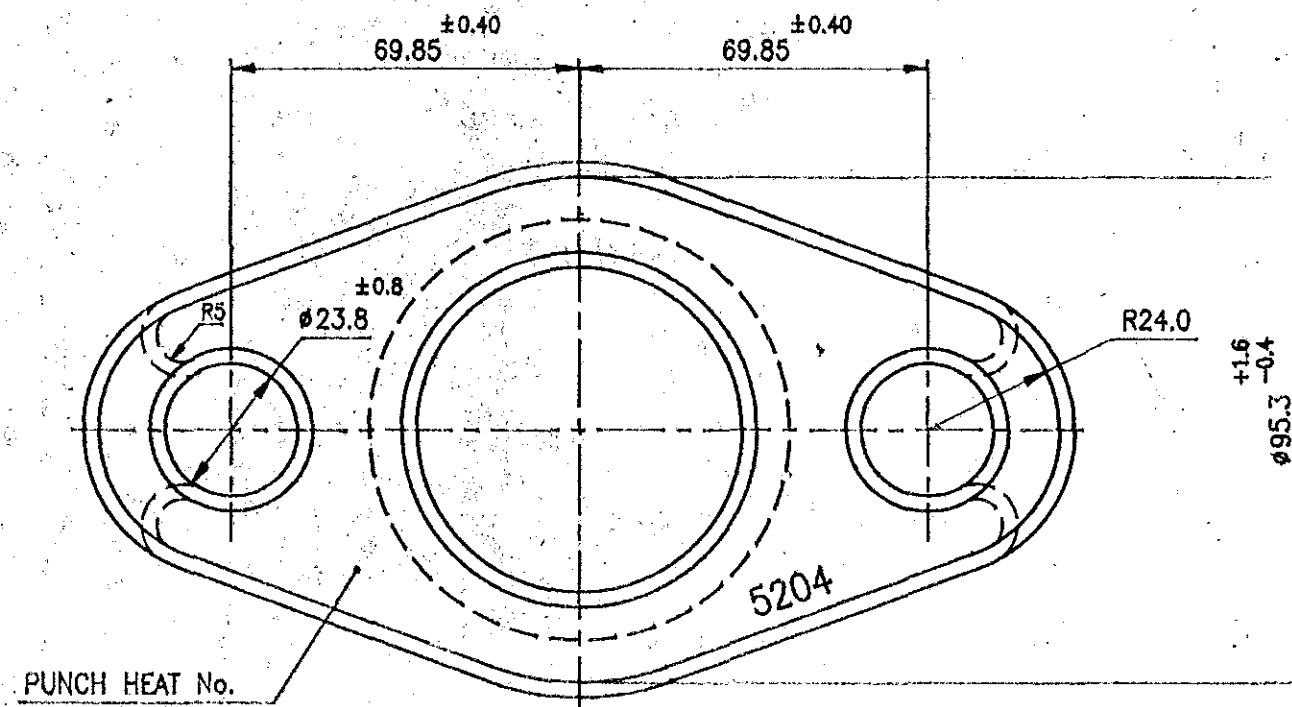
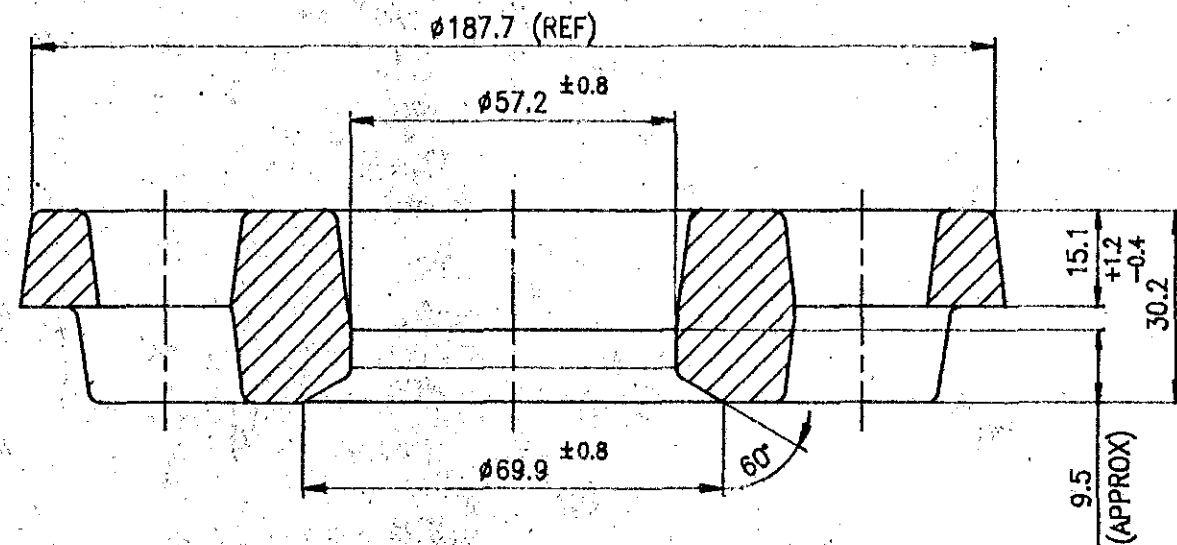


DRAWING NO.
3-V-5204-04994F

NOTES:

FORGING TOLERANCES

LENGTH NO HEIGHT TOLERANCE : $\begin{bmatrix} +1.3 \\ -0.7 \end{bmatrix}$

THICKNESS TOLERANCE : $\begin{bmatrix} +1.2 \\ -0.4 \end{bmatrix}$

FILLET AND
EDGE RADII

mm	TOL %
0-10	+50 -25
10-32	+40 -20
32-100	+30 -15

02. FORGING DRAFT 7° (MAX)
03. MISMATCH : 0.5mm
04. RESIDUAL FLASH : 0.6mm
05. FOR UNTOLERANCED FORGING DIMENSIONS REFER APPLICABLE STDG.
06. UNSPECIFIED FORGING RADII - R1.6
07. FORGING SHALL COMPLY WITH THE REQUIREMENTS OF APPLICABLE TDC.
08. DIMENSIONS IN THE DRAWING EXCLUDE FORGING DRAFT.
09. FORINGS ARE TO BE SAND BLASTED OR SHOT BLASTED AND HEAT TREATED AS SPECIFIED.
10. HEIGHT OF FORGING LETTERS : 5 mm

RETRACED WITH REVISION No. 01 ON 17.03.95

01	FORGING	92 033 515	ASTM A105 CERTIFY	NORMALISED	-	1.39	-	-	-
NO OFF	DESCRIPTION	MATL CODE	MATL SPECH	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	NAME	SIGN	DATE	NO. OF VAR.
CHD	R. MOHAN	R. Mohan	17.03.95	
APPD	K. RAVICHANDRAN	(Signature)	6.4.95	
	N. NAGARAJAN	(Signature)	6.4.95	

DEPT VL	SCALE	WEIGHT (KG).	REFERENCE INFORMATION	NO. OF ITEM
CODE 320	NTS	1.39	DRESSER DRG. No. D7257 A08A/CK456 (2391)	
TITLE	CARD CODE	DRAWING NO.	CAD: F304994F	REV
GLAND FLANGE	U 01	3-V-5204-04994F		01

REV	DATE	ALTERED
01	25.3.95	CHD & APPD (Signature)
DCN: FS: 0318	IN NOTES 5 & 7 STANDARD / PROCEDURE NUMBERS REMOVED.	

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.