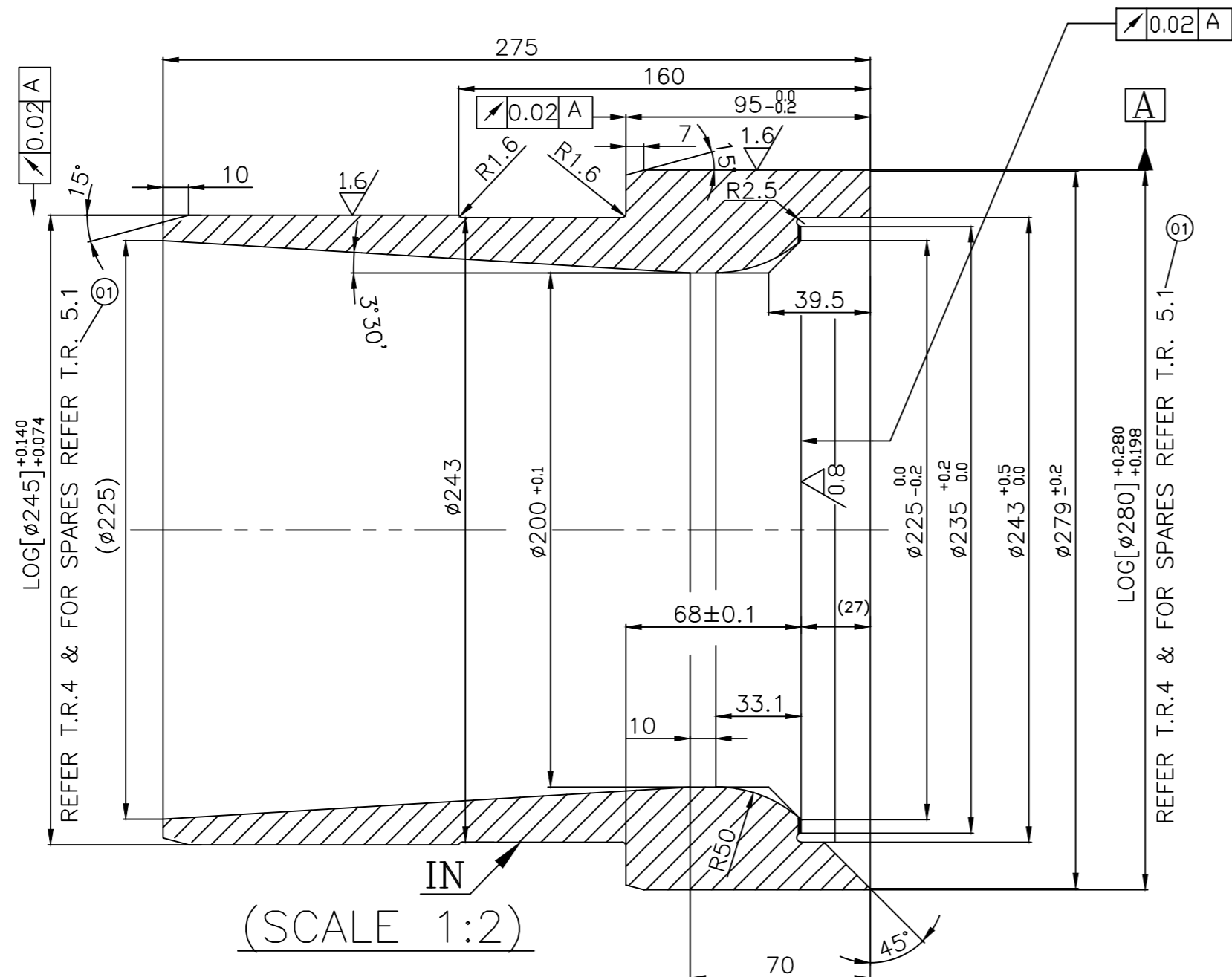
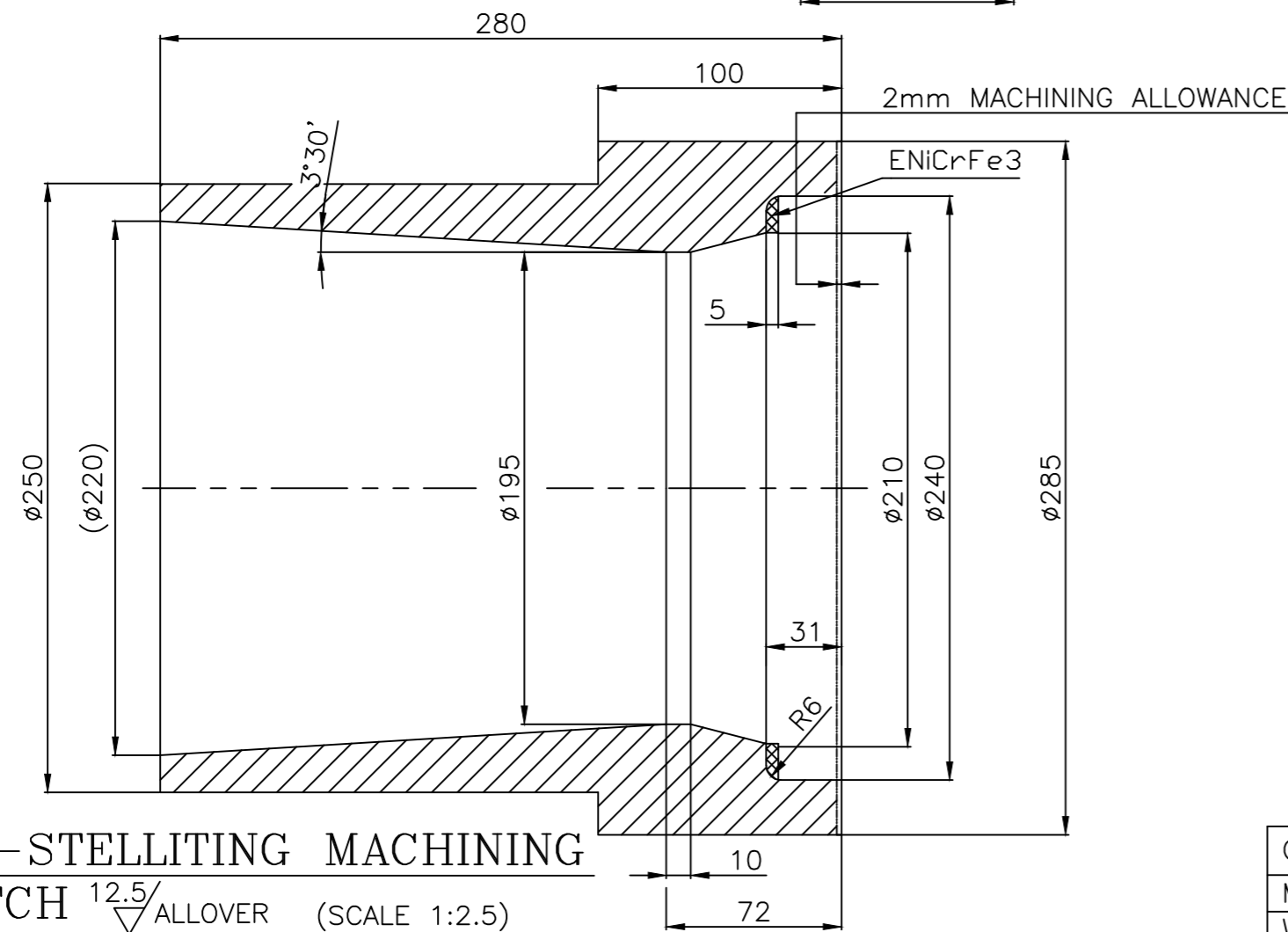


2-11222-24002
DRAWING No.

3.2/ ALLOVER UNLESS OTHERWISE STATED



(SCALE 1:2)



PRE-STELLING MACHINING SKETCH 12.5/ ALLOVER (SCALE 1:2.5)

TECH. REQUIREMENTS :-

1. STELLING SHALL BE DONE AT A PLACE AS SHOWN WITH ELECTRODE ENICrFe3 AS PER HWO610198.
2. IDENTIFICATION SHALL BE DONE ACCORDING TO HWO400397 AT THE PLACE MARKED WITH IN
3. DIMENSIONS IN THE BRACKETS ARE FOR REFERENCE ONLY.
4. Log[ø245]^{+0.140}/_{+0.074} AND Log[ø280]^{+0.280}/_{+0.198} SHALL BE MADE WITH 1mm. ALLOWANCE FOR FINISH MACHINING DURING ASSEMBLY.

5. TECH. REQ. FOR SPARES :-

- 5.1 4MM ALLOWANCE SHOULD BE ADDED ON LOG[ø245]^{+0.140}/_{+0.074} AND LOG[ø280]^{+0.280}/_{+0.198}.
- 5.2 4MM ALLOWANCE SHOULD BE PROVIDED ON ø250 & ø285 FOR PRE-STELLING MACHINING SKETCH.

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2-11222-02002
(8670172)
Ref. Drawing No.

Sign & Date

Inventory No

GRADE OF UNTOL.DIM	
M/CG.-ø/M/ƒ	AA0230208
WELDING-A/B/ø/∅ AA0621104	
GAS CUTTING-'T3'AA0621101	

-GMS No. / CBOM No. 01122224000		STATUS OF DRG	
AGREED DEPT	NAME	SIGN	DATE
STT	S.SARKAR	-sd-	13.12.04

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT
STEAM TURBINE

Bharat Heavy Electricals Ltd. RANIPUR, HARDWAR	NAME	SIGN	DATE	No. OF VAR	
	DRN	S.C.G.	-SD-		13.12.04
	CHD	S.K.S.	-SD-		13.12.04
APPD	B.S.G.	-SD-	13.12.04	73 74	

DEPT	STE	SCALE	WEIGHT (KG)	REF. TO ASSY. DRG.	ITEM No.	No. OF ITEMS
CODE	4011	1:2,1:2.5	33.00	0-11222-024000	002	001

TITLE :	VALVE SEAT	CARD CODE	7	DRAWING NO.	2-11222-24002	No. OF SHEETS	01
						22 23 24	

REV	DATE	ALTERED CHECKED	REV	DATE	ALTERED CHECKED	REV	DATE	ALTERED CHECKED	REV	DATE	ALTERED CHECKED	REV	DATE	ALTERED CHECKED	REV	DATE	ALTERED CHECKED	REV	DATE	ALTERED CHECKED	

REV	DATE	ALTERED UKH	-sd-
01	27.07.07	CHECKED NIRALA	-sd-
CHANGED AS PER C/A NO. STE-07-F0213.			