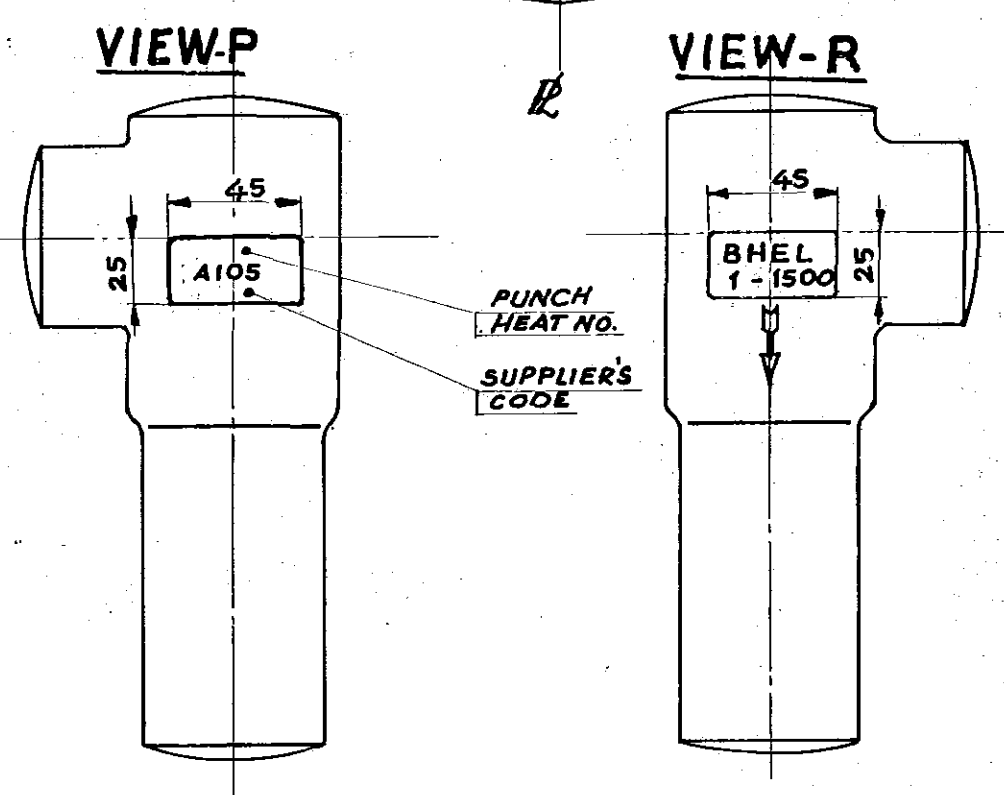
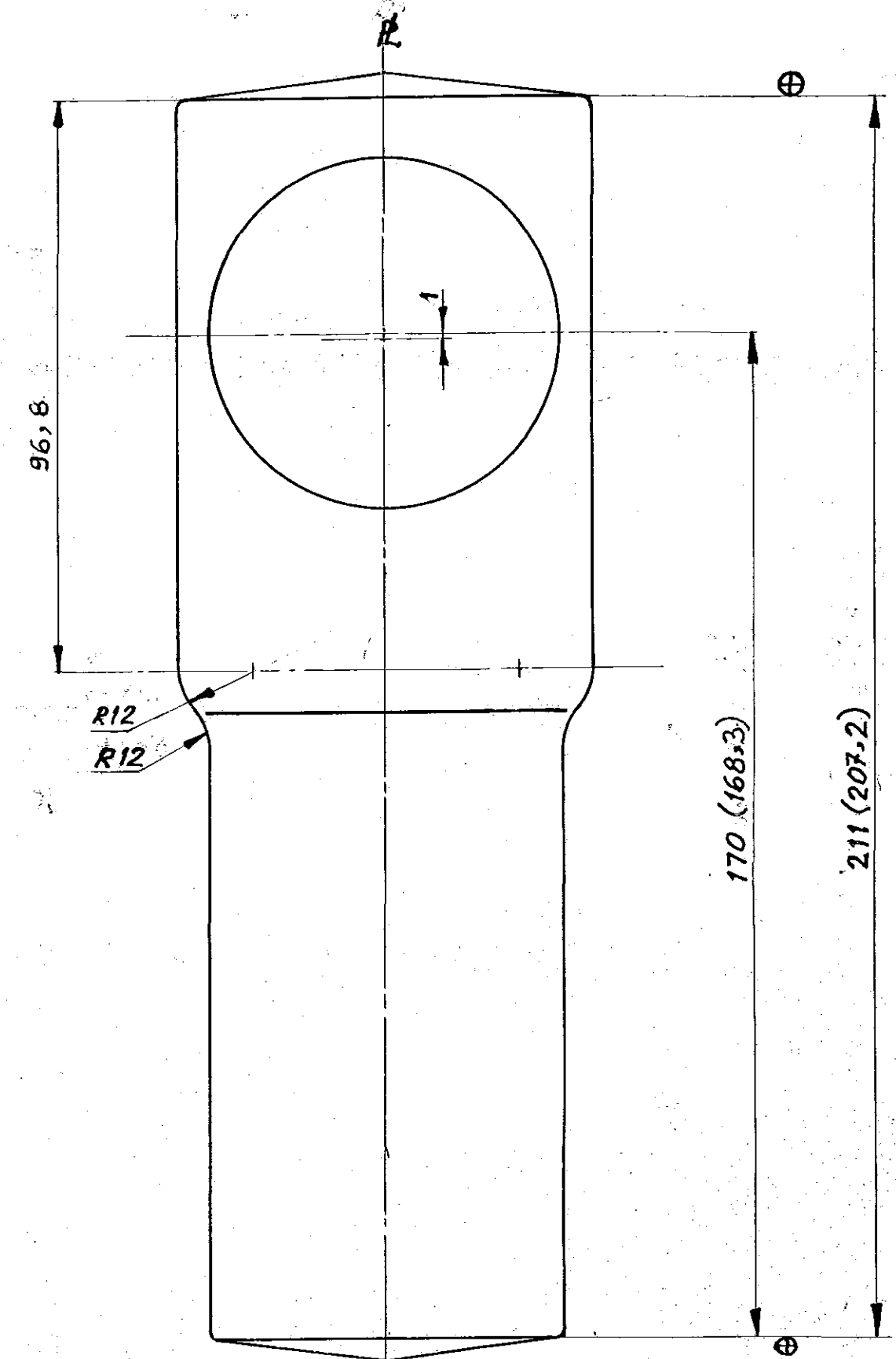
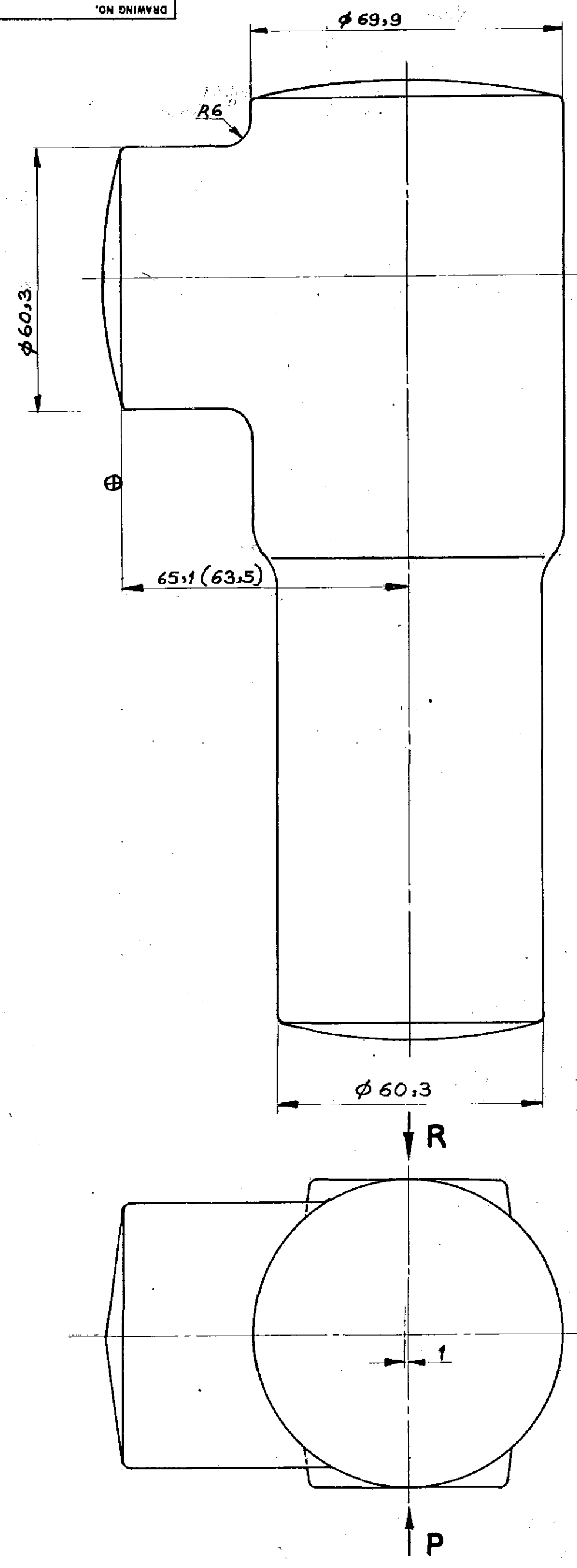


FIRST ANGLE PROJECTION (ALL DIMENSIONS IN MILLIMETRES)
FOR TOLERANCE OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT RCP/QP

CAUTION THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LTD. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY MANNER DETRIMENTAL TO THE INTEREST OF THE COMPANY.



NOTES:-

1. FORGING TOLERANCES.
LENGTH AND HEIGHT } +1.9
TOLERANCE } -0.9
THICKNESS TOLERANCE } +1.7
Fillet and edge } -0.8 mm
RADI } 0 - 10 +50 - 25
10 - 32 +40 - 20
32 - 100 +30 - 15
2. FORGING DRAFT - 7°
3. MISMATCH - 1 mm
4. RESIDUAL FLASH - 1.2 mm
5. UNLESS OTHERWISE STATED TOLERANCES SHALL CONFORM TO BS-4114 NORMAL.
6. UNSPECIFIED FORGING RADI-R 1.6
7. FORGING SHALL COMPLY WITH THE REQUIREMENTS OF APPLICABLE TDC.
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 BRACKETS FOR INFORMATION.
11. FORGINGS ARE TO BE SAND BLASTED OR SHOT BLASTED AND HEAT TREATED AS SPECIFIED.
12. HEIGHT OF FORGING LETTERS 5 MM.

DIE FORGING 92024559		ASTM A105 ATTEST	NORMALISED	-	-	-	-	-	-
NO OFF	DESCRIPTION	CODE NO	FINAL MATL.	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRG. NO.	ITEM NO.
BPH		BHARAT HEAVY ELECTRICALS LTD., BOILER PLANT UNIT, TIRUCHIRAPALLI-620 014							
DEPT	CODE	SCALE	WEIGHT (kg)	BODY		IT NO.			
05-228/B		1:1	6.97	B-7205FF018/C8262(2180)					
REV. 01		DATE 29.1.97	ALTERED R. Mohan	CHECKED & APPD. M. Mohan	TITLE BODY (1"-7105)				
QUALITY REFERENCES REMOVED.					DRAWN D. DEVA SAHAYAM				
					CHECKED				
					APPROVED				
					DATE				
					15 16 REV. 17				
					2-V-5620-02653F 01				