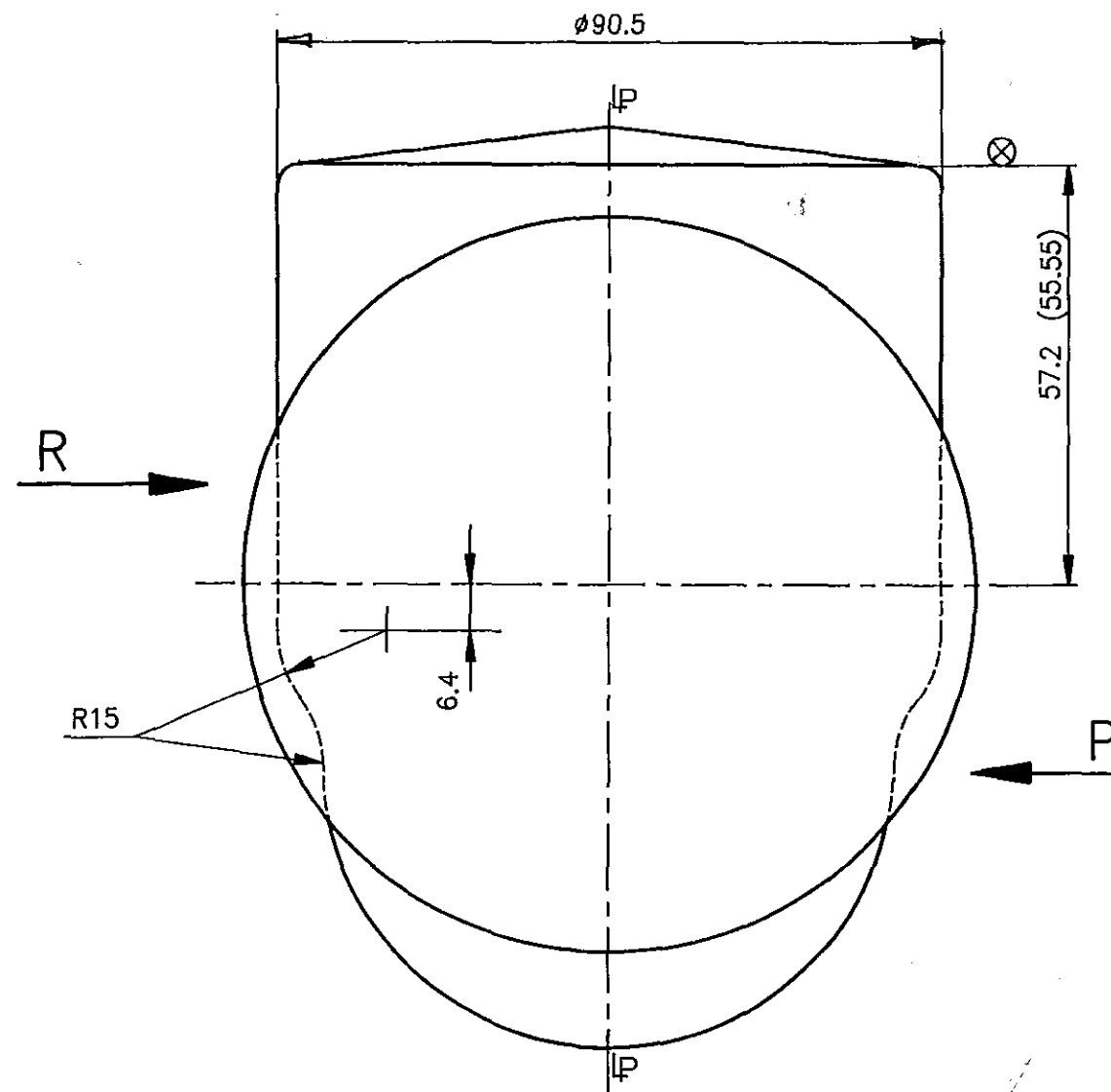
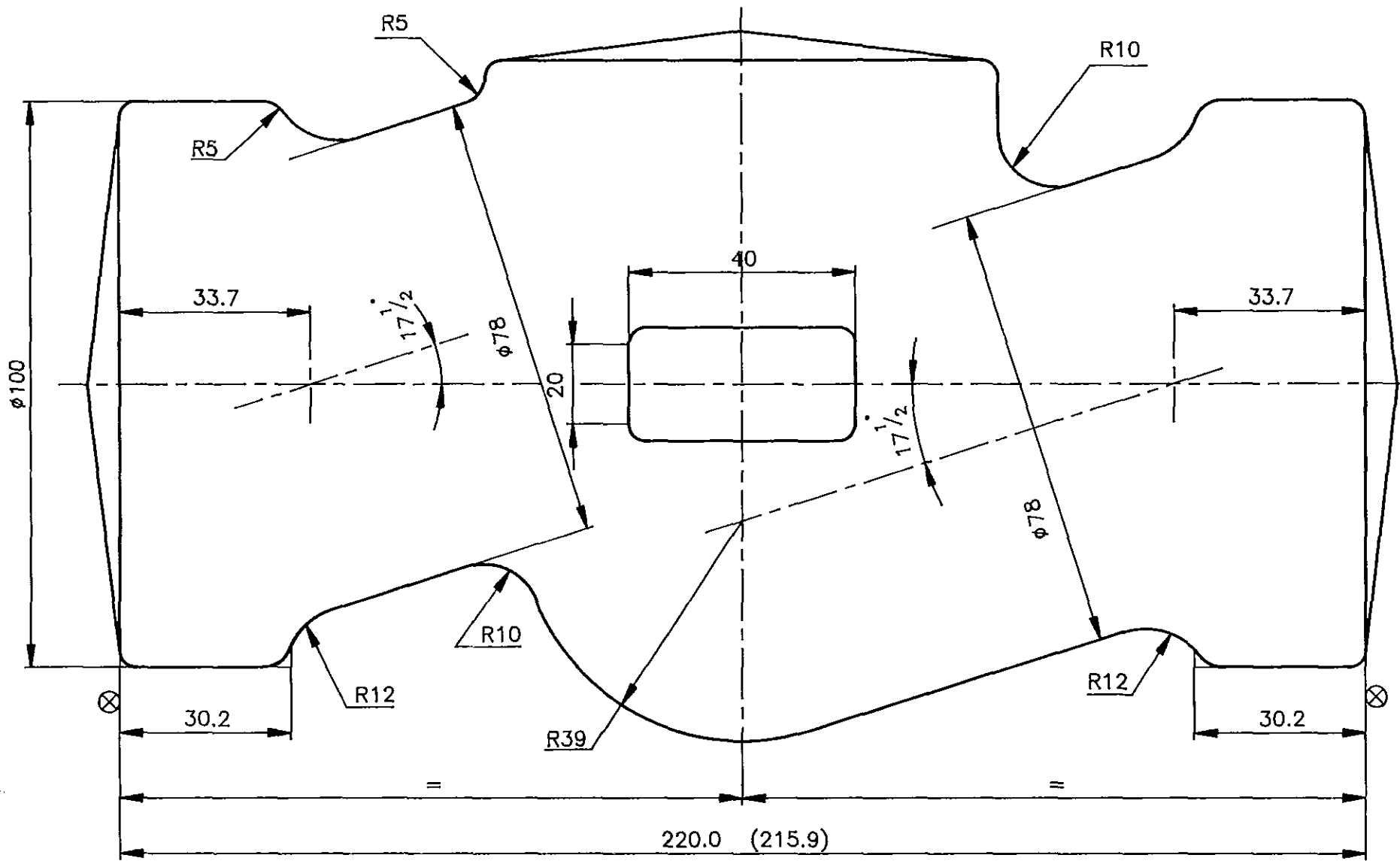


DRAWING NO.
2-V-5204-02678F

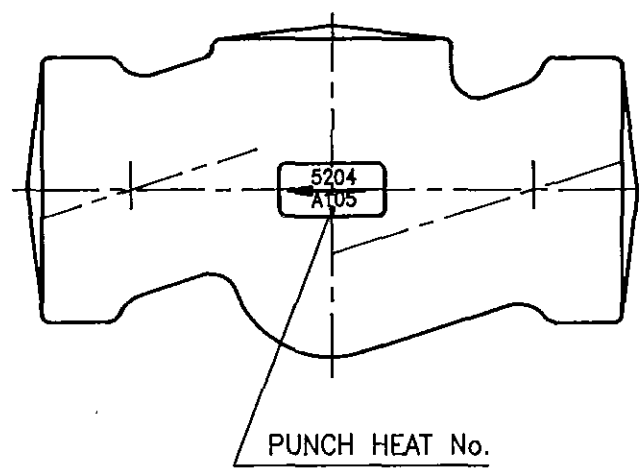
ALL DIMENSIONS ARE IN MILLIMETRES

NOTES:

- FORGING TOLERANCES
LENGTH AND HEIGHT TOLERANCE : $\begin{bmatrix} +2.1 \\ -1.1 \end{bmatrix}$ mm TOL. %
THICKNESS TOLERANCE : $\begin{bmatrix} +1.7 \\ -0.8 \end{bmatrix}$ mm TOL. %
FILLET AND EDGE RADI $\begin{bmatrix} 0-10 & +50-25 \\ 10-32 & +40-20 \\ 32-100 & +32-15 \end{bmatrix}$
- MISMATCH : 1.0
- RESIDUAL FLASH : 1.2
- DRAFT : 7
- UNSPECIFIED FORGING RADII R 2.5
- FORGING SHALL COMPLY WITH THE REQUIREMENTS OF APPLICABLE TDC.
- DIMENSIONS IN THE DRAWING EXCLUDE FORGING DRAFT
- MACHINING ALLOWANCES ARE INCLUDED ON ALL MACHINABLE SURFACES MARKED $\oplus$
- FINISH MACHINED DIMENSIONS ARE INDICATED WITHIN BRACKETS FOR INFORMATION
- FORINGS ARE TO BE SAND BLASTED OR SHOT BLASTED AND HEAT TREATED AS SPECIFIED
- THE IDENTIFICATION MARKS AND SPECIFICATION NUMBERS SHALL BE IN RAISED LETTERS
- SIZE OF FORGING LETTERS : 5 mm
- HEIGHT OF PADS - 2 mm

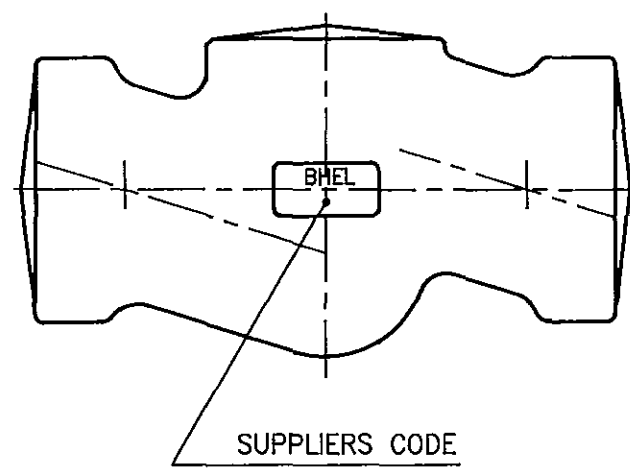


VIEW - P



PUNCH HEAT No.

VIEW - R



SUPPLIERS CODE

TOLERANCE FOR UNTOLERANCED DIMENSIONS	
UPTO 6 MM	± 0.1 MM
> 6 UPTO 120 MM	± 0.2 MM
MORE THAN 120 MM	± 0.5 MM
ANGULAR TOLERANCE	± 0.5 Deg.
CHAMFER	± 5 Deg.

REV	DATE	ALTERED
ZONE		CHECKED

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.

FORGING	92 024 551	ASTM A105 ATTEST	NORMALISED	-	6.88	-	-	-	-
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.									
DEPT	VL	GRADE OF UNTOL DIM	SCALE	WEIGHT (KG)	REFERENCE INFORMATION				
CODE	320	6-M-F	NTS	6.88	DRESSER DRG. : B-747FA 01A/EK446 (023) CAD: F202678F				
TITLE					CARD CODE	DRAWING NO.			
BODY					U 01	2-V-5204-02678F			
						REV			
						01			

RETRACED WITH REV.01 ON 29.01.95