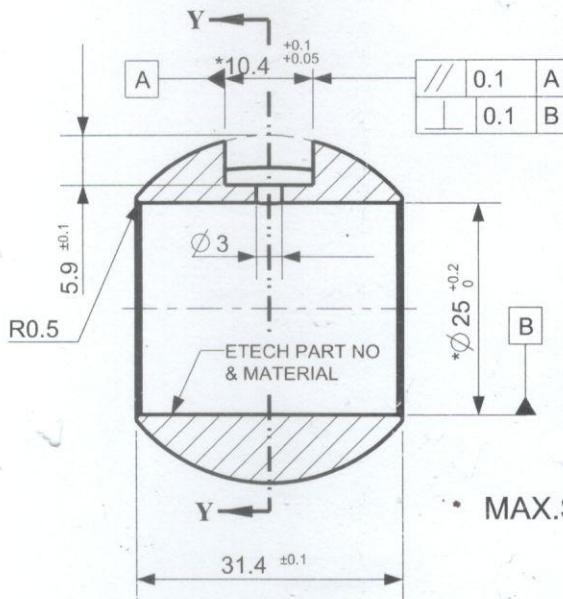
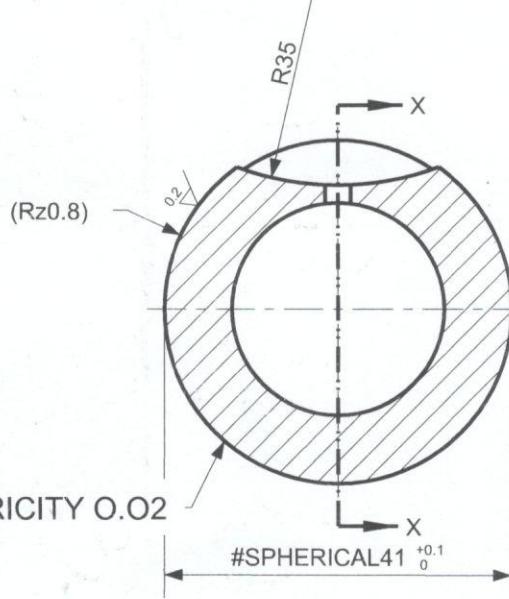


GEOMETRIC STRAIGHTNESS		RUN OUT	ANGLE	PROFILE OF A LINE	SYMMETRY	GRAIN	JMBER	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12
TOLERANCE	FLATNESS				RA IN MICRONS	RA IN MICRONS	0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50	
IS:8000 (F.L.T)-1985	ROUNDNESS	CONCENTRICITY	CYLINDRICITY	TRUE POSITION	PARALLELISM	PERPENDICULARITY													
DT:30.05.16	REV.-1	IV-MC-A4	DEVIATION ON NON TOLERANCED LINEAR MACHINED DIMENSIONS. IS:2102 (PL-1)-1980 MEDIUM CLASS	FROM UPTO & INCLUDING	mm		SCALE	WEIGHT	1. ALL DIMENSIONS ARE IN mm. 2. DO NOT SCALE THE DRAWING. 3. REMOVE SHARP EDGES AND CORNERS. 4. IF IN DOUBT PLEASE ASK	APPD.	SDW	SDW							
0.5 - 6		0.1		NTS	0.1 Kg					DATE	24.03.23								
6 - 30		0.2								CHD.	BGU								
30 - 120		0.3								DATE	24.03.23								
120 - 315		0.5								DRN.	MRP								
315 - 1000		0.8								DATE	24.03.23								
1000 - 2000		1.2								REV.	0	SHEET :1 OF 1							
2000 - 4000		2																	

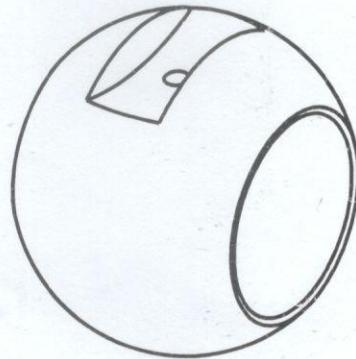
REVISIONS																		
No.	DESCRIPTION												ECN NO.	DATE	DRN	APPD		
0													-	-	-	-		
1																		
2																		
3																		



SECTION X-X



SECTION Y-Y

ISOMETRIC VIEW  
FOR REFERENCE

## FOR METAL SEAT

SPHERICAL OD OF BALL (200µm COATING)

AFTER COATING FINISH  $\phi 41.4^{+0.05}$ 

MAINTAIN SURFACE FINISH 0.1 (Rz0.4)

CONTROLLED COPY

*SPN*

## NOTES :-

1. ALL DIMENSIONS ARE IN MM.
2. ALL UNSPECIFIED CHAMFER TO BE 0.5X45
3. FOR MATERIAL REFER CORRESPONDING B.O.M.
4. CRITICAL DIMENSIONS ARE MARKED WITH \*
5. DIMENSIONS GIVE IN ( ) ARE ONLY REFERENCE
6. COATING TO BE DONE AS PER REQUIREMENT (REFER BOM)
7. #COATING -200µm ON THE FINISHED BALL HARDNESS 60 TO 65 HRC

THIS DESIGN & DRAWING IS PROPERTY OF  
M/S. INTERVALVE POONAWALLA LTD.  
MUST NOT BE COPIED OR LENT WITHOUT  
PERMISSION IN WRITING.



INTER VALVE POONAWALLA LTD.

TITLE:- NPS 1 (DN25) FB#300 -  
BALL MACHINING-2 PIECE FBV  
DRG. NO.: B09052200000

1. ALL DIMENSIONS ARE IN mm.  
2. DO NOT SCALE THE DRAWING.  
3. REMOVE SHARP EDGES AND CORNERS.  
4. IF IN DOUBT PLEASE ASK

1.6 (0.2 )

APPD.	SDW	SDW
DATE	24.03.23	
CHD.	BGU	
DATE	24.03.23	
DRN.	MRP	MRP
DATE	24.03.23	
REV.	0	SHEET :1 OF 1