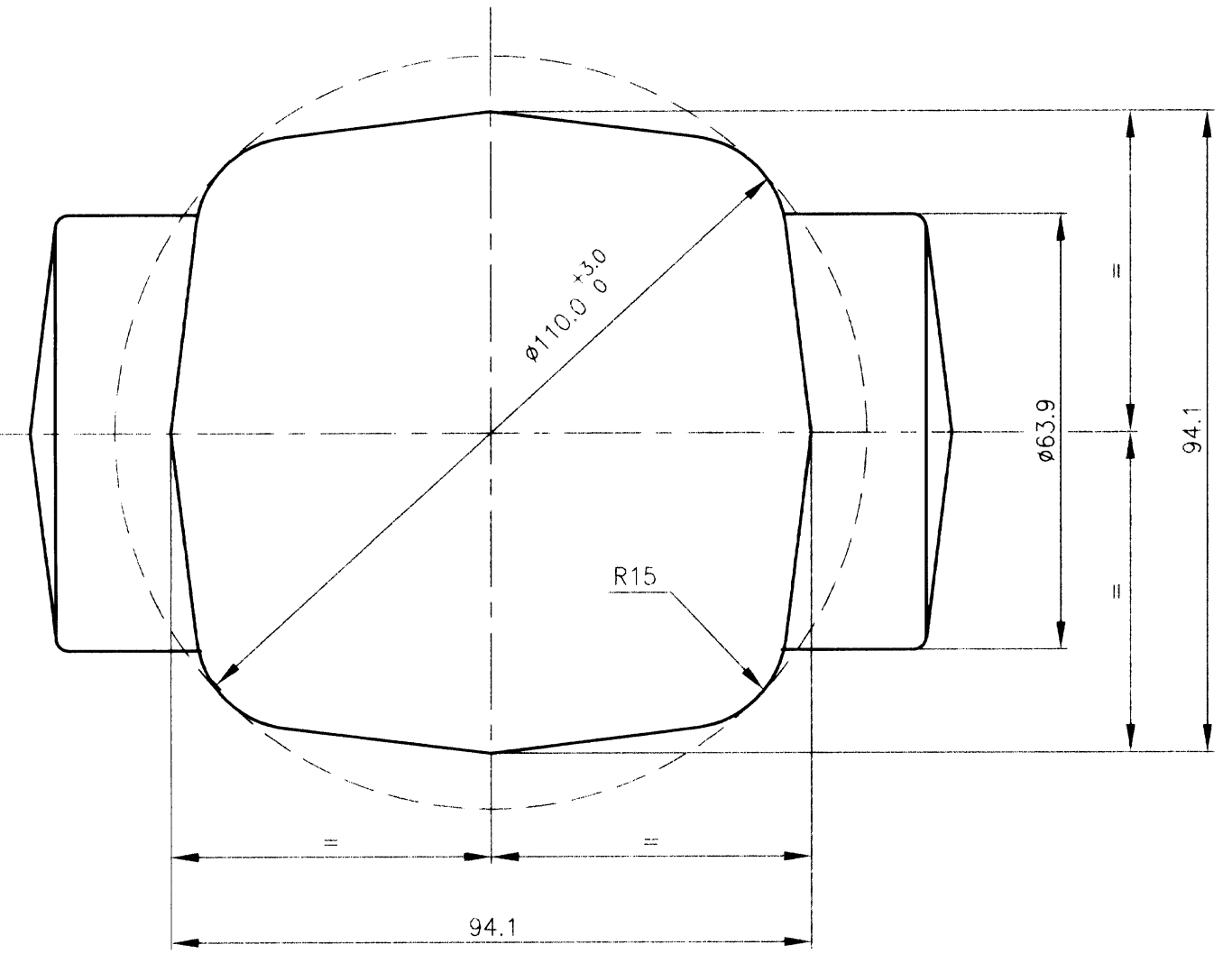
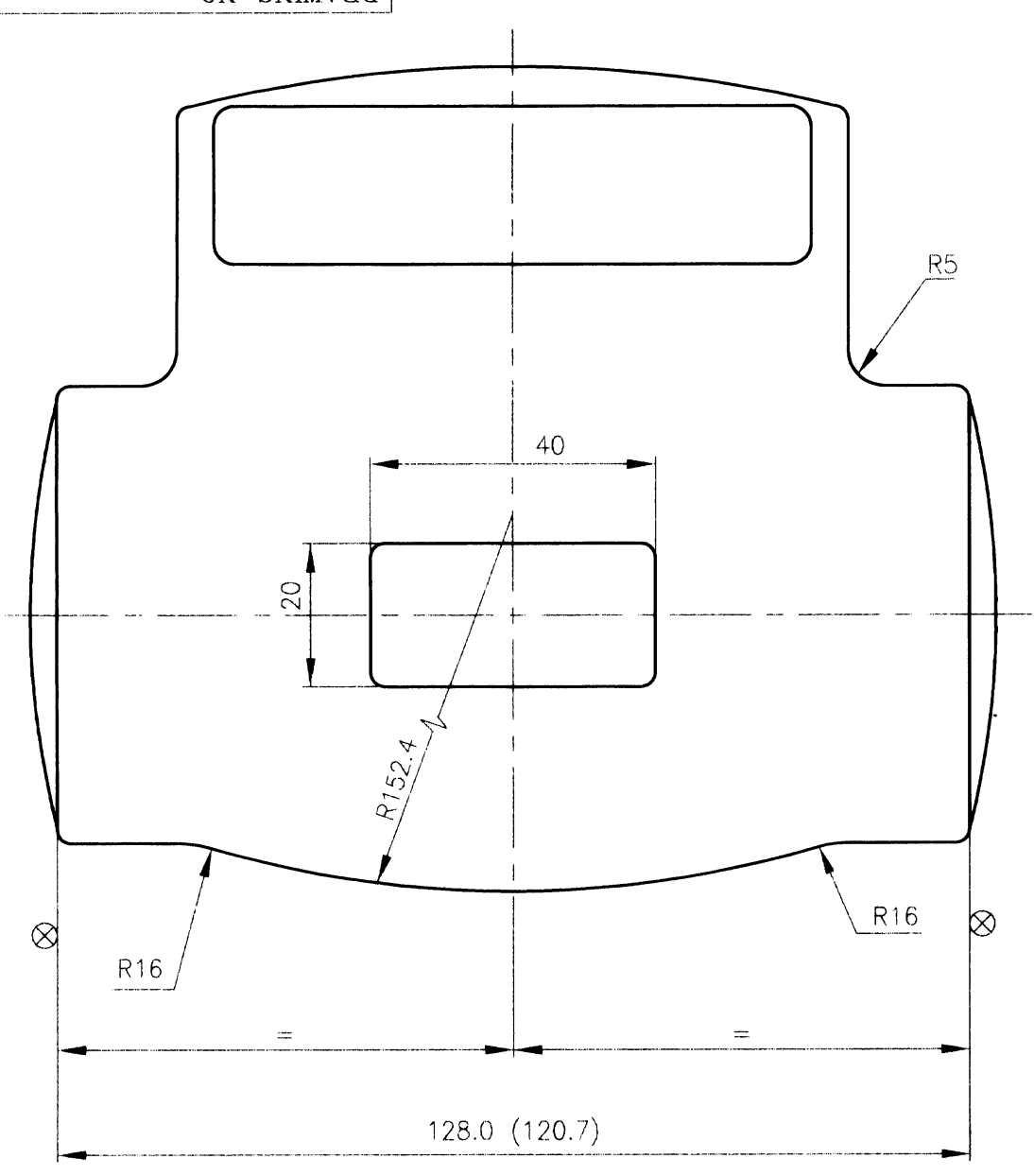
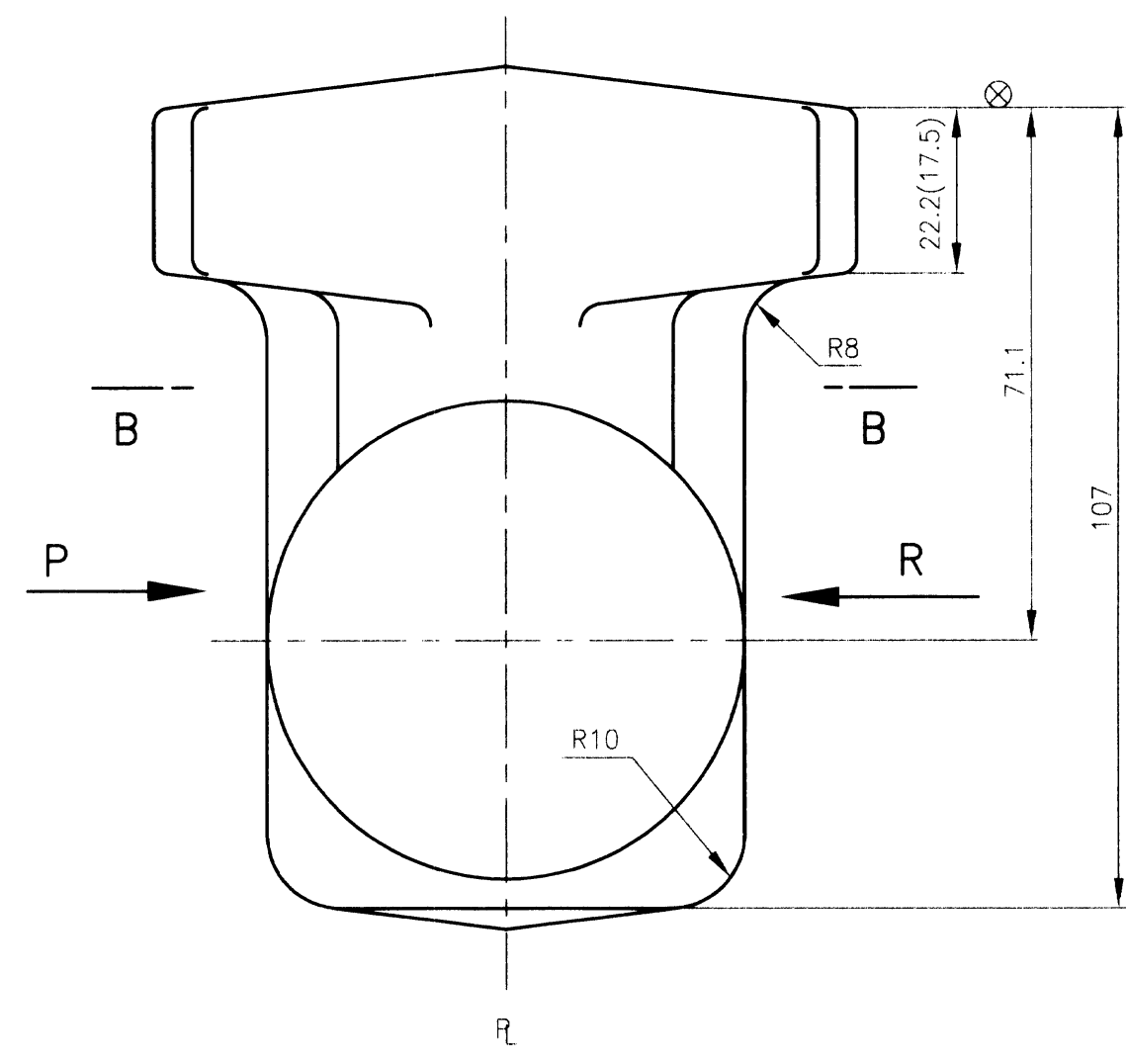


2-V-5906-02690F
DRAWING NO

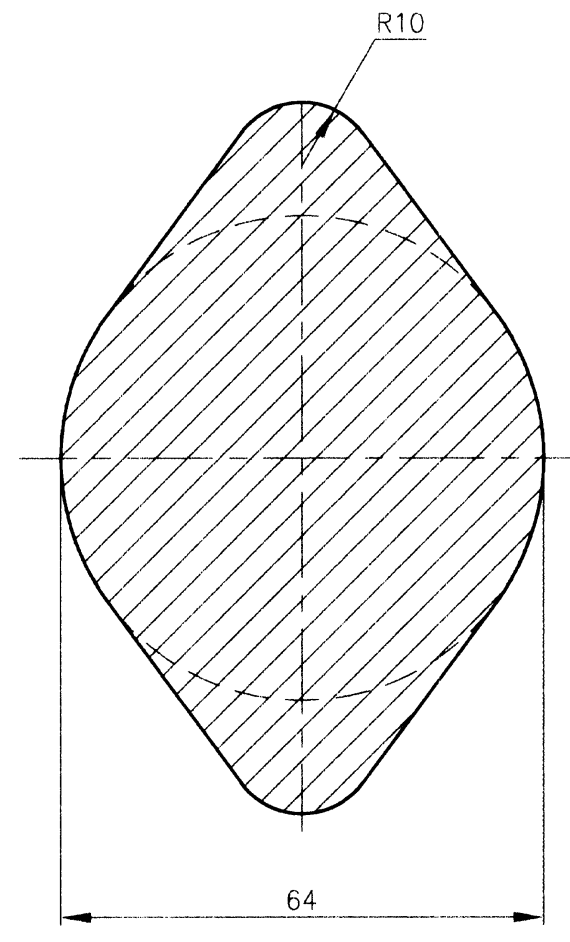
ALL DIMENSIONS ARE IN MILLIMETRES. FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP / QP

NOTES:

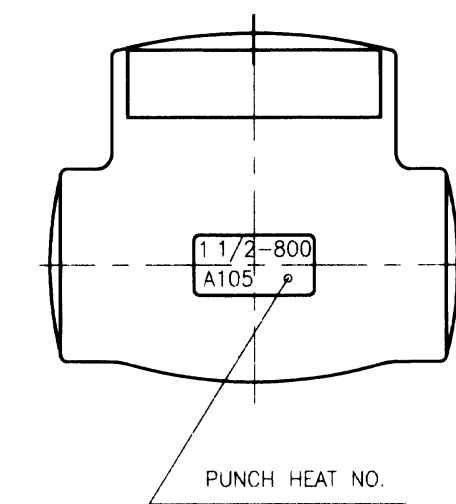
01. FORGING TOLERANCES
LENGTH AND HEIGHT TOLERANCE : $\begin{bmatrix} +1.9 \\ -0.9 \end{bmatrix}$
THICKNESS TOLERANCE : $\begin{bmatrix} +1.7 \\ -0.8 \end{bmatrix}$
Fillet and Edge Radii : $\begin{bmatrix} 0-10 & +50-25 \\ 10-32 & +40-20 \\ 32-100 & +32-15 \end{bmatrix}$ mm TOL. %
02. MISMATCH : 1.0
03. RESIDUAL FLASH : 1.2
04. DRAFT : 7° (MAX)
05. UNSPECIFIED FORGING RADII R 2.5
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 $\otimes$
09. FINISH MACHINED DIMENSIONS ARE INDICATED WITHIN BRACKETS FOR INFORMATION
10. FORINGS ARE TO BE SAND BLASTED OR SHOT BLASTED AND HEAT TREATED AS SPECIFIED
11. THE IDENTIFICATION MARKS AND SPECIFICATION NUMBERS SHALL BE IN RAISED LETTERS
12. SIZE OF FORGING LETTERS : 5 mm
13. HEIGHT OF PADS : 2 mm



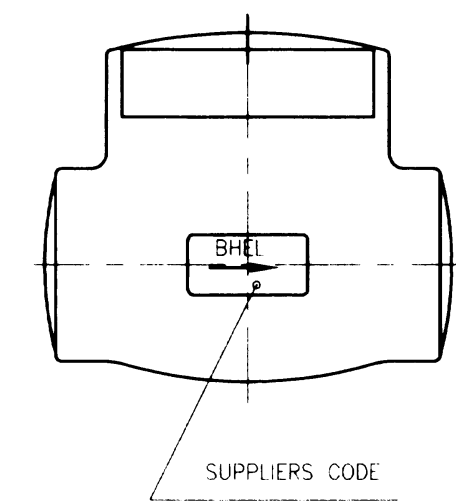
SECTION-BB



VIEW-R



VIEW-P



DRAWING RETRACED WITH REV.04 ON 04.05.2001

01	DIE FORGING	92 024 547	ASTM A105 ATTEST	NORMALISED	-	6.2	-	-	-
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		DEPT V L		SCALE NTS	WEIGHT (KG) 6.2	REFERENCE INFORMATION B957FE01A/ C0638 (038) CAD: F202690F		NO. OF ITEMS	
BHARAT HEAVY ELECTRICALS LTD. UNIT: HIGH PRESSURE BOILER PLANT TIRUCHIRAPALLI-620014		DRN M.SRINIVASAN	SIGN 10/05/01	DATE 04.05.01	NO. OF VAR	DRAWING NO. 2-V-5906-02690F		REV 04	
365-120		CHD P. BOOMINATHAN	SIGN X	DATE 04.05.01	NO. OF VAR	CARD CODE U 01		REV 04	
APPD K.S. RAMAN		SIGN U		DATE 04.05.01	NO. OF VAR	DRAWING NO. 2-V-5906-02690F		REV 04	

REV	DATE	ALTERED
		CHD & APPD
ZONE		

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