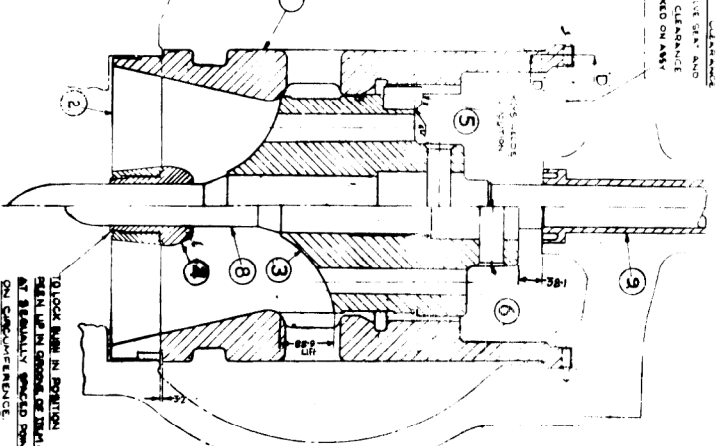
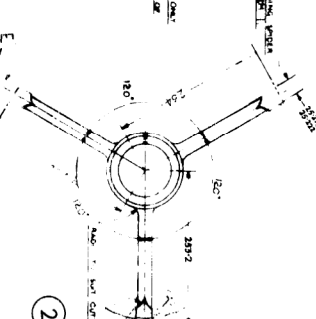
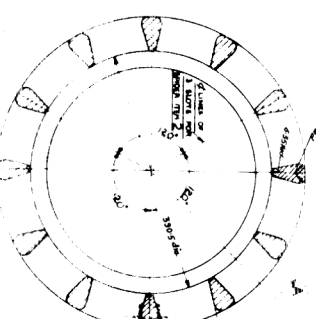
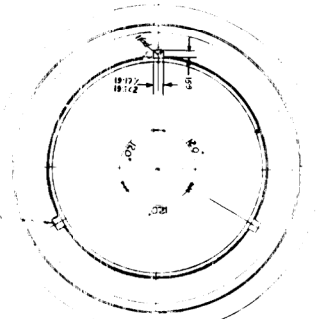
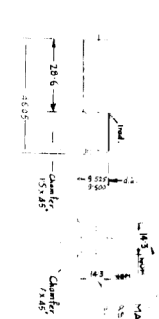
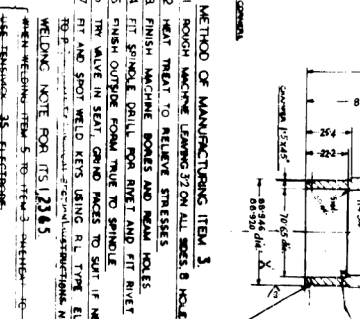
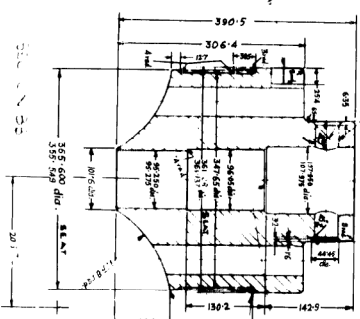
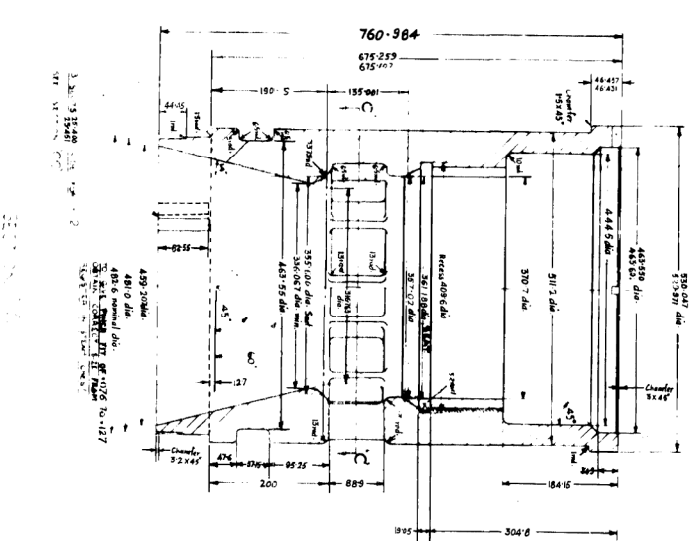


ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE STATED.

THIRD ANGLE PROJECTION



ITEM	TOOL	DESCRIPTION
1	1456881	Copy Template
2	1456880	Set of four turning tools
3	1456879	Copy Template
4	1456878	Large gauge for inner seat
5	1456877	Gauge for outer seat
6	1456876	Copy Template for outer seat
7	1456875	Drill bit for seat hole
8	1456874	Copy Template for seat hole
9	1456873	Drill bit for seat hole
10	1456872	Copy Template for seat hole
11	1456871	Drill bit for seat hole
12	1456870	Copy Template for seat hole
13	1456869	Drill bit for seat hole
14	1456868	Copy Template for seat hole
15	1456867	Drill bit for seat hole
16	1456866	Copy Template for seat hole
17	1456865	Drill bit for seat hole
18	1456864	Copy Template for seat hole
19	1456863	Drill bit for seat hole
20	1456862	Copy Template for seat hole
21	1456861	Drill bit for seat hole
22	1456860	Copy Template for seat hole
23	1456859	Drill bit for seat hole
24	1456858	Copy Template for seat hole
25	1456857	Drill bit for seat hole
26	1456856	Copy Template for seat hole
27	1456855	Drill bit for seat hole
28	1456854	Copy Template for seat hole
29	1456853	Drill bit for seat hole
30	1456852	Copy Template for seat hole
31	1456851	Drill bit for seat hole
32	1456850	Copy Template for seat hole
33	1456849	Drill bit for seat hole
34	1456848	Copy Template for seat hole
35	1456847	Drill bit for seat hole
36	1456846	Copy Template for seat hole
37	1456845	Drill bit for seat hole
38	1456844	Copy Template for seat hole
39	1456843	Drill bit for seat hole
40	1456842	Copy Template for seat hole
41	1456841	Drill bit for seat hole
42	1456840	Copy Template for seat hole
43	1456839	Drill bit for seat hole
44	1456838	Copy Template for seat hole
45	1456837	Drill bit for seat hole
46	1456836	Copy Template for seat hole
47	1456835	Drill bit for seat hole
48	1456834	Copy Template for seat hole
49	1456833	Drill bit for seat hole
50	1456832	Copy Template for seat hole
51	1456831	Drill bit for seat hole
52	1456830	Copy Template for seat hole
53	1456829	Drill bit for seat hole
54	1456828	Copy Template for seat hole
55	1456827	Drill bit for seat hole
56	1456826	Copy Template for seat hole
57	1456825	Drill bit for seat hole
58	1456824	Copy Template for seat hole
59	1456823	Drill bit for seat hole
60	1456822	Copy Template for seat hole
61	1456821	Drill bit for seat hole
62	1456820	Copy Template for seat hole
63	1456819	Drill bit for seat hole
64	1456818	Copy Template for seat hole
65	1456817	Drill bit for seat hole
66	1456816	Copy Template for seat hole
67	1456815	Drill bit for seat hole
68	1456814	Copy Template for seat hole
69	1456813	Drill bit for seat hole
70	1456812	Copy Template for seat hole
71	1456811	Drill bit for seat hole
72	1456810	Copy Template for seat hole
73	1456809	Drill bit for seat hole
74	1456808	Copy Template for seat hole
75	1456807	Drill bit for seat hole
76	1456806	Copy Template for seat hole
77	1456805	Drill bit for seat hole
78	1456804	Copy Template for seat hole
79	1456803	Drill bit for seat hole
80	1456802	Copy Template for seat hole
81	1456801	Drill bit for seat hole
82	1456800	Copy Template for seat hole
83	1456799	Drill bit for seat hole
84	1456798	Copy Template for seat hole
85	1456797	Drill bit for seat hole
86	1456796	Copy Template for seat hole
87	1456795	Drill bit for seat hole
88	1456794	Copy Template for seat hole
89	1456793	Drill bit for seat hole
90	1456792	Copy Template for seat hole
91	1456791	Drill bit for seat hole
92	1456790	Copy Template for seat hole
93	1456789	Drill bit for seat hole
94	1456788	Copy Template for seat hole
95	1456787	Drill bit for seat hole
96	1456786	Copy Template for seat hole
97	1456785	Drill bit for seat hole
98	1456784	Copy Template for seat hole
99	1456783	Drill bit for seat hole
100	1456782	Copy Template for seat hole



METHOD OF MANUFACTURING ITEM 3
 1. MACHINING DRAWING 37 ON ALL SIZES 8 HOLES TO BE DRILLED 28 DIA.
 2. HEAT TREAT TO RELIEVE STRESSES
 3. FINISH MACHINE BORES AND MOUNT HOLES
 4. FIT SPINBLE DRILL FOR SEAT AND FIT RIVET
 5. FINISH OUTSIDE FORM TO SPINBLE
 6. TRY VALVE IN SEAT GRIND POKES TO SAT IF NECESSARY
 7. FIT AND SPOT WELD KEYS USING R.L. TYPE ELECTRODE (OR TUNGSTEN IN ELECTRODE) DETAIL OF KEYWAY SEE DRAWING 37
 8. FINISH GRIND PRESS 75 TO GRIND FROM SEAT
 9. FINISH GRIND PRESS 75 TO GRIND FROM SEAT

METHOD OF MANUFACTURING ITEM 4
 1. MACHINING DRAWING 37 ON ALL SIZES 8 HOLES TO BE DRILLED 28 DIA.
 2. HEAT TREAT TO RELIEVE STRESSES
 3. FINISH MACHINE BORES AND MOUNT HOLES
 4. FIT SPINBLE DRILL FOR SEAT AND FIT RIVET
 5. FINISH OUTSIDE FORM TO SPINBLE
 6. TRY VALVE IN SEAT GRIND POKES TO SAT IF NECESSARY
 7. FIT AND SPOT WELD KEYS USING R.L. TYPE ELECTRODE (OR TUNGSTEN IN ELECTRODE) DETAIL OF KEYWAY SEE DRAWING 37
 8. FINISH GRIND PRESS 75 TO GRIND FROM SEAT
 9. FINISH GRIND PRESS 75 TO GRIND FROM SEAT

METHOD OF MANUFACTURING ITEM 5
 1. MACHINING DRAWING 37 ON ALL SIZES 8 HOLES TO BE DRILLED 28 DIA.
 2. HEAT TREAT TO RELIEVE STRESSES
 3. FINISH MACHINE BORES AND MOUNT HOLES
 4. FIT SPINBLE DRILL FOR SEAT AND FIT RIVET
 5. FINISH OUTSIDE FORM TO SPINBLE
 6. TRY VALVE IN SEAT GRIND POKES TO SAT IF NECESSARY
 7. FIT AND SPOT WELD KEYS USING R.L. TYPE ELECTRODE (OR TUNGSTEN IN ELECTRODE) DETAIL OF KEYWAY SEE DRAWING 37
 8. FINISH GRIND PRESS 75 TO GRIND FROM SEAT
 9. FINISH GRIND PRESS 75 TO GRIND FROM SEAT

METHOD OF MANUFACTURING ITEM 6
 1. MACHINING DRAWING 37 ON ALL SIZES 8 HOLES TO BE DRILLED 28 DIA.
 2. HEAT TREAT TO RELIEVE STRESSES
 3. FINISH MACHINE BORES AND MOUNT HOLES
 4. FIT SPINBLE DRILL FOR SEAT AND FIT RIVET
 5. FINISH OUTSIDE FORM TO SPINBLE
 6. TRY VALVE IN SEAT GRIND POKES TO SAT IF NECESSARY
 7. FIT AND SPOT WELD KEYS USING R.L. TYPE ELECTRODE (OR TUNGSTEN IN ELECTRODE) DETAIL OF KEYWAY SEE DRAWING 37
 8. FINISH GRIND PRESS 75 TO GRIND FROM SEAT
 9. FINISH GRIND PRESS 75 TO GRIND FROM SEAT

2612298

DATE	BY	REVISION
1972-01-10	...	1
1972-01-10	...	2
1972-01-10	...	3
1972-01-10	...	4
1972-01-10	...	5
1972-01-10	...	6
1972-01-10	...	7
1972-01-10	...	8
1972-01-10	...	9
1972-01-10	...	10
1972-01-10	...	11
1972-01-10	...	12
1972-01-10	...	13
1972-01-10	...	14
1972-01-10	...	15
1972-01-10	...	16
1972-01-10	...	17
1972-01-10	...	18
1972-01-10	...	19
1972-01-10	...	20
1972-01-10	...	21
1972-01-10	...	22
1972-01-10	...	23
1972-01-10	...	24
1972-01-10	...	25
1972-01-10	...	26
1972-01-10	...	27
1972-01-10	...	28
1972-01-10	...	29
1972-01-10	...	30
1972-01-10	...	31
1972-01-10	...	32
1972-01-10	...	33
1972-01-10	...	34
1972-01-10	...	35
1972-01-10	...	36
1972-01-10	...	37
1972-01-10	...	38
1972-01-10	...	39
1972-01-10	...	40
1972-01-10	...	41
1972-01-10	...	42
1972-01-10	...	43
1972-01-10	...	44
1972-01-10	...	45
1972-01-10	...	46
1972-01-10	...	47
1972-01-10	...	48
1972-01-10	...	49
1972-01-10	...	50
1972-01-10	...	51
1972-01-10	...	52
1972-01-10	...	53
1972-01-10	...	54
1972-01-10	...	55
1972-01-10	...	56
1972-01-10	...	57
1972-01-10	...	58
1972-01-10	...	59
1972-01-10	...	60
1972-01-10	...	61
1972-01-10	...	62
1972-01-10	...	63
1972-01-10	...	64
1972-01-10	...	65
1972-01-10	...	66
1972-01-10	...	67
1972-01-10	...	68
1972-01-10	...	69
1972-01-10	...	70
1972-01-10	...	71
1972-01-10	...	72
1972-01-10	...	73
1972-01-10	...	74
1972-01-10	...	75
1972-01-10	...	76
1972-01-10	...	77
1972-01-10	...	78
1972-01-10	...	79
1972-01-10	...	80
1972-01-10	...	81
1972-01-10	...	82
1972-01-10	...	83
1972-01-10	...	84
1972-01-10	...	85
1972-01-10	...	86
1972-01-10	...	87
1972-01-10	...	88
1972-01-10	...	89
1972-01-10	...	90
1972-01-10	...	91
1972-01-10	...	92
1972-01-10	...	93
1972-01-10	...	94
1972-01-10	...	95
1972-01-10	...	96
1972-01-10	...	97
1972-01-10	...	98
1972-01-10	...	99
1972-01-10	...	100

3556(14) DIA. EMERGENCY VALVE
 REVERSE FLOW VENTURI TYPE.
 (120 MW)
 SCALE 1:1
 M.O. 190006/1 G.2612298

HEAVY ELECTRICALS (INDIA) LIMITED
 BHOPAL