

2-V-H404-08282F
DRAWING NO.

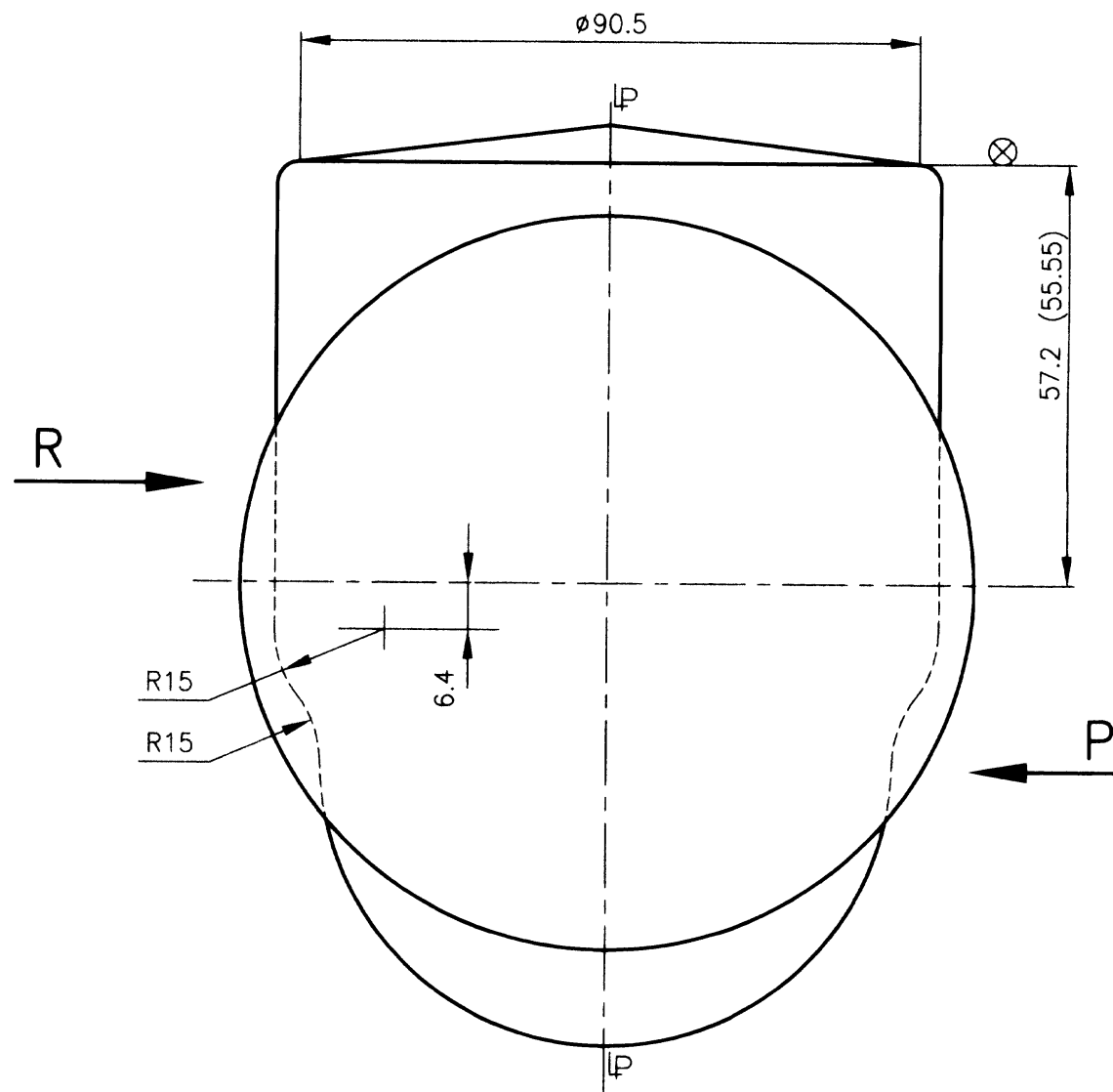
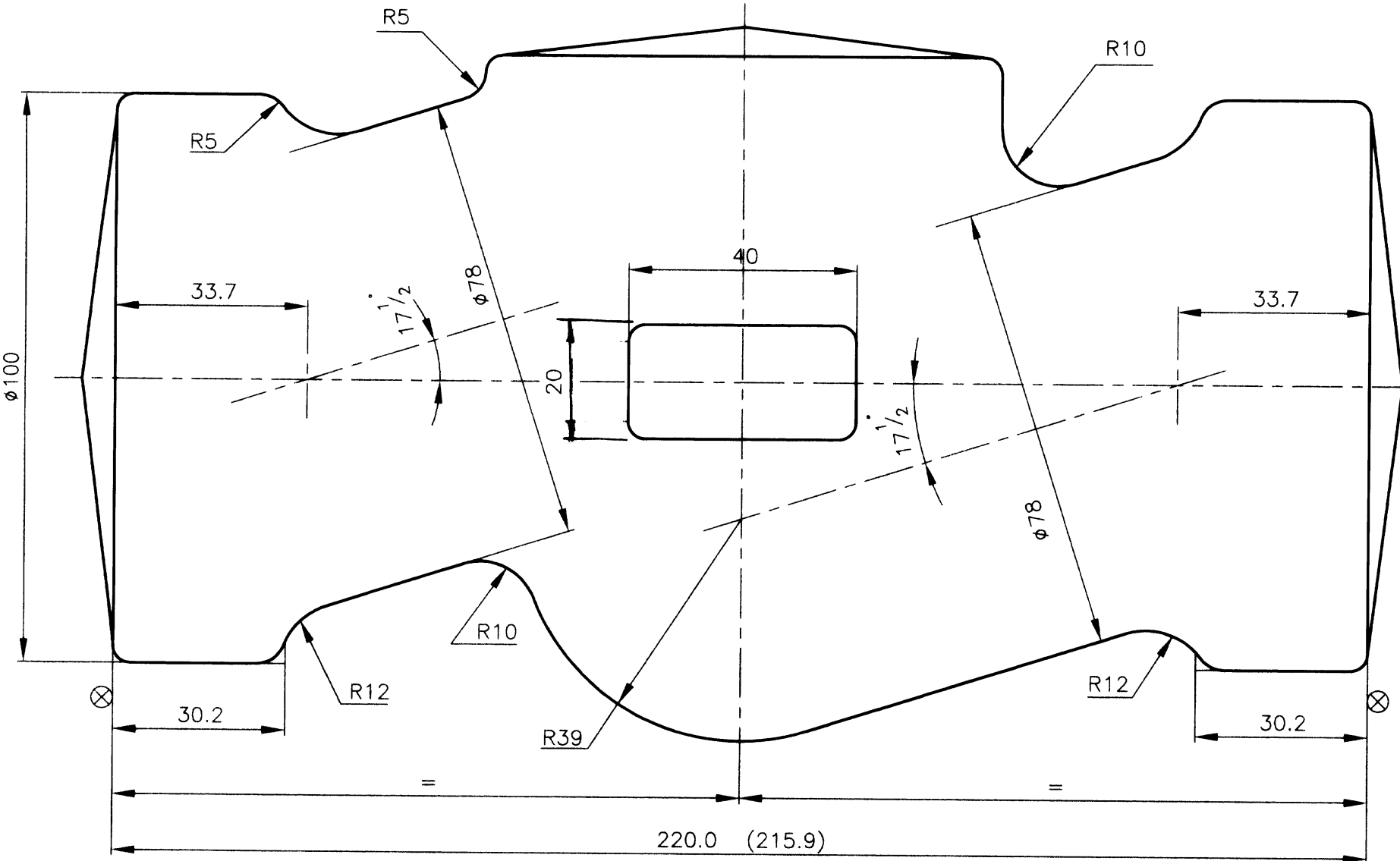
ALL DIMENSIONS ARE IN MILLIMETRES. FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP / QP

NOTES:

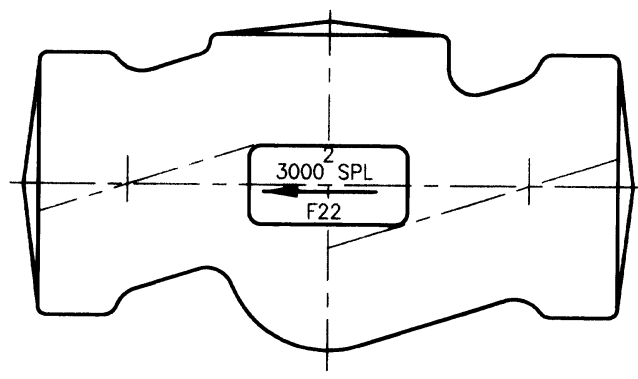
01. FORGING TOLERANCES
LENGTH AND HEIGHT TOLERANCE : $\begin{bmatrix} +2.1 \\ -1.1 \end{bmatrix}$
THICKNESS TOLERANCE : $\begin{bmatrix} +1.7 \\ -0.8 \end{bmatrix}$
Fillet and Edge Radii : $\begin{matrix} \text{mm} & \text{TOL. \%} \\ 0-10 & +50-25 \\ 10-32 & +40-20 \\ 32-100 & +32-15 \end{matrix}$
02. MISMATCH : 1.0
03. RESIDUAL FLASH : 1.2
04. DRAFT : 7
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 $\oplus$
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

SPECIAL NOTE:

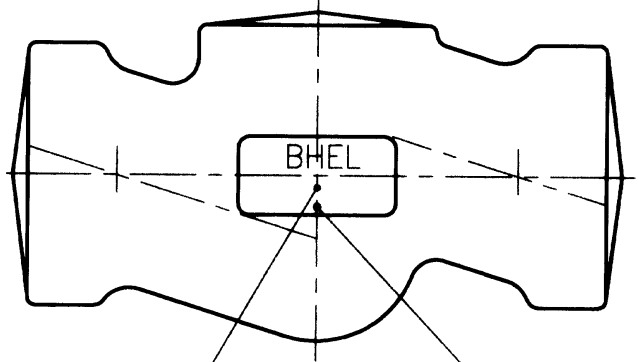
01. QUALITY PROCEDURE AS APPLICABLE FOR SPECIAL CLASS VALVES.



VIEW - P



VIEW - R



SUPPLIERS CODE PUNCH HEAT No.

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REV	DATE	ALTERED
		CHD & APPD
ZONE		

	FORGING	92 033 992	ASTM A182-F22 Cl.3 - ATTEST	NORMALISED & TEMPERED	-	6.88	-	-	-
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. TIRUCHIRAPALLI-620014.				DRN M.SRINIVASAN	SIGN P. BOOMINATHAN	DATE 26.08.2K	NO. OF VAR.		
365-120				CHD K.S.RAMAN		26.08.2K			
DEPT V L		SCALE NTS		WEIGHT (KG). 6.88		REFERENCE INFORMATIONS CAD: F208282F			NO. OF ITEMS
CODE 320									
TITLE BODY						CARD CODE U 01	DRAWING NO. 2-V-H404-08282F		REV