

01. FORGING TOLERANCES

LENGTH & HEIGHT TOLERANCE : +1.9
-0.9

THICK TOLERANCE : $+1.7$
 -0.8

FILLET & EDGE RADII :	<u>mm</u>	<u>TOLERANCE %</u>	
0 to 10		+50	-25
10 to 32		+40	-20
32 to 100		+30	-15

02. FORGING DRAFT : 7°
03. MISMATCH : 1mm
04. RESIDUAL FLASH : 1.2mm

05. UNSPECIFIED FORGING RADII . . . : R1.6
06. FORGING SHALL COMPLY WITH THE REQUIREMENTS OF *APPLICABLE TDC.*
07. DIMENSIONS IN THE DRAWING EXCLUDE FORGING DRAFT
08. MACHINING ALLOWANCES ARE INCLUDED ON ALL
MACHINABLE SURFACES MARKED ⊗

09. FORGINGS ARE TO BE SAND BLASTED OR SHOT BLASTED AND
HEAT TREATED AS SPECIFIED

10. HEIGHT OF FORGING LETTERS 5 mm

* 11. THE IDENTIFICATION MARKS AND SPECIFICATION NUMBERS SHALL BE IN RAISED LETTERS.

[illegible]

	BHARAT HEAVY ELECTRICALS LTD., BOILER PLANT UNIT, TIRUCHIRAPPALLI-620 014.	NAME	M. SRINIVASAN	SUFF	M. Srinivasan	DATE	
		DRAWN		CHECKED	N. PARAMESWARAN		
		APPROVED	N. NAGARAJAN			24.7.9	

REV	DATE	ALTERED	DEPT	GRADE OF UNTOL DIM	FIRST ANGLE	SCALE	WEIGHT (kg)	COMP CODE / REF	ITEM #
		CHECKED	VL CODE	C/W/P		NTS	13.3	B-7207FF01/EF528 (2-86)	
ZONE			320						
TITLE						DRG No.		REV SI	
BODY						2-V-5610-02568F			

ALL DIMENSIONS ARE IN INCHES