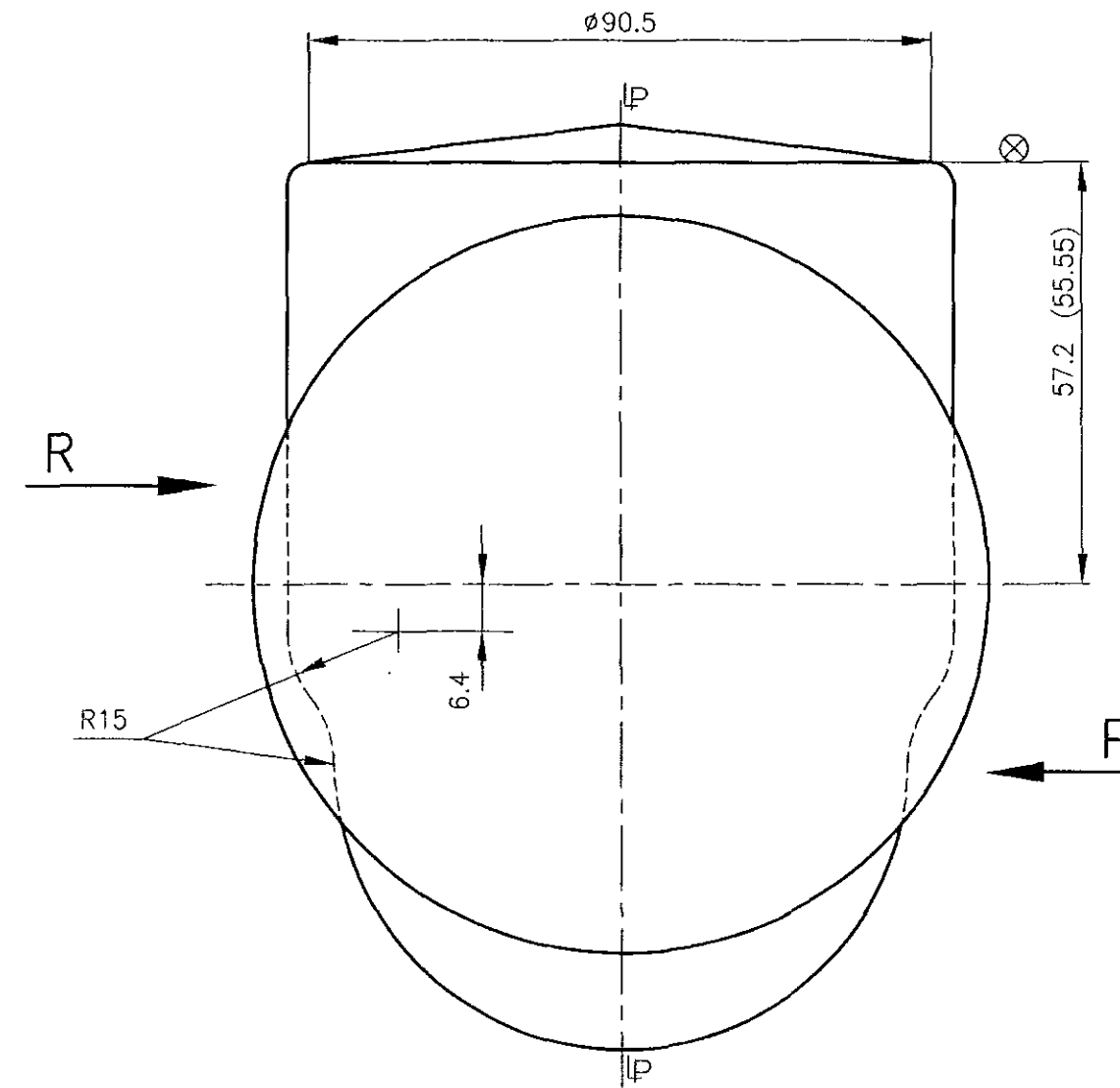
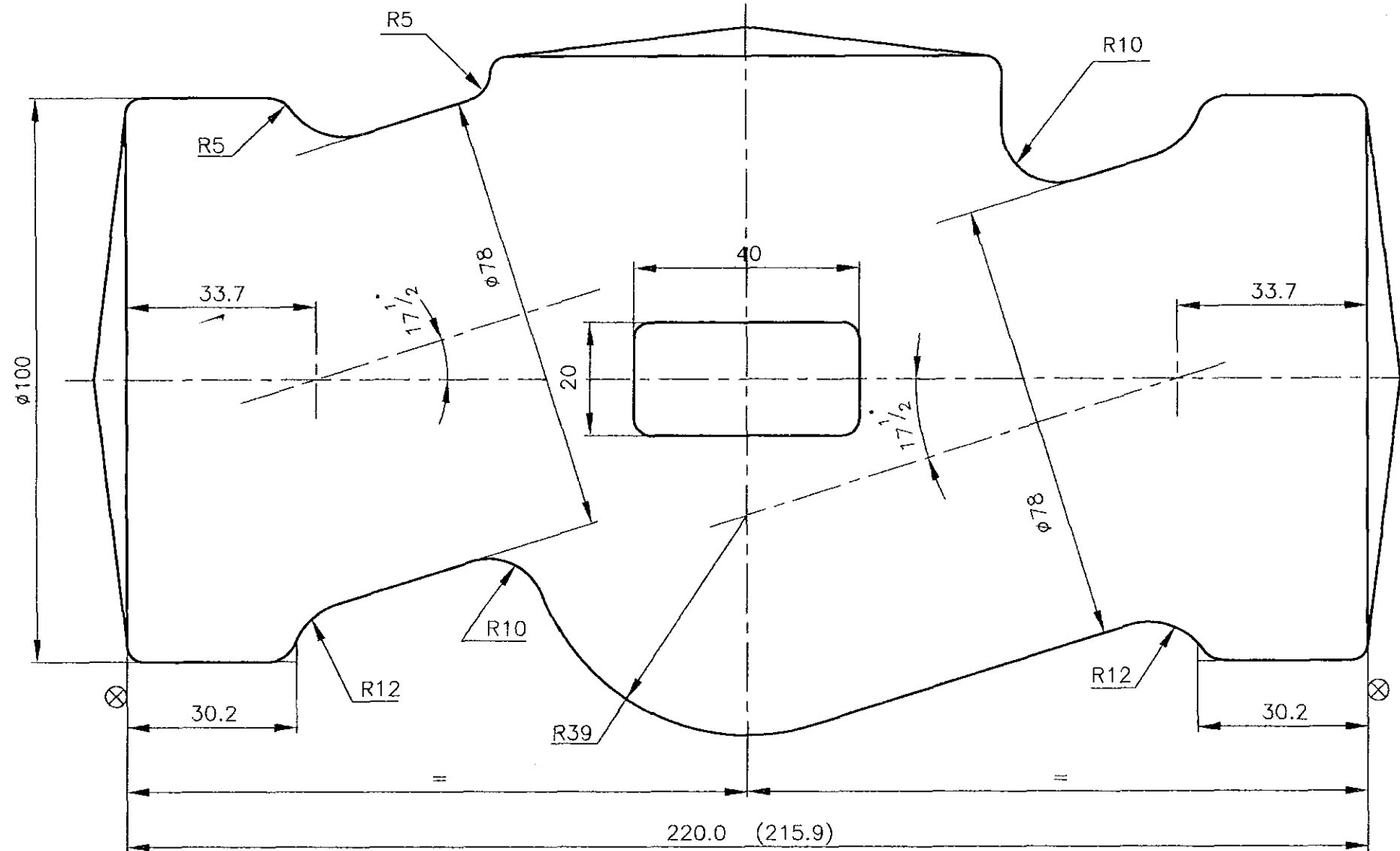


DRAWING NO.
2-V-5209-02679F

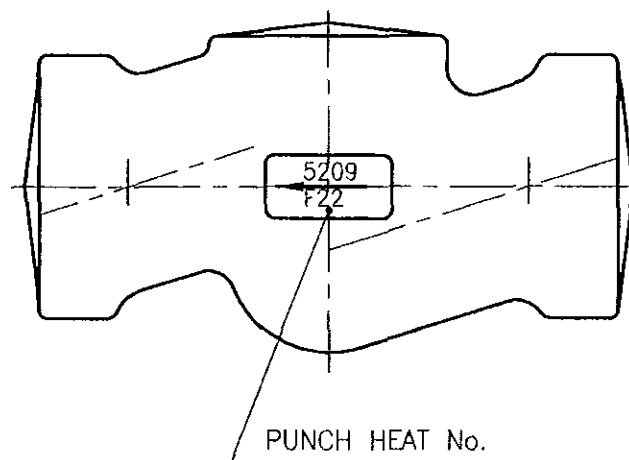
ALL DIMENSIONS ARE IN MILLIMETRES. FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP / QP

NOTES:

- FORGING TOLERANCES
LENGTH AND HEIGHT TOLERANCE : $\begin{bmatrix} +2.1 \\ -1.1 \end{bmatrix}$
THICKNESS TOLERANCE : $\begin{bmatrix} +1.7 \\ -0.8 \end{bmatrix}$
FILLET AND EDGE RADII : $\begin{bmatrix} 0-10 & +50-25 \\ 10-32 & +40-20 \\ 32-100 & +32-15 \end{bmatrix}$ mm TOL. %
- 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 $\otimes$
- 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

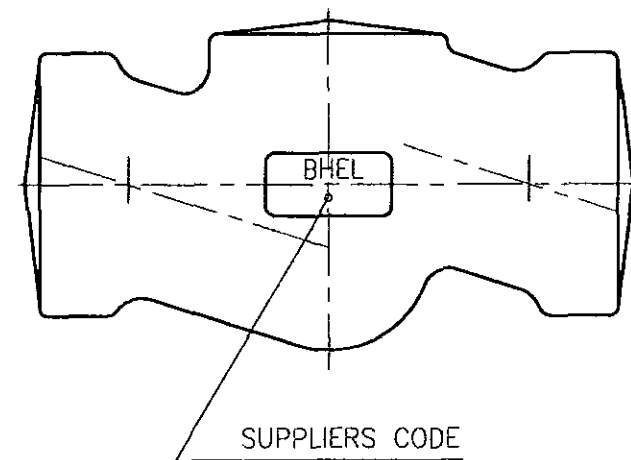


VIEW - P



PUNCH HEAT No.

VIEW - R



SUPPLIERS CODE

REV	DATE	ALTERED
01	17.11.2K	CHD & APPD
MATERIAL A182 F22 CL.3 WAS A182 F22		

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.

RETRACED WITH REV:01 ON 16.11.2K									
FORGING	92 024 546	ASTM A182 F22 CL.3 ATTEST	NORMALISED & TEMPERED	-	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.				DRN	NAME	SIGN	DATE	NO. OF VAR.	
365-120				CHD	P. BOOMINATHAN		16.11.2K		
				APPD	K.S. RAMAN		16.11.2K		
DEPT	V L	SCALE	WEIGHT (KG)	REFERENCE INFORMATION				NO. OF ITEMS	
CODE	320	NTS	6.88	CAD: F202679F					
TITLE					CARD CODE	DRAWING NO.	REV		
BODY					U 01	2-V-5209-02679F	01		