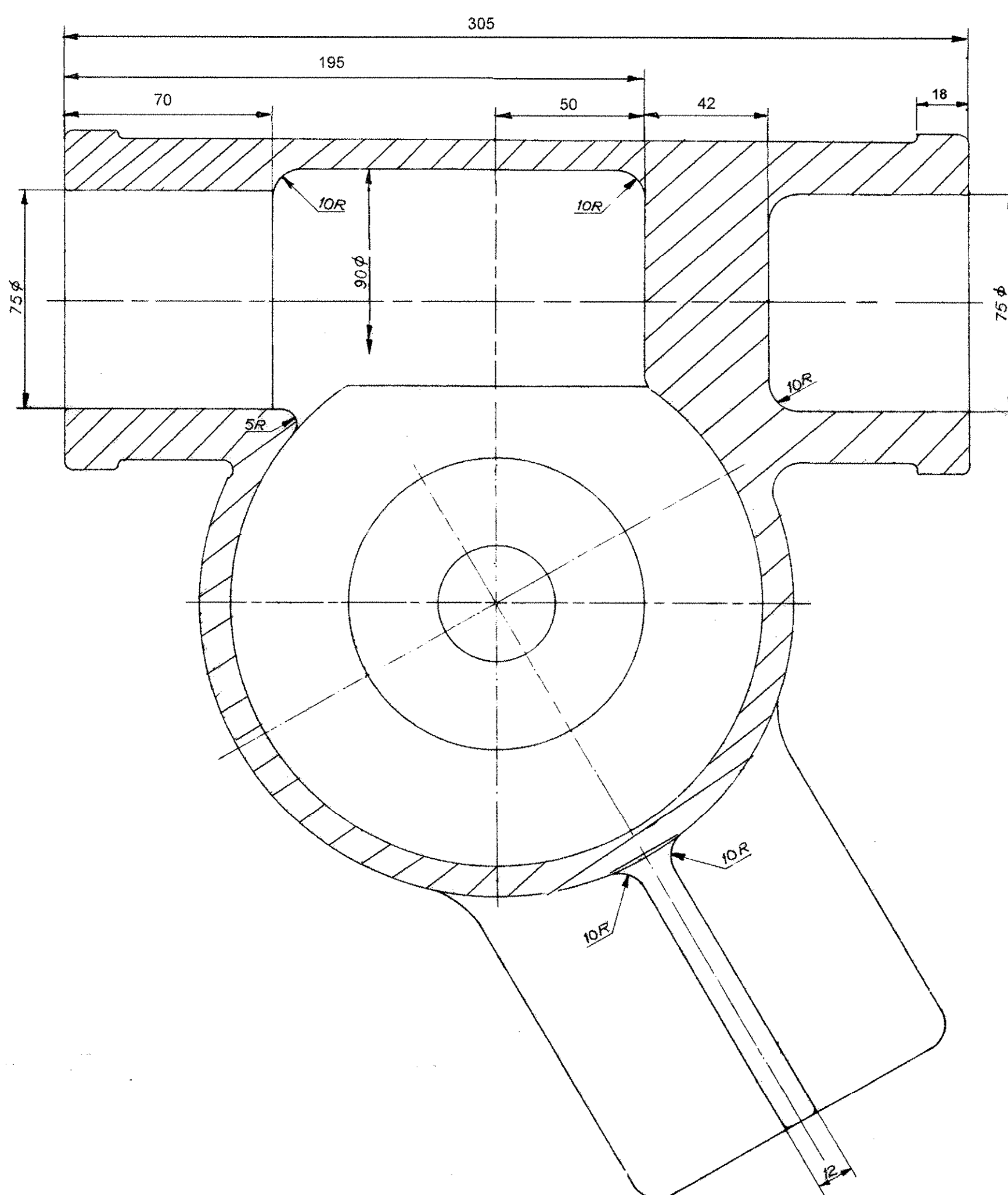
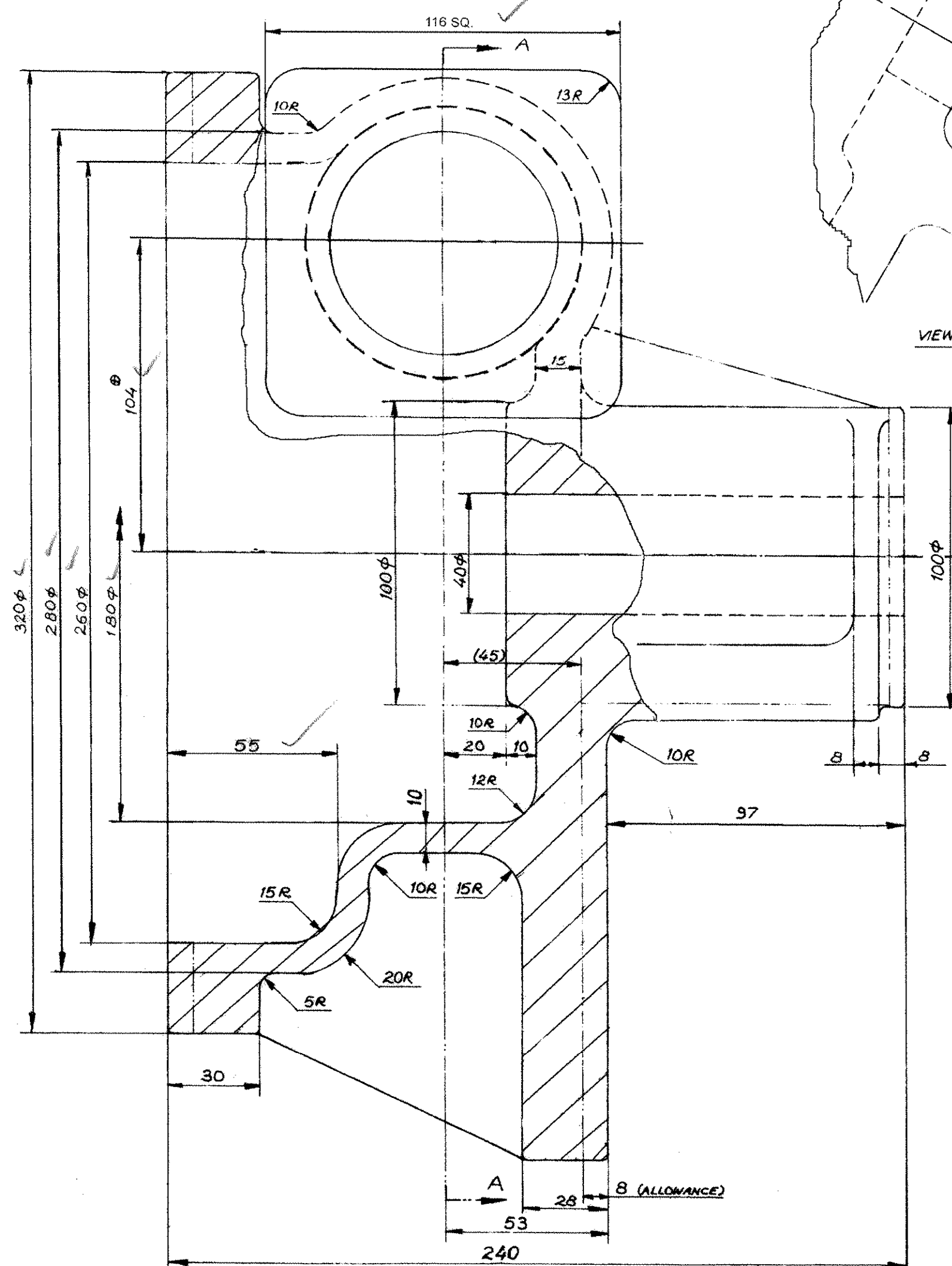


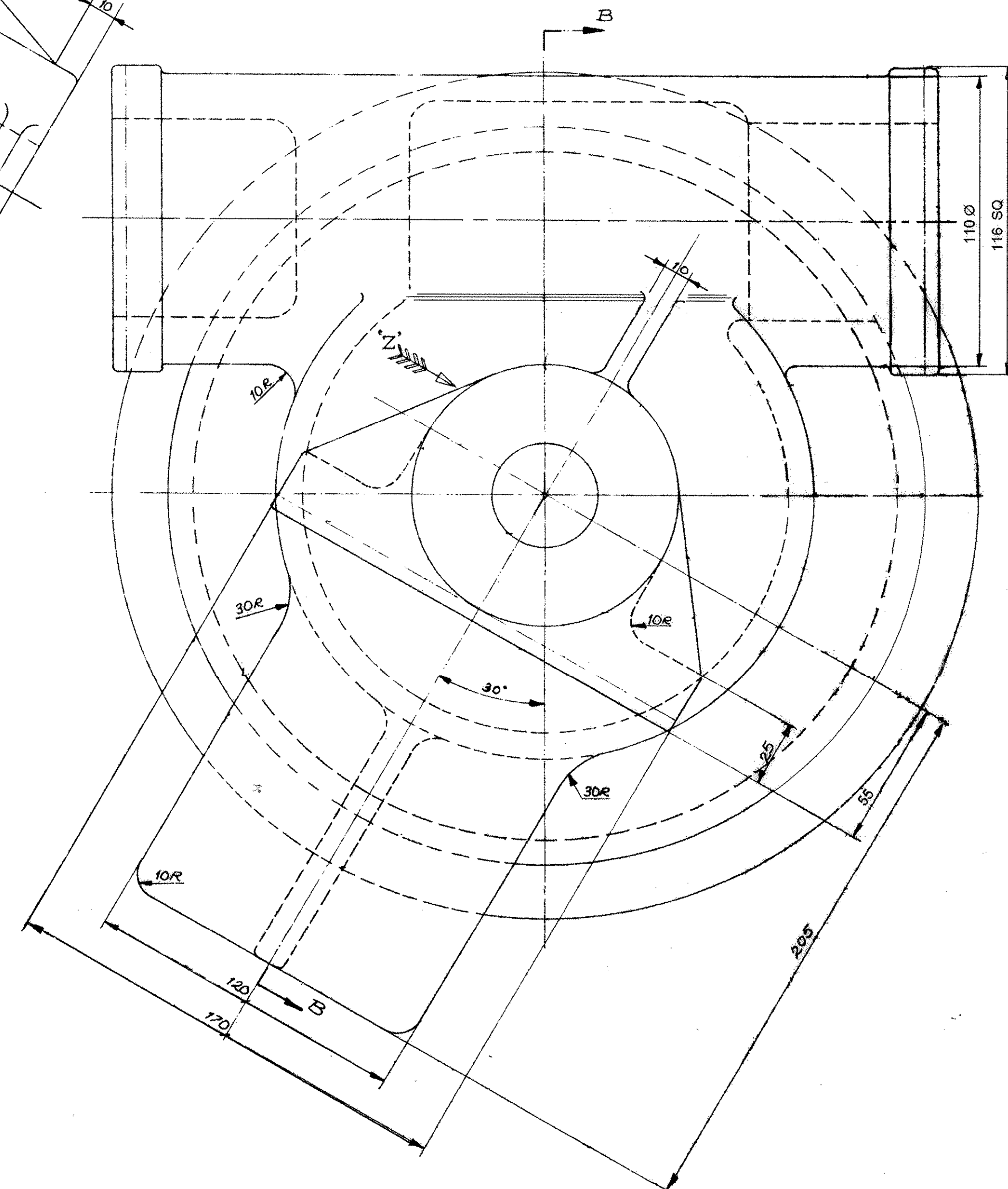
PART.NO/DS CAT.NO.
IFL 8404 SHT 2
ILG 1016



SECTION A-A



SECTION B-B



CASTING TOLERANCES

- (a) ON WALL THICKNESS $+1.5$
 -0
(b) IMPORTANT CENTRE DISTANCES MARKED $\oplus$ THUS ± 1 mm

NOTE

1. CASTING TO BE DULY CLEANED & FREE FROM FINS, RUNNERS, RISERS ETC.
2. CASTING TO BE FREE FROM CRACKS, BLOW HOLES & OTHER CASTING DEFECTS.
3. CASTING TO BE SUPPLIED IN FINALLY HEAT TREATED CONDITION.
4. RADII WHERE NOT SPECIFIED TO BE TAKEN AS 3 mm.
5. DRAFT TAPER PERMITTED.
6. FOR MACHINING SEE DRG. IFL 8404 SHT.1

CASTING SHOULD BE TESTED FOR RADIOGRAPHIC TEST
AS PER A S T M E-155-2000, LEVEL - 1

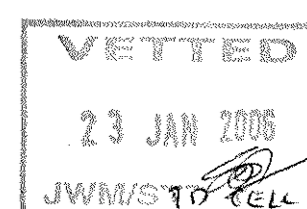
NOTE: RADIOGRAPHY TESTS IS MEANT FOR
TRADE SUPPLIES ONLY

CHEMICAL COMPOSITION

GRADE	AL	Cu	Si	Mg	Fe	Mn	Ni	Zn	Pb	Sn	Ti
		Max	Max	Max	Max	Max	Max	Max	Max	Max	
2280 WP IS:617-75	Remai nder	4.0- 5.0	0.25 0.10	0.25 0.1	0.1 0.1	0.1 0.1	0.1 0.1	0.05 0.05	0.05 0.2- 0.3		

MECHANICAL PROPERTIES

GRADE	TENSILE STRENGTH N/mm ² (Kg/mm ²)	SPECIFIC ELONGATION%
2280 WP IS:617-75	310 (31.5)	9



				2280 WP IS:617-1975		WT=12.81 Kg	
संख्या NO.OFF	विवरण DESCRIPTION	पुर्त क. PART NO.	पदार्थ MATERIAL	मानक STANDARD	परिमाण DIMENSIONS	अधिकार REMARKS	
सामान्य सौकर्यता GENERAL TOLERANCE				CHEMICAL COMPOSITION MECHANICAL PROPERTIES			
रेखिक परिमाण LINEAR DIMENSION				ADDED ON DT-23-1-06			
0-6				MATL. ADDED LETTER NO.30823 COW(W4) DT-15-8-89			
6-30				N/A			
30-120				N/A			
120-250				N/A			
250-500				N/A			
500-1000				N/A			
1000-2000				N/A			
2000-3000				N/A			
3000-4000				N/A			
4000-5000				N/A			
5000-6000				N/A			
6000-7000				N/A			
7000-8000				N/A			
8000-9000				N/A			
9000-10000				N/A			
10000-11000				N/A			
11000-12000				N/A			
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13000-14000				N/A			
14000-15000				N/A			
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