSIONS ARE IN MILLIMETRES. FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP / QP







SECTION-AA



NOTES:

FORGING TOLERANCES

1. LENGTH AND HEIGHT TOLERANCES +1.7 −0.8
   THICKNESS TOLERANCES +1.5 −0.7
2. MISMATCH : 0.7
3. RESIDUAL FLASH : 0.8
4. DRAFT : 7°

FILLET AND EDGE RADII	mm	TOL.	
	0–10	+50	−25
	10–32	+40	−20
	32–100	+32	−15

5. UNLESS OTHERWISE STATED TOLERANCES SHALL CONFORM TO BS-4114 NORMAL
6. UNSPECIFIED FORGING RADII R 2.5
7. FORGING SHALL COMPLY WITH THE REQUIREMENTS OF APPLICABLE TDC.
8. DIMENSIONS IN THE DRAWING EXCLUDE FORGING DRAFT
9. MACHINING ALLOWANCES ARE INCLUDED ON ALL MACHINABLE SURFACES MARKED ⊗
10. FINISH MACHINED DIMENSIONS ARE INDICATED WITHIN BRACKETS FOR INFORMATION
11. FORGING ARE TO BE SAND BLASTED OR SHOT BLASTED AND HEAT TREATED AS SPECIFIED
12. THE MATERIAL SPECIFICATION, TYPE NUMBER, SUPPLIERS CODE SHALL BE IN RAISED LETTERS.
13. SIZE OF FORGING LETTERS 5mm
14. FOR LF 2 MATL,HARDNESS SHOULD NOT BE MORE THAN 22 HRC.
15. # MARKED ITEMS IGC TEST SHALL BE CONDUCTED.

SL No.	PROCESS	DRAWING No	MATL CODE	MATL SPECN	HEAT TREATMENT	MATL MARK	TYPE No
#09	DIE FORGING	2.V.U782.02508F/00	92502139	ASTM-A182 F316 CERTIFY	SOLUTION ANNEALED	F316	U782
08	DIE FORGING	2.V.HL80.02508F/00	92502074	ASTM-A182 F51 CERTIFY	SOLUTION ANNEALED	F51	HL80
07	DIE FORGING	2.V.HL72.02508F/00	92502058	ASTM-A182 F91 CERTIFY	NORMALISED & TEMPERED	F91	HL72
06	DIE FORGING	2.V.HL69.02508F/00	92502053	ASTM-A182 F304L CERTIFY	SOLUTION ANNEALED	F304L	HL69
05	DIE FORGING	2.V.5920.02508F/05	92008456	ASTM-A182 F316 L CERTIFY	SOLUTION ANNEALED	F316L	5920
04	DIE FORGING	2.V.5292.02508F/05	92008432	ASTM-A350 LF2 CERTIFY	N & T	LF2	5292
03	DIE FORGING	2.V.5970.02508F/05	92008394	ASTM-A182 F304 CERTIFY	SOLUTION ANNEALED	F-304	5970
02	DIE FORGING	2.V.5934.02508F/05	92008388	ASTM-A182 F316 CERTIFY	SOLUTION ANNEALED	F-316	5934
01	DIE FORGING	2.V.5904.02508F/05	92008302	ASTM-A105 CERTIFY	NORMALISED	A-105	5904

REV	DATE	ALTERED	
09	11.10.18	MADHURAM / CHD &APPD	MADHURAM & KRS
08	15.11.16	KRP / CHD & APPD	KRP & KRS
07	15.07.16	DRS / CHD & APPD	DRS & KRS
06	18.06.16	DRS / CHD & APPD	DRS & KRS
05	29.1.97	CHD & APPD	
04	28.1.86	CHD & APPD	
03	31.8.85	CHD & APPD	
02	7.1.85	CHD & APPD	
01	19.6.83	CHD & APPD	

REV	Description
09	Sl.no.09 included. Note no.15 included
08	Sl.no.08 included.
07	Sl.no.07 included.
06	Sl.no.06 included.
05	QUALITY REFERANCES REMOVED. (DCN:FS 0572)
04	DIMENSION 38.2 0 -1.0 WAS 38.2
03	F 316L MATL. INCLUDED.
02	A350-LF2 MATL. INCLUDED.
01	F-316 AND F-304 MATL.INTRODUCED. DRG.No. 2-V-0000-02508F WAS 2-V-5904-02508F.

ZONE

CAUTION: The information on this document is the property of BHARAT HEAVY ELECTRICALS LTD. It must not be used directly or indirectly in any way detrimental to the interest of the company.

TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT

BHARAT HEAVY ELECTRICALS LTD.,
UNIT: HIGH PRESSURE BOILER PLANT.
TIRUCHIRAPALLI-620014.
365-120

	NAME	SIGN	DATE	NO.OF VAR.
DRN	RCS		25.4.80	
CHD	P.BOOMINATHAN		25.4.80	
APPD	K.S.RAMAN		25.4.80	

DEPT	CODE	SCALE	WEIGHT (KG).	REFERENCE INFORMATIONS	NO. OF ITEMS
VL	320	NTS	1.35	YOKE B 955FE02A/EH472(036)	

TITLE	CARD CODE	DRAWING NO.	REV
YOKE 1"-C800	U 01	2-V-0000-02508F	09

Size A2