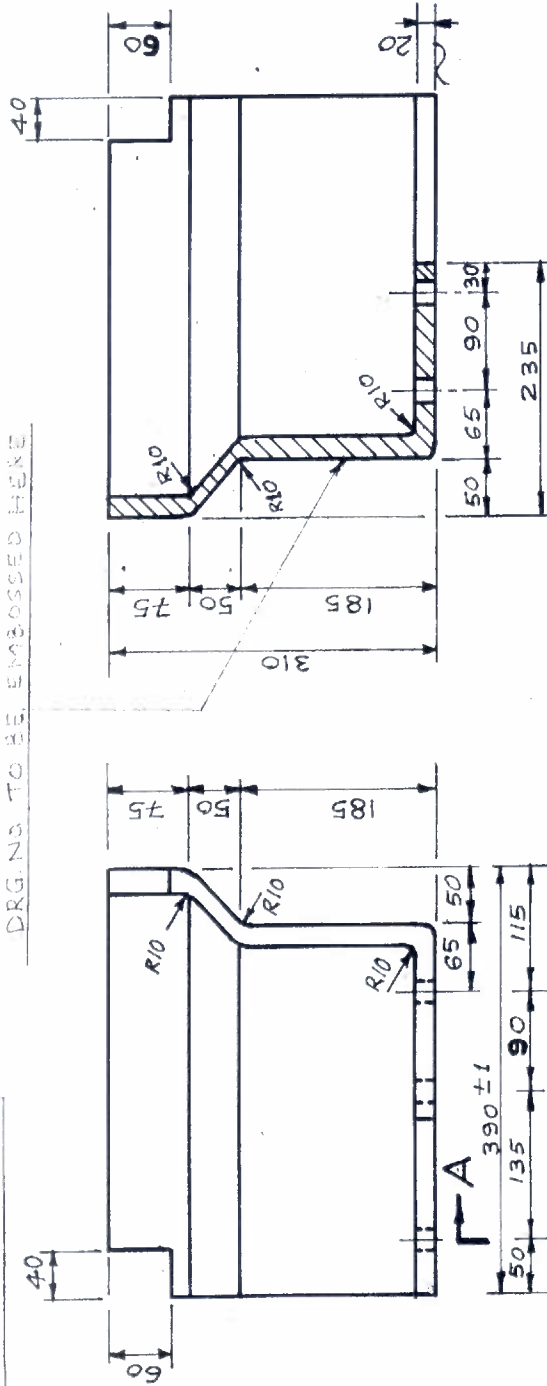


FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

DRAWING NUMBER

BOGIE CURB CASTING

DRG.NG TO BE EMBOSSED HERE



SECTION-A-A

TEST	UNIT	GRADE	C	S	P	SI	Mn	Ni	Cr	Mo	N	Fe
HEAT RESISTANT	HEAT RESISTANT	J92655 A297, A508	0.50	0.04	0.04	2.0	1.0	2.0	26.0	0.5	0.15	Rem
		J93005 A297, A608	0.5	0.04	0.04	2.0	1.0	2.0	26.0	0.5	0.15	Rem
		J93103 A297, A608	0.5	0.04	0.04	2.0	1.0	2.0	26.0	0.5	0.15	Rem
			3.1			2.0		0.8	1.5			
			3.5			2.8		1.2	2.0			

TYPE OF PRODUCT

OR

NAME OF CUSTOMER / PROJECT

NOTE: SURFACES MARKED \cup TO BE SMOOTH FINISHED BY SHOT BLASTING OR GRINDING.

TEST PIECE MAY BE CAST INTEGRALLY ANY SUITABLE / CONVENIENT PLACE OF EACH CASTING

REV	DATE	BY	DATE	BY	DATE	BY
R2	24/11/18	P1	18/10/18	P1	18/10/18	P1

W.T. RECALCULATED & REORGANIZED MATERIAL ADDED

BHARAT HEAVYELECTRICALS LTD.
 UNIT: C.F.F.P., HARDWAR.

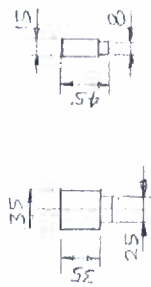
CORNER CURB CASTING (TYPE-1)

DEPT. DESIGN | SCALE 1:5 | WEIGHT (KG) 48.8 | REF. TO ASSY. DRG.

DRAWN: GUPTA | NAME: GUPTA | SIGN: [Signature] | DATE: 15.3.81

APPROVED: [Signature] | DRAWING NO: 01,01,018 | SHEET NO. 1 | NO. OF SHEETS: 1

Dimensions to be Controlled Within Limits as Shown
 Machining Tolerance + 25 mm Unless Otherwise Shown, Non Machining Tolerance ±



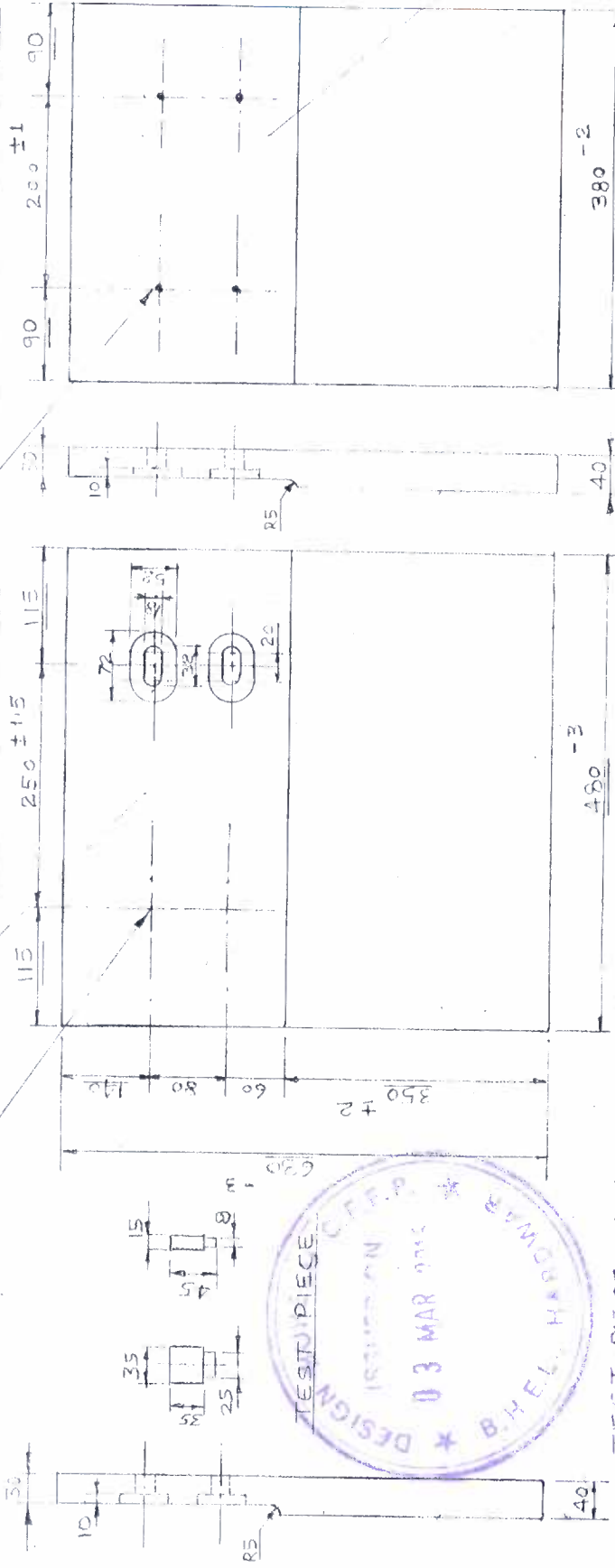
The information on this document is the property of BHARAT HEAVY ELECTRICALS LIMITED. It must not be used directly or indirectly in any way detrimental to the interest of the company.

FOR HR (C) 312148 WESMAN FURNACE Ref. Drg. No. 18/10/18

REV.	DATE	BY	WT. RECALCULATED
R3	24/11/01		

4 SLOTTED COUNTER BORE HOLES

DRG. NO. TO BE EMBOSSED HERE



NOTE: THESE CASTINGS MAY BE CAST INTEGRALLY AT ANY SUITABLE/CONVENIENT PLACE OF EACH CASTING.

LDO FIRED RH FURNACES (TEMP. 1350°C)

QTY. REQD.

ITEM - 1

ITEM - 2

MATERIAL: HEAT-RESISTING STEEL.

COMP : C : 0.2
Si : 0.7
CR : 30.0
OB : 1000°C
T : 700°C

MAX. SERVICE TEMP.: 1150°C

MATERIAL: HEAT RESISTING C.I.

C : 3.1% - 3.5%
SI : 2% - 2.8%
NI : 0.8% - 1.2%
CY : 1.5% - 2%

NO	DISCRPTIONS	ITEM	ITEM
1	2	1	2
1.	7 M.W. R.H.F.	5	3
2.	10 M.W. R.H.F.	2	4
3.	8 M.W. R.H.F.	1	3
4.	10 M.VULCAN RHF	4	-
5.	9 M. R.H.F. / H.F.S.	5	3

R1 29.7
R2 15.6

ADD ALTERNATIVE MATERIAL

NO	DISCRPTIONS	ITEM	ITEM	UNIT	QTY	MO	N	FC
1	2	1	2	1	2	1	2	1
1.	HC J92605 A 2977 AG08	0.50	0.04	0.04	2.0	1.0	2.0	0.15
2.	HC J92605 A 2977 A 308	1.5	7.0	1.5	7.0	1.5	7.0	0.15
3.	HC J92605 A 2977 A 308	2.0	11.0	2.0	11.0	2.0	11.0	0.15

BHARAT HEAVY ELECTRICALS LTD.
UNIT : CENTRAL FOUNDRY FORGE PLANT.
HARDWAR.

DEPTT.	F. E.	SCALE	1:1.5	WEIGHT (KGS)	82.8
TITLE	FRONT. DOOR SEAL CASTING (TEMP. FURNACE)				
DRAWN			WORKED	CHECKED	APPROVED
NAME			ASHTA	ASHTA	ASHTA
SIGN.			DATE	10-5-01	
DRAWING NO.			01/0156	REV. R3	
SHEET NO.			1	NO OF SHEETS 1	

FF 8121011363 (ITEM 2) FOR HR. STEEL
FF 8121011345 (ITEM 4) FOR HR. C.I.
FF 8121011388 (ITEM 1) FOR HR. STEEL

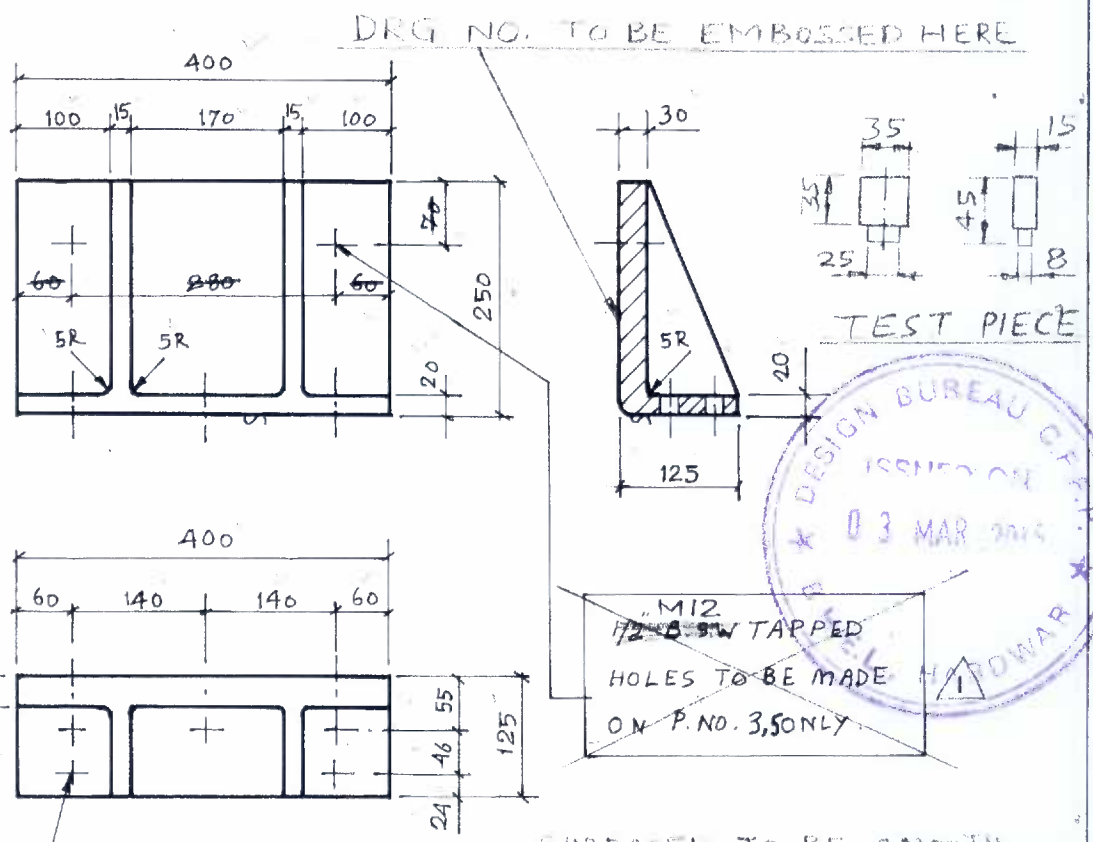
DRG. NO. TO BE EMBOSSED HERE

FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

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REV	DATE	ALTERED	REV	DATE	ALTERED	REV	DATE	ALTERED
1	25.11	K. S. Singh	2	15.12.07	Change of Dr. Hole	3	24.10.11	K. S. Singh
		CHECKED			CHECKED			CHECKED
TAP, P.D. & NUT REQUIRED			WT. RECALCULATED					

NOTE:-
TEST PIECE MAY BE CAST INTEGRALLY AT ANY SUITABLE/ CONVENIENT PLACE OF EACH CASTING



5 Nos, 18φ DRILLED HOLES-FOR M16 BOLTS.

SURFACES TO BE SMOOTH FINISHED BY SHOT BLASTING OR GRINDING.

R2 HEAT RESISTANT STEEL :-

ACT. DESG.	GRADE	UNS. NO.	ASTM. SPEC.	C	S	P	Si	Mn	Ni	Cr	Mo	N	Fe
HC	J92605	A297	A608	≤ 0.5	≤ 0.04	≤ 0.04	≤ 2.0	≤ 1.2	≤ 2.0	≤ 26.0	≤ 0.5	≤ 0.15	REMN.

HEAT RESISTANT C.I

3.1	-	-	2.0	-	0.8	1.5	-	-	-
3.5	-	-	2.8	-	1.2	2.0	-	-	-



BHARAT HEAVY ELECTRICALS LTD.
UNIT: C.F.F.P., HARDWAR.

DEPT.	CODE	SCALE	WEIGHT (KG)	REF. TO ASSY. DRG.	ITEM NO.
		1:12.5 1:7.5	31.8		

SIDE, TOP & BOTTOM CASTING			
TYPE: I P. NO. 2.3 & 5			
7 M. FURNACE			
DRAWN	NAME	SIGN.	DATE
CHECKED			
APPROVED			

Dimensions to be Controlled Within Limits as Shown	CARD CODE	DRAWING NO.	15 16 REV. 17
Machining Tolerance + 25 mm Unless Otherwise Shown. Non Machining Tolerance ±		01.01.011	3
SHEET NO. 1		NO. OF SHEETS. 1	

312149 WESMAN Ref. Drg. No.
FF812101155 FOR HR (C.I.)
FF12101154 FOR HR (STEEL)
Inventory No.

FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

DOOR CASTING



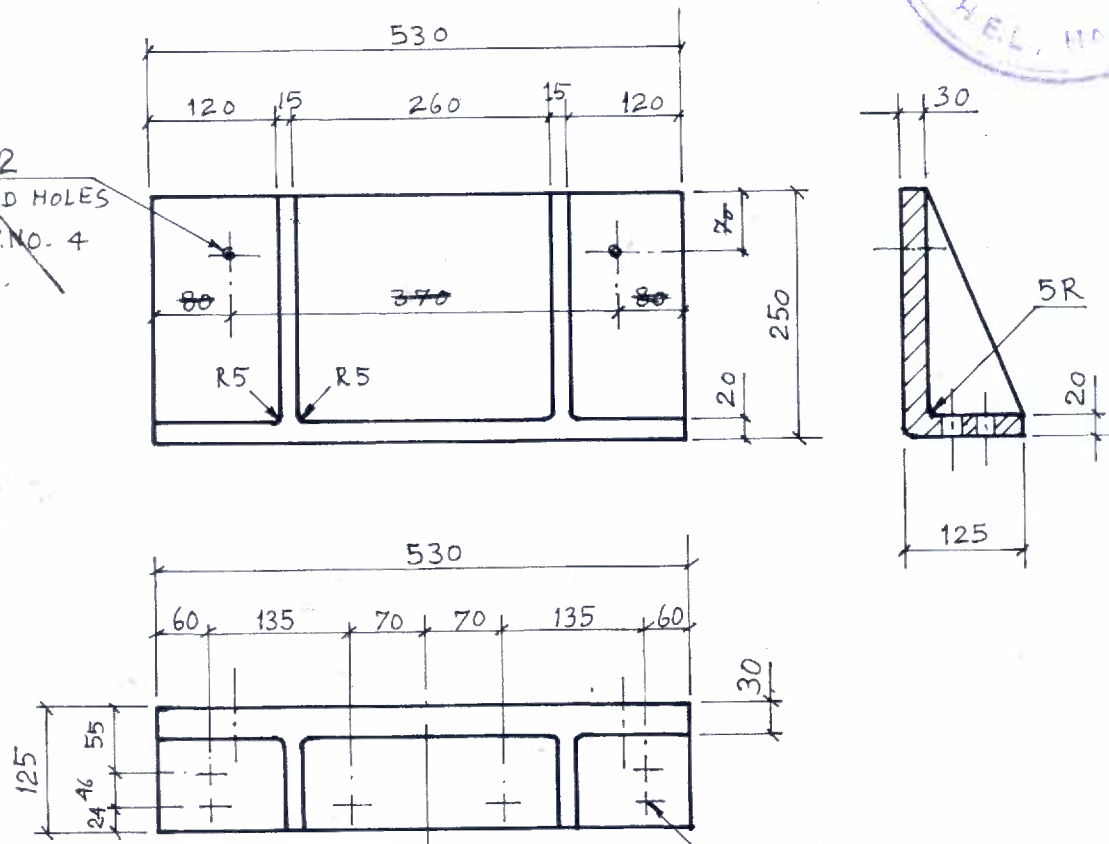
REV	DATE	ALTERED	REV	DATE	ALTERED
1	12-11-10	Checked	R2	5-8-11	Checked
TYPE: P. NO. 2.4 & 7			Change of the Material		
REVISION: 1					

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312077 WESMAN

FFR12101110-01
FF 02101110-05
Inventory No.

M 12
TAPPED HOLES
FOR P.NO. 4
ONLY.



SURFACED TO BE SMOOTH FINISHED BY SHOT BLASTING OR GRINDING. 6 NOS. ϕ 18 DRILLED HOLES FOR M16 BOLTS

R2	HEAT RESISTANT STEEL :-											
ACI	GRADE		C	S	P	Si	Mn	Ni	Cu	Mo	N	FC
DESG	UNS. NO.	ASTM SPEC.	\leq	\leq	\leq	\leq	\leq	2.0 4.0	0.5 0.2	\leq	\geq	REM.
HC	J92605	A297-A608	0.15	0.04	0.04	2.0	1.0			0.5	0.15	
HEAT RESISTANT C.I												
			3.1 3.5	-	-	2.0 2.8	-	0.8 1.2	1.5 2.0	-	-	-



BHARAT HEAVY ELECTRICALS LTD.
UNIT: C.F.F.P., HARDWAR.

DEPT.	CODE	SCALE	WEIGHT (KG)	REF. TO ASSY. DRG.	ITEM NO.
		N.T.S.	31.00		
SIDE, TOP & BOTTOM CASTING P.NO. 2.4 & 7 10M FURNACE				NAME	DATE
				Ashok	3-3-81
				Checked	22-9-81
				APPROVED	

Dimensions to be Controlled Within Limits as Shown Machining Tolerance + .25 mm Unless Otherwise Shown. Non Machining Tolerance \pm	CARD CODE	DRAWING NO. 01.01.005	15 16 REV. 17 2
SHEET NO. 1		NO. OF SHEETS, 1	