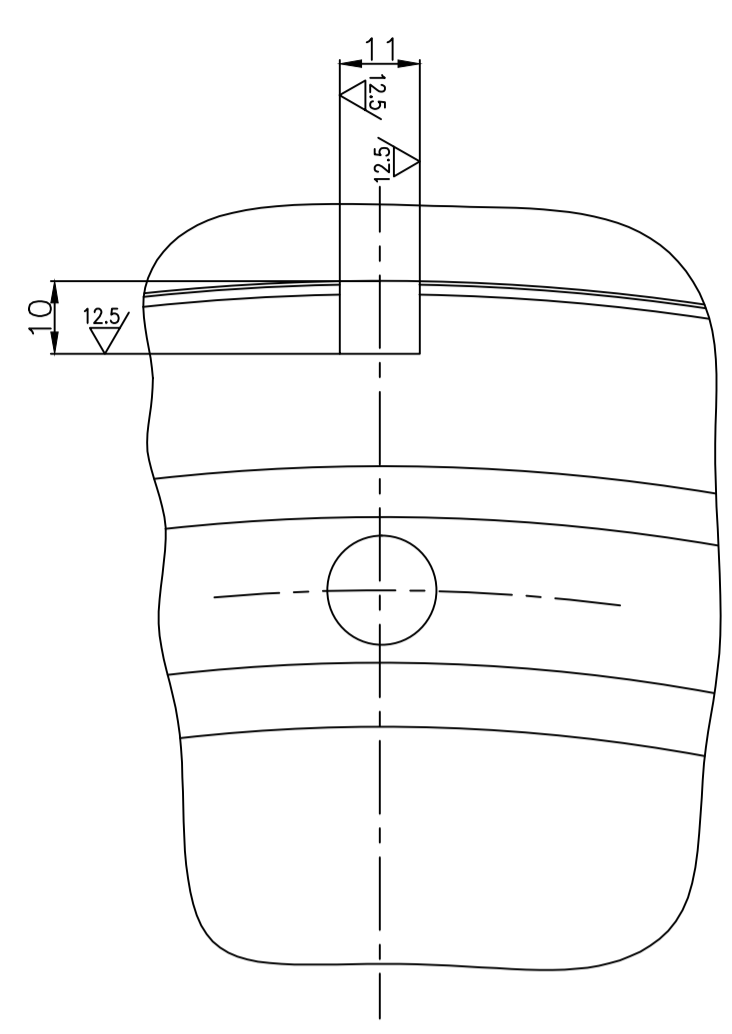
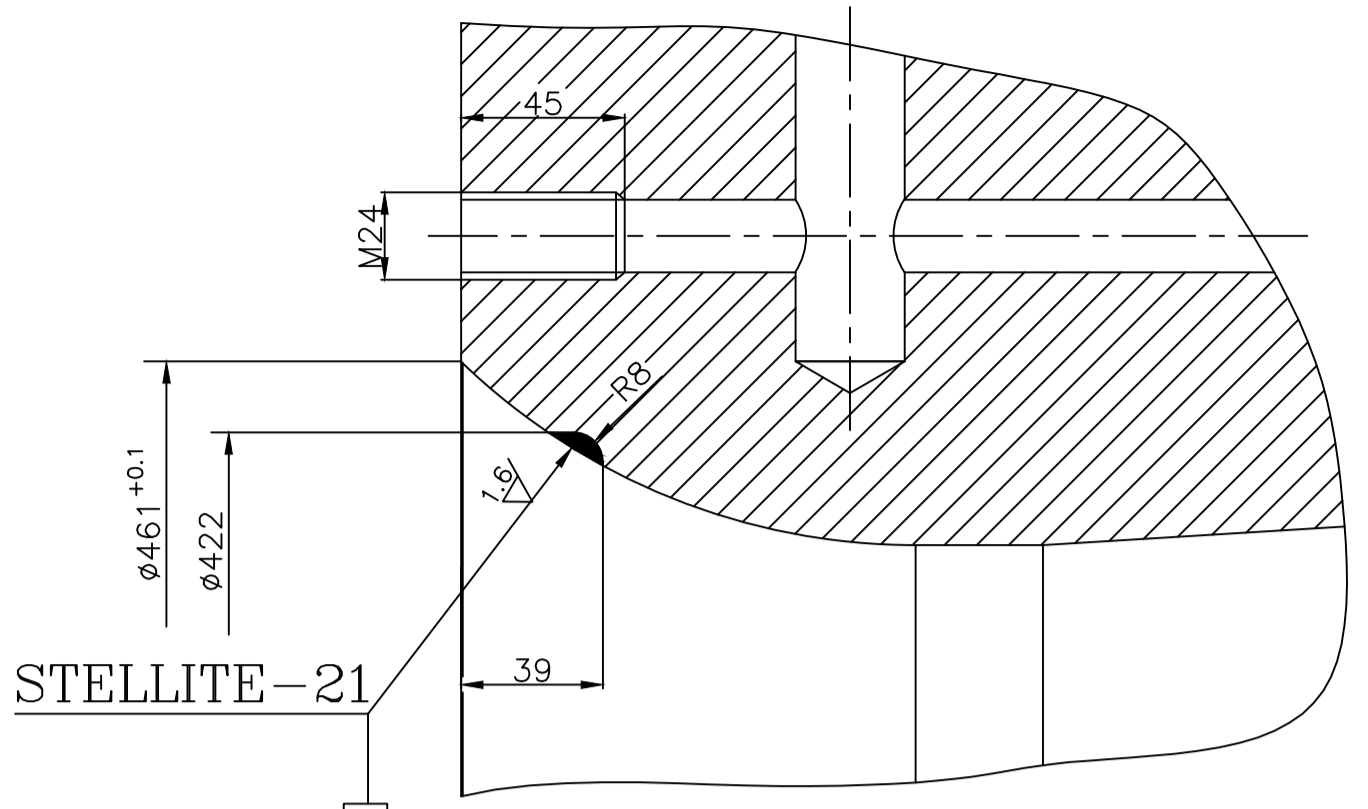


11029-121-11321-57011
DRG. NO. 1-11321-57011

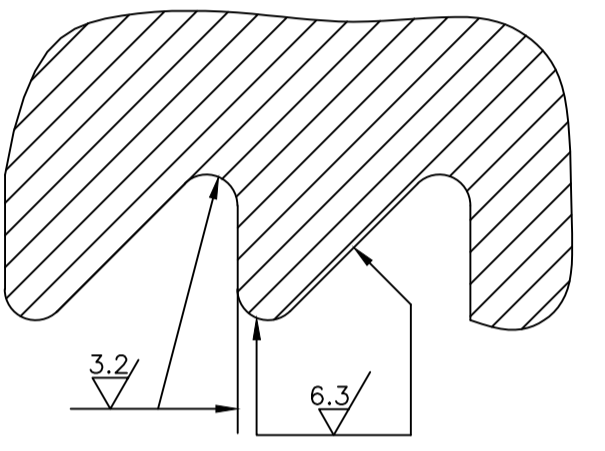
3/2 ALL OVER UNLESS OTHERWISE STATED



VIEW R
SCALE 1:1



DETAIL-II
SCALE 1:2.5



DETAIL-III
NTS

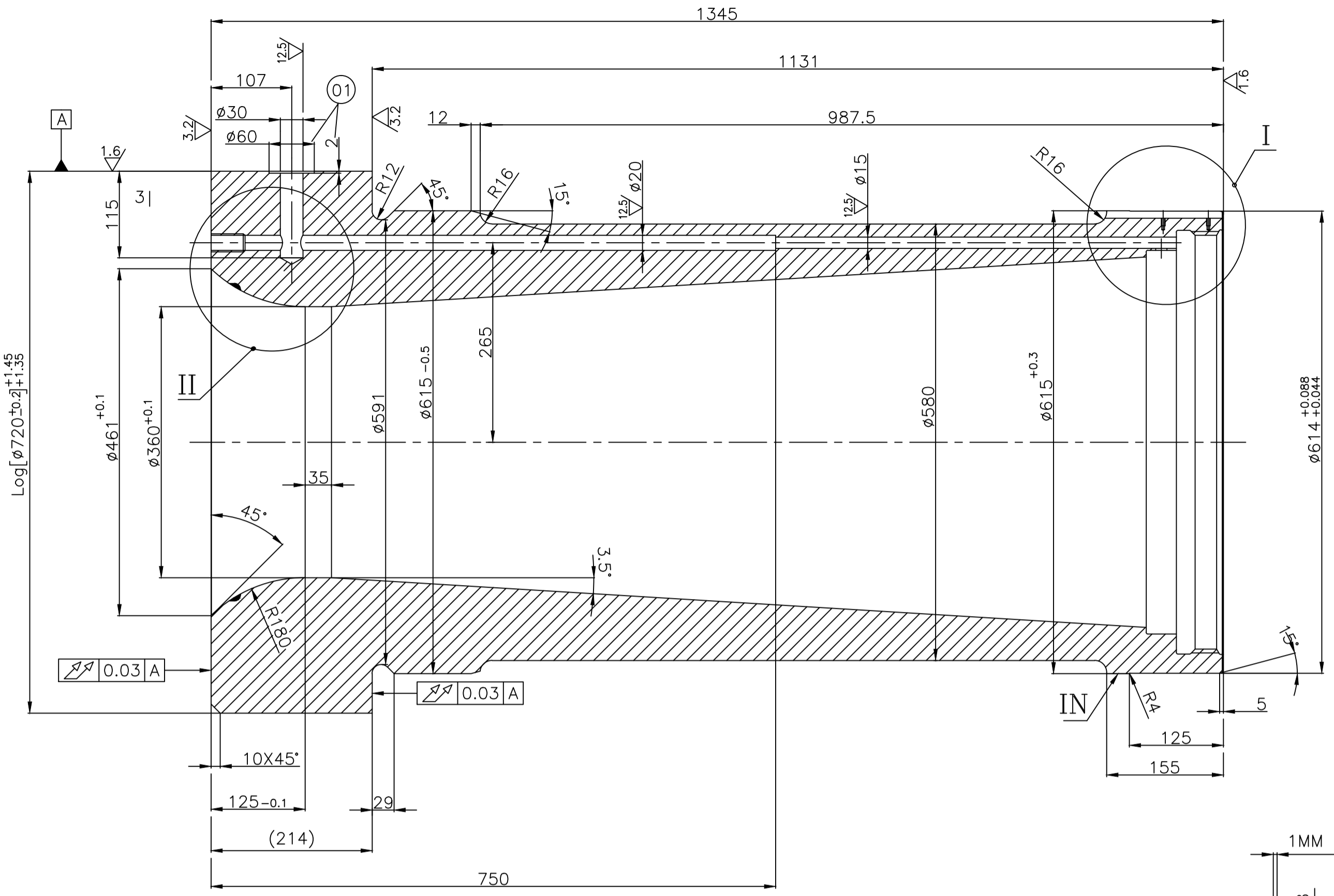
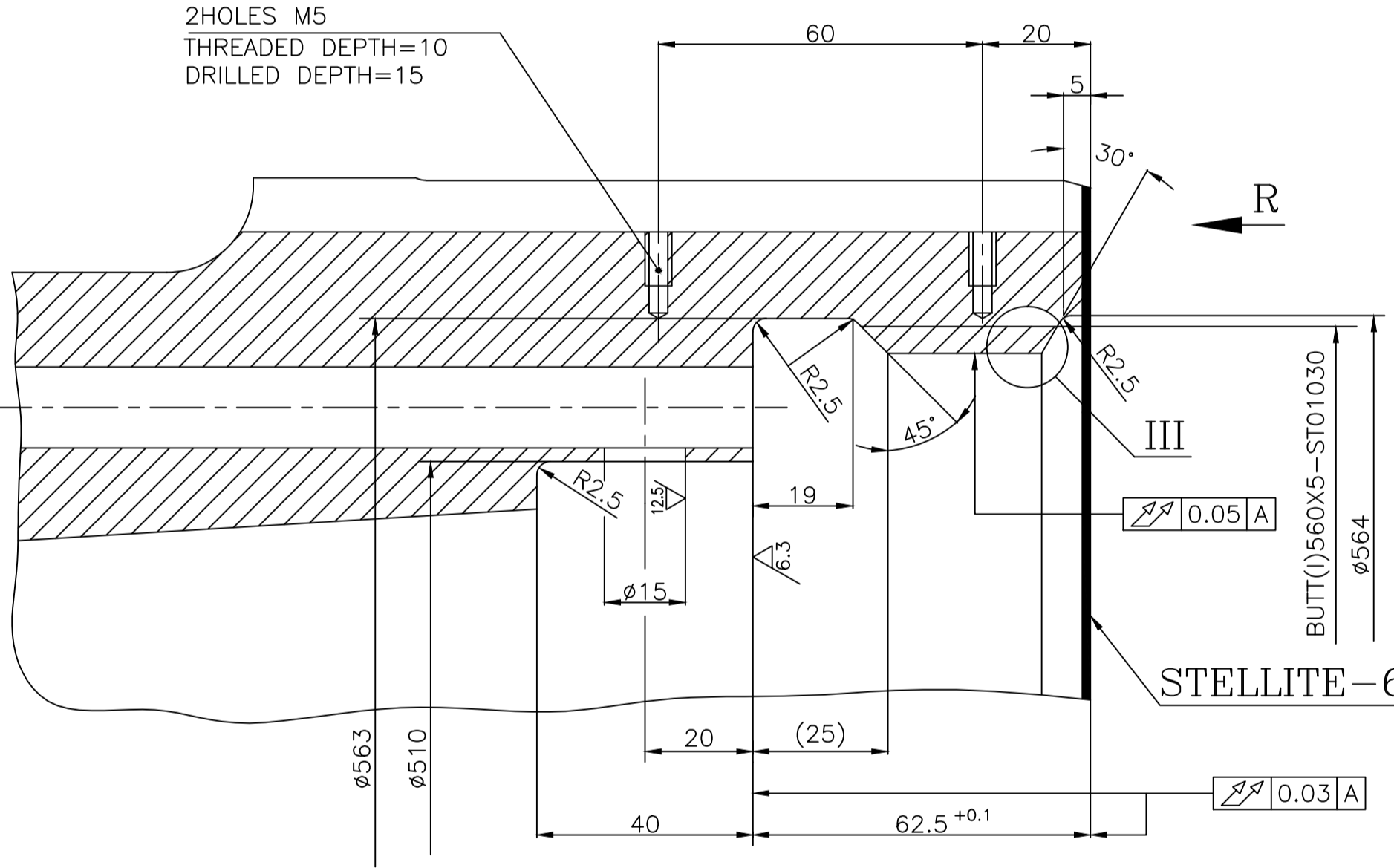
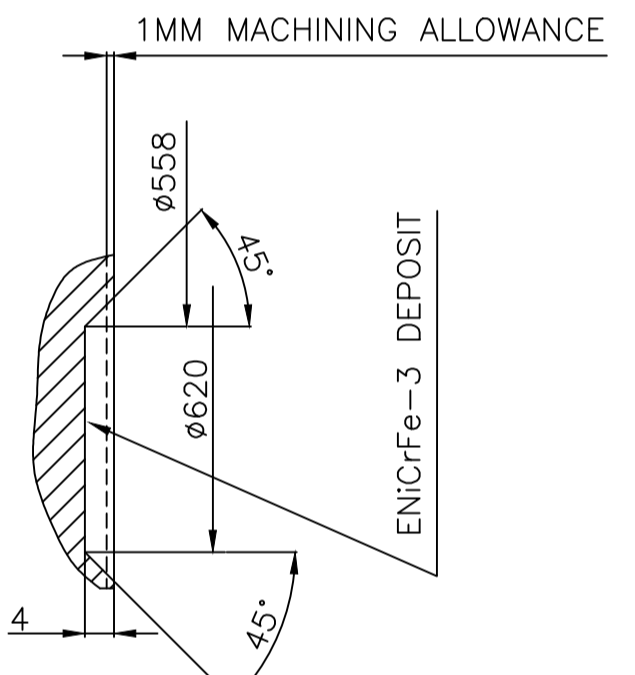


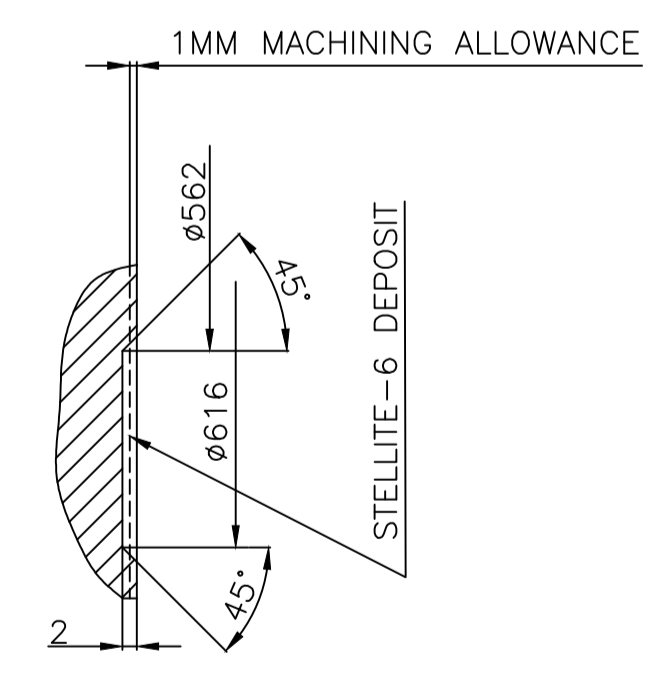
FIG.1- PRESTELLITE DETAIL FOR STELLITE-6 DEPOSIT WITH BUFFER LAYER OF ENICrFe-3 & DEPOSIT OF STELLITE-21
SCALE 1:5 (3/2 EXCEPT OTHERWISE STATED)



DETAIL-I
SCALE 1:1



DETAIL-X1
SCALE 1:1



DETAIL-X2
SCALE 1:1

TECH. REQUIREMENTS:-

1. ALL UNDIMENSIONED EDGES SHALL BE CHAMFERED TO 0.5X45°.
2. PRE-STELLITING MACHINING DETAIL SHALL BE ACC. TO FIG.1.
3. STELLITE-6 WITH BUFFER LAYER OF ENICrFe-3 SHALL BE DONE AS PER DETAIL X1
4. STELLITE-21 SHALL BE DEPOSITED ACC. TO HW0610199 ON THE SURFACES SHOWN AS
5. IDENTIFICATION SHALL BE DONE AS PER HW 0400397 AT THE PLACE MARKED WITH IN.

NOTE:-

1. ROUGH MACHINED CASTING DRG. NO. 2-11321-57902
2. MATERIAL HW19581(GS-17CRMOV5-10/STELLITE-6 & STELLITE-21)
3. MATERIAL CODE : W92311321307

GMS No. / C.B.O.M. - NO. CBOM 01132157000		STATUS OF DRG		TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT	
AGREED DEPT	NAME	SIGN	DATE	STEAM TURBINE	
MTE	S.SARKAR	-sd-	18.08.07	BHARAT HEAVY ELECTRICALS LTD.	
WT	P.NATH	-sd-	21.08.07	RANIPUR, HARDWAR	
GRADE OF UNTOL.DIM				DRN	R.P.S
M/C.G.-Ø/M/F AA0230208				CHD	BS GUPTA
WELDING-Ø/B/Ø/Ø AA0621104				APPD	BS GUPTA
GAS CUTTING -T3-AA0621104				DATE	24/08/07
REV	DATE	ALTERED	REV	DATE	ALTERED
		CHECKED			CHECKED
01					
CHANGES MADE AS PER C.A.NO.-STE-08-F0228				DEPT	STE
				CODE	4011
				TITLE	DIFFUSER
				SCALE	1:5
				WEIGHT (KG)	1850.00
				REF. TO ASSY. DRG.	0-11321-57010
				ITEM NO.	001
				DRAWING NO.	1-11321-57011
				CARD CODE	7
				SHEET No.	01
				No. OF SHEETS	01

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INVENTORY NO. SIGN. AND DATE
REF. DRG. NO. & DATE
PDC186324 & 180219