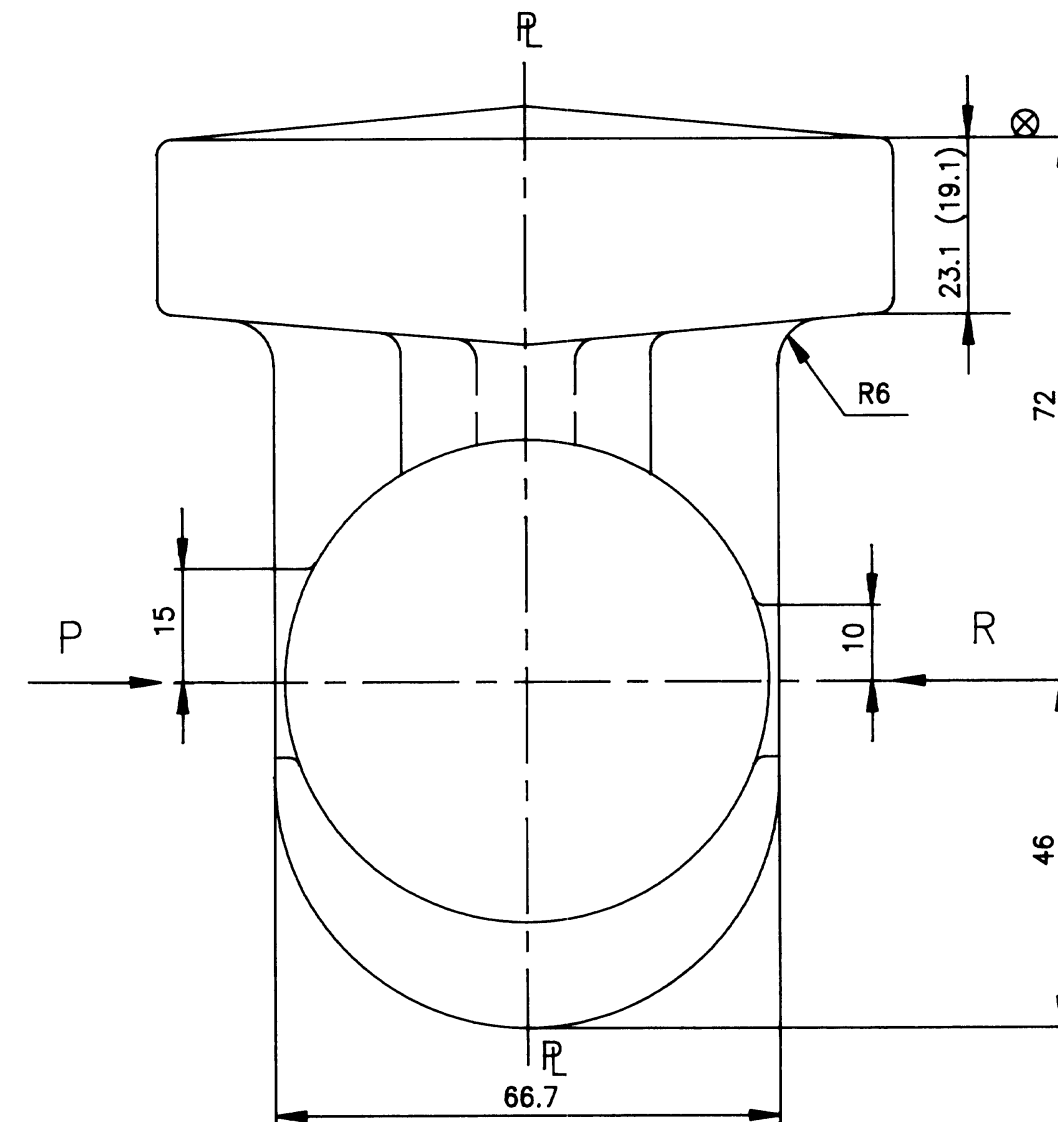
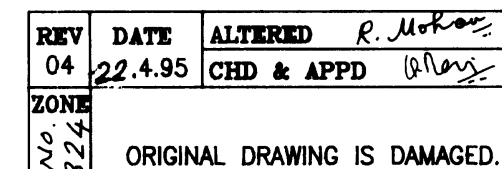
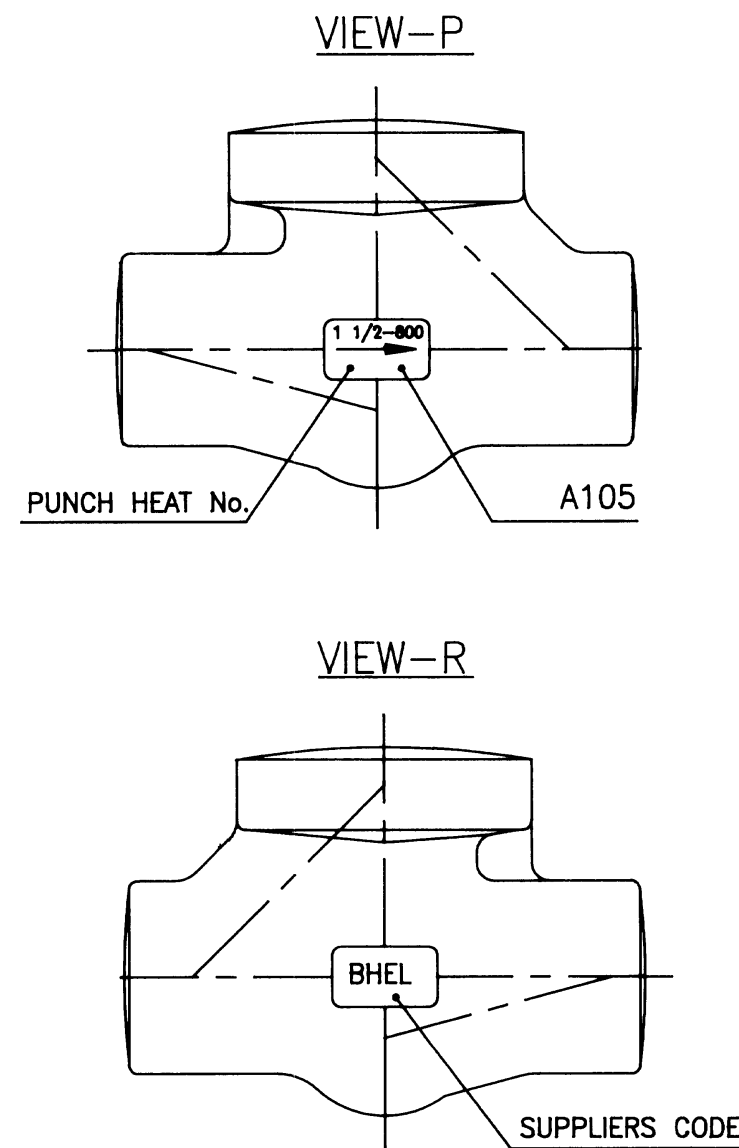




NOTES:

01. FORGING TOLERANCES
- | | mm | TOL. % |
|---------------------------------------|--|--------|
| LENGTH AND HEIGHT TOLERANCE | $\left[\begin{array}{l} + 2.1 \\ - 1.1 \end{array} \right]$ | |
| THICKNESS TOLERANCE | $\left[\begin{array}{l} + 1.7 \\ - 0.8 \end{array} \right]$ | |
- FILLET AND
EDGE RADI $\left[\begin{array}{ll} 0-10 & +50-25 \\ 10-32 & +40-20 \\ 32-100 & +32-15 \end{array} \right]$
02. MISMATCH : 1.0
03. RESIDUAL FLASH : 1.2
04. DRAFT : 7°
05. UNLESS OTHERWISE STATED TOLERANCES SHALL CONFORM TO APPLICABLE TDC.
06. UNSPECIFIED FORGING RADI R 3
07. FORGING SHALL COMPLY WITH THE REQUIREMENTS OF APPLICABLE TDC.
08. DIMENSIONS IN THE DRAWING EXCLUDE FORGING DRAFT
09. MACHINING ALLOWANCES ARE INCLUDED ON ALL MACHINABLE SURFACES MARKED ⊕
10. FINISH MACHINED DIMENSIONS ARE INDICATED WITHIN BRACKETS FOR INFORMATION
11. FORINGS ARE TO BE SAND BLASTED OR SHOT BLASTED AND HEAT TREATED AS SPECIFIED
12. THE IDENTIFICATION MARKS AND SPECIFICATION NUMBERS SHALL BE IN RAISED LETTERS
13. SIZE OF FORGING LETTERS : 5 mm
14. HEIGHT OF PADS - 2 mm



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 REVISION No. 04 ON 22.04.95											
01	FORGING	92024544	ASTM A105 -ATTEST	NORMALISED	10	5.70	-	-	-		
No OFF	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, TIRUCHIRAPPALLI-680014.					DRN	NAME R. MOHAN	SIGN <i>R. Mohan</i>	DATE 22.4.95	NO. OF VAR.		
					CHD	K.RAVICHANDRAN	<i>[Signature]</i>	22.4.95			
					APPD	N.NAGARAJAN	<i>[Signature]</i>	22.4.95			
DEPT	VL			SCALE	WEIGHT (KG).	REFERENCE INFORMATIONS				NO. OF THROW	
CODE	320			NTS	5.70	B-5537FA01A/EC151(059)					
TITLE					CARD CODE	DRAWING NO.				REV	
BODY (1-1/2" - C800 - A105)					U 01	2-V-5716-02689F				04	
						CAD: F202689F					

RETRACED WITH REVISION No. 04 ON 22.04.95