THE REST

SECTION B-B

SECTION A-A

SECTION C-C

SECTION D-D

VIEW W
SCALE 1:10

SECTION L-L
(SCALE 1:2·5)

VIEW V
(SCALE 1:1)

DETAIL-II
(SCALE 1:1)

DETAIL-I
(SCALE 1:1)

SECTION E-E
SCALE N.I.S.

16 THREADED HOLES EQUALLY SPACED ON CIRCUMFERNCE

4 HOLES M10 DRILLED DEPTH 19·5 THREADED DEPTH 12

REFER T. R. 7

MACHINING ALLOWANCE IS TO BE MERGED WITH CONTOUR

GRIND A SMOOTH CONTOUR AT PASSAGE

DEPTH OF BORE 193 +1
DEPTH OF THREAD 12

EDGES = 0·2 CHAMFERED

TECH. REQTS:—

1. ALL THE INNER SPACES ARE OIL SPACES AND THE SAME MUST BE CLEANED FROM MOULDING SAND AND MACHINING CHIPS.
2. THE CASTING SHALL BE SUPPLIED IN ROUGH MACHINED CONDITION WITH 3±1 mm ALLOWANCE ON ALL SURFACES MARKED WITH MACHINING SYMBOL ▽.
3. THE CASTING SHALL BE SUPPLIED TO MEET FULL THE REQUIREMENTS AS PER HW 19799.
4. THE CASTING SHALL BE SUBJECTED TO HYDRAULIC TESTING AT 25 ATA FOR 10 MINUTES AS PER HW 0981001 AFTER FINISH MACHINING AT HEEP HARDWAR ALONG WITH ITS COVER. THE SUPPLIER SHALL TAKE NECESSARY PRECAUTIONS TO AVOID LEAKAGE OF CASING DURING PRESSURE TESTING.
5. THE SUPPLIER'S EMBLEM AND DRG. NO. SHOULD BE CAST ON AND THE CASTING IDENTIFICATION NO. SHALL BE PUNCHED AT A PLACE MARKED ON THE DRG. AS PER ST 00004 AND SHALL BE ENCIRCLED WITH PAINT.
6. HOLES LESS THAN ⌀40 SHALL NOT BE MACHINED BY SUPPLIER.
7. HOLES A AND B OF THE CASING DRG. NO 0114 04 18011 (ZONE E-13,14) SHOULD BE COINCIDED WITH TH CORRESPONDING HOLES A AND B OF I. P. C. V. SERVOMOTOR COVER DRG. NO. 0-114 04-18001 (ZONE D-14,13). THIS MUST BE ENSURED BY THE CASTING SUPPLIER OF THE CASING & COVER
8. THE CASTING SHALL BE SUBJECTED TO KEROSENE OIL TESTING AS PER BHEL STANDARD NO. 0933-003 ALTERNAT FLUID HAVING SIMILAR VISCOSITY AS KEROSENE CAN ALSO BE USED SUBJECT TO PRIOR APPROVAL FROM BHEL.

CASTING	01	I.P.C.V. SERVOMOTOR	0-114-04-18011		00	W.O. 01-04-12 HW 19799				280	CG
VAR OO	REMARKS	ITEM No.	DESCRIPTION	STD	DRAWING No.	VAR	MATERIAL SPECN	UNIT	UNIT WEIGHT (KG)		STS

GMS No./GR. SP. No. GMS 01140018200 — STATUS OF DRG: A

	NAME	SIGN	DATE
MTE	PK S		23-6-97
S.T.T	NCT		25/6/97

DISTRIBUTION :- STM-4 TGX-STM-1 FBM-4 STE-1

GRADE OF UNTOL. DIM:-
MCG. :- E/M/F/ AA 023 0208
WELDING :- T1' 0 810.003
GAS CUTTING :- T3' AA 0621101

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT: STEAM TURBINE

BHARAT HEAVY ELECTRICALS LTD. BHOPAL

	NAME	SIGN	DATE
DRN	A.E.D.D		
CHD	R.C.A.		
APPD	B.S.S		2/9/97

SCALE 1:2·5 — WEIGHT (KG) 280 — REF. TO ASSY. DRG. 0-114 04-18200 — REV 01

TITLE: I.P.C.V. SERVOMOTOR CASING

DRAWING No. 0-114 04-18011 — CARD CODE — SHEET No. 01 — No. OF SHEETS

REV	DATE	ALTERED	CHECKED
02	24/12/96	CHANGED AS PER C/A No. STE-02-02259	
01	27-7-96	CHANGED AS PER C/A No. STE-96-1482	