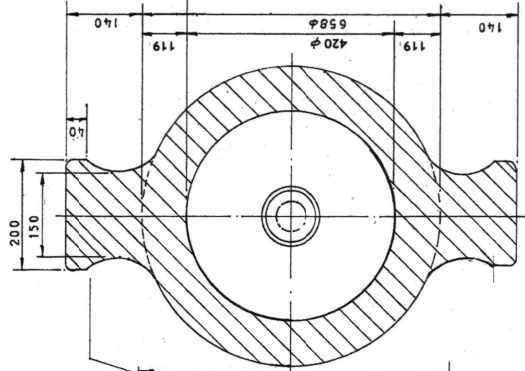
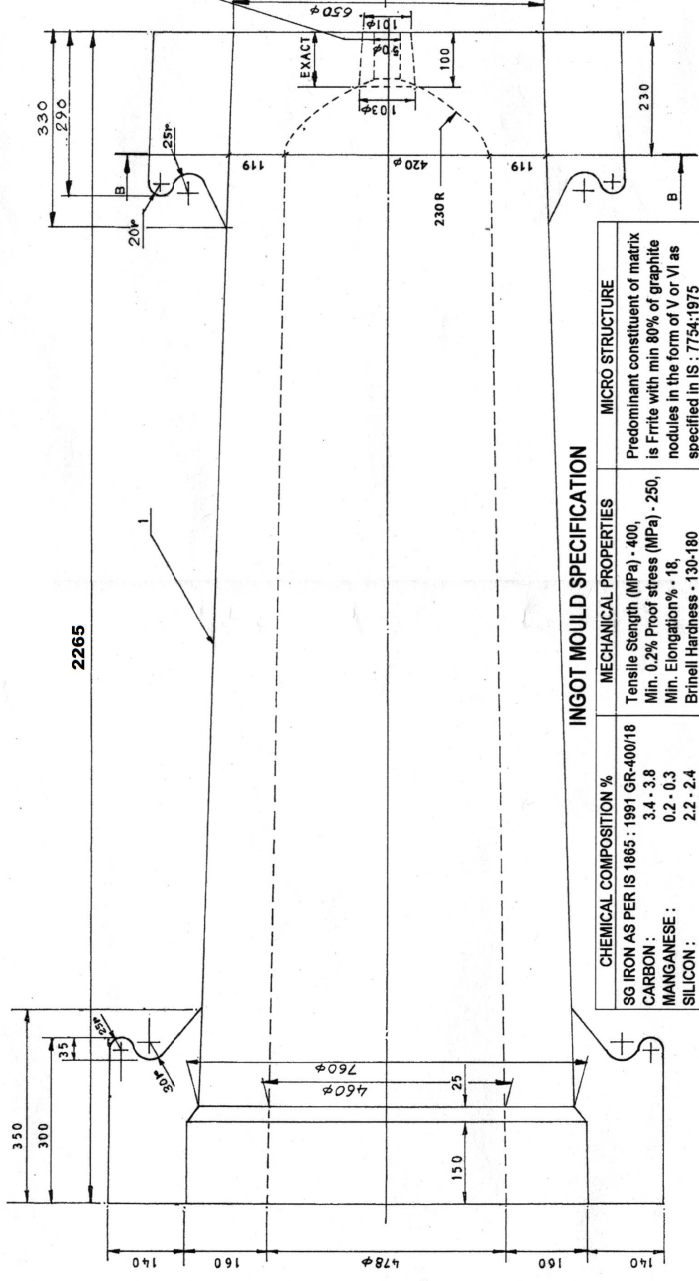
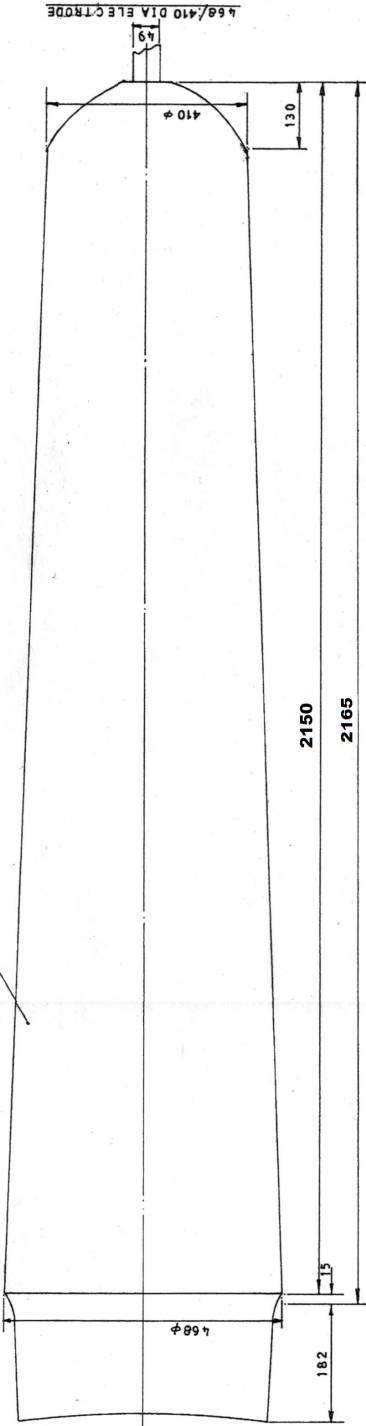


ALL DIMENSIONS ARE IN mm



INGOT MOULD SPECIFICATION

CHEMICAL COMPOSITION %	MECHANICAL PROPERTIES	MICRO STRUCTURE
SG IRON AS PER IS 1885 : 1991 OR-400/18	Tensile Strength (MPa) - 400,	Predominant constituent of matrix is Fritte with min 80% of graphite nodules in the form of V or VI as specified in IS : 7754:1975
CARBON : 3.4 - 3.8	Min. 0.2% Proof stress (MPa) - 250,	
MANGANESE : 0.2 - 0.3	Min. Elongation% - 18,	
SILICON : 2.2 - 2.4	Brinell Hardness - 130-180	
SULPHUR : 0.03 Max.		
PHOSPHORUS : 0.08 Max.		
MAGNESIUM : 0.04 - 0.05		

GENERAL PROPERTIES

1. THE INSIDE SURFACE SHOULD BE CLEAN FROM MOULDING SAND, FREE FROM SEAMS, SAND DEPRESSIONS, PROJECTIONS, CRACKS, CRUST, CAVITIES, COLD SHUT, SCRUFF MARKS, PITCHING, SCARBS, 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, PROJECTION, FINES AND BURNT SAND.
3. EASY STRIPPING OF INGOT TO BE GUARANTEED.
4. 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.
5. DEVIATIONS IN INGOT MOULD DIMENSIONS SHALL BE GOVERNED AS PER IS : 8350-1977
6. 02 Nos. CAST ON TEST SAMPLE MUST BE PROVIDED AT SUITABLE POSITION.

AWM/SMR
21.05.15
HOS/SMR
21-05-2015



UN CONTROLLED

ITEM NO.	1	MOULD ϕ 450 x 2250mm LG.	NO OFF	S.G. IRON	UNIT: KG.
DESCRIPTION					
INDEX		DESCRIPTION OF AMENDMENT			
		ϕ 450 x 2250 mm LG. S.G. Iron Ingot Mould			
		BASED ON REF. DRG. NO. LEVD/1000/12/A (R1)			
		METAL & STEEL FACTORY TISHA PORE			
		DRG. NO.			O.H. - 387
		SCALE			1:5
		DATE			19/05/15
		CHECKED			
		APPROVED			
		W.M.O.C.			N/A