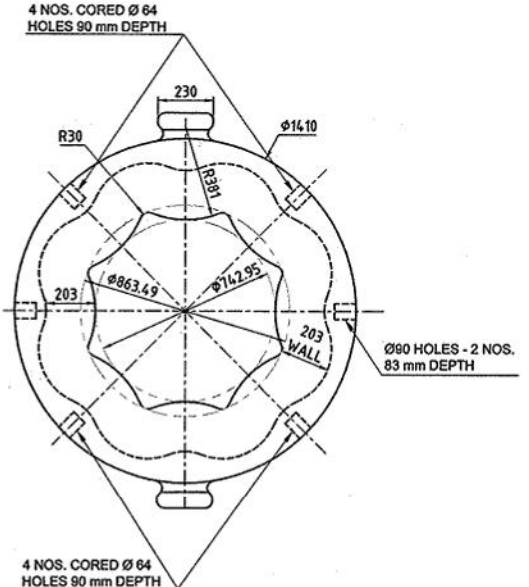
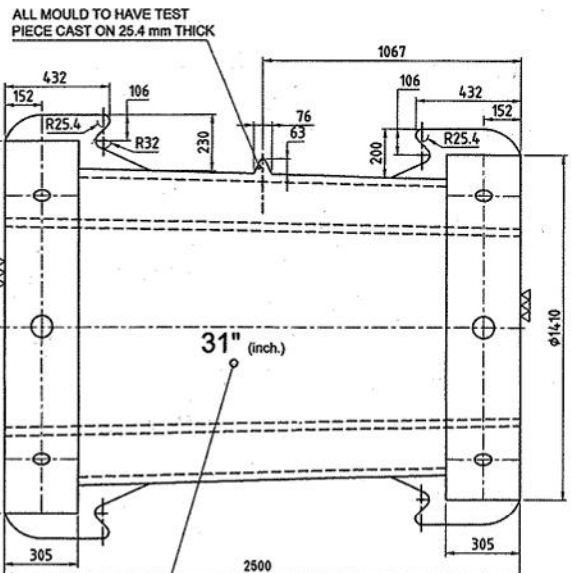
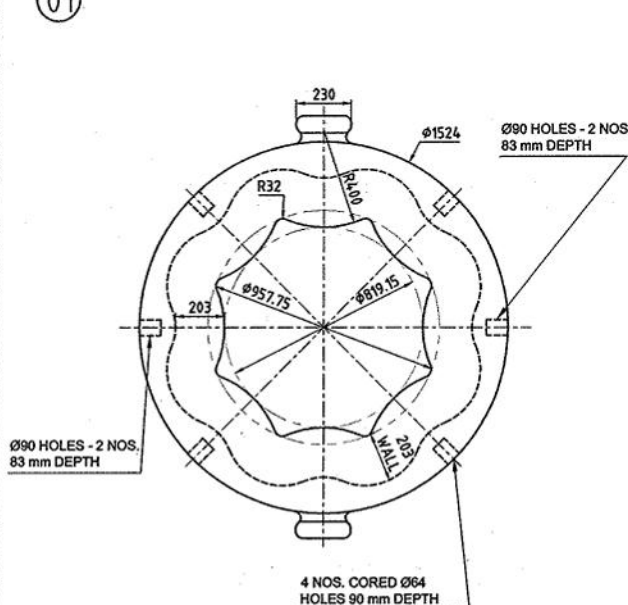


01

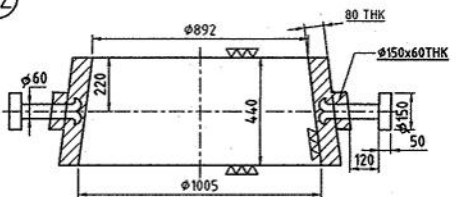


THE SIZE OF THE MOULD TO BE CAST CLEARLY ON TWO OPPOSITE FACES OF THE MOULD AS SHOWN.

* INGOT MOULD & CASING SPECIFICATION

MATERIAL GRAY CAST IRON (IS 210 : 1993)
GRADE : FG 260

02



JWM/SMR
12-03-11

JT.GM/F
12/11

NOTES :-

1. THE INSIDE SURFACE SHOULD BE CLEAN FROM MOULDING SAND, FREE FROM SEAMS, SAND DEPRESSIONS, PROJECTIONS, CRACKS, CRUST, CAVITIES, COLD SHUT, SCRUFF MARKS, PITTINGS, SCABS, RAT TAIL AND OTHER SIMILAR DEFECTS.
2. NO RECTIFICATION OF INSIDE DEFECTS OR CAVITIES BY WELDING IS PERMITTED, OUTSIDE SURFACE SHALL BE FREE FROM CRACKS, CAVITIES, PROJECTIONS, FINS AND BURN SAND.
3. BOTTOM FACE OF INGOT MOULD SHOULD BE CAST TO MAKE IT PERPENDICULAR TO THE AXIS OF INGOT MOULD TOP AND BOTTOM SURFACE SHOULD BE MACHINED.
4. DEVIATIONS IN INGOT MOULD DIMENSIONS SHALL BE GOVERNED AS PER CL 15 OF IS: 3005 (PART III) 1982.
5. MATERIAL SHOULD HAVE STRUCTURE OF CAST IRON PEARITIC-FERRITIC WITH FLECKED GRAPHITE AND WITHOUT PRESENCE OF FREE COMMENTATE.

ITEM NO.	DESCRIPTION	NO.OFF	MATERIAL	HARDNESS	REMARKS
02	HOT TOP CASING	01	*		
01	31" (inch) MOULD	01	*		
AMENDMENTS					
R ₂	INGOT MOULD LENGTH & CASING SPECIFICATION AMENDED, VIDE REF. HOS/SMR MEMO NO. 8406/13-14/SMR/MAT DT. 08-4-2013				
R ₁	DRG. REPRODUCED AFTER REVISION VIDE REF MEMO NO. SMR/10-11/GENL DT 21.12.10				
INDEX				DATE	NAME
				08/12/2010	Sajal Kr. Pramanik
	DESCRIPTION			SCALE	DRAWN
	C.I. INGOT MOULD			1:20	TRACED
	31" x 2500 mm LENGTH & CASING				CHECKED
	FOR SMS SECTION				APPROVED
	[BASED ON SKETCH]				JWM/DO
	METAL & STEEL FACTORY, ISHAPORE				AWM/QC
					DRG. NO. OH-1012/72

R₂