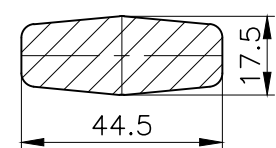
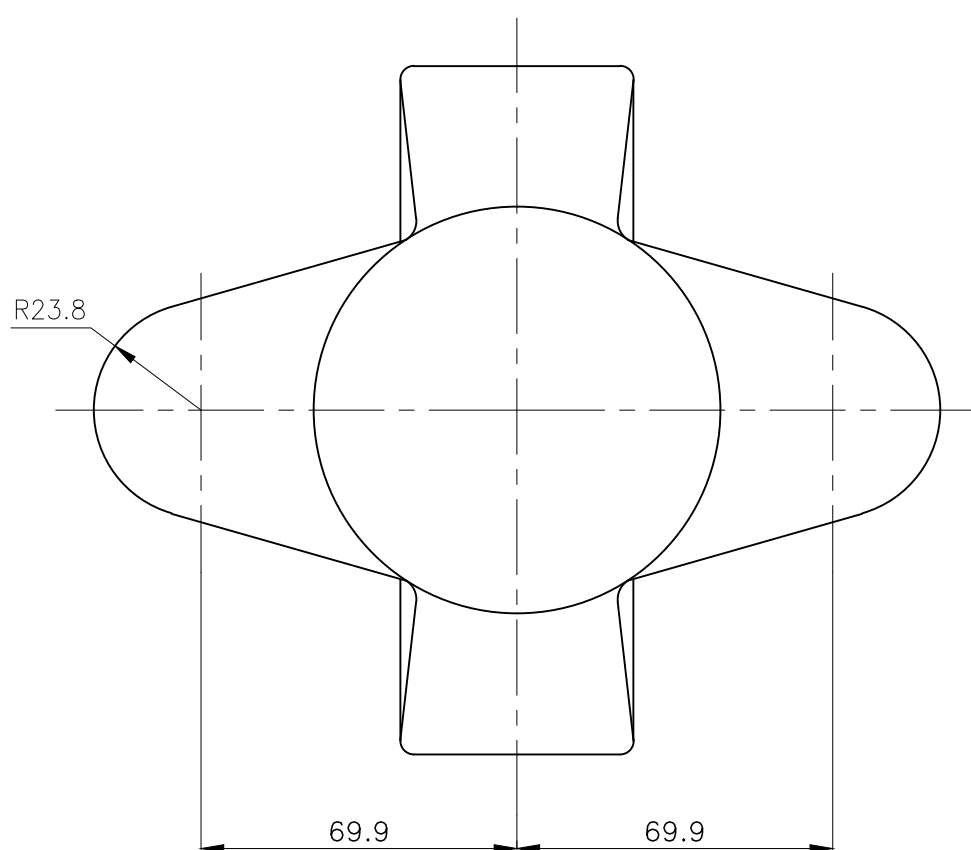
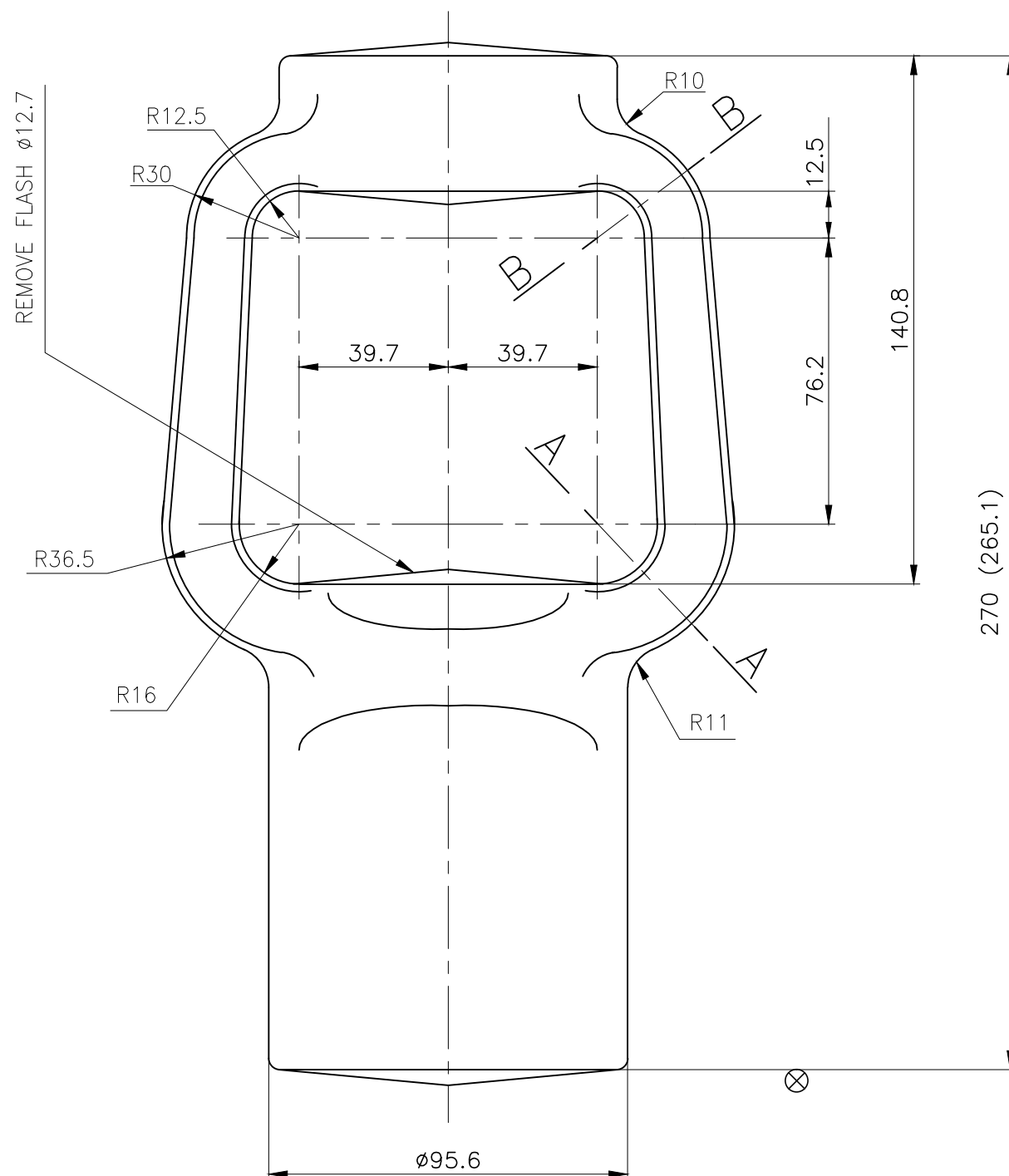
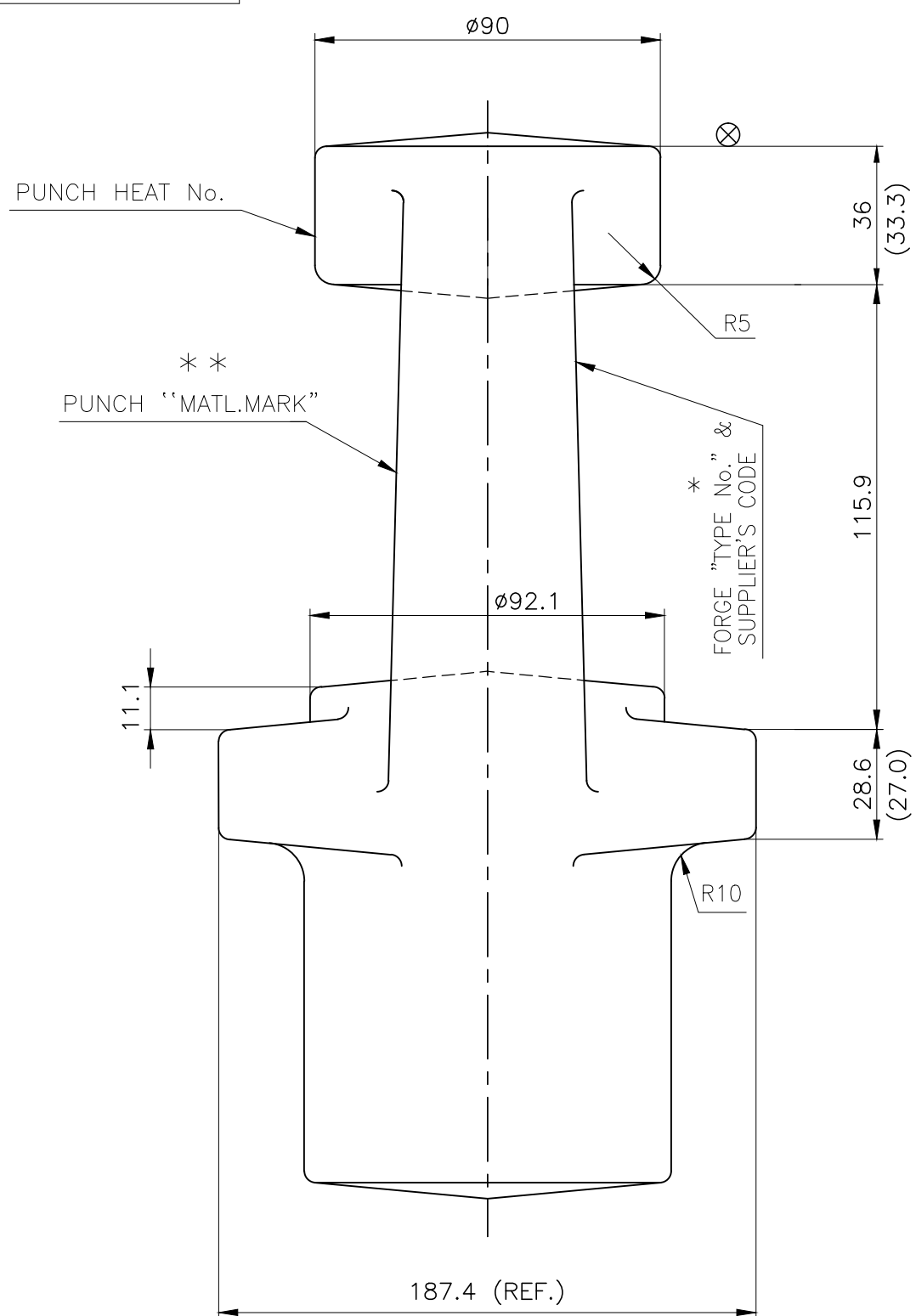


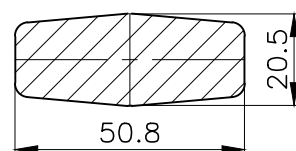
2-V-0000-02800F

DRAWING NO.

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



SECTION-BB



SECTION-AA

REV 04	DATE 02.07.15	ALTERED DRS CHD & APPD DRS & KRS		REV 03	DATE 08.03.10	ALTERED S.V.NATHAN CHD & APPD M.RAJAKUMAR		REV 02	DATE 15.02.01	ALTERED M.SRINIVASAN CHD & APPD P.BOOMINATHAN		REV 01	DATE 20.11.96	ALTERED R.MOHAN CHD & APPD K.S.RAMAN.	
	SL.No. 04 INCLUDED				SL.No. 02&03 INCLUDED			DCN: FS0673	MATERIAL A182 F22 CL.3 WAS A182-F22			DCN: FS0543	ZONE	1.BOTTOM DIMENSION, ø95.6 WAS ø92.1 2.NOTES UPDATED	

F92	D001	04	FORGING	92 203 388	ASTM A182 F92 CERTIFY	NORMALISED &TEMPERED	—	12.0		2.V.D001.02800F/00 92 203 388 0000	—
F316	HB07	03	FORGING	92 201 990	ASTM A182 F316 CERTIFY	SOLUTION ANNEALED	—	12.0	—	2.V.HB07.02800F/00 92 201 990 0000	—
F91	H967	02	FORGING	92 201 969	ASTM A182 F91 CERTIFY	NORMALISED &TEMPERED	—	12.0	—	2.V.H967.02800F/00 92 201 969 0000	—
F22	5209	01	FORGING	92 008 376	ASTM A182 Gr. F22 CL.3 CERTIFY	NORMALISED &TEMPERED	—	12.0	—	2.V.5209.02800F/02 92 008 376 0000	—
MATL.MARK * *	TYPE No. *	S.L No.	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No COMPONENT CODE	ITEM No

NOTES:

1. FORGING TOLERANCES:-
- | | |
|--------------------------------|------|
| LENGTH AND HEIGHT TOLERANCES : | +2.7 |
| | -1.3 |
| THICKNESS TOLERANCES: | +2.4 |
| | -1.2 |
- FILLET AND EDGE RADII: mm. TOL. %
- | | |
|--------|--------|
| 0-10 | +50-25 |
| 10-32 | +40-20 |
| 32-100 | +32-15 |
2. MISMATCH : 1.2
3. RESIDUAL FLASH : 1.4
4. DRAFT : 7° (MAX.)
5. UNSPECIFIED FORGING RADII ARE R3
6. FORGING SHALL COMPLY WITH THE REQUIREMENTS OF LATEST APPLICABLE QUALITY PROCEDURE.
7. DIMENSIONS IN THE DRAWING EXCLUDE FORGING DRAFT.
8. MACHINING ALLOWANCES ARE INCLUDED ON ALL MACHINABLE SURFACES MARKED ⊗
9. FINISH MACHINED DIMENSIONS ARE INDICATED WITHIN BRACKET FOR INFORMATION.
10. FORGINGS ARE TO BE SAND BLASTED OR SHOT BLASTED HEAT TREATED AS SPECIFIED.
11. THE MATERIAL SPECIFICATION, TYPE No., SUPPLIER'S CODE SHALL BE IN FORGED RAISED LETTERS (5 mm. HEIGHT)
12. THIS DRAWING IS DIMENTIONALLY IDENTICAL TO DRAWING No. 2-V-5204-02799F/01

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.

DRN	NAME STEPHEN	SIGN	DATE 02.07.15	NO.OF VAR.
CHD	DEEPAKRAJ		02.07.15	
APPD	K.RAJASEKARAN		02.07.15	

DEPT	VL			SCALE	WEIGHT (KG).	REFERENCE INFORMATION		NO. OF ITEMS
CODE	320			NTS	12.0			
TITLE					CARD CODE	DRAWING NO.		REV
YOKE 2"-2500					U 01	2-V-0000-02800F		04