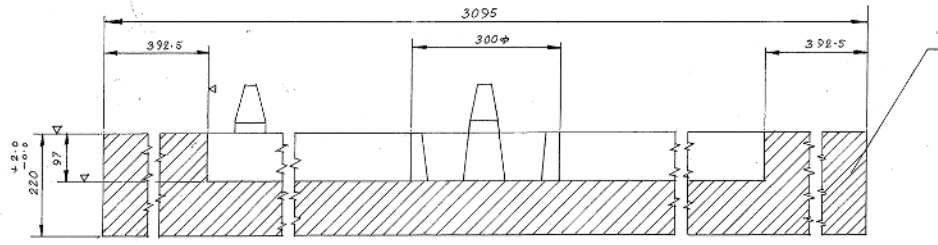
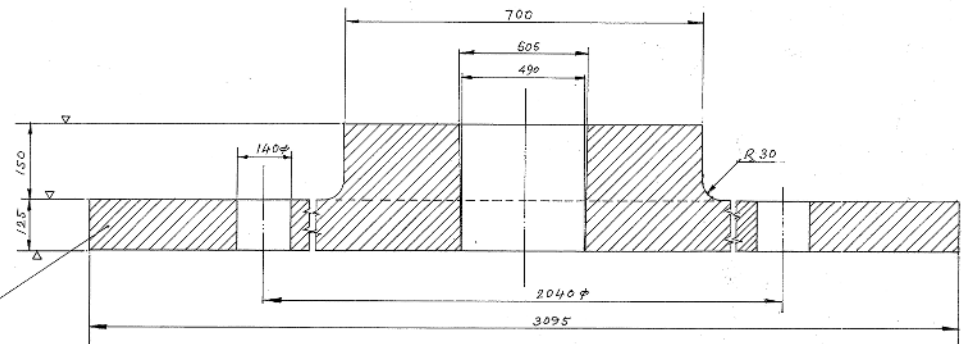


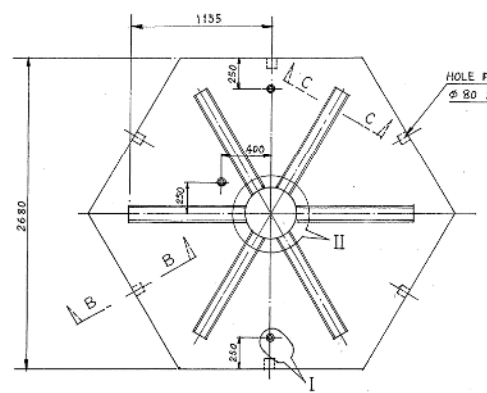
P.V COPY



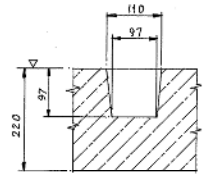
ENL'D SEC-AA



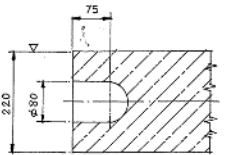
ENL'D SEC-DD



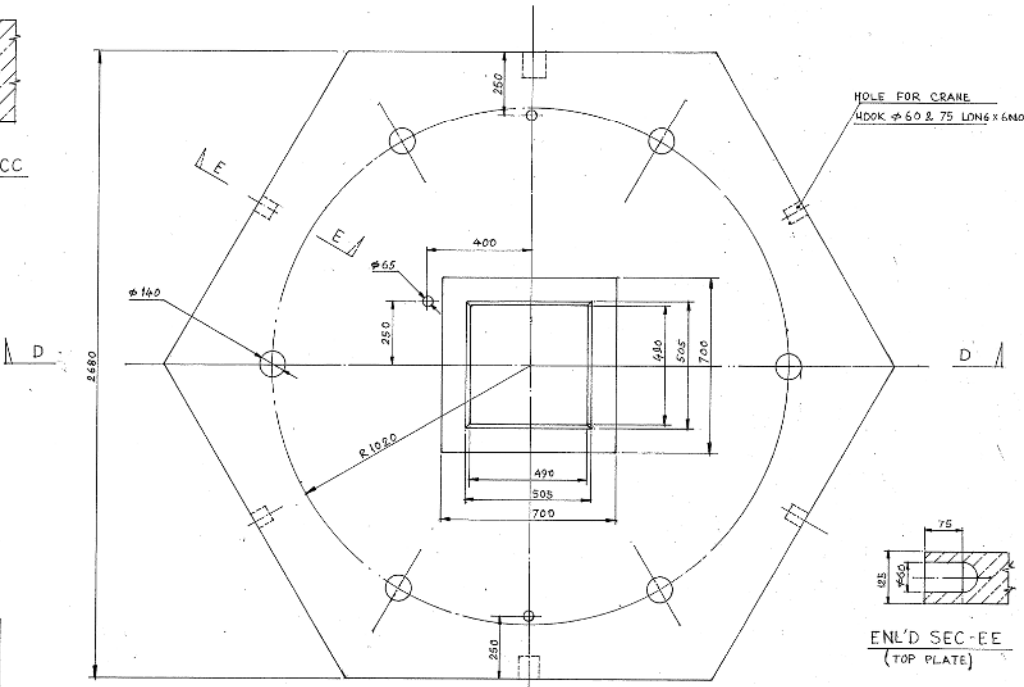
PLAN



ENL'D SEC-CC

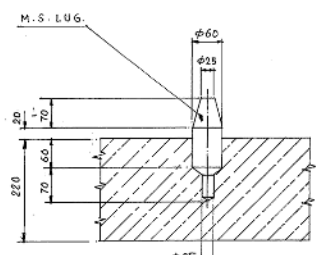


ENL'D SEC-BB
(BOTTOM PLATE)

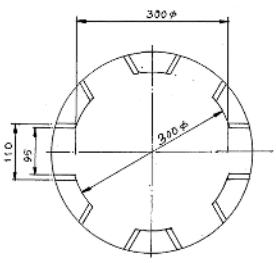


PLAN

ENL'D SEC-EE
(TOP PLATE)



ENL'D DETAIL - I



ENL'D DETAIL - II

TOP & BOTTOM PL. SPECIFICATION	
MATERIAL	GREY CAST IRON (IS:3005 PART-II 1982)
COMPOSITION	%
CARBON EQUIVALENT	4.0-4.5
TOTAL CARBON	3.4-3.6
COMBINED CARBON	0.10-0.30
SILICON	1.4-1.8
MANGANESE	0.50-0.90
SULPHUR MAX	0.08
PHOSPHORUS MAX	0.3

1. THE INSIDE SURFACE SHOULD BE CLEAN FROM MOULDING SAND, FREE FROM SEAMS, SAND DEPRESSION, PROJECTIONS, CRACKS, CRUST, CAVITIES, COLD SHUT, SCRUFF MARKS, FITTINGS, 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, PROJECTION, FINS AND BURNT SAND.
3. EASY STRIPPING OF INGOT TO BE GUARANTEED.
4. BOTTOM & TOP FACE OF THE TOP PLATE AND TOP FACE OF BOTTOM PLATE SHOULD BE MACHINED AS TO MAKE IT PERPENDICULAR TO THE AXIS OF INGOT MOULD.
5. DEVIATIONS OF CASTING DIMENSIONS SHALL BE GOVERNED AS PER CL 15 OF IS:3005(PART-II) 1982.
6. MATERIAL SHOULD HAVE STRUCTURE OF CAST IRON PEARLITIC-FERRITIC WITH FLAKED GRAPHITE AND WITHOUT PRESENCE OF FREE CEMENTITE.

NOTE

Sumit
J.T. MANAGER (STEEL)

ITEM NO.	DESCRIPTION AND FINAL DIMENSION	NO. OFF	MATERIAL	HARDNESS	REMARKS
2	TOP PLATE	1	GREY IRON		
1	BOTTOM PLATE	1	GREY IRON		
INDEX					
DESCRIPTION OF AMENDMENTS					
TOP & BOTTOM PLATES (TYPE-B)					
FOR - 10 TON E.S.R					
BASED ON "MANDASTAR" DRG. NO. M1-2572-EP-88-02-32 (REV-A)					
REF:- MEMO NO. 5/67/SMB/784 DT. 21.02.82					
METAL & STEEL FACTORY, SHAPORE					

NO	DATE	ZONE	REMARKS	CONTRACTOR	DRG. NO.	DETAILS
A	16/02/83	GEN	MODIFIED			
REVISION						
REFERENCE DRAWINGS						