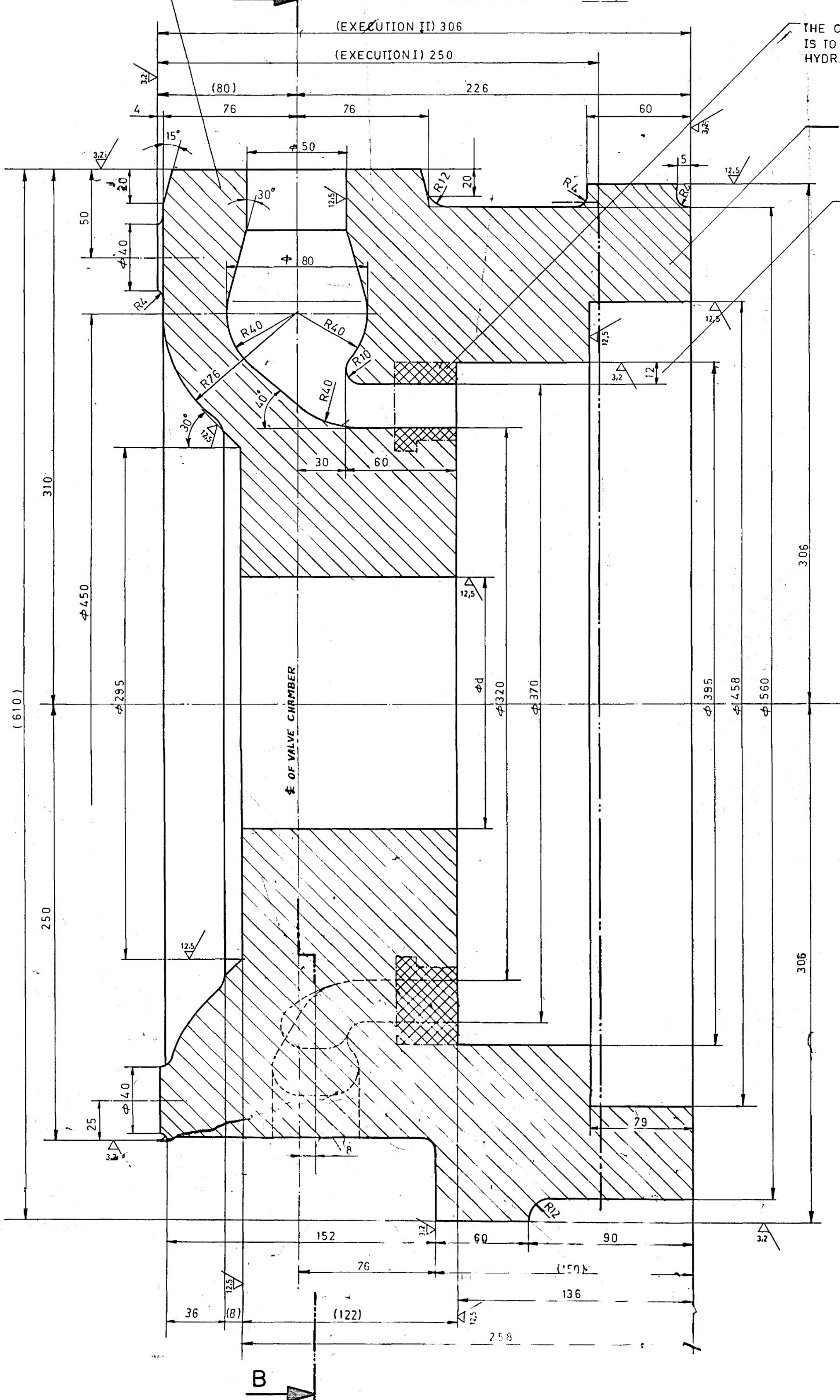
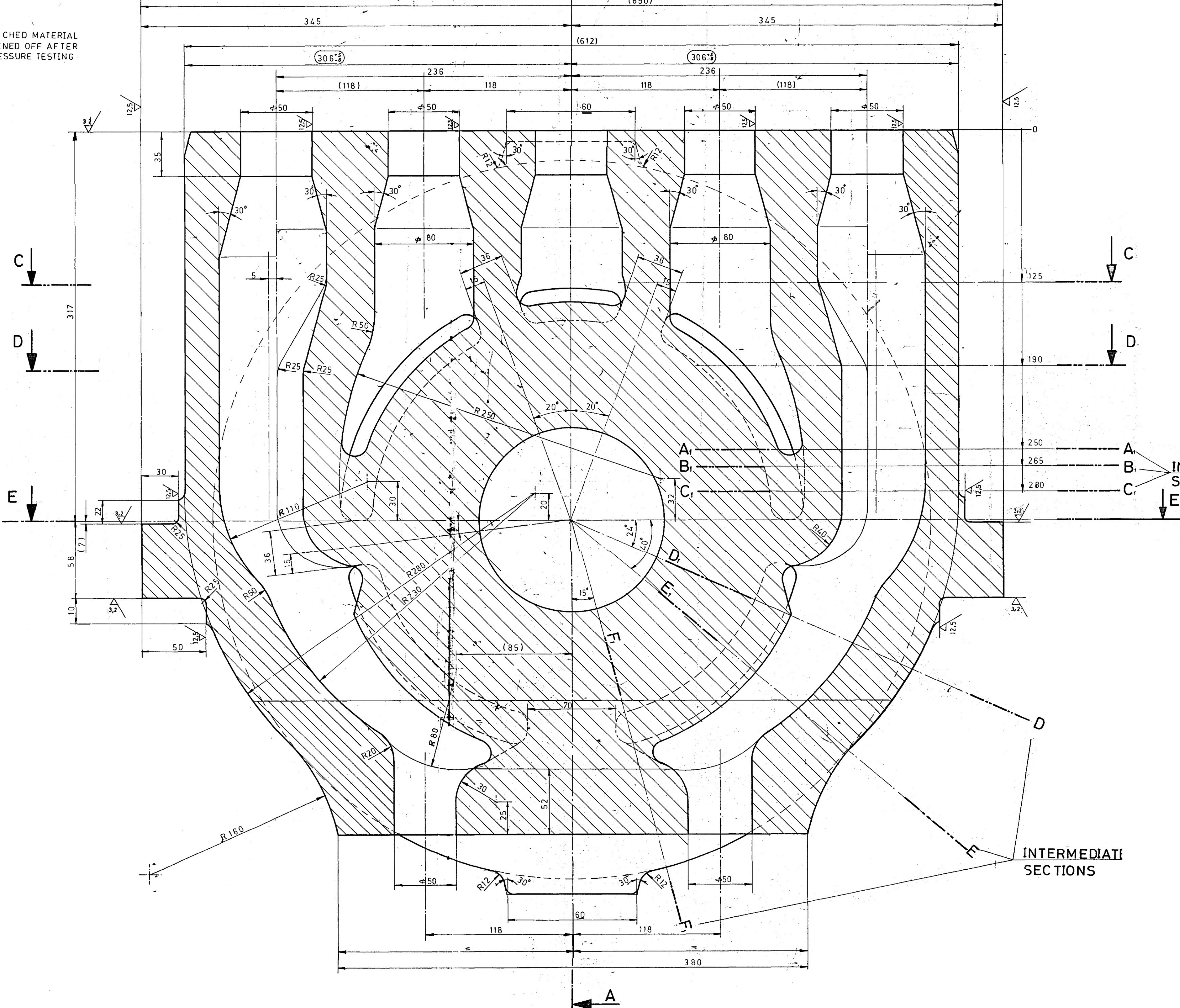


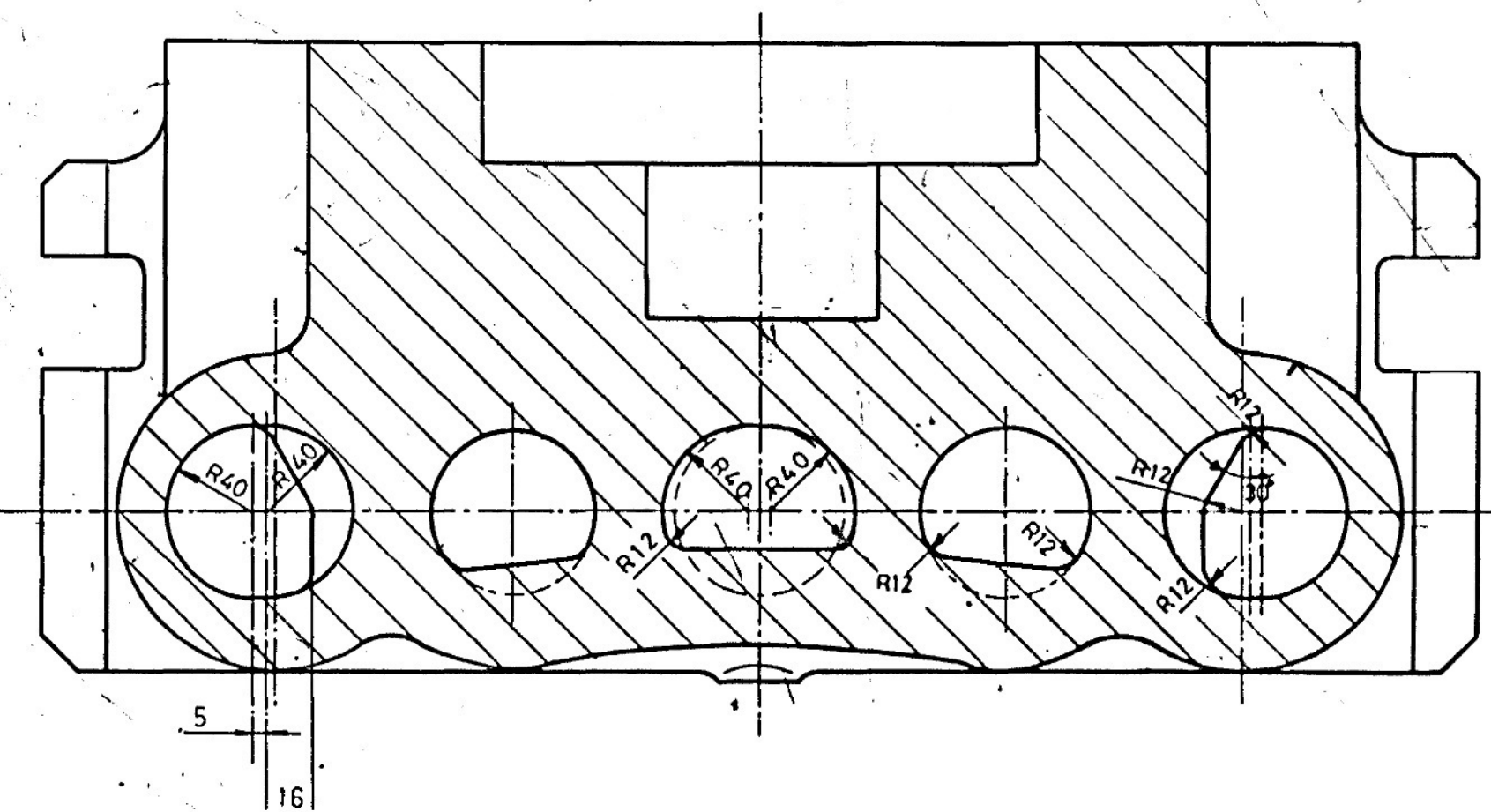
SECTION A-A S:1:16



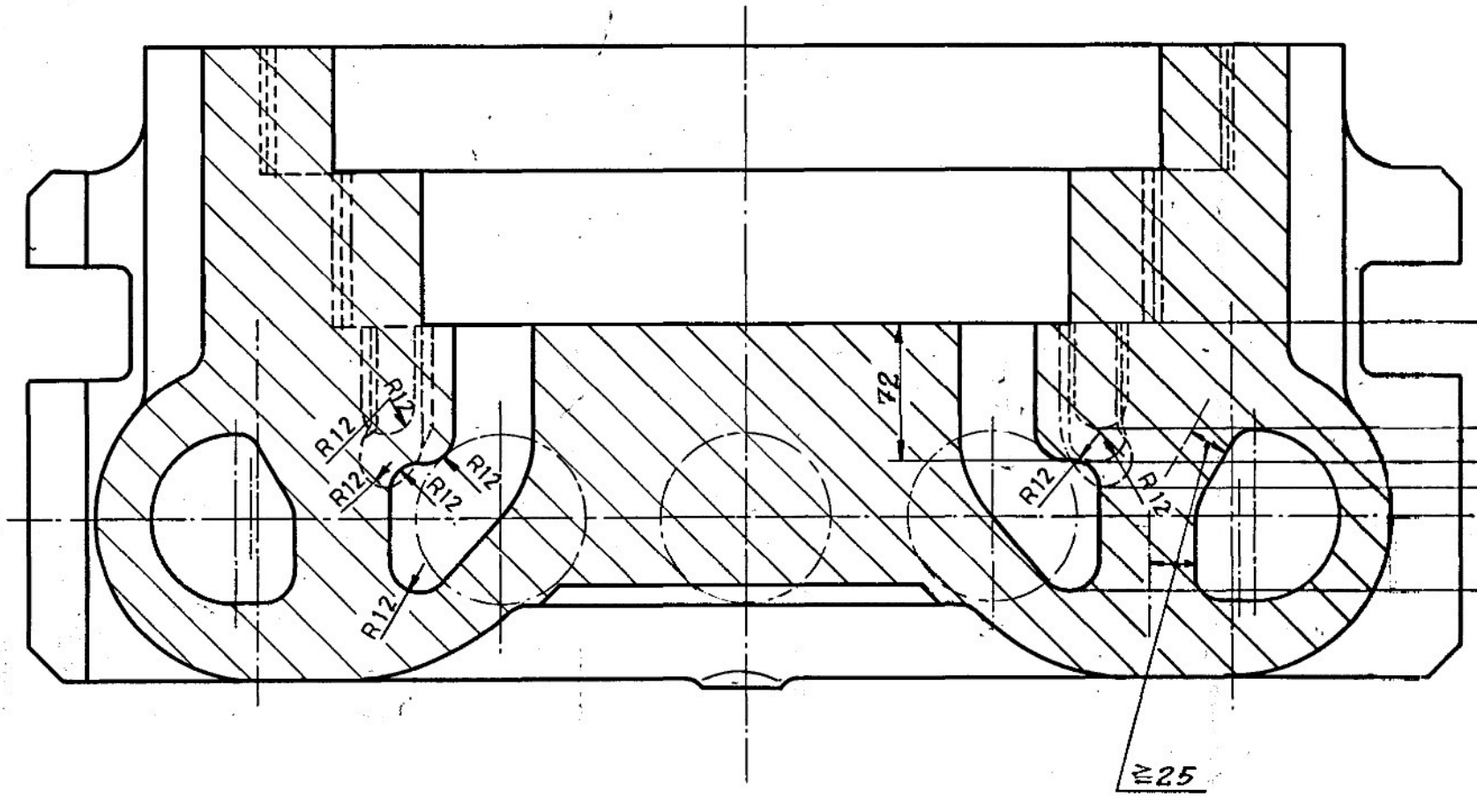
SECTION B-B S:1:16



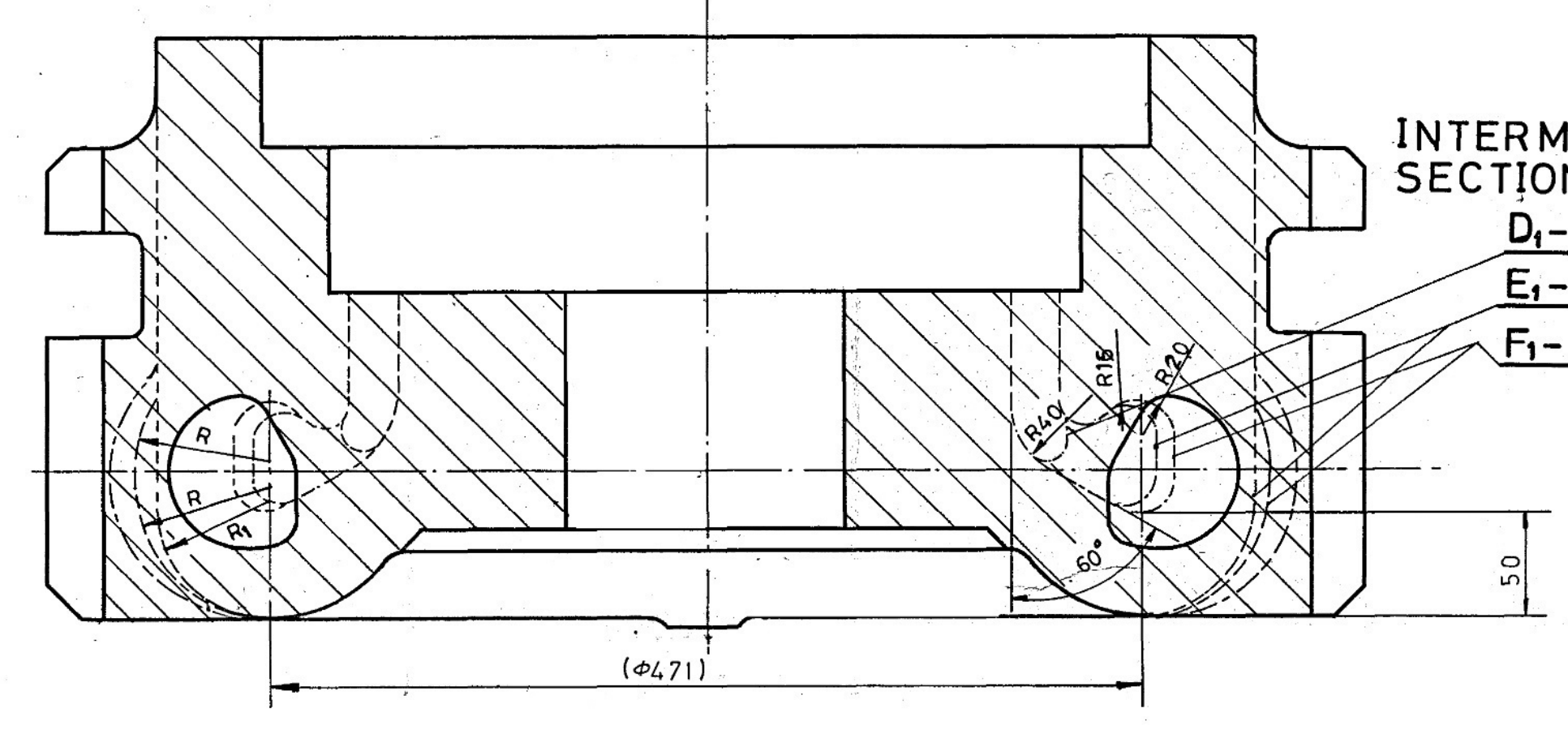
SECTION C-C



SECTION D-D



SECTION E-E



- NOTES:-**
- CASTING TO BE SUPPLIED IN COMPLETELY ROUGH MACHINED CONDITION AS PER TDC-0100/75
  - AFTER ROUGH MACHINING AND HEAT-TREATMENT THE CASTING SHOULD BE COMPLETELY FREE FROM ONLY RESIDUAL INTERNAL STRESSES.
  - HEAT TREATMENT PROCESS ACTUALLY FOLLOWED MUST BE SUBMITTED WITH DIAGRAM.
  - INTEGRAL KEEL BLOCKS ARE TO BE PROVIDED ON THE CASTING AS SHOWN.
  - TESTS ARE TO BE CARRIED OUT AS PER TDC-0100/75
  - CARRYOUT X RAY TEST AS PER TDC-0100/75.
  - DEGREE OF ACCURACY OF CASTING AS PER DIN1683/B
  - CREEP PROPERTIES FOR THE CASTING MATERIAL CONFORMING TO DIN MATERIAL SPECIFICATION (AS PER ORDER) SHOULD BE GUARANTEED BY THE SUPPLIER.
  - MARKINGS AS PER TDC 0100/75 TO BE MADE AT PLACES SHOWN THUS.....
  - THE SUPPLIED CASTING SHOULD NOT CONTAIN ANY CHAPLETS AND CHILLS.
  - THE GIVEN DRAWING DIMENSIONS ARE WITHOUT ANY MACHINING ALLOWANCE.
  - ALLOWANCE FOR ROUGH MACHINING FOR DIMENSIONS UP TO 500mm = 3 ± 1 OVER 500mm = 4 ± 2.
  - DIMENSIONS MARKED THUS ARE TO BE MAINTAINED BY MACHINING IF NECESSARY.
  - ADDITIONAL LOOSE PATTERN PIECES.
  - UNMENTIONED RADII R = 10mm.

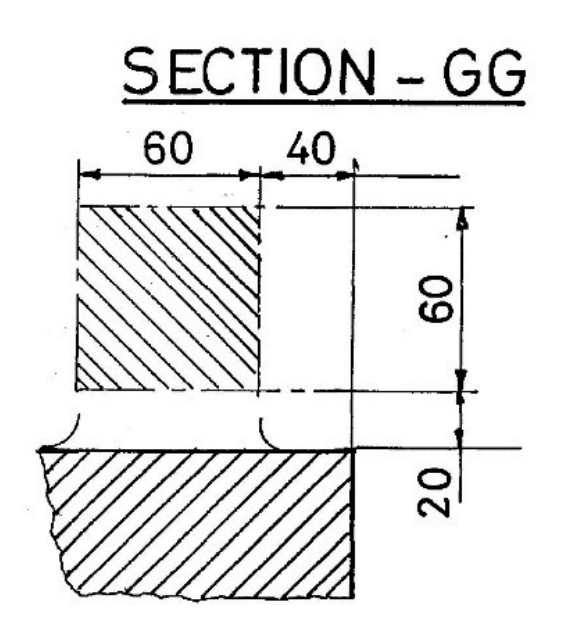
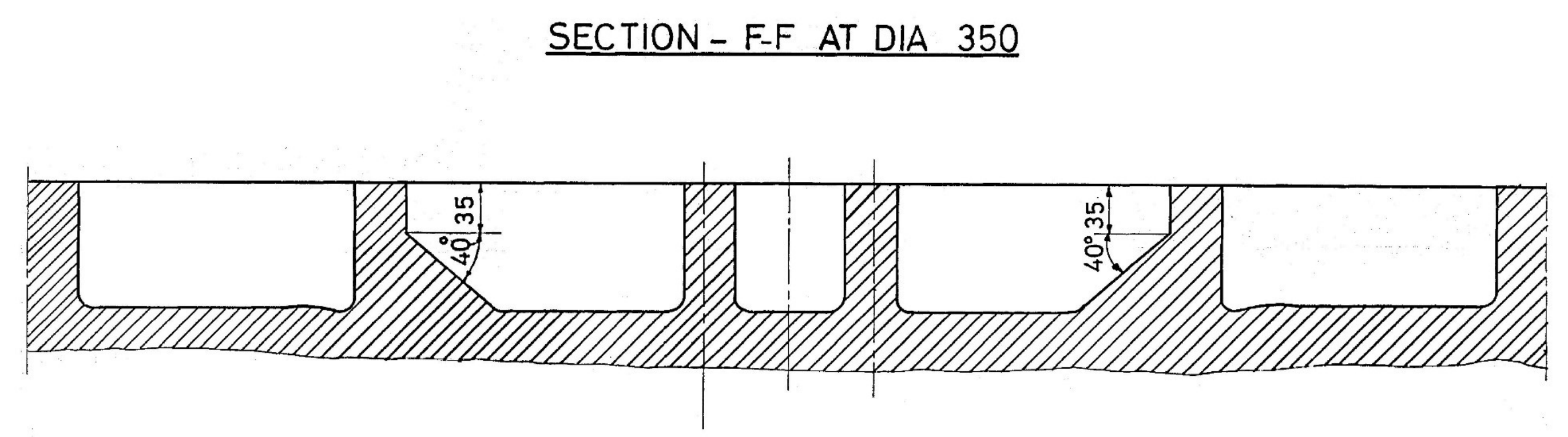
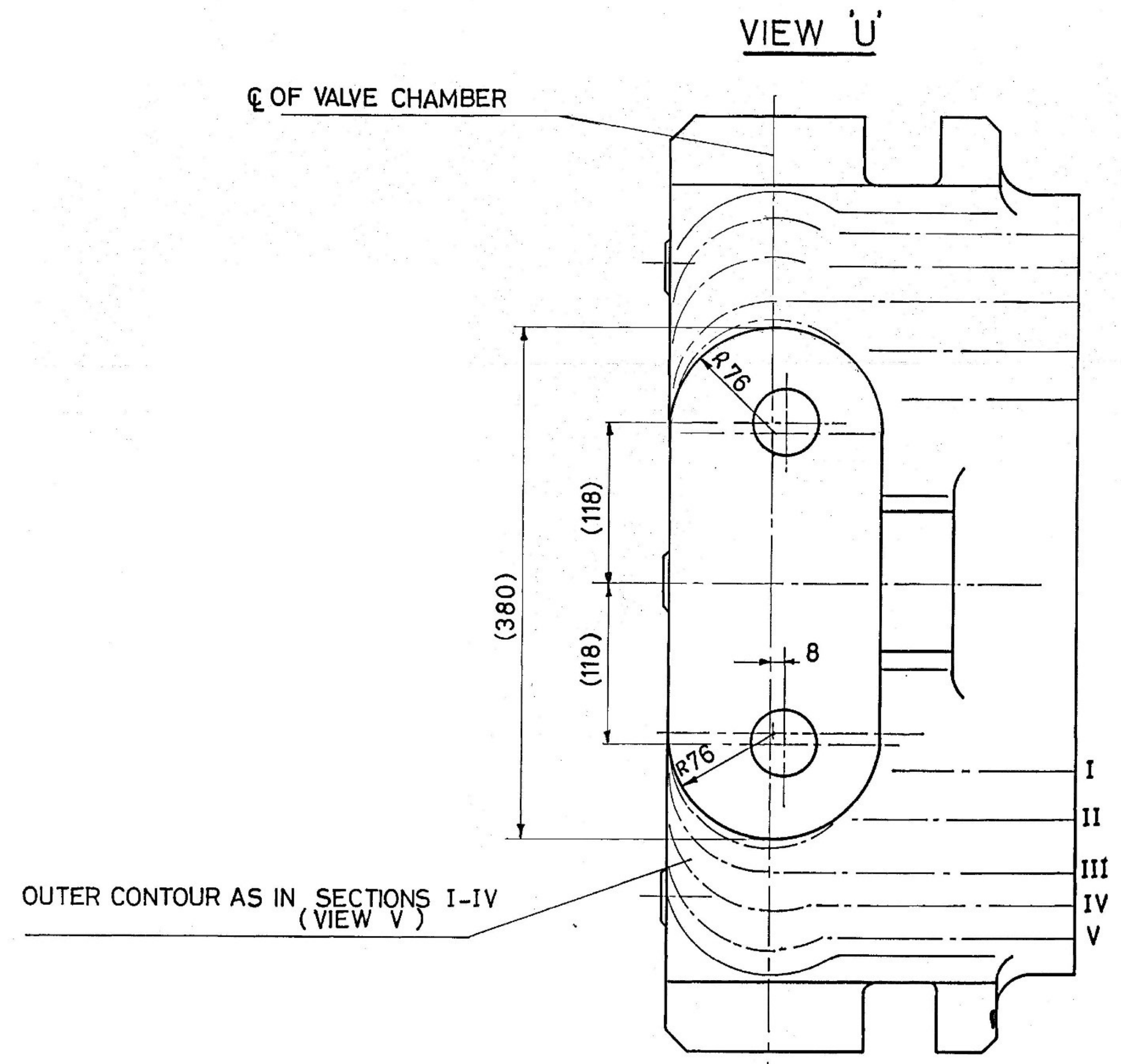
PATTERN No. FOR POS. 1. 5-8934-0024-00  
PATTERN No. FOR POS. 2. 5-8934-0025-00

EXECUTION	Pos.	Ø d	MATERIAL	VAR.
I	1	210	HY19573	06
I	1	140	HY19573	-05
II	1.2	180		-04
II	1.2	245		-03
II	1.2	140		-02
I	1	245		-01
I	1	140		-00

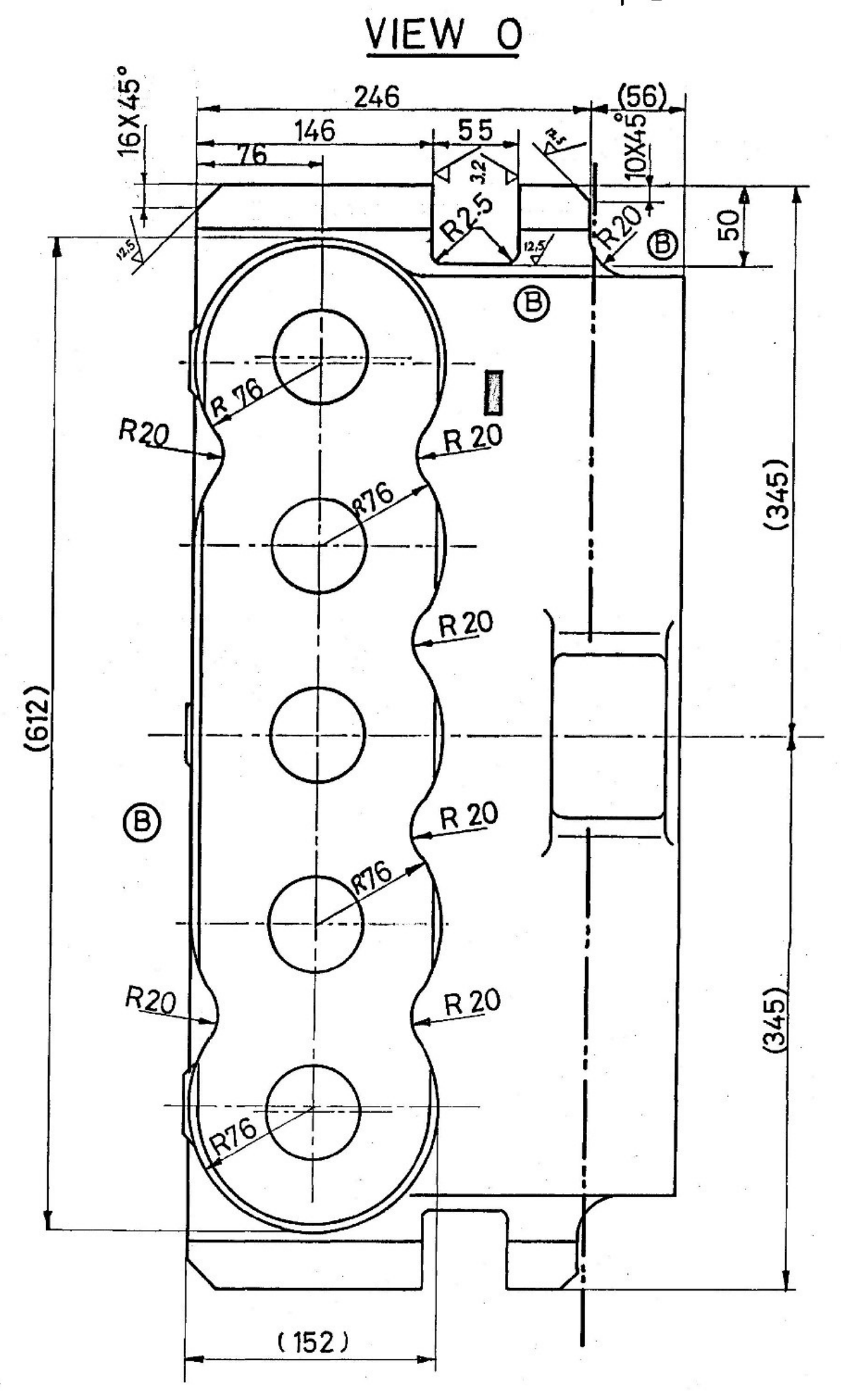
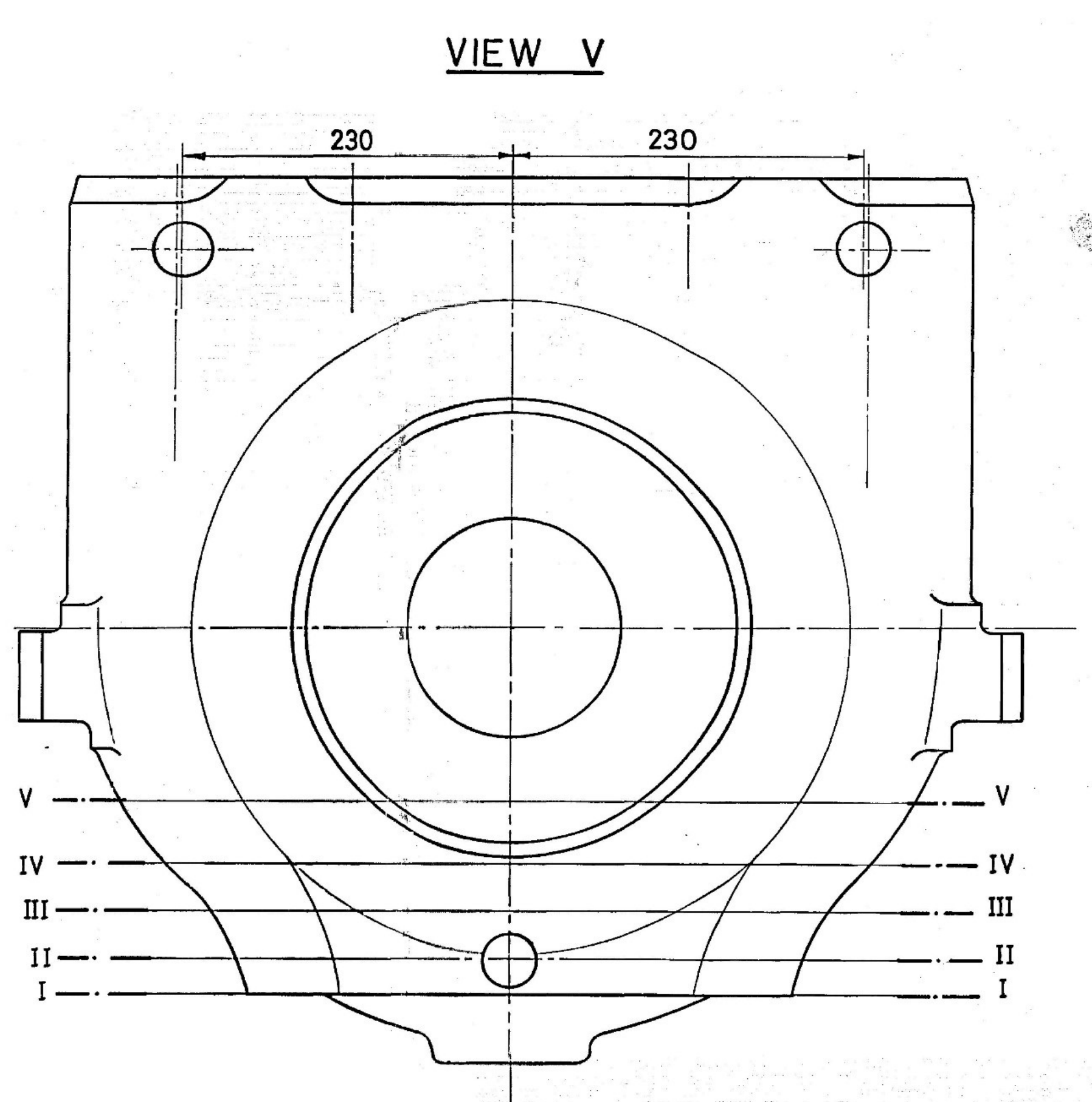
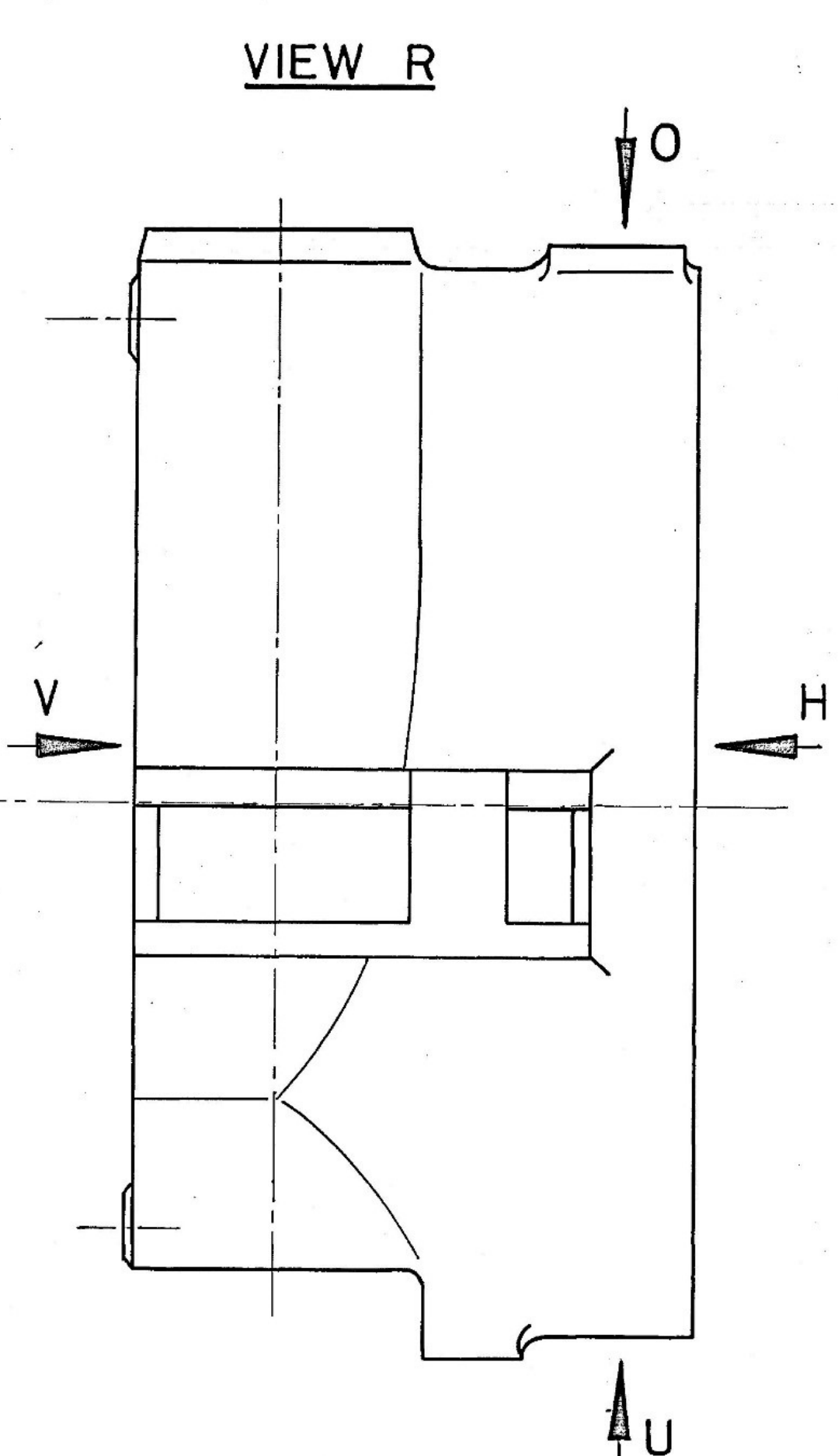
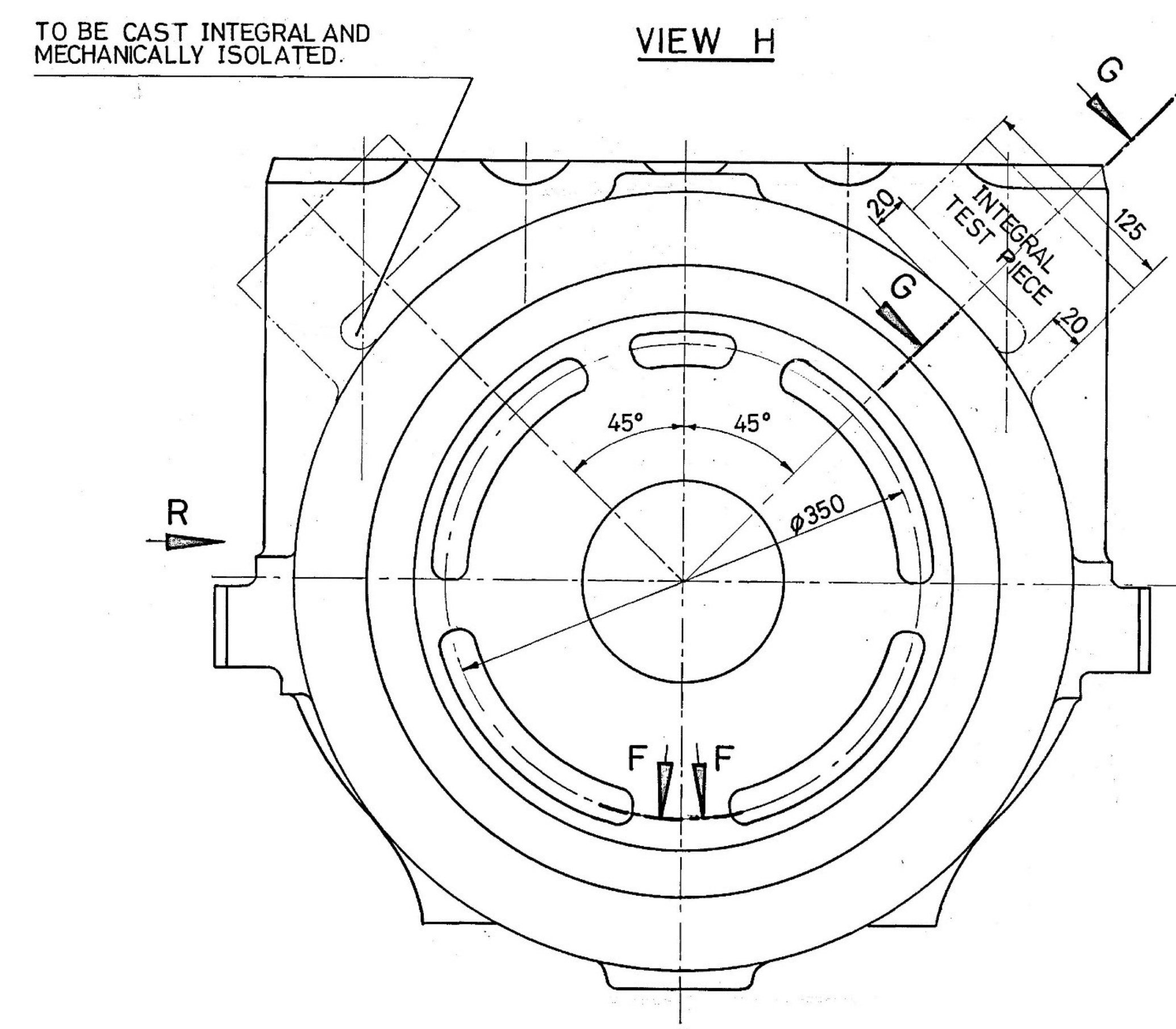
BHARAT HEAVY ELECTRICALS. LTD.  
CENTRAL FOUNDRY FORGE PLANT  
RANIPUR HARDWAR

REV	DATE	ALTERED CHECKED	REV	DATE	ALTERED CHECKED	REV	DATE	ALTERED CHECKED
ZONE			ZONE			ZONE		

DEPTT. FDY. TECH. SCALE N.T.S. WEIGHT NAME SIGN DATE  
TITLE INNER CASING (B2)  
PROJECT AND CUSTOMER NAME TECHNOLOGY NO. 00000  
DRAWING NO. 0-301-02-10008/S  
SHEET NO. NO. OFF SHEETS-2



- NOTES:-
1. CASTING TO BE SUPPLIED IN COMPLETELY ROUGH MACHINED CONDITION AS PER TDC - 0100/75.
  2. AFTER ROUGH MACHINING AND HEAT-TREATMENT THE CASTING SHOULD BE COMPLETELY FREE FROM ANY RESIDUAL INTERNAL STRESSES.
  3. HEAT-TREATMENT PROCESS ACTUALLY FOLLOWED MUST BE SUBMITTED WITH DIAGRAM.
  4. INTEGRAL KEEL BLOCKS ARE TO BE PROVIDED ON THE CASTING AS SHOWN.
  5. TESTS ARE TO BE CARRIED OUT AS PER TDC - 0100/75.
  6. CARRYOUT X-RAY TEST AS PER TDC - 0100/75.
  7. DEGREE OF ACCURACY OF CASTING AS PER DIN 1683/B.
  8. CREEP PROPERTIES FOR THE CASTING MATERIAL CONFORMING TO DIN MATERIAL SPECIFICATION (AS PER ORDER) SHOULD BE GUARANTEED BY THE SUPPLIER.
  9. MARKINGS AS PER TDC 0100/75 TO BE MADE AT PLACES SHOWN THUS....
  10. TO BE HYDRAULICALLY PRESSURE TESTED AT BHEL WORKS. TEST PRESSURE = 4.67 ATG



REV	DATE	ALTERED	REV	DATE	ALTERED	REV	DATE	ALTERED
ZONE		CHECKED	ZONE		CHECKED	ZONE		CHECKED

REV	DATE	DESCRIPTION	REV	DATE	DESCRIPTION	REV	DATE	DESCRIPTION

DEPTT. FOUNDRY TECH. SCALE N.T.S. WEIGHT NAME SIGN DATE

TITLE: INNER CASING (B2)

PROJECT AND CUSTOMER NAME: 00000

TECHNOLOGY NO: 0-301-02-10008/S

DRAWING NO: 0-301-02-10008/S

SHEET NO. 2 NO. OF SHEETS 2