

DRAWING NO. 2-V-0000-05524F

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

NOTES:

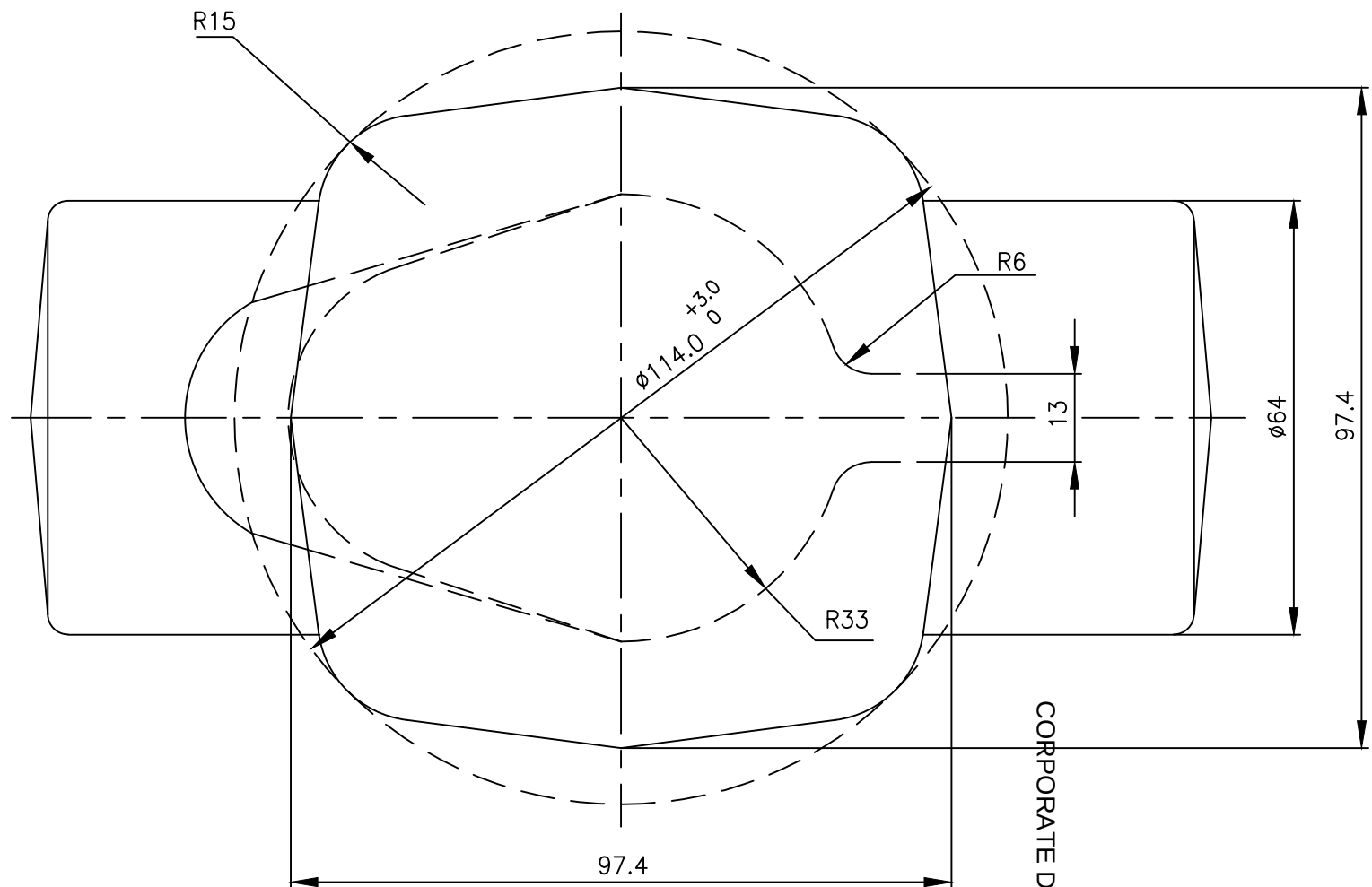
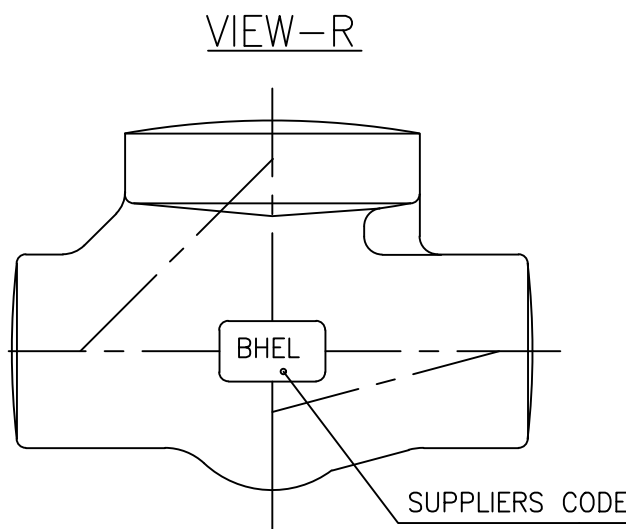
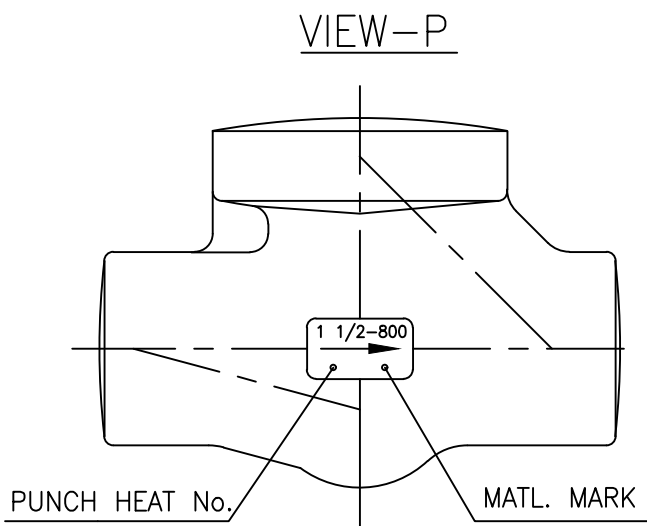
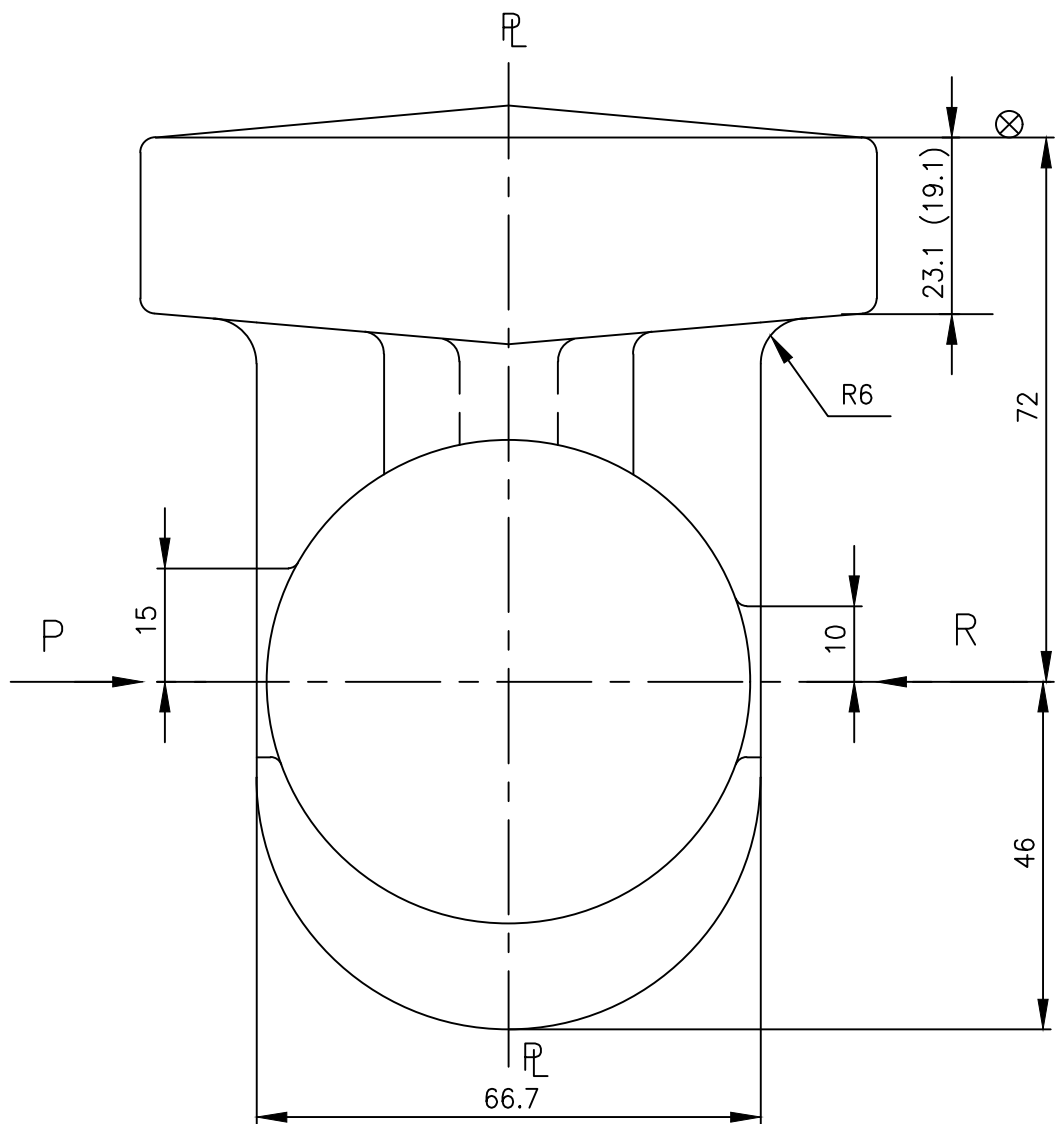
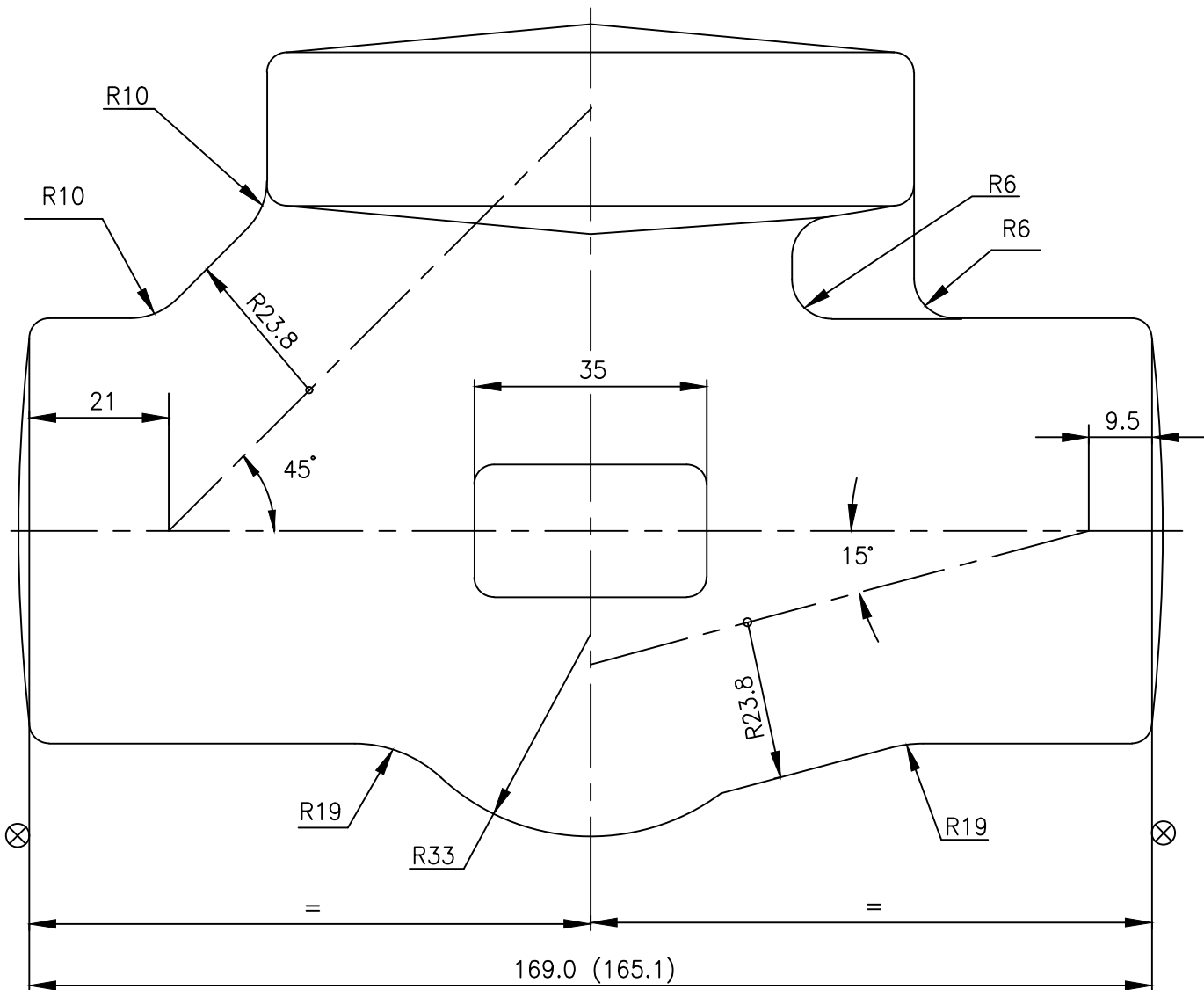
- ## 01. FORGING TOLERANCES

LENGTH AND HEIGHT TOLERANCE $\left[\begin{array}{c} + 2.1 \\ - 1.1 \end{array} \right]$
THICKNESS TOLERANCE $\left[\begin{array}{c} + 1.7 \\ - 0.8 \end{array} \right]$

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

02. MISMATCH : 1.0
03. RESIDUAL FLASH : 1.2
04. DRAFT : 7°
05. UNLESS OTHERWISE STATED TOLERANCES SHALL CONFORM
TO BS : 4114 NORMAL
06. UNSPECIFIED FORGING RADII R 3
07. FORGING SHALL COMPLY WITH THE REQUIREMENTS OF
APPLICABLE TDC.
08. DIMENSIONS IN THE DRAFTING EXCLUDE FORGING DRAFT
09. MACHINING ALLOWANCES ARE INCLUDED ON ALL MACHINABLE
SURFACES MARKED ⊕
10. FINISH MACHINED DIMENSIONS ARE INDICATED WITHIN BRACKETS
FOR INFORMATION
11. FORINGS ARE TO BE SAND BLASTED OR SHOT BLASTED AND
HEAT TREATED AS SPECIFIED
12. THE IDENTIFICATION MARKS AND SPECIFICATION NUMBERS
SHALL BE IN RAISED LETTERS
13. SIZE OF FORGING LETTERS : 5 mm
14. HEIGHT OF PADS - 2 mm
15. # MARKED ITEMS IGC TEST SHELL BE CONDUCTED.

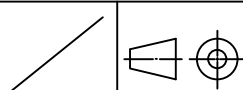
THIS DRAWING IS DIMENSIONALLY IDENTICAL TO DRAWING NO.
2-V-5944-02689F (TABULATED DRAWING) WHICH WAS APPROVED
BY CIB.
THIS DRAWING IS MADE AS INDIVIDUAL DRAWING BASED ON THE
DIRECTION GIVEN BY CIB.



CORPORATE DRG ID: TP-DG-2-V-0000-05524F/0

REV	DATE	ALTERED	S.MADHURAM
02	20.10.18	CHD & APPD	MRP & KRS
ZONE	Sl.No. 03 included. Note No. 15 included.		

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.

#03.	DIE FORGING	92502163	SA A182 F316-ATTEST	SOLUTION ANNEALED	46	5.70	-	2.V.U779.05524F	001
02.	DIE FORGING	92502057	SA A182 F304L-ATTEST	SOLUTION ANNEALED	46	5.70	-	2.V.HL71.05524F	001
01.	DIE FORGING	92024723	SA A182 F316-ATTEST	SOLUTION ANNEALED	46	5.70	-	2.V.5944.05524F	001
SL No.	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT									
 BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI-620014. 365-120				DRN	NAME R.MOHAN	SIGN	DATE 07.08.92	NO.OF VAR.	
				CHD	N.P.ESWARAN		05.09.92		
				APPD	N.NAGARAJAN		14.09.92		
DEPT V L		SCALE	WEIGHT (KG).	REFERENCE INFORMATIONS				NO. OF ITEMS	
CODE 320		NTS	5.70						
TITLE				CARD CODE	DRAWING NO.				REV
BODY				U 01	2-V-0000-05524F				02