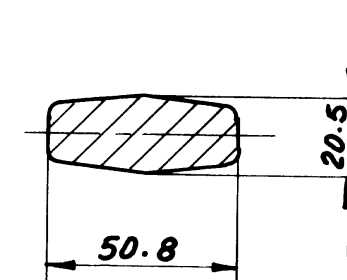
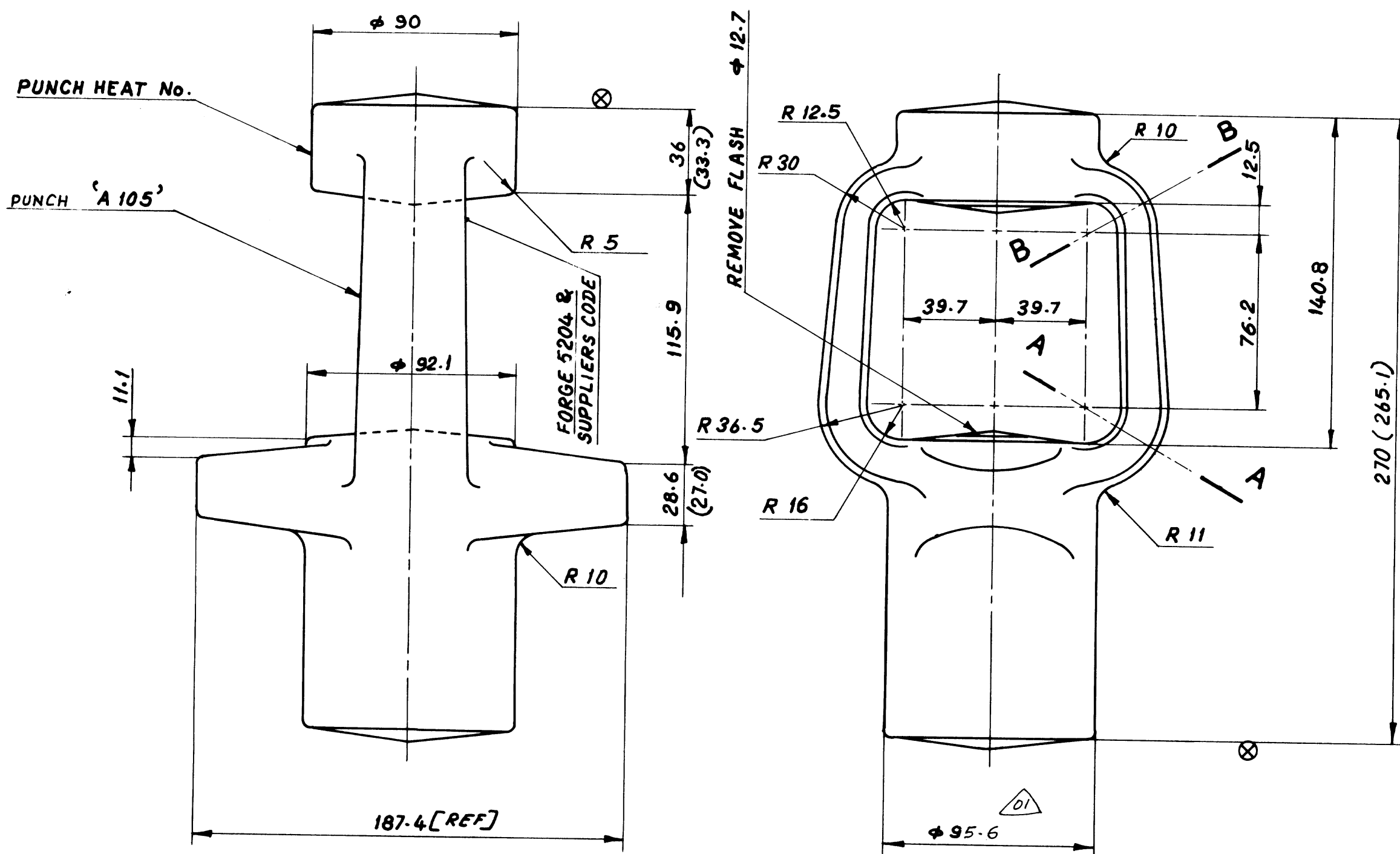


FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT ACP/SP
FIRST ANGLE PROJECTION (ALL DIMENSIONS IN MILLIMETRES)

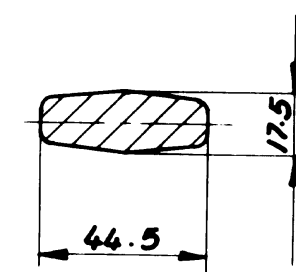
2-V-5204-02799F

DRAWING NO.

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.



SECTION-AA



SECTION-BB

NOTES:-

- FORGING TOLERANCES.**
- | | mm. | TOL % |
|---|--------|---------|
| 1. LENGTH AND HEIGHT }
TOLERANCE }
THICKNESS TOLERANCE } | 0-10 | +50 -25 |
| | 10-32 | +40 -20 |
| | 32-100 | +32 -15 |
| 2. MISMATCH | 1.2 | |
| 3. RESIDUAL FLASH | 1.4 | |
| 4. DRAFT | 7° | |
| 5. UNLESS OTHERWISE STATED TOLERANCES SHALL CONFORM TO BS: 4114 NORMAL. | | |
| 6. UNSPECIFIED FORGING RADII R 3 | | |
| 7. FORGING SHALL COMPLY WITH THE REQUIREMENTS OF LATEST APPLICABLE QUALITY PROCEDURE. | | |
| 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 BRACKET FOR INFORMATION. | | |
| 11. FORGINGS ARE TO BE SAND BLASTED OR SHOT BLASTED AND HEAT TREATED AS SPECIFIED. | | |
| 12. THE MATERIAL SPECIFICATION, TYPE No., SUPPLIERS CODE SHALL BE IN FORGED RAISED LETTERS. | | |
| 13. SIZE OF FORGING LETTERS 5 mm. | | |

SPECIAL NOTE:-

1. ALTERNATE TO CASTING DRG. No. 2-V-5204-02676 R/01

No. OFF	DESCRIPTION	CODE No.	ASTMA 105 CERTIFY	NORMALISED	12.0				
			FINAL MATL	HEAT TREATMENT	SCRAP SORT	NET WT. [kg]	GROSS WT. [kg]	DRG. No.	ITEM No.
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT									
00545 035									
Bharat Heavy Electricals Ltd., BOILER PLANT UNIT TIRUCHIRAPALLI-620 014		DRN	NAME	SIGN	DATE	NO. OF VAR			
		CHD	V.G. KRISHNAN		10.8.81				
		APPD							
REV 01	DATE 20.11.96	ALTERED: R. Mohan	CHECKED & APPD: V. G. KRISHNAN	DEPT	GRADE OF UNTOL. DIM C/M/F	SCALE 1:2	WEIGHT (kg) 12.00	REF TO ASBY (OLD DRG) Yoke 8-767 PA 02-C6030 (441)	ITEM NO.
TITLE Yoke 2"-2500 U 01 2-V-5204-02799F 01									