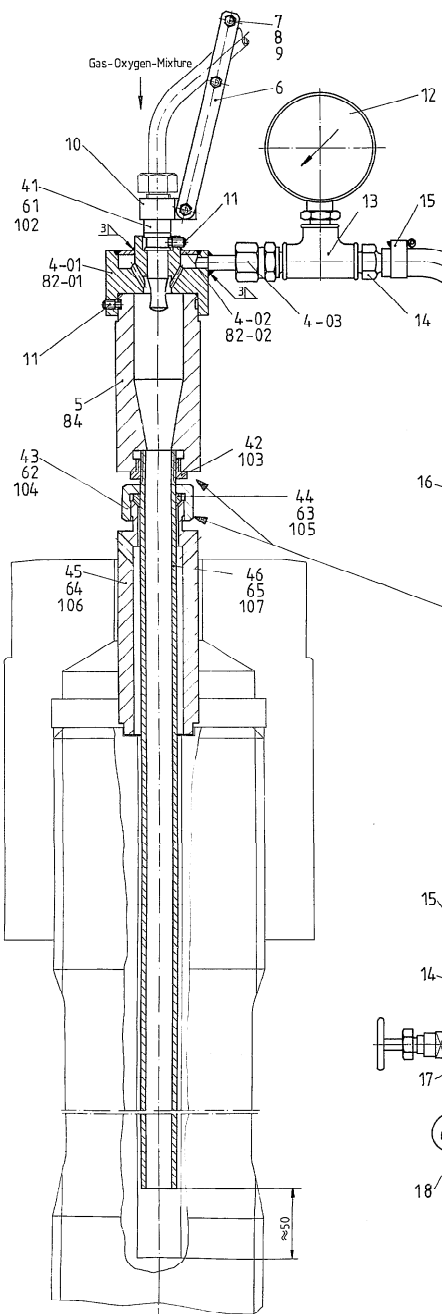


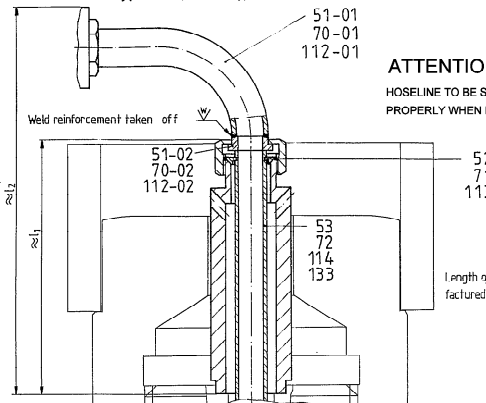
0099S 51021 1

Type 1



heating hole diameter	l ₁	l ₂
20	105	186
25	142	220
32	142	245
35	184	295

Type 2 (all parts of type 1 are included)

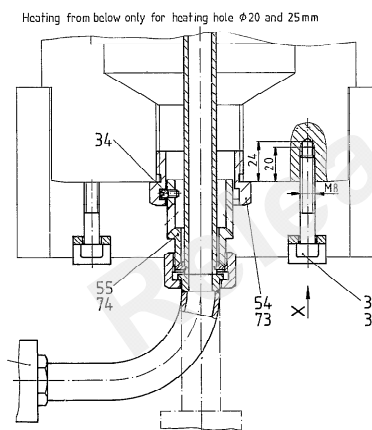


ATTENTION!

HOSELINE TO BE SUPPORTED PROPERLY WHEN IN USE

Length of the metal hose manufactured before starting to heat.

Type 3 (all parts of type 2 and also type 1 are included)

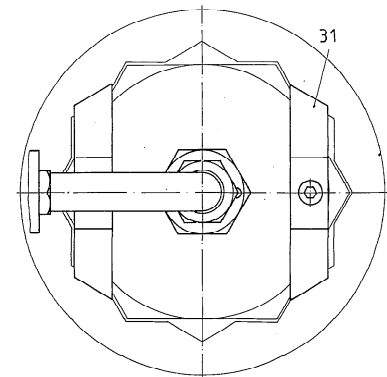


ATTENTION!

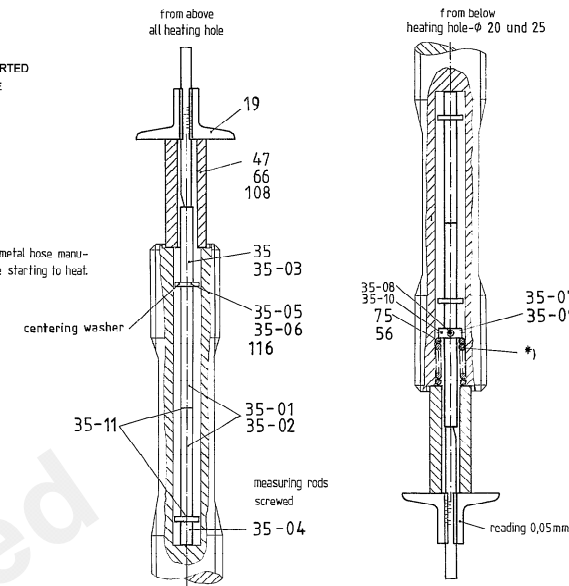
HOSELINE TO BE SUPPORTED PROPERLY WHEN IN USE

All thread connections lubricated with lubricating material MOLYKOTE P-37

view X



Using of the measuring instruments



Part 36 magnet lifter for the measuring rods is not shown

*) The spring is to prestressed such that the gauge rod is pressed to the bottom of the hole the sleeve is resting on.

Parts 3, 81 and 101 are boxes for the parts packing.
Description part 28 and tables of contents part 29 are inserted in the boxes.

NOTE:

- 1) This drawing covers the broad guideline on design, manufacture & supply of stud heating and measuring device. Scope of supply covers associated compressed air piping including fine regulating valve, pressure gauge and pipe fittings. A measuring device for measuring the extension of stud/bolt is also included in the scope of supply. Scope of supply shall be as per Type-3 which shall include all the parts specified in Type-2 & Type-1 along with items specified in Type-3 as shown in this drawing.
(For detail scope of supply and part item details refer sheet no. 2 to 13 of this drawing)
- 2) Design should ensure that vent holes for release of hot gases in outer tube remain open to atmosphere in all operating condition.
- 3) This heating device is a portable unit. Heating should be possible in any of the stud in assembled condition.
- 4) The arrangement shown in this drawing is for reference purpose. The sole responsibility of mechanical design rests with supplier.
- 5) Certificate of compliance to be provided by supplier

BHEL MATERIAL CODE: W90312015020

C.B.O.M. No.		STATUS OF THIS U		TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		STEAM TURBINE	
DESIGNED BY	NAME	SIGN	DATE				
GRADE OF UNTOL.DIM							
M/C.G.- AA0230208							
WELDING-AA0621104							
GAS CUTTING-T3-AA0621104							
REV	DATE	ALTERED CHECKED	REV	DATE	ALTERED CHECKED		
DEPT STE CODE 4011				SCALE N.T.S		WEIGHT (KG) 70.0	REF. TO ASSY. DRG. ITEM No.
TITLE STUD HEATING AND MEASURING DEVICE				CARD CODE		DRAWING NO. 1-12015-56600	
				SHEET No.01		No. OF SHEETS 19	
						A1 SIZE	