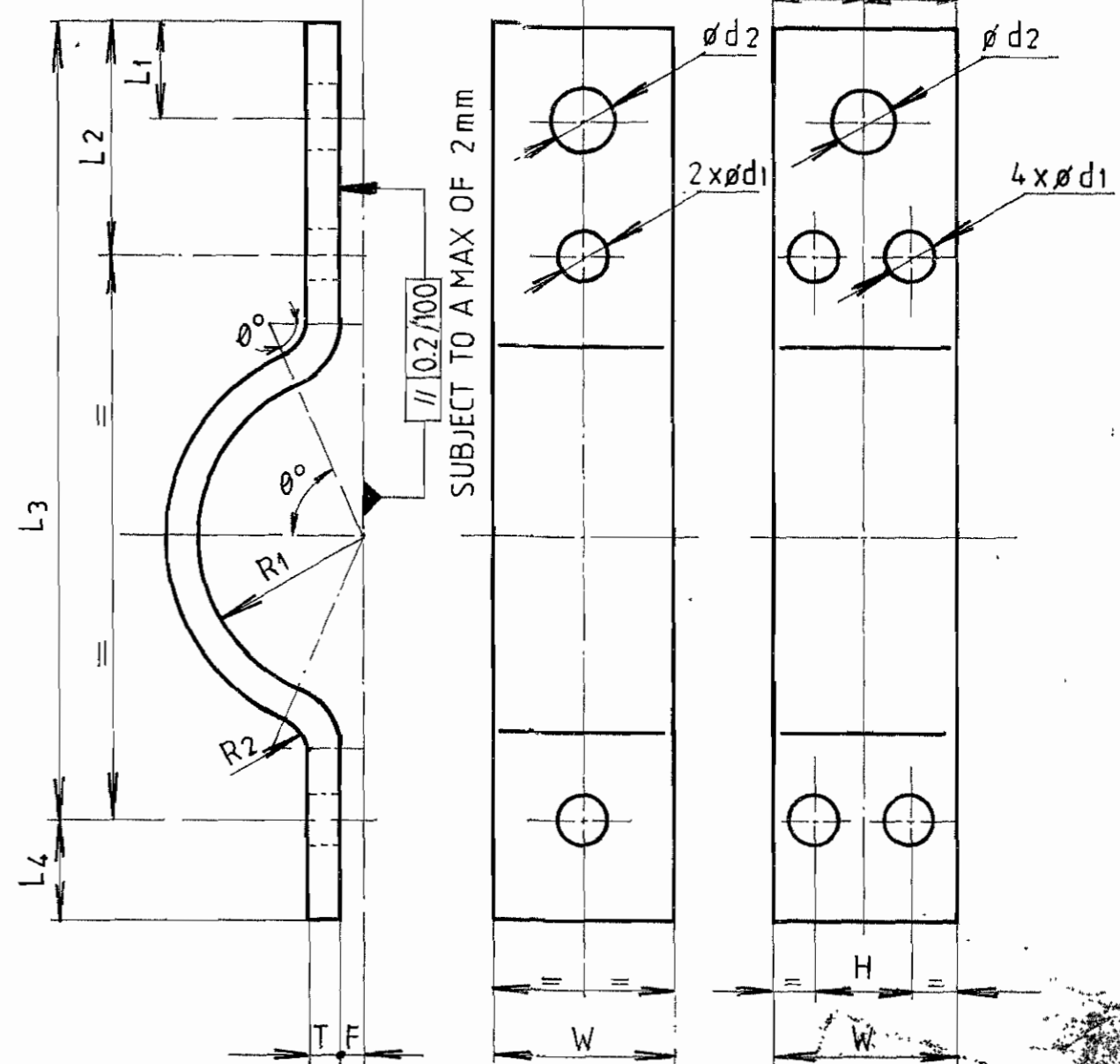


05266-666-08-Z

DRAWING NO.

VAR NO	PIPE SIZE O.D	RAW MATL SIZE T x W x DL	L1	L2	L3	L4	∅ d1	∅ d2	F	H	R1	R2	θ°			TYPE	MATL CODE	WT (Kg)	REMARKS
01	73.0	8 x 50 x 265	24	90	227	18	15	18	10	—	38.2	16	57			A	15.942.222	0.83	
02	88.9	8 x 50 x 302	24	101	257	18	15	18	10	—	46.2	16	61			A	15.942.222	0.95	
03	114.3	8 x 50 x 339	24	97	282	18	15	18	10	—	59.2	16	66			A	15.942.222	1.07	
04	168.3	8 x 40 x 447	24	117	361	18	15	18	10	—	86.7	16	72			A	15.942.222	1.12	
05	168.3	12 x 60 x 463	36	121	381	18	15	26	10	—	86.7	24	68			A	15.942.110	2.62	
06	219.1	12 x 50 x 550	24	126	441	18	15	18	10	—	112.5	24	72			A	15.942.110	2.59	
07	219.1	16 x 75 x 586	42	131	473	30	23	30	12.5	—	112.5	32	68			A	15.942.112	5.52	
08	273.0	8 x 40 x 640	24	142	496	18	15	18	10	—	140	16	78			A	15.942.222	1.60	
09	273.0	16 x 60 x 659	36	136	527	18	15	26	10	—	140	32	72			A	15.942.112	4.97	
10	273.0	16 x 85 x 688	51	146	547	30	23	36	12.5	—	140	32	71			A	15.942.112	7.35	
11	323.9	12 x 50 x 723	24	131	557	18	15	18	10	—	165.8	24	77			A	15.942.110	3.40	
12	323.9	20 x 70 x 763	42	126	599	30	23	30	12.5	—	165.8	40	71			A	15.942.113	8.38	
13	323.9	20 x 105 x 788	62	143	621	36	27	41	15	—	165.8	40	71			A	15.942.113	13.00	
14	355.6	12 x 50 x 783	24	139	598	18	15	18	10	—	182	24	78			A	15.942.110	3.69	
15	355.6	20 x 70 x 822	42	134	641	30	23	30	12.5	—	182	40	73			A	15.942.113	9.03	
16	355.6	20 x 110 x 847	62	151	663	36	27	41	15	—	182	40	72			A	15.942.113	14.63	
17	406.4	12 x 50 x 863	24	138	650	18	15	18	10	—	207.8	24	79			A	15.942.110	4.07	
18	406.4	20 x 75 x 901	42	132	693	30	23	30	12.5	—	207.8	40	74			A	15.942.113	10.61	
19	406.4	20 x 120 x 926	62	149	715	36	27	41	15	—	207.8	40	74			A	15.942.113	17.45	
20	457	16 x 60 x 967	36	149	733	18	15	26	10.5	—	233.6	32	78			A	15.942.112	7.28	
21	457	25 x 70 x 1005	51	138	775	30	23	36	12.5	—	233.6	50	73			A	15.942.114	13.80	
22	457	20 x 125 x 997	62	164	771	24	19	41	15	70	233.6	40	75			B	15.942.113	19.56	
23	508	16 x 60 x 1056	36	158	795	18	15	26	11	—	259.5	32	79			A	15.942.112	7.96	
24	508	25 x 70 x 1095	51	146	837	30	23	36	12.5	—	259.5	50	75			A	15.942.114	15.04	
25	508	25 x 100 x 1111	62	154	850	36	27	41	15	—	259.5	50	74			A	15.942.114	21.80	
26	559	16 x 60 x 1175	36	196	885	18	15	26	12	—	285.5	32	80			A	15.942.112	8.85	
27	559	30 x 70 x 1219	51	172	939	30	23	36	12.5	—	285.5	60	74			A	15.942.199	20.10	
28	559	25 x 105 x 1231	62	192	942	36	27	41	15	—	285.5	50	76			A	15.942.114	25.37	
29	610	20 x 60 x 1231	36	160	921	18	15	26	13	—	311.4	40	79			A	15.942.113	11.60	
30	610	30 x 70 x 1273	51	146	967	30	23	36	13	—	311.4	60	75			A	15.942.199	20.99	
31	610	30 x 100 x 1290	62	154	981	36	27	41	15	—	311.4	60	75			A	15.942.199	30.38	



- NOTE:**
- PIPE CLAMPS SHALL BE MANUFACTURED FROM FLATS OR FROM PLATES SHEARED ALONG THE GRAINS AND THE EDGES DRESSED OFF SHARP CORNERS.
 - SUBSTITUTION OF PLATE MATERIALS IS-2002 CLASS.3 IN PLACE OF GR.70 (C) IS ACCEPTABLE.
 - ALL HOLES TO BE MATCH DRILLED BY ASSEMBLING THE HALF CLAMPS.
 - MANUFACTURE AND INSPECTION SHALL BE AS PER QCP NO. 06 OF PIPING CENTRE.
 - DIMENSIONS W, H, L1, L2, L3 & L4 SHALL BE MAINTAINED WITH TOLERANCE OF ±1mm FROM THE EDGE.
 - REFER DRAWING NO: 2.80.999.99251 FOR BOM DETAILS & DRAWING NO: 2.80.999.99252 FOR CLAMP SELECTION.
 - CLAMPS SHALL BE SUPPLIED IN ASSEMBLED CONDITION ALONG WITH FASTENERS ETC AS SHOWN IN DRAWING NO-2.80.999.99252.
 - BIN CODES SHALL BE PUNCHED ON THE CLAMP ASSY AFTER MANUFACTURE.

TYPE OF PRODUCT OR NAME OF CUSTOMER / PROJECT		STANDARD	
MATERIAL: SA.515 Gr.70 (C)			
BHEL	BHARAT HEAVY ELECTRICALS LTD.,	DRN	R.SRINIVASAN
	PIPING CENTRE, MADRAS	CHKD	R.NANATH
		APPD	S.JAYAKUMAR
DEPT.	GRADE OF UN TOL DIM C/M/F	SCALE	WEIGHT (Kg)
CODE		NTS	REFER TABLE
TITLE	PIPE CLAMP (C.S)		REV No.
	CARD CODE	DRAWING No	REV
	U 01	2.80.999.99250.	02

REV 02 DATE 4/2/91 ALTD: GA APPD: [Signature]

REV 01 DATE 19.04.91 ALTERED R SRINIVASAN. CHECKED [Signature]

QCP NO. ALTERED IN ZONE FOR VAR.NOS.13,16,19,22,25,28, AND 31 HOLE ∅d2 ALTD FROM 43 To 41 mm

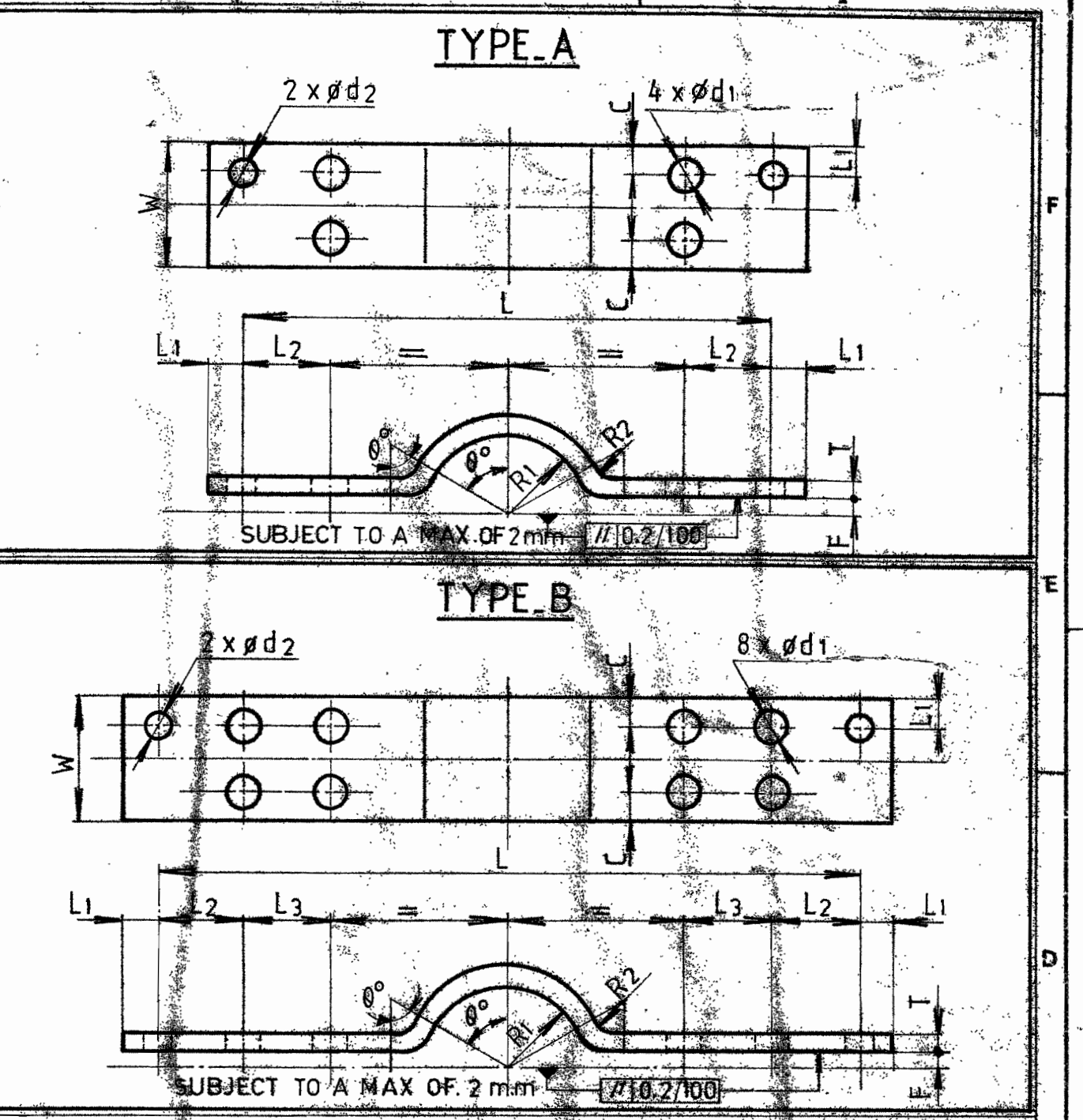
NOTE-4.

05-228/C

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VAR NO	TYPE	PIPE SIZE DIA m.m.	L		L1	L2		L3	C	Ø d1	Ø d2	F	R1	R2	θ°	T x W	DEV. LENGTH		MATL CODE	WEIGHT		REMARKS	VAR NO
			MIN	MAX		MIN	MAX										MIN	MAX		MIN	INCR. IN Kg/100mm		
																	MIN	MAX					
01.	A	73.0	400	650	25	125	250	—	30	15	18	10	38.2	24	52	12 x 110	467	717	15.942.110	4.84	1.036	01	
02.	A	73.0	400	650	37	120	245	—	30	15	26	10	38.2	32	48	16 x 140	490	740	15.942.112	8.62	1.758	02	
03.	A	88.9	400	650	25	115	240	—	30	15	18	10	46.2	24	56	12 x 110	474	724	15.942.110	4.91	1.036	03	
04.	A	88.9	400	650	37	109	234	—	30	15	26	10	46.2	32	52	16 x 135	497	747	15.942.112	8.43	1.696	04	
05.	A	114.3	400	800	25	100	300	—	30	15	18	10	59.2	24	61	12 x 120	486	886	15.942.110	5.50	1.130	05	
06.	A	114.3	400	800	37	87	287	—	30	15	26	10	59.2	40	54	20 x 110	506	906	15.942.113	8.74	1.727	06	
07.	A	168.3	550	900	25	145	320	—	30	15	18	10	86.7	24	68	12 x 135	664	1014	15.942.110	8.44	1.272	07	
08.	B	168.3	550	900	37	84	259	46	30	15	26	10	86.7	40	62	20 x 115	681	1031	15.942.113	12.30	1.806	08	
09.	B	168.3	550	900	43	75	250	46	30	15	30	10	86.7	50	58	25 x 120	690	1040	15.942.114	16.25	2.355	09	
10.	A	219.1	650	1000	25	167	342	—	30	15	18	10	112.5	24	72	12 x 145	791	1141	15.942.110	10.80	1.366	10	
11.	A	219.1	650	1000	37	151	326	—	30	15	26	10	112.5	40	66	20 x 130	807	1157	15.942.113	16.47	2.041	11	
12.	B	219.1	650	1000	43	95	270	46	30	15	30	10	112.5	50	63	25 x 130	815	1165	15.942.114	20.79	2.551	12	
13.	A	273.0	750	1100	25	180	355	—	30	15	18	10	140.0	32	72	16 x 110	915	1265	15.942.112	12.64	1.382	13	
14.	A	273.0	750	1100	37	171	346	—	30	15	26	10	140.0	40	70	20 x 140	935	1285	15.942.113	20.55	2.198	14	
15.	B	273.0	750	1100	43	105	280	46	30	15	30	10	140.0	60	64	30 x 110	938	1288	15.942.199	24.30	2.591	15	
16.	B	273.0	750	1100	52	81	256	52	35	19	36	15	140.0	80	59	40 x 135	943	1293	15.942.117	39.97	4.239	16	
17.	A	323.9	900	1200	25	228	378	—	30	15	18	10	165.8	32	74	16 x 110	1093	1393	15.942.112	15.10	1.382	17	
18.	B	323.9	900	1200	37	162	312	46	30	15	26	10	165.8	50	69	25 x 110	1106	1406	15.942.114	23.88	2.159	18	
19.	B	323.9	900	1200	43	152	302	46	30	15	30	10	165.8	60	67	30 x 110	1114	1414	15.942.199	28.86	2.591	19	
20.	B	323.9	900	1200	52	116	266	58	40	23	36	13	165.8	80	62	40 x 145	1120	1420	15.942.117	50.99	4.553	20	
21.	A	355.6	900	1250	25	211	386	—	30	15	18	10	182.0	32	75	16 x 110	1110	1460	15.942.112	15.34	1.382	21	
22.	B	355.6	900	1250	37	145	320	46	30	15	26	10	182.0	50	71	25 x 110	1123	1473	15.942.114	24.24	2.159	22	
23.	B	355.6	900	1250	43	135	310	46	30	15	30	10	182.0	60	68	30 x 115	1130	1480	15.942.199	30.60	2.708	23	
24.	B	355.6	900	1250	52	98	273	58	40	23	36	13	182.0	80	64	40 x 150	1135	1485	15.942.117	53.46	4.710	24	
25.	A	406.4	950	1400	25	209	434	—	30	15	18	10	207.8	32	77	16 x 110	1189	1639	15.942.112	16.43	1.382	25	
26.	B	406.4	950	1400	37	143	368	46	30	15	26	10	207.8	50	73	25 x 115	1201	1651	15.942.114	27.11	2.257	26	
27.	B	406.4	950	1400	43	132	357	46	30	15	30	10	207.8	60	70	30 x 120	1207	1657	15.942.199	34.11	2.826	27	
28.	B	406.4	950	1400	52	95	320	58	40	23	36	13	207.8	80	66	40 x 165	1211	1661	15.942.117	62.74	5.181	28	
29.	A	457.0	1000	1500	25	209	459	—	30	15	18	13	233.6	32	78	16 x 115	1262	1762	15.942.112	18.23	1.444	29	
30.	B	457.0	1000	1500	37	142	392	46	30	15	26	13	233.6	50	73	25 x 120	1274	1774	15.942.114	30.00	2.355	30	
31.	B	457.0	1000	1500	43	122	372	52	35	19	30	15	233.6	60	71	30 x 130	1277	1777	15.942.199	39.10	3.062	31	
32.	B	457.0	1000	1500	52	92	342	58	40	23	36	13	233.6	80	68	40 x 175	1287	1787	15.942.117	70.72	5.495	32	
33.	A	508.0	1050	1500	25	207	432	—	30	15	18	13	259.5	32	79	16 x 110	1341	1791	15.942.112	18.53	1.382	33	
34.	B	508.0	1050	1500	37	140	365	46	30	15	26	13	259.5	50	75	25 x 115	1352	1802	15.942.114	30.51	2.257	34	
35.	B	508.0	1050	1500	43	120	345	52	35	19	30	15	259.5	60	73	30 x 125	1354	1804	15.942.199	39.86	2.944	35	
36.	B	508.0	1050	1500	52	89	314	58	40	23	36	13	259.5	80	70	40 x 165	1364	1814	15.942.117	70.67	5.181	36	
37.	A	559.0	1150	1550	25	231	431	—	30	15	18	13	285.5	32	80	16 x 110	1470	1870	15.942.112	20.31	1.382	37	
38.	B	559.0	1150	1550	37	163	363	46	30	15	26	13	285.5	50	76	25 x 115	1480	1880	15.942.114	33.40	2.257	38	
39.	B	559.0	1150	1550	43	143	343	52	35	19	30	15	285.5	60	74	30 x 125	1482	1882	15.942.199	43.63	2.944	39	
40.	B	559.0	1150	1550	52	102	302	65	50	27	36	15	285.5	80	71	40 x 170	1488	1888	15.942.117	79.43	5.338	40	
41.	A	610.0	1200	1600	25	229	429	—	30	15	18	13	311.4	32	80	16 x 110	1548	1948	15.942.112	21.39	1.382	41	
42.	B	610.0	1200	1600	37	161	361	46	30	15	26	13	311.4	50	77	25 x 115	1558	1958	15.942.114	35.16	2.257	42	
43.	B	610.0	1200	1600	43	141	341	52	35	19	30	15	311.4	60	75	30 x 125	1560	1960	15.942.199	45.92	2.944	43	
44.	B	610.0	1200	1600	52	99	299	65	50	27	36	15	311.4	80	72	40 x 170	1566	1966	15.942.117	83.59	5.338	44	



NOTES:
 01. FOR ACTUAL 'L' DIMENSION REFER GMS.
 02. 'L' VALUE SELECTED SHALL BE BETWEEN 'L' MIN. AND 'L' MAX.
 03. SUBSTITUTION OF PLATE MATERIAL IS: 2002 CLASS 3 IN PLACE OF SA-515 GR 70(C) IS ACCEPTABLE.
 04. MANUFACTURE AND INSPECTION SHALL BE AS PER QCP NO. 06 OF PIPING CENTRE.
 05. ALL HOLES SHALL BE MATCH DRILLED BY ASSEMBLING THE HALF CLAMPS. C
 06. REFER DRAWING NO: 2.80.999.99258 FOR B.O.M DETAILS & DRAWING NO: 2.80.999.99259 FOR CLAMP SELECTION.
 07. ACTUAL WEIGHT SHALL BE CALCULATED FROM 'L' ACTUAL (FROM GMS)

$$\text{ACTUAL WEIGHT} = \text{WEIGHT FOR 'L' MIN} + \left[\frac{(\text{'L' ACTUAL} - \text{'L' MIN})}{100} \times \text{INCREMENT WT PER 100MM} \right]$$

 08. ACTUAL DEVELOPED LENGTH = DL FOR 'L' MIN + $\left[\frac{(\text{'L' ACTUAL} - \text{'L' MIN})}{2} \right]$
 09. CLAMPS SHALL BE SUPPLIED IN ASSEMBLED CONDITION ALONG WITH FASTENERS ETC AS SHOWN IN DRAWING NO: 2.80.999.99258.
 10. ACTUAL 'L2' = 'L2' MIN + $\left[\frac{(\text{'L' ACTUAL} - \text{'L' MIN})}{2} \right]$

TYPE OF PRODUCT OR NAME OF CUSTOMER / PROJECT: **STANDARD**
 MATERIAL: SA-515 GR 70(C)

BHARAT HEAVY ELECTRICALS LTD., PIPING CENTRE, MADRAS

DRN	R. SHRINIVASAN	DATE		No. OF VAR
CHD	R. ANANTH.			
APPD	S. JAYAKUMAR	DATE	31/8/10	

DEPT. CODE: **NTS**

SCALE: REFER TABLE

TITLE: **RISER CLAMP (CS)**

WEIGHT (KG): REFER TABLE

REF TO ASSEMBLY / OLD DRG

CARD CODE: U 01

DRAWING NO: **2.80.999.99257**

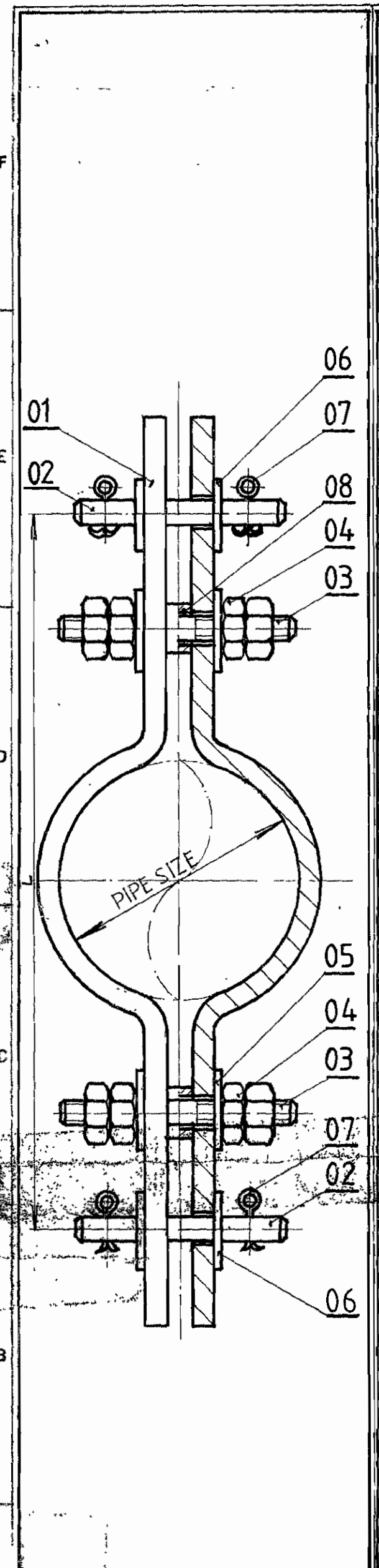
REV: **02**

REV DATE: 02/20/10
 ALTERED BY: [Signature]
 APPROVED BY: [Signature]
 NOTE: 10 ADDED.
 QCP NO. ALTERED IN NOTE-4.

05-228/C

FIRST ANGLE PROJECTION (ALL DIMENSIONS IN MILLIMETRES)

CAUTION THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LTD. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.



ASSY VAR. NO	PIPE SIZE	ITEM NO:01 RISER CLAMP		ITEM NO:02 LOAD PIN		ITEM NO:03 STUD		ITEM NO:04 NUT		ITEM NO:05 STUD WASHER		ITEM NO:06 LOAD PIN WASHER		ITEM NO:07 SPLIT PIN		ITEM NO:08 SPACER RING		'L' MIN	ASSY WT. FOR 'L' MIN	INCREMENT WT. Kg PER 100mm OF 'L'	REMARKS VAR. NO									
		DRAWING NO.	QTY	DRAWING NO.	QTY	DRAWING NO.	QTY	DRAWING NO.	QTY	DRAWING NO.	QTY	DRAWING NO.	QTY	DRAWING NO.	QTY	DRAWING NO.	QTY													
01	73.0	2.80.999.99257	01	2	4.80.999.99307	08	2	4.80.999.99308	05	4	413.19.12000	-	16	414.08.12000	-	8	414.08.16000	-	4	417.04.04025	-	4	4.80.999.99323	01	4	400	11.036	2.072	01	
02	73.0		02			09											414.08.24000	-		417.04.06045	-					400	19.268	3.516	02	
03	88.9		03			08											414.08.16000	-		417.04.04025	-					400	11.176	2.072	03	
04	88.9		04			09											414.08.24000	-		417.04.06045	-					400	18.888	3.392	04	
05	114.3		05			08											414.08.16000	-		417.04.04025	-					400	12.356	2.260	05	
06	114.3		06			09											414.08.24000	-		417.04.06045	-					400	19.508	3.454	06	
07	168.3		07			08											414.08.16000	-		417.04.04025	-					550	18.236	2.544	07	
08	168.3		08			09			8		-	32		-	16	414.08.24000	-		417.04.06045	-					8	550	27.608	3.612	08	
09	168.3		09			10			8		-	32		-	16	414.08.27000	-		417.04.06045	-					8	550	35.860	4.710	09	
10	219.1		10			08			4		-	16		-	8	414.08.16000	-		417.04.04025	-					4	650	22.956	2.732	10	
11	219.1		11			09			4		-	16		-	8	414.08.24000	-		417.04.06045	-					4	650	34.968	4.082	11	
12	219.1		12			10			8		-	32		-	16	414.08.27000	-		417.04.06045	-					8	650	44.940	5.102	12	
13	273.0		13			08			4		-	16		-	8	414.08.16000	-		417.04.04025	-					4	750	26.636	2.764	13	
14	273.0		14			09			4		-	16		-	8	414.08.24000	-		417.04.06045	-					4	750	43.128	4.396	14	
15	273.0		15			14			8		-	32		-	16	414.08.27000	-		417.04.06045	-					8	750	52.200	5.182	15	
16	273.0		16			15			09	8	413.19.16000	-	32	414.08.16000	-	16	414.08.33000	-		417.04.08056	-				06	8	750	87.408	8.478	16
17	323.9		17			08			05	4	413.19.12000	-	16	414.08.12000	-	8	414.08.16000	-		417.04.04025	-				01	4	900	31.556	2.764	17
18	323.9		18			09			8		-	32		-	16	414.08.24000	-		417.04.06045	-					8	900	50.768	4.318	18	
19	323.9		19			14					-	32		-		414.08.27000	-		417.04.06045	-					8	900	61.320	5.182	19	
20	323.9		20			15			08		413.19.20000	-		414.08.20000	-		414.08.33000	-		417.04.08056	-				08	8	900	111.744	9.106	20
21	355.6		21			08			05	4	413.19.12000	-	16	414.08.12000	-	8	414.08.16000	-		417.04.04025	-				01	4	900	32.036	2.764	21
22	355.6		22			09				8	-	32			16	414.08.24000	-		417.04.06045	-					01	8	900	151.488	4.318	22
23	355.6		23			14					-	32				414.08.27000	-		417.04.06045	-					01	8	900	116.800	4.318	23
24	355.6		24			15			08		413.19.20000	-		414.08.20000	-		414.08.33000	-		417.04.08056	-				08	8	900	116.800	4.318	24
25	406.4		25			08			05	4	413.19.12000	-	16	414.08.12000	-	8	414.08.16000	-		417.04.04025	-				01	4	950	34.216	2.764	25
26	406.4		26			09				8	-	32		-	16	414.08.24000	-		417.04.06045	-					01	8	950	57.228	4.514	26
27	406.4		27			14					-	32		-		414.08.27000	-		417.04.06045	-					01	8	950	71.820	5.652	27
28	406.4		28			15			08		413.19.20000	-		414.08.20000	-		414.08.33000	-		417.04.08056	-				08	8	950	135.244	10.362	28
29	457.0		29			08			05	4	413.19.12000	-	16	414.08.12000	-	8	414.08.16000	-		417.04.04025	-				05	4	1000	37.880	2.888	29
30	457.0		30			09			05	8	413.19.12000	-	32	414.08.12000	-	16	414.08.24000	-		417.04.06045	-				05	8	1000	63.136	4.730	30
31	457.0		31			14			09		413.19.16000	-		414.08.16000	-		414.08.27000	-		417.04.06045	-				06	8	1000	84.352	6.124	31
32	457.0		32			15			08		413.19.20000	-		414.08.20000	-		414.08.33000	-		417.04.08056	-				08	8	1000	151.204	10.990	32
33	508.0		33			08			05	4	413.19.12000	-	16	414.08.12000	-	8	414.08.16000	-		417.04.04025	-				05	4	1050	38.480	2.764	33
34	508.0		34			09			05	8	413.19.12000	-	32	414.08.12000	-	16	414.08.24000	-		417.04.06045	-				05	8	1050	64.156	4.514	34
35	508.0		35			14			09		413.19.16000	-		414.08.16000	-		414.08.27000	-		417.04.06045	-				06	8	1050	85.872	5.888	35
36	508.0		36			15			08		413.19.20000	-		414.08.20000	-		414.08.33000	-		417.04.08056	-				08	8	1050	151.104	10.362	36
37	559.0		37			08			05	4	413.19.12000	-	16	414.08.12000	-	8	414.08.16000	-		417.04.04025	-				05	4	1150	42.040	2.764	37
38	559.0		38			09			05	8	413.19.12000	-	32	414.08.12000	-	16	414.08.24000	-		417.04.06045	-				05	8	1150	69.936	4.514	38
39	559.0		39			14			09		413.19.16000	-		414.08.16000	-		414.08.27000	-		417.04.06045	-				06	8	1150	93.412	5.888	39
40	559.0		40			15			02		413.19.24000	-		414.08.24000	-		414.08.33000	-		417.04.08056	-				09	8	1150	172.272	10.676	40
41	610.0		41			08			05	4	413.19.12000	-	16	414.08.12000	-	8	414.08.16000	-		417.04.04025	-				05	4	1200	44.200	2.764	41
42	610.0		42			09			05	8	413.19.12000	-	32	414.08.12000	-	16	414.08.24000	-		417.04.06045	-				05	8	1200	73.456	4.514	42
43	610.0		43			14			09		413.19.16000	-		414.08.16000	-		414.08.27000	-		417.04.06045	-				06	8	1200	97.992	5.888	43
44	610.0		44			15			02		413.19.24000	-		414.08.24000	-		414.08.33000	-		417.04.08056	-				09	8	1200	180.592	10.676	44

NOTE:
 01. ACTUAL ASSY WEIGHT = ASSY. WEIGHT FOR 'L' MIN + $\left[\frac{('L' \text{ SELECTED} - 'L' \text{ MIN})}{100} \right] \times \text{INCREMENT WEIGHT FOR 100mm OF 'L'}$
 02. FOR ACTUAL 'L' DIMENSION REFER GMS.

STANDARD

REV 01 DATE 19.04.91 ALTERED BY R. SRINIVASAN. CHECKED BY R. ANANTH. FOR VAR. NOS. 40 & 44. ASSY WT. FOR 'L' MIN ALTD.

BHARAT HEAVY ELECTRICALS LTD.
 PIPING CENTRE, MADRAS

DRN: R. SHRINIVASAN, SGM: [Signature], NAME: [Signature]
 CHD: R. ANANTH., NAME: [Signature]
 APPD: S. JAYAKUMAR, NAME: [Signature]

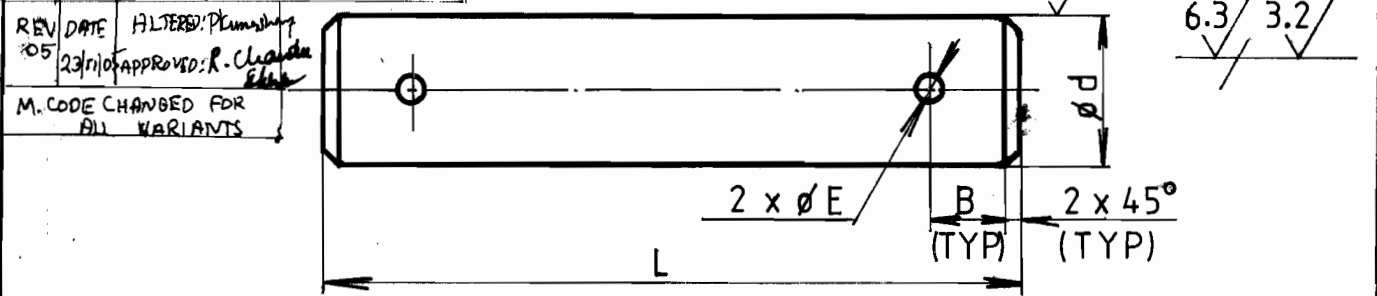
DPT: [Blank] GRADE OF UN TOL. DIM: C/M/F, SCALE: NTS, WEIGHT (Kgr.): REFER TABLE, REF TO ASSY/ OLD DRG: [Blank], ITEM No.: [Blank]

TITLE: **RISER CLAMP ASSY. (CS)**, CARD CODE: U 01, DRAWING No.: **2.80_999_99258.**, REV: **01**

SIZE A2

FIRST ANGLE PROJECTION (ALL DIMENSIONS IN MILLIMETRES)

REV 01	DATE 4.5.90	ALTERED N.M.NATHAN. CHECKED sd. S.J.	REV 02	DATE 21.6.90	ALTERED R.SRINIVASAN. CHECKED <i>[Signature]</i>	REV 03	DATE 31.8.90	R.SRINIVASAN. <i>[Signature]</i>
VAR NOS.08 TO 12 ADDED.			VAR NO.13 ADDED.			VAR NOS.14 & 15 ADDED FOR VAR NO:12 ϕ d MATL.CODE & WEIGHT ALTERED. DRG REDRAWN.		
REV 04	DATE 22.03.91	ALTERED: R. SRINIVASAN CHECKED: <i>[Signature]</i>						
VAR. NOS. 08 TO 15 BIN.CODE ADDED.								



VAR NO	ϕ d	ϕ E	B	L	MATL.CODE BIN.CODE	MATL SPEC	WT(Kg)	REMARKS
01.	19	7	12	110	15 339 139 0000	SA-105 (C)	0.240	
02.	22	7	12	130	15 339 139 0000		0.380	
03.	24	7	12	150	15 339 139 0000		0.530	
04.	27	7	12	160	15 339 140 0000		0.710	
05.	30	9	15	150	15 339 140 0000		0.830	
06.	33	9	15	150	15 339 280 0000		1.000	
07.	36	9	15	150	15 339 141 0000		1.190	
08.	16	4	12	100	15-339-1390000 94 822 1610000	\triangle 05	0.160	
09.	24	6.3	12	125	15-339-1390000 94 822 2413000		0.440	
10.	28	6.3	12	125	15-339-1400000 94 822 2813000		0.600	\triangle 01
11.	34	8	15	160	15-339-2800000 94 822 3416000		1.140	
12.	39	8	15	165	15-339-1410000 94 822 3917000		1.540	\triangle 03 \triangle 04
13.	46	10	15	165	15-339-1420000 94 822 4617000		2.140	\triangle 02
14.	28	6.3	12	150	15-339-1400000 94 822 2815000		0.720	\triangle 03
15.	34	8	15	180	15-339-2800000 94 822 3418000		1.280	\triangle 03

CAUTION: THIS INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LTD. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

		BHARAT HEAVY ELECTRICALS LTD.		DRN.	R. SRINIVASAN	SIGN	<i>[Signature]</i>	DATE	
BOILER PLANT UNIT				CHD	M.M.MANI.	S/D			
TIRUCHIRAPALLI- 620 014.				APPD.	S.JAYAKUMAR.	S/D	26.5.90		31.8.90
DEPT.	GRADE OF UNTOL DIM		SCALE	WEIGHT (Kg)	REFER TABLE		REF TO ASSY/OLD DRG	ITEM No.	
CODE	C/M/F		NTS						
TITLE				CARD CODE	DRAWING No.		REV.		
LOAD PIN				U 01	4-80-999-99307.		05		