

 EC-002	PURCHASE SPECIFICATION	TBV	001
	TECHNICAL DELIVERY CONDITIONS FOR BALL-SEAT RING ASSEMBLY	Rev. No.	00
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- 1.0 Component : Ball-Seat Assembly
- 1.1 Material Code : 964655840000 (8-C300-CF8M-BA51)
964656120000 (8-C300-CF8M-BA01)
- 2.0 Scope : It includes the manufacturing of individual components, lapping and their assembly. Material / assembly should be dispatched in lapped condition.
- 3.0 Specifications :
- 3.1 Dimensions : Refer the individual drawings of components and assembly for dimensions and tolerance's.
- 3.2 Manufacturing : Manufacturing / workmanship of Ball, Seat Rings and Assembly must be as per individual and assembly drawings mentioned under list of drawings.
- 4.0 Inspection and Testing : 1. Inspection shall be carried out by BHEL /Third Party Inspector (TPI) at supplier's works.
2. Test certificate should be supplied including raw material, coating thickness, surface finish after lapping and assembly.
- 5.0 Marking / Identification : Material code should be legitimately printed /marked on each assembly.
- 6.0 Packing and Dispatch : a) The components should be covered with material like thermocol to avoid any surface damage during transit and handling.
b) Ball-Seat assembly must be packed in Sea worthy packing in such a manner that there should not be any damage to surface of components and assembly during the transit.
- 7.0 Storage : Ball-Seat Ring assembly must be stored under covered area. The storage area should be dust free.
- 8.0 Critical check points : a) Visual check for any deformation / deviation.
b) Dimensional check as per drawing.
c) After lapping, the sealing impression of ball with the seat rings to be ensured for continuity with help of blue matching.

Rev: 00 Dt.:11.01.2014	<i>BHEL, IVP, Goindwal Sahib</i>	
Ravinder Singh (Prepared By)	Ravinder Singh (Checked By)	Rakesh Kumar (Approved By)

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LIST OF DRAWINGS / FIGURES

1.	964655840000	:	8-C300-CF8M-BA51
1.1.	3-V-BA51-25285	:	BALL-SEAT ASSEMBLY (BA51)
1.2.	3-V-BA51-25220	:	SEAT RING - DOWNSTREAM
1.3.	3-V-BA51-25219	:	SEAT RING - UPSTREAM
1.4.	3-V-BA51-25221	:	BALL 8"-C300-FLOATING
2.	964656120000	:	8-C300-CF8M-BA01
2.1.	3-V-BA01-25318	:	BALL-SEAT ASSEMBLY (BA01)
2.2.	3-V-BA01-25067	:	SEAT RING
2.3.	3-V-BA01-25069	:	BALL 8"-C300-TRUNNION

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