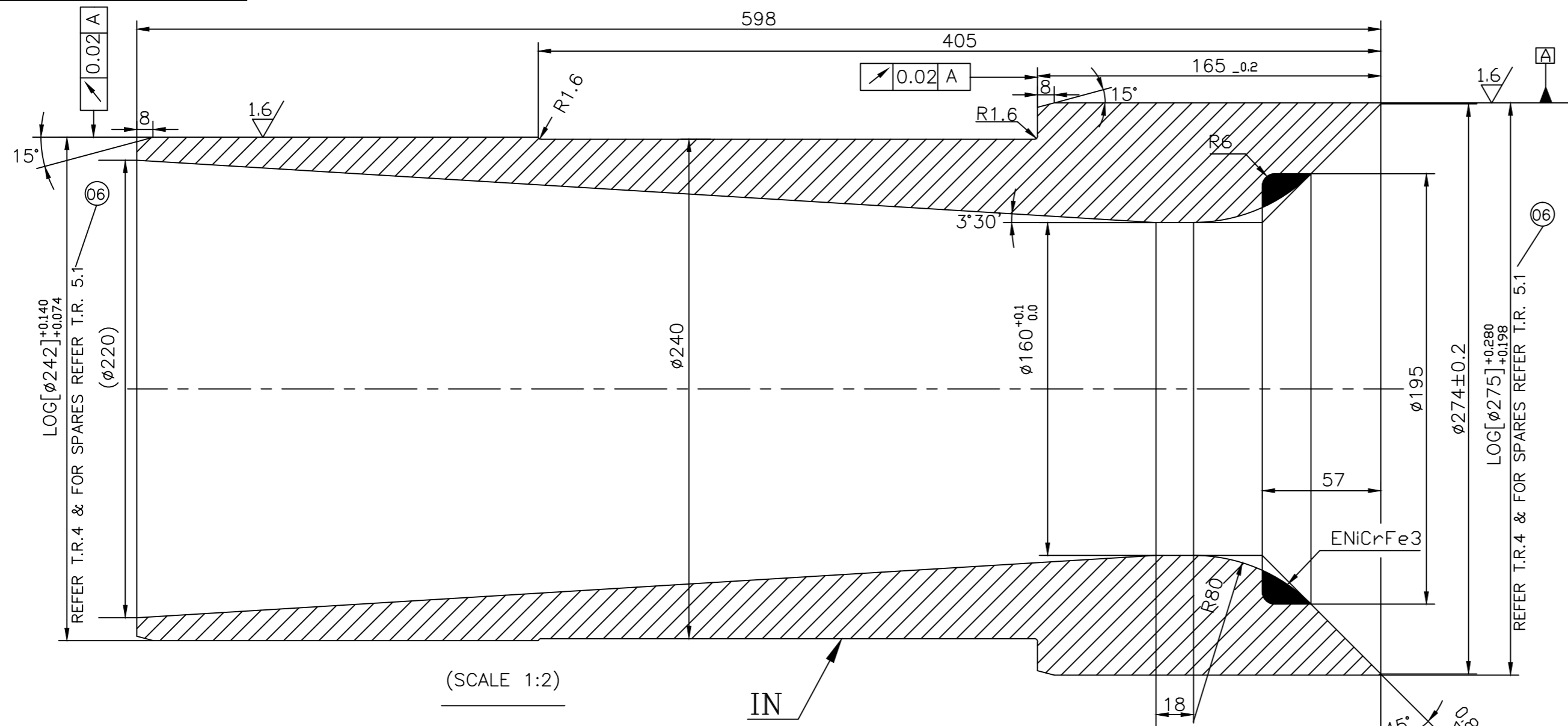


2-11222-02003

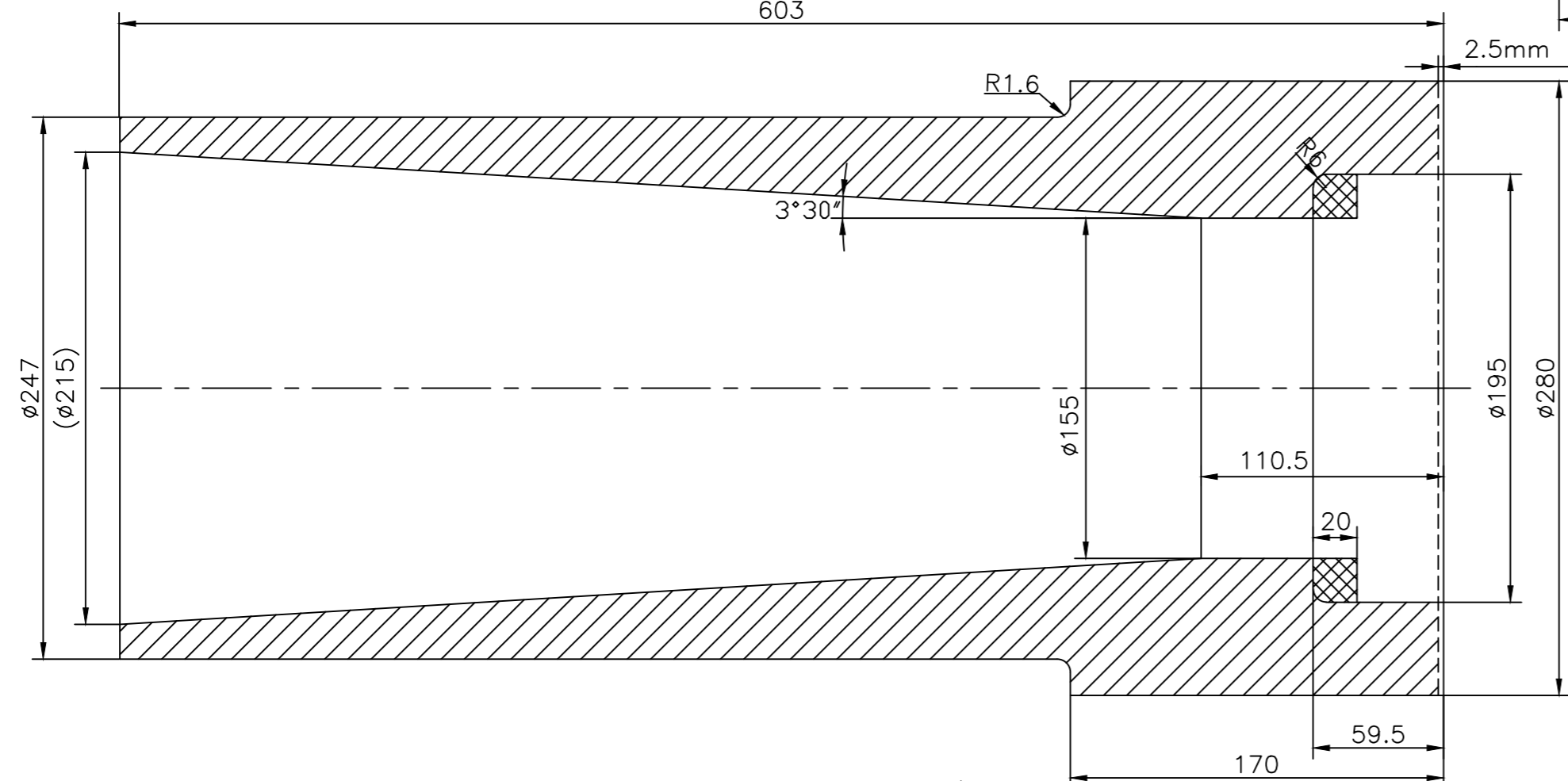
3.2/ ALL OVER UNLESS OTHERWISE STATED



(SCALE 1:2)

IN

2.5mm MACHINING ALLOWANCE



PRE-STELLITING MACHINING SKETCH 12.5/ ALL OVER (SCALE 1:2.5)

TECH. REQUIREMENTS :-

- STELLITING SHALL BE DONE AT THE SURFACE AS SHOWN WITH ELECTRODE ENiCrFe3 AS PER HW0610198.
- IDENTIFICATION SHALL BE DONE ACCORDING TO HW0400397 AT THE PLACE MARKED WITH IN
- DIMENSIONS IN THE BRACKETS ARE FOR REFERENCE ONLY.
- LOG [ø242]^{+0.140}/_{+0.074} AND LOG [ø275]^{+0.280}/_{+0.198} SHALL BE MADE WITH 1MM ALLOWANCE FOR FINISH MACHINING DURING ASSEMBLY.

5. TECH. REQ. FOR SPARES :-

- 4MM ALLOWANCE SHOULD BE PROVIDED ON LOG [ø242]^{+0.140}/_{+0.074} AND LOG [ø275]^{+0.280}/_{+0.198}
- 4MM ALLOWANCE SHOULD BE PROVIDED ON ø247 & ø280 FOR PRE-STELLITING MACHINING SKETCH.

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8670171b Ref. Drawing No. Sign & Date Inventory No.

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

GRADE OF UNTOL.DIM			
M/CG.-C/M/F	AA0230208		
WELDING-A/B/C/D	AA0621104		
GAS CUTTING-T3	AA0621101		

REV	DATE	ALTERED CHECKED	UKH	REV	DATE	ALTERED CHECKED	S.C.G
06	24.07.07	CHECKED	NIRALA	05	22.11.04	CHECKED	S.K.S

GMS No./ CBOM No. 01122202000				STATUS OF DRG	
AGREED DEPT	NAME	SIGN	DATE		
STT	B.CHAUDARY	-sd-	17.8.83		
MTE	C.B.SHARMA	-sd-	13.7.83		
WT	R.K.JAIN	-sd-	4.8.83		

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		STEAM TURBINE			
Bharat Heavy Electricals Ltd. Ranipur, Hardwar		DRN	NAME	SIGN	DATE
		ASHOK	ASHOK	-sd-	21.7.83
		CHD	R.P.G	-sd-	28.7.83
		APPD	M.R.K	-sd-	19.10.83
DEPT	STE	SCALE	WEIGHT (KG)	REF. TO ASSY. DRG.	ITEM No.
4011		1:2,1:2.5	100.00	0-11222-02000	03
TITLE : VALVE SEAT		CARD CODE		DRAWING NO. 2-11222-02003	
				SHEET No.01 No. OF SHEETS 01	