



- NOTES:-**
1. MATERIAL : CARBON STEEL CASTING TO BHEL SPEC. NO. TM111486.
 2. CASTING SHALL BE CAREFULLY SCALED AND CLEANED.
 3. REMOVE ALL SHARP EDGES AND CORNERS.
 4. FIRM SHOULD HAVE THEIR OWN FOUNDRY DULY APPROVED BY ROSO AS CLASS-A FOUNDRY FOR CASTING THE RAW MATERIAL OF SPECIFIED GRADE (CARBON STEEL CASTING TO IS:1030/89 GRADE-230-450W) FOR ITEM STATOR CHAMBER/DE & NDE OR THEY HAVE TO SUBMIT ADEQUATE DOCUMENTARY EVIDENCE REGARDING SOURCING OF RAW MATERIAL (CASTING) FROM ROSO APPROVED CLASS-A FOUNDRY ONLY.

GENERAL TOLERANCE FOR LINER AND ANGULAR MEASUREMENTS FOR MACHINING ACCORDING

RATED MEASUREMENTS	>0.5	>3	>6	>30	>120	>400	>1000	>2000	>4000	>8000	>12000	>18000	20000
DAUGHTON GRADE	±0.1	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4	±5	±6

SURFACE ROUGHNESS VALUE TO IS:3073

SYMBOL	GRADE NUMBER	N11	N10	N9	N8	N7	N6	N5	N4
Ra (µm)	25	12.5	6.3	3.2	1.6	0.8	0.4	0.2	

REVISIONS

REV	DATE	DESCRIPTION	BY	CHKD
01	02/05/11	ISSUED FOR MFG		
02	27/11/11	REVISIONS		
03	29/12/12	REVISIONS		
04	05/05/13	REVISIONS		
05	05/05/13	REVISIONS		
06	05/05/13	REVISIONS		
07	05/05/13	REVISIONS		
08	05/05/13	REVISIONS		
09	05/05/13	REVISIONS		
10	05/05/13	REVISIONS		
11	05/05/13	REVISIONS		
12	05/05/13	REVISIONS		
13	05/05/13	REVISIONS		
14	05/05/13	REVISIONS		
15	05/05/13	REVISIONS		
16	05/05/13	REVISIONS		

SIZE A1

INVENTORY NO.	SIGN. & DATE	REF. DRG. NO.

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