

BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL

FOUNDRY DIVISION

Date : 04.10.13

NOTES FOR MANUFACTURE OF ALUMINIUM PATTERN
(TECHNICAL DELIVERY CONDITIONS)

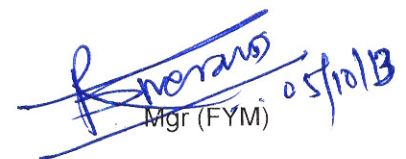
DESCRIPTION : ALUMINIUM PATTERN

NOTE FOR MANUFACTURING OF PATTERN

- 1 Casting produced from the aluminium pattern should be exactly as per drawing (Excluding machining allowance and drafting taper)
- 2 **Designing Solid/3D model**
 - 2.1 Solid/3D model of casting to be made
 - 2.2 Solid/3D model of pattern (including contraction and machining allowance) to be made
 - 2.3 The party should submit and get the solid/3D model of casting and pattern approved from indenting department.
- 3 The party should have CNC machining facility as the pattern is to be machined on CNC M/c.
- 4 Material used for pattern manufacturing LM6
- 5 **Pattern detail**
 - 5.1 Contraction allowance for pattern manufacturing - 1%
 - 5.2 Machining allowance - 5 mm on ID, top and bottom not be made.
 - 5.4 Pattern to be properly finished with taper of 5 degree.
 - 5.5 Removable Lifting handles to be provided for proper handling of pattern.
- 6 **Details of Down sprue, Runner bar, Ingate and Risers to be provided suitable to casting .**
 - 6.1 Down sprue - center pouring - to be made by foundry division
 - 6.2 Runner bar -tu suit
 - 6.3 Ingate - Cross bar to be fitted on top side of runner bar - size - 12 mm Depth
- 7 Identification Mark - Pattern no. to be cast depressed in the area (1) as shown in drawing.
- 8 Mould made by using above pattern should produce one number casting at a time.

General

- 1 Drawing will be supplied by Foundry division, BHEL, Bhopal to the manufacturer/ supplier.
- 2 Supplier to be associated during production of first - off casting.
- 3 Supplier to furnish detailed dimensional report of pattern equipment vis a vis casting drawing dimensions. along with the pattern equipment.
- 4 Final clearance shall be given only after successful casting at Foundry division, BHEL, Bhopal.


Mgr (FYM) 05/10/13

For the use of the...
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