FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

DRG. NO. 2-136-06-30533/00

SH. 01 OF 01

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COMPUTER FILE NAME 2DA1106A.DWG

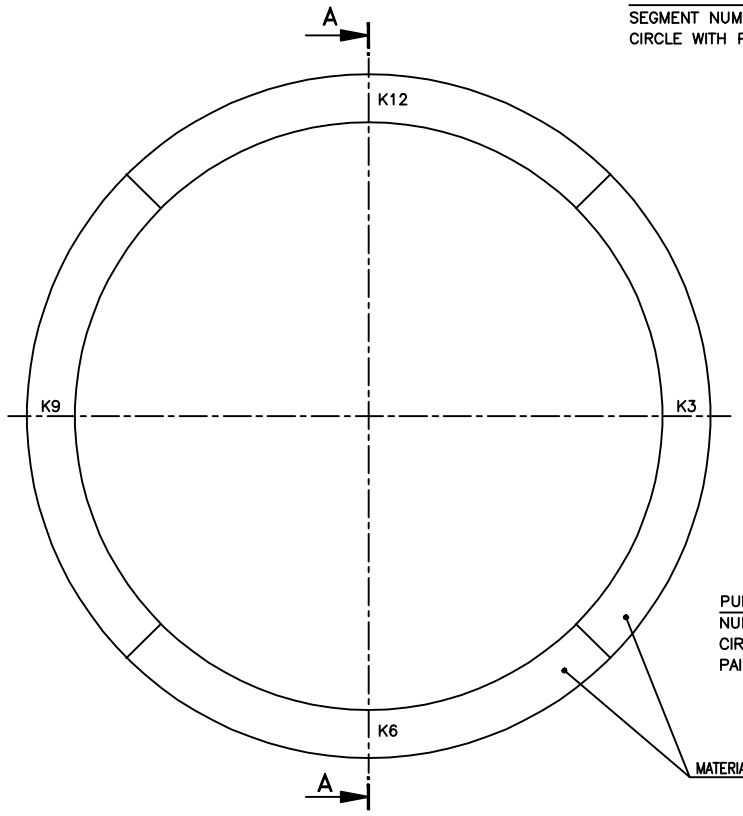
REF. DRG. NO. HY0230261

SIGN. AND DATE

INVENTORY NO

GENERAL DIMENSIONAL LIMITS,FITS & TOLERANCES AS PER HY0230261

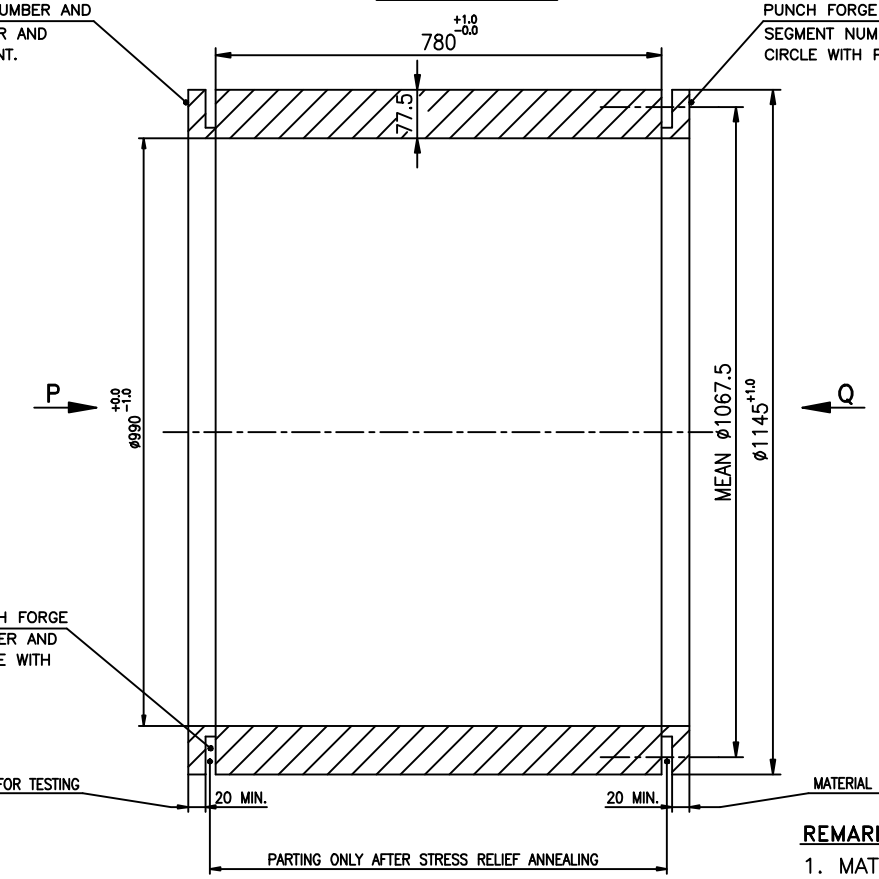
VIEW–Q



INGOT BOTTOM

PUNCH FORGE NUMBER AND SEGMENT NUMBER AND CIRCLE WITH PAINT.

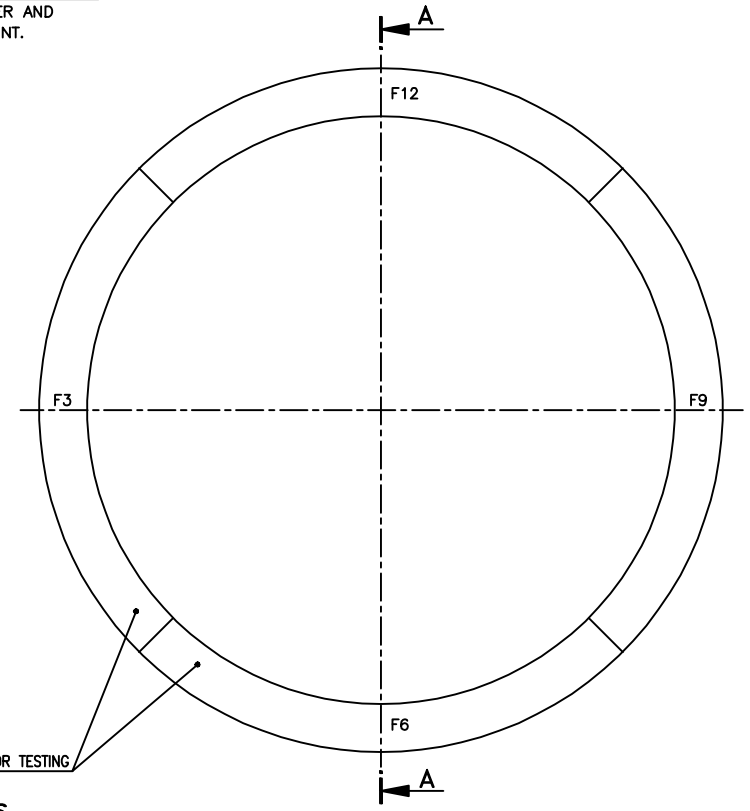
SECTION–A–A

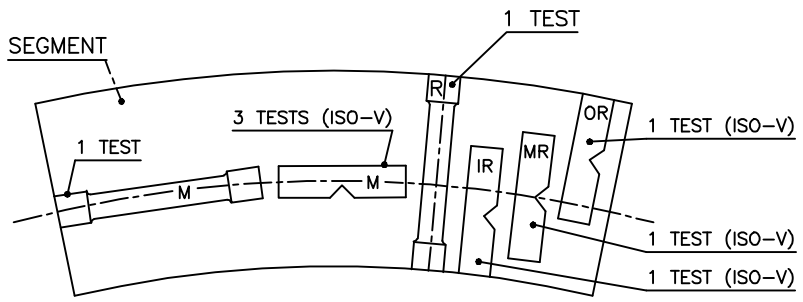


INGOT TOP

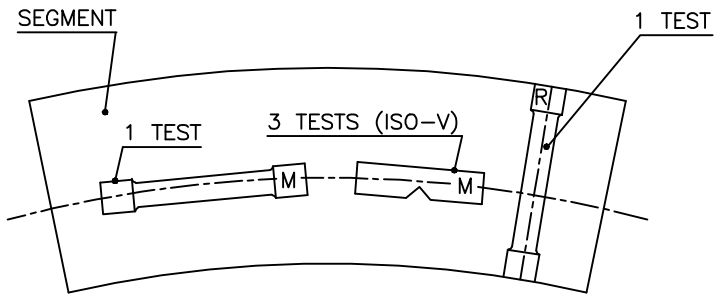
PUNCH FORGE NUMBER AND SEGMENT NUMBER AND CIRCLE WITH PAINT.

VIEW–P





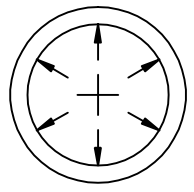
TEST PROBES FROM SEGMENTS K3 & F6



TEST PROBES FROM SEGMENTS K9 & F12

M : MEAN DIA
IR : INNER RADIAL
OR : OUTER RADIAL
R : RADIAL
MR : MEAN RADIAL

TYPE OF LOAD



REMARKS

1. MATERIAL OF THE FORGING: X8 Cr Mn N18 18K.
2. SPECIFICATION: HY 19372/01 (VAR 14)
3. SURFACE FINISH OF THE FORGING: $\overset{3.2}{\nabla}$ (MICRONS C.L.A.)
4. **MECHANICAL PROPERTIES:**
   - 0.2% PROOF STRESS : 1150 N/mm^2 Min.
   - ELONGATION (L=5d) : 16% Min.
   - REDUCTION IN AREA : 53% Min
   - IMPACT STRENGTH(ISO–V) : 78 J Min.
5. THE DRAWING REFERS TO ROUGH MACHINED RETAINING RING FORGING.(VAR.01) NO ADDITIONAL ALLOWANCES NEED BE GIVEN OVER THOSE SHOWN ABOVE.
6. THE RING WILL BE SUBJECTED TO THE TYPE OF LOAD SHOWN IN THE FIGURE.

ITEM NO.	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG. NO. OR FORGING DRG. NO.	MATERIAL CODE	NET WT.	GROSS WT.
	RETAINING RING FORGING	2–136–06–30533	00		TG9517250428	1591	
					HY19372	2	
					MATERIAL SPECN.	QUANTITY	

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED.

1. REF. TO HY 0230261 FOR UNSPECIFIED TOLERANCES.
2. CHAMFER M/CD. SHARP EDGES 1.2 TO 1.0 AT 45°.
3. INTERNAL M/CD. CORNER RADII 1 TO 0.7
4. THE SURFACE ROUGHNESS WHEREVER NOT SHOWN SHALL BE TAKEN FROM THE SURFACE ROUGHNESS SHOWN OUT SIDE THE BACK SLASH GIVEN ON THE TOP MOST RIGHT CORNER OF THE DRG.

TYPE OF PRODUCT: TARI 1080–36Q

NAME OF CUSTOMER/PROJECT

BHARAT HEAVY ELECTRICALS LIMITED
HYDERABAD

	NAME	SIGN.	DATE	NO.OF VAR.
DRN.	A.ANAND		11.10.08	NA
CHD.	SHAUKAT		11.10.08	
APPD.	U.SRIDHAR		11.10.08	

DEPT.	SCALE	WEIGHT (KG)	REF. TO ASSY DRG.	ITEM NO.	NO.OF ITEMS
EME	N.T.S	1591	1–136–06–31044	2	NA
CODE 425					

TITLE: RETAINING RING FORGING

CARD CODE: NA

DRAWING NO. 2–136–06–30533 REV. 00

SHEET NO. 01 NO OF SHEETS 01

REV.	DATE	ALTD / CHD.	APPD.	ZONE