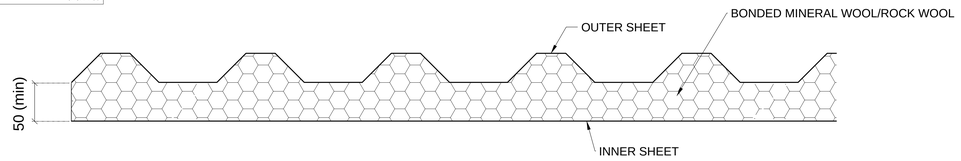
0-38-611-03781

DRAWING NO

FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER PLANT STD. NO TP-023-0299



SPECIFICATION: –

001. SANDWICHED METAL CLADDING SHEET –LIFT STRUCTURE.

Sandwiched metal cladding as per the specification given below, to cover the side of Lift Well, for an area of 2000 sqm. The height of Lift well is 128 m and the sides are 3500 & 3250 mm. Suitable opening for landing will be made at site.

Specification of Sandwiched Metal Cladding Sheet:

a). Outer sheet (external) is troughed, both side galvanized mild steel (IS–513) sheet having 0.63mm minimum thickness. Galvanizing coating shall be minimum 180 gm/sqm as per IS 277. The outer side (exposed face) shall be permanently colour coated with Polyfluro vinyl coating (PVF) of Dry Film Thickness (DFT) 20 microns minimum over primer. The inner side coating shall be provided with suitable precoating of 7 microns minimum.

b). Inner sheet (internal) is both side galvanized mild steel sheet (IS–513) having 0.63mm minimum thickness. Galvanizing coating shall be minimum 180 gm/sqm as per IS 277. The outer side (exposed face) shall be permanently colour coated with 20 microns minimum of silicon modified polyester(SMP) paint. The inner side coating shall be 7 microns minimum of silicon modified paint.

c). As per specification, Z spacers are required for every 750mm(max) to hold the outer & inner sheet together with insulation. Z spacer requirement has been deleted now and hence the integrity of outer + insulation + inner sheet should be ensured as an integrated panel without Z spacer & also after fitment at site.

d). Insulation shall be sandwiched and bonded between the above Outer and Inner sheets. Insulation shall be bonded mineral wool of minimum thickness 50mm conforming to IS–8183 having a density of 48kg/cubic.metre for rock wool.

General Specification:
The Permanent Prepainted Galvanized steel sheet shall meet the requirements of IS:14246 and shall conform to class 3 for the durability.

The colour of the Outer exposed surface is Blue (RAL 5012) and the other colours can be either Blue or Dove Grey or any other light colours.

002. PRECOATED G.I. CORNER BARGE BOARD 0.63x400x2440. 01

CONTINUOUSLY PREPAINTED GALVANISED STEEL SHEETS TO SPECIFICATION IS:14246 AS PER FOLLOWING REQUIREMENTS:

BASE METAL	:	Mild steel as per IS:513
NOMINAL THICKNESS	:	0.63mm (Without negative tolerance)
GALVANISING	:	The base metal shall be galvanized with minimum Grade of zinc coating 180 grams/sq.m as per IS:277
TOP SIDE PAINT	:	Top side coating shall be 20 microns minimum of Silicon Modified Polyester (SMP) paint.
BOTTOM SIDE PAINT	:	Bottom side coating shall be 7 microns minimum of epoxy Painting.
DURABILITY OF PAINT COATING	:	As per Class–3 of IS: 14246.

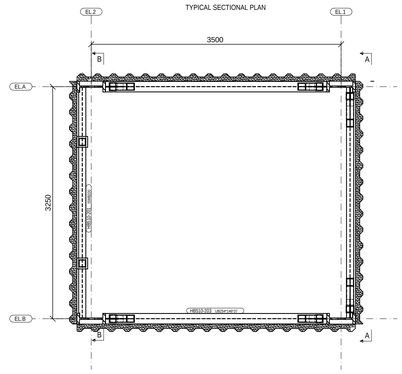
Note: The Top side colour of sheets shall be Blue (RAL 5012) ; however the colour code is to be confirmed with commercial (FB)

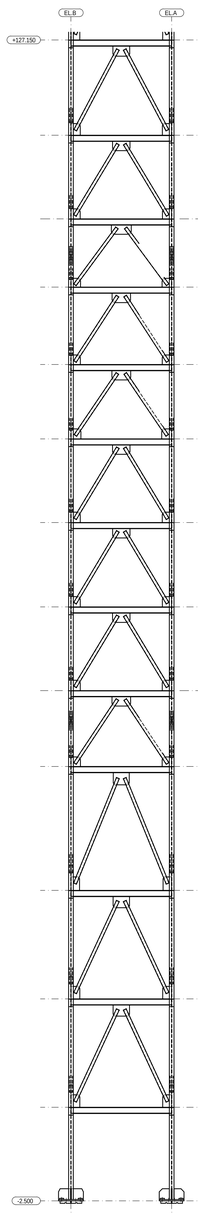
003. PRECOATED G.I. PLAIN SHEET 0.63x1000x3000. 01

CONTINUOUSLY PREPAINTED GALVANISED STEEL SHEETS TO SPECIFICATION IS:14246 AS PER FOLLOWING REQUIREMENTS:

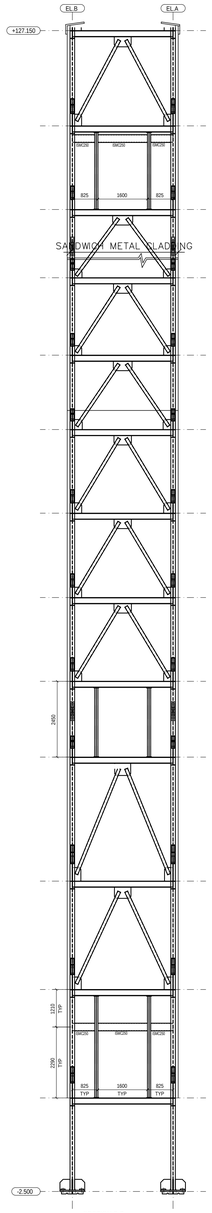
BASE METAL	:	Mild steel as per IS:513
NOMINAL THICKNESS	:	0.63mm (Without negative tolerance)
GALVANISING	:	The base metal shall be galvanized with minimum Grade of zinc coating 180 grams/sq.m as per IS:277
TOP SIDE PAINT	:	Top side coating shall be 20 microns minimum of Silicon Modified Polyester (SMP) paint.
BOTTOM SIDE PAINT	:	Bottom side coating shall be 7 microns minimum of epoxy Painting.
DURABILITY OF PAINT COATING	:	As per Class–3 of IS: 14246.

Note: The Top side colour of sheets shall be Blue (RAL 5012) ; however the colour code is to be confirmed with commercial (FB)

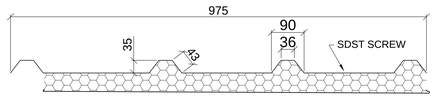




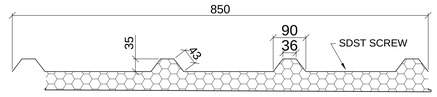
SECTION A-A



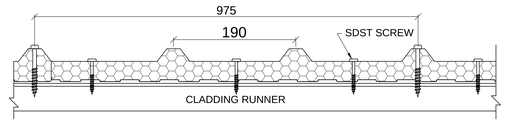
SECTION B-B



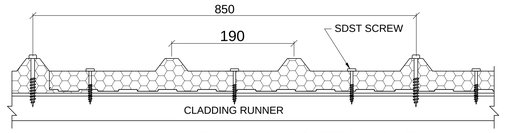
SANDWICHED METAL CLADDING SHEET PROFILE DETAIL



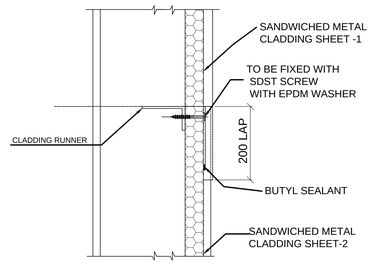
SANDWICHED METAL CLADDING SHEET PROFILE DETAIL



SANDWICHED METAL CLADDING SHEET FIXING DETAIL



SANDWICHED METAL CLADDING SHEET FIXING DETAIL



TYPICAL END LAP DETAIL

Note:

1) As these are made as panels and fitted in site, necessary projection of sheets at side/sides or at top/bottom for overlapping shall be ensured by supplier as per lap detail.

2) Supplier to suggest the arrangement of panels showing minimum 2 consecutive panels sidewise & vertical for providing panel deployment in site around lift enclosure through suitable sketches.

3) Corner closing arrangement using specification 002 shall be suggested by vendor through suitable sketches.

4) Supplier to specify the screwing details & self tapping screw sizes for panel & corner joints & others if any (supply scope of self tapping screws by BHEL only and hence supplier need not consider for pricing).

REV	DATE	ALTERED : S.SATHYASEELAN
01	08-05-2018	CHD & APPD : M.SHANMUGAM
REMARKS: BARGE BOARD AND PLAIN SHEET DIMENSION REVISED		

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT

Bharat Heavy Electricals Ltd
UNIT: HIGH PRESSURE BOILER PLANT
TIRUCHIRAPALLI - 620014

BHEL

	NAME	SIGNATURE	DATE
DRN	K.S.PANDIAN		09-04-2018
CHD	S.SATHIYA		10-04-2018
APPD	M.SHANMUGAM		10-04-2018

DEPT: ST
CODE: 122
ALL DIMENSIONS ARE IN MM
PROJECTION
SCALE: NTS
WEIGHT (Kg)
REF TO ASSY / OLD DWG

TITLE: TYPICAL SANDWICHED METAL CLADDING SHEET DETAILS

DRAWING NO : 0-38-611-03781

REV 01