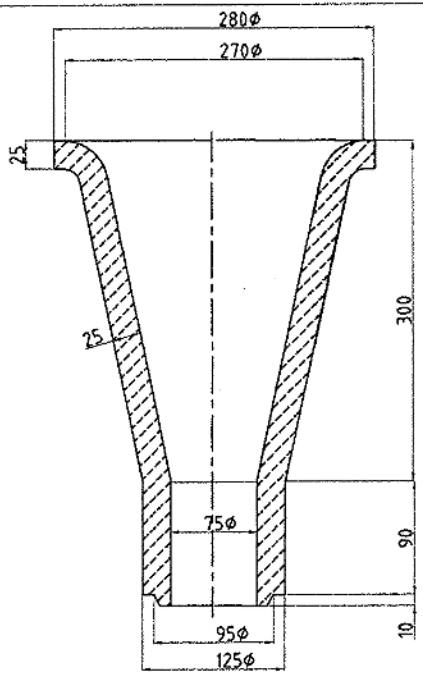
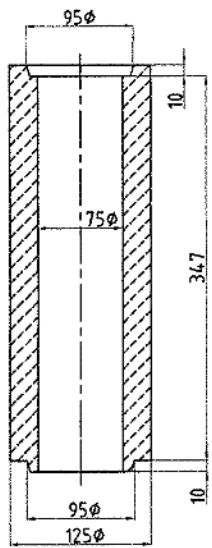


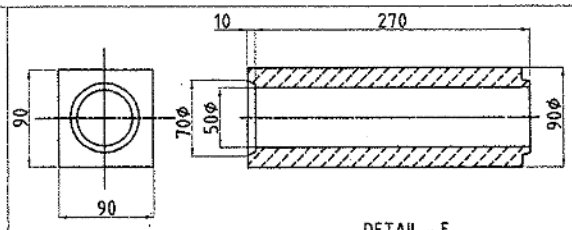
P.V. COPY



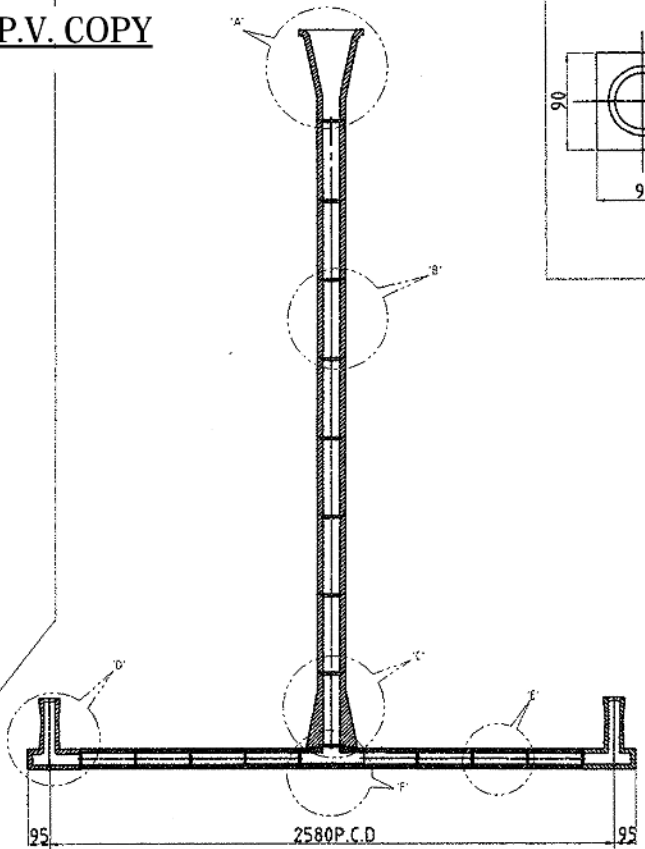
DETAIL - A
TRUMPET FUNNEL



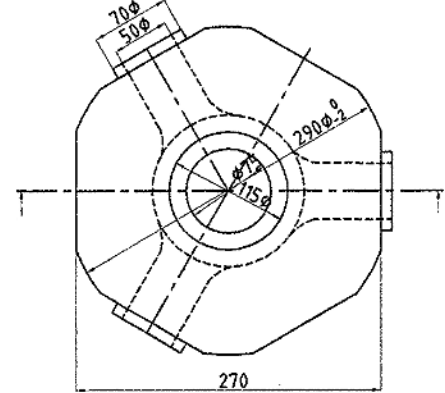
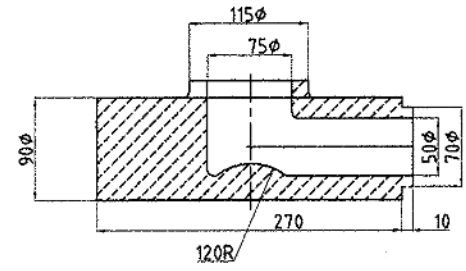
DETAIL - B
TRUMPET BODY BRICK



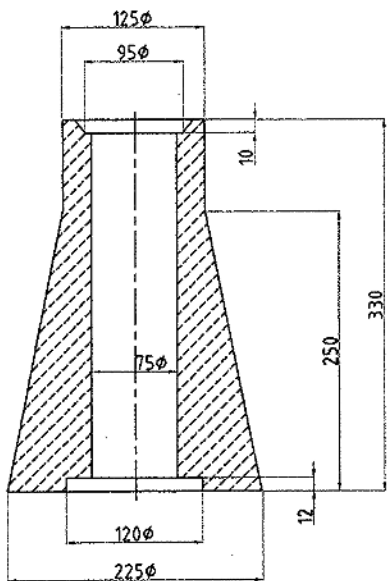
DETAIL - E
BOTTOM PLATE RUNNER BRICK



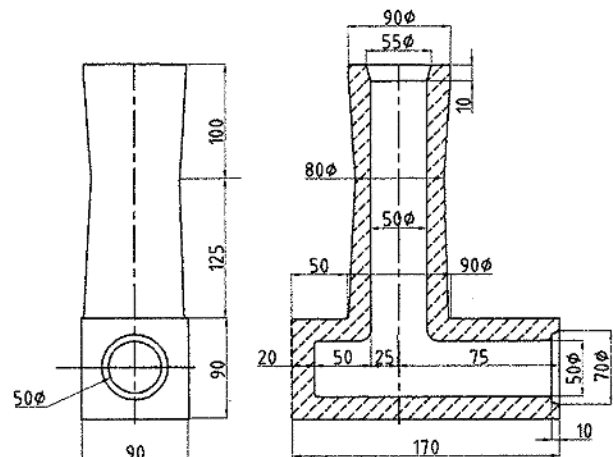
LINER REFRACTORIES FOR UPHILL TEEMING FOR HEXAGONAL INGOT MOULD SET UP WITH TYPE 'A' TOP AND BOTTOM PLATE ASSY.



DETAIL - F



DETAIL - C
TRUMPET END SLEEVE



DETAIL - D
BOTTOM PLATE RUNNER END SLEEVE

SEGMENT	MATERIAL	NO. OFF	SPECIFICATION
A	FIRE BRICK	1	Al ₂ O ₃ - 65% min. Fe ₂ O ₃ - 3.0% max. PHYSICAL PROPERTIES :- AP% = 30% max. BD gm/cc = 2.5 min. PLC% at 1500° C/2hrs = ± 2.0 PCE(OC) = 35 min. SPECIAL NOTE :- There should be no erosion of liner brick & sticking of brick material on runner/riser is not acceptable.
B	----DO----	10 (2 nos. extra)	
C	----DO----	1	
D	----DO----	3	
E	----DO----	9	
F	----DO----	1	

R ₁	IN SPECIFICATION & NO. OFF COLUMN AMENDED VIDE REF. MEMO NO. 84/SMR/11-12/DRG dt. 08-8-2011				DATE	NAME
ITEM NO.	DESCRIPTION	NO. OFF	MATERIAL	HARDNESS	REMARKS	
INDEX	LINER REFRACTORIES FOR RADIAL FORGING INGOT MOULD. 3 WAY				SCALE	DRAWN
					1:1	16.02.06
					TRACED	5. DEB ROY
					CHECKED	
METAL & STEEL FACTORY, ISHAPORE				APPROVED	DATE	NAME
				JWM/DO	16.02.06	S. DEB ROY
				WM/PL		

DRG. AMENDED AS PER MEMO NO. SMR/84/MISC/07/221
 DRG. AMENDED AS PER MEMO NO. SMR/84/MISC/06/227