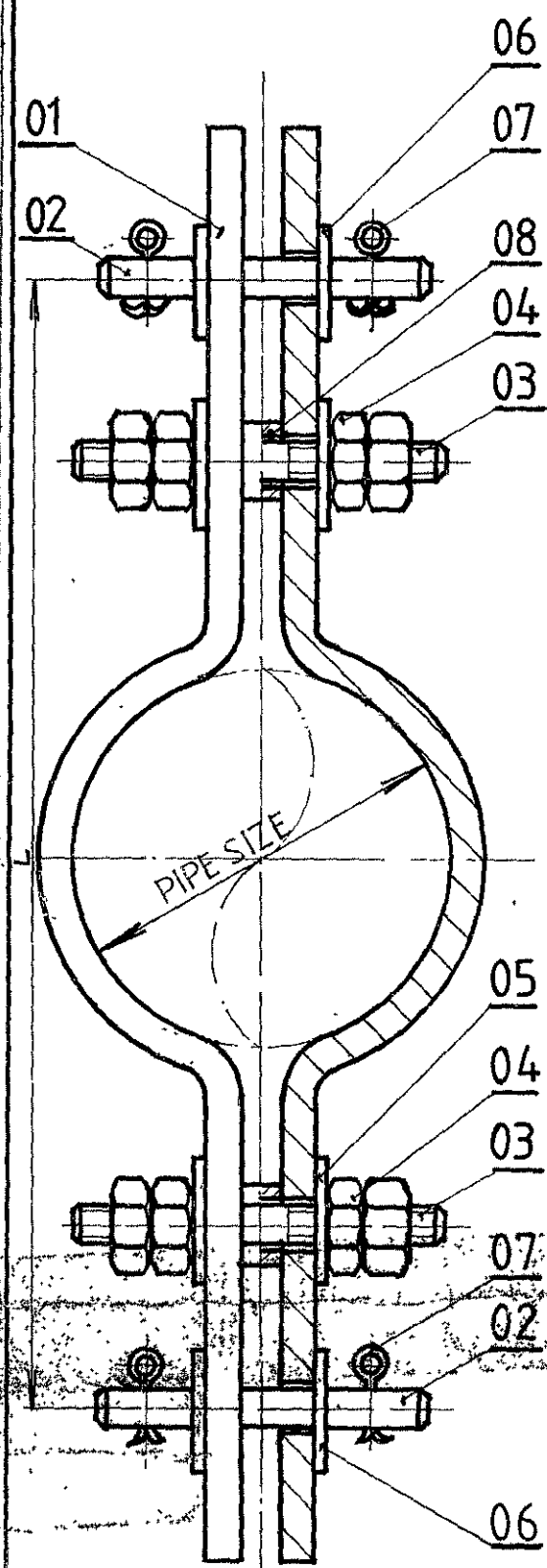


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FIRST ANGLE PROJECTION (ALL DIMENSIONS IN MILLIMETRES)



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.	VAR NO QTY	DRAWING NO.	VAR NO QTY	DRAWING NO.	VAR NO QTY	DRAWING NO.	VAR NO QTY	DRAWING NO.	VAR NO QTY	DRAWING NO.	VAR NO QTY	DRAWING NO.	VAR NO QTY	DRAWING NO.	VAR 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				-	-	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	51.488	4.318	22
23	355.6		23		14				-	-	414.08.27000	-	417.04.06045	-			01 8	900	61.320	5.182	23
24	355.6		24		15		08	413.19.20000	-	414.08.20000	-	414.08.33000	-	417.04.08056	-		08 8	900	111.744	9.106	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				-	-	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	4.710	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	5.998	35
36	508.0		36		15		08	413.19.20000	-	414.08.20000	-	414.08.33000	-	417.04.08056	-		08 8	1050	151.04	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	-	417.08.27000	-	417.04.06045	-		06 8	1200	97.992	5.888	43
44	610.0		44		15		02	413.19.24000	-	414.08.24000	-	417.08.33000	-	417.04.08056	-		09 8	1200	180.592	10.676	44

NOTE:

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

STANDARD



BHARAT HEAVY ELECTRICALS LTD.,
PIPING CENTRE, MADRAS

DRN R.SHRINIVASAN
CHD R.ANANTH.
APPD S.JAYAKUMAR

REV 01 DATE 19.04.91
ZONE FOR VAR. NOS. 40 & 44
ASSY WT. FOR 'L' MIN ALTD.

DPT: C/DE OF UN TOL DIM C/M/F
CODE

SCALE
NTS

WEIGHT (KG)
REFER TABLE

REF TO ASSY/ OLD DRG

ITEM No.

RISER CLAMP ASSY. (CS)

CARD COPY
U 01

DRAWING No
2-80-999-99258.

REV
01