

आविष्कार संख्या/DRAWING NO.

[illegible]

0.5	
-----	--

PATTERN NO	REF NOTE 05
------------	-------------

Ø38 THRU 1-
TAP 2 HOLES

Ø56 THRU 2" NPT TAF

//	0.5	A
----	-----	---

4 mm THICK PLATE, CASING
CORNER MATCHING PROFILE

14 NOS M20 TAPPED HOLE

S

$\uparrow$ M

VIEW-M

3 mm THICK BOX AROUND
O.D. OF PIPE

CORNER SPACE TO BE FILLED
WITH WELD MATERIAL

DETAIL-T

NOTES:-

- 01 MATERIAL M.S. TO CONFORM TO IS:2062 Gr.- E 250 QUALITY A (LATEST REV.)
02 CASING TO BE CLEANED & PAINTED WITH RED-OXIDE ON OUTSIDE ONLY AS PER E&D:330.
03 TOLERANCE ON THICKNESS OF CASING AS PER IS:1852 CLAUSE 7.3 (LATEST REV.).
04 D.P. TEST ON WELDED JOINT TO BE CARRIED OUT AS PER E&D:331 (LATEST REV.).
05 PATTERN NO. TO BE WELD DEPOSITED ON OUTER SIDE AS FOLLOWS:-

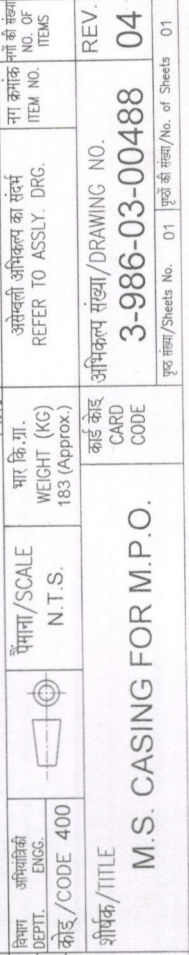
0-61-488-00507-883-XRP

- 06 MFG. & INSP. SHOULD BE DONE AS PER E&D:306 (LATEST REV.).
07 FLANGE IS TO BE FULL WELDED ON EACH END OF CASING.
08 WELDING TO BE CARRIED OUT AS PER PROCEDURE E&D:330 (LATEST REV.).

B

A2 साइज़/A2 SIZE

DATE OF SALE	INVENTORY NO.
--------------	---------------



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इस प्रलेख में दी गई सूचना भारत हेवी इलेक्ट्रिकल्स लिमिटेड की सम्पत्ति है। इसका प्रत्यक्ष या अप्रत्यक्ष रूप में किसी भी तरह प्रयोग नहीं किया जाए, जो कंपनी के हित में हानिकार हो।

संशोधन
REV.

दिनांक
DATE

संशोधनकर्ता
ALTERED BY

जांचकर्ता
CHD

संशोधन
REV.

दिनांक
DATE

संशोधनकर्ता
ALTERED BY

जांचकर्ता
CHD

विभाग
DEPTT.

अभियंत्रिकी
ENGG.

कोड / CODE
400

शीर्षक / TITLE
M. S. CASING (I.D.-635)

कार्ड कोड
CARD CODE

पैमाना / SCALE
N.T.S.

भार कि.ग्रा.
WEIGHT (KG)

असेम्बली अभिकल्प का संदर्भ
REFER TO ASSLY. DRG.

नग क्रमांक
ITEM NO.

अभिकल्प संख्या / DRAWING NO.
3-986-03-01019

गुच्छ संख्या / Sheets No. 01

गुच्छों की संख्या / No. of Sheets 01

REV.
00

हस्ताक्षर और दिनांक / SIGN & DATE

संशोधन अभिकल्प संख्या
REFERENCE DRG. NO.

सामग्री सूची संख्या
INVENTORY NO.

प्रथम कोण प्रक्षेपण / FIRST ANGLE PROJECTION

सभी विमाएं मिलीमीटर में हैं। / ALL DIMENSIONS ARE IN mm.

61010-30-986-3
अभिकल्प संख्या / DRAWING NO.

LOCATION OF PATTERN NO.

3mm PLATE TO BE CUT TO FORM AN ARROW AND WELD ALL AROUND 3 mm FILLET

1

2

3

4

5

6

7

E/F

S

X

E/F

L2±2 (AHS)

R±2

0°±0.5°

L1±2 (TES)

A.H.S. = ARROW HEAD SIDE

T.E.S. = TAIL END SIDE

* C-1 = CENTER OF 1ST SEGMENT

** 135 = 135 mm FROM RESPECTIVE END

FLANGE DET.-E

WT.-9.7 Kg (Approx.)

FLANGE DET.-F

WT.-31 Kg (Approx.)

LUG DET.-S

WT.-0.55 Kg (Approx.)

EP DETAIL OF PLATE -A

NOTES:-

01 MATERIAL M.S. TO CONFORM TO IS:2062 Gr.- E 250 QUALITY A (LATEST REV.)

02 CASING TO BE CLEANED & PAINTED AS PER PAINTING SCHEME ON OUTER SIDE ONLY.

03 TOLERANCE ON THICKNESS OF CASING AS PER IS:1852 CLAUSE 7.3 (LATEST REV.)

04 D.P. TEST ON WELDED JOINT TO BE CARRIED OUT AS PER E&D:331 (LATEST REV.)

05 ARROW TO BE WELDED AS FOLLOWS:-

06 PATTERN NO. IS TO BE WELD DEPOSITED OF HEIGHT 5 mm AS GIVEN IN THE CHART FOR EXAMPLE FOR VAR. NO. 22 .

1-02277-90-22

07 FLANGE IS TO BE FULL WELDED AT EACH END OF CASING .

08 MFG. & INSPECTION SHOULD BE DONE AS PER E&D:306 (LATEST REV.)

09 WELDING IS TO BE CARRIED OUT AS PROCEDURE E&D:330 (LATEST REV.)

10 ALL SEGMENTS TO BE FULL WELDED.

23	90	635	1270	100	1270	1-02277-90-23	7.5°,15°,15°,15°,15°,15°,7.5°	1,2,3,4,5,6,7	E	F	C-2	C-6	500	497
22	90	635	1270	100	1270	1-02277-90-22	7.5°,15°,15°,15°,15°,15°,7.5°	1,2,3,4,5,6,7	E	E	C-2	C-6	500	485
21	73	635	1270	100	1270	1-02277-73-21	7.3°,14.6°,14.6°,14.6°,14.6°,7.3°	1,2,3,4,5,7	E	E	C-2	C-6	500	433
20	65	635	1270	100	1270	1-02277-65-20	6.5°,13°,13°,13°,13°,6.5°	1,2,3,4,5,7	E	E	C-2	C-6	500	408
19	60	635	1270	100	1270	1-02277-60-19	7.5°,15°,15°,15°,7.5°	1,2,3,4,7	E	E	C-2	C-6	500	393
18	57	635	1270	100	1270	1-02277-57-18	5.7°,11.4°,11.4°,11.4°,11.4°,5.7°	1,2,3,4,5,7	E	E	C-2	C-6	500	384
17	55	635	1270	100	1270	1-02277-55-17	5.5°,11°,11°,11°,11°,5.5°	1,2,3,4,5,7	E	E	C-1	C-7	500	377
16	53	635	1270	100	1270	1-02277-53-16	5.3°,10.6°,10.6°,10.6°,10.6°,5.3°	1,2,3,4,5,7	E	E	C-1	C-7	500	372
15	50	635	1270	100	1270	1-02277-50-15	6.25°,12.5°,12.5°,12.5°,6.25°	1,2,3,4,7	E	E	C-2	C-6	500	362
14	45	635	1270	100	1270	1-02277-45-14	7.5°,15°,15°,7.5°	1,2,3,7	F	F	C-1	C-7	500	370
13	45	635	1270	100	1270	1-02277-45-13	7.5°,15°,15°,7.5°	1,2,3,7	F	E	C-1	C-7	500	358.5
12	45	635	1270	100	1270	1-02277-45-12	7.5°,15°,15°,7.5°	1,2,3,7	E	E	C-1	C-7	500	347
11	45	635	635	100	169	1-02277-45-11	7.5°,15°,15°,7.5°	1,2,3,7	F	F	C-1	C-7	-	147.5
10	40	635	1270	100	1270	1-02277-40-10	5°,10°,10°,10°,5°	1,2,3,4,7	E	E	C-1	-	900	331
09	32	635	1270	100	1270	1-02277-32-09	4°,8°,8°,8°,4°	1,2,3,4,7	E	E	140	-	900	306
08	30	635	1270	100	1270	1-02277-30-08	7.5°,15°,7.5°	1,2,7	E	E	C-1	-	900	300
07	28	635	1270	100	635	1-02277-28-07	7°,14°,7°	1,2,7	E	E	C-1	-	400	205.5
06	27	635	1270	100	635	1-02277-27-06	6.75°,13.5°,6.75°	1,2,7	E	E	C-1	-	400	203
05	25	635	1270	100	635	1-02277-25-05	6.25°,12.5°,6.25°	1,2,7	E	E	C-1	-	400	196
04	23	635	1270	100	635	1-02277-23-04	5.75°,11.5°,5.75°	1,2,7	E	E	C-1	-	400	190.5
03	20	635	1270	100	635	1-02277-20-03	5°,10°,5°	1,2,7	E	E	*C-1	-	400	181
02	17	635	1270	100	635	1-02277-17-02	4.25°,8.5°,4.25°	1,2,7	E	E	C-1	-	400	172
01	15	635	1270	100	635	1-02277-15-01	3.75°,7.5°,3.75°	1,2,7	E	E	**135	-	400	166

विभाग
DEPTT.

अभियंत्रिकी
ENGG.

कोड / CODE
400

शीर्षक / TITLE
M. S. CASING (I.D.-635)

कार्ड कोड
CARD CODE

पैमाना / SCALE
N.T.S.

भार कि.ग्रा.
WEIGHT (KG)

असेम्बली अभिकल्प का संदर्भ
REFER TO ASSLY. DRG.

नग क्रमांक
ITEM NO.

अभिकल्प संख्या / DRAWING NO.
3-986-03-01019

गुच्छ संख्या / Sheets No. 01

गुच्छों की संख्या / No. of Sheets 01

REV.
00

हस्ताक्षर और दिनांक / SIGN & DATE

संशोधन अभिकल्प संख्या
REFERENCE DRG. NO.

सामग्री सूची संख्या
INVENTORY NO.

A3 साइज़/A3 SIZE

स्वत्वाधिकार एवं गोपनीय
इस पत्र में दी गई सूचना भारत हेवी इलेक्ट्रिकल्स लिमिटेड की
सम्पत्ति है। इसका प्रत्यक्ष या अप्रत्यक्ष रूप में किसी भी तरह
प्रयोग नहीं किया जाए जो कम्पनी के हित में हानिकार हो।

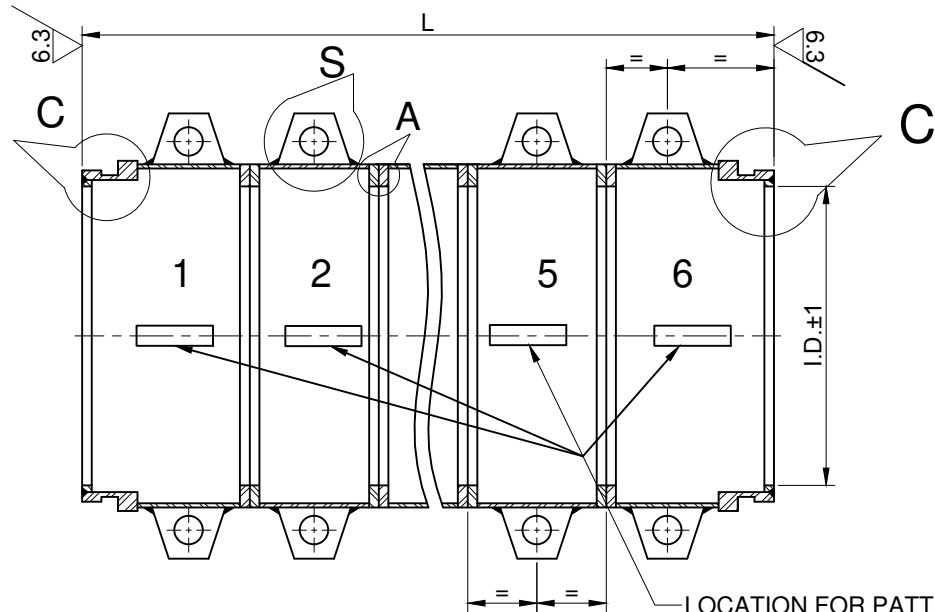
DIMENSIONS TO BE CONTROLLED
WITHIN LIMITS AS SHOWN
MACHINING TOLERANCE ± 0.25 mm
UNLESS OTHERWISE SHOWN
NON-MACHINING TOLERANCE ± 0.5

संदर्भित अभिकल्प संख्या
REFERENCE DRG. NO.

हस्ताक्षर और दिनांक/SIGN & DATE

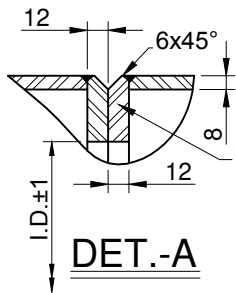
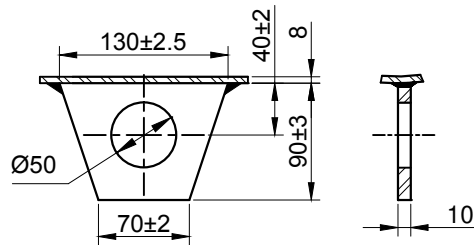
सामग्री सूची संख्या
INVENTORY NO.

3-986-06-01020
3-986-06-01020



LUG DET.-S

WT.-0.55 Kg (Approx.)



DET.-A

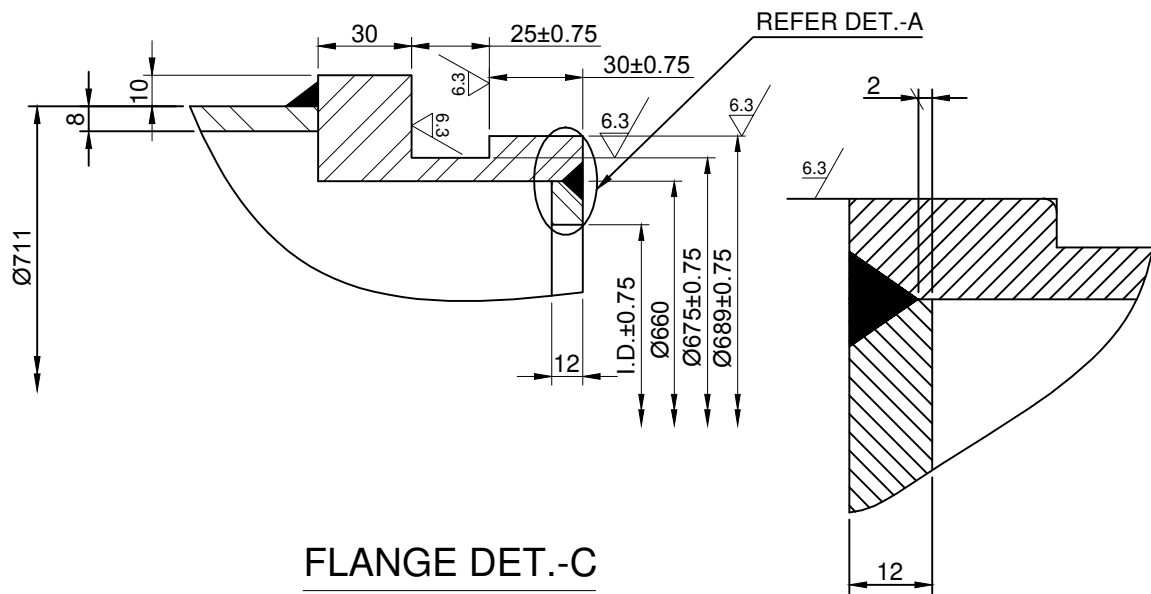
- WT.- 7.5 Kg (Approx.)

NOTES:-

- 01 MATERIAL M.S. TO CONFORM TO IS:2062 Gr.- E250 QUALITY A (LATEST REV.)
02 CASING TO BE CLEANED & PAINTED AS PER PAINTING SCHEME ON OUTER SIDE ONLY.
03 TOLERANCE ON THICKNESS OF CASING AS PER IS:1852 CLAUSE 7.3 (LATEST REV.)
04 D.P. TEST ON WELDED JOINT TO BE CARRIED OUT AS PER E&D:331 (LATEST REV.)
05 PATTERN NO. / PART NO.TO BE WELD DEPOSITED OF HEIGHT 5 mm IN ALL PARTS AS GIVEN
IN THE CHART FOR EXAMPLE- FOR VAR. NO.07 PART NO.-4 WELD DEPOSIT AS FOLLOWS:-

3-01863-07 / 4

- 06 FLANGE IS TO BE FULL WELDED ON EACH END OF CASING .
07 THE STRAIGHT PIPE SHOULD BE SUPPLIED IN PARTS AFTER CHECKING ALIGNMENT .
08 WELDING TO BE CARRIED OUT AS PER PROCEDURE E&D:330 (LATEST REV.).
09 PART LENGTH SHOULD BE MAINTAINED SUCH THAT TOTAL LENGTH WILL COME WITHIN TOLERANCE.



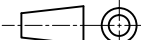
FLANGE DET.-C

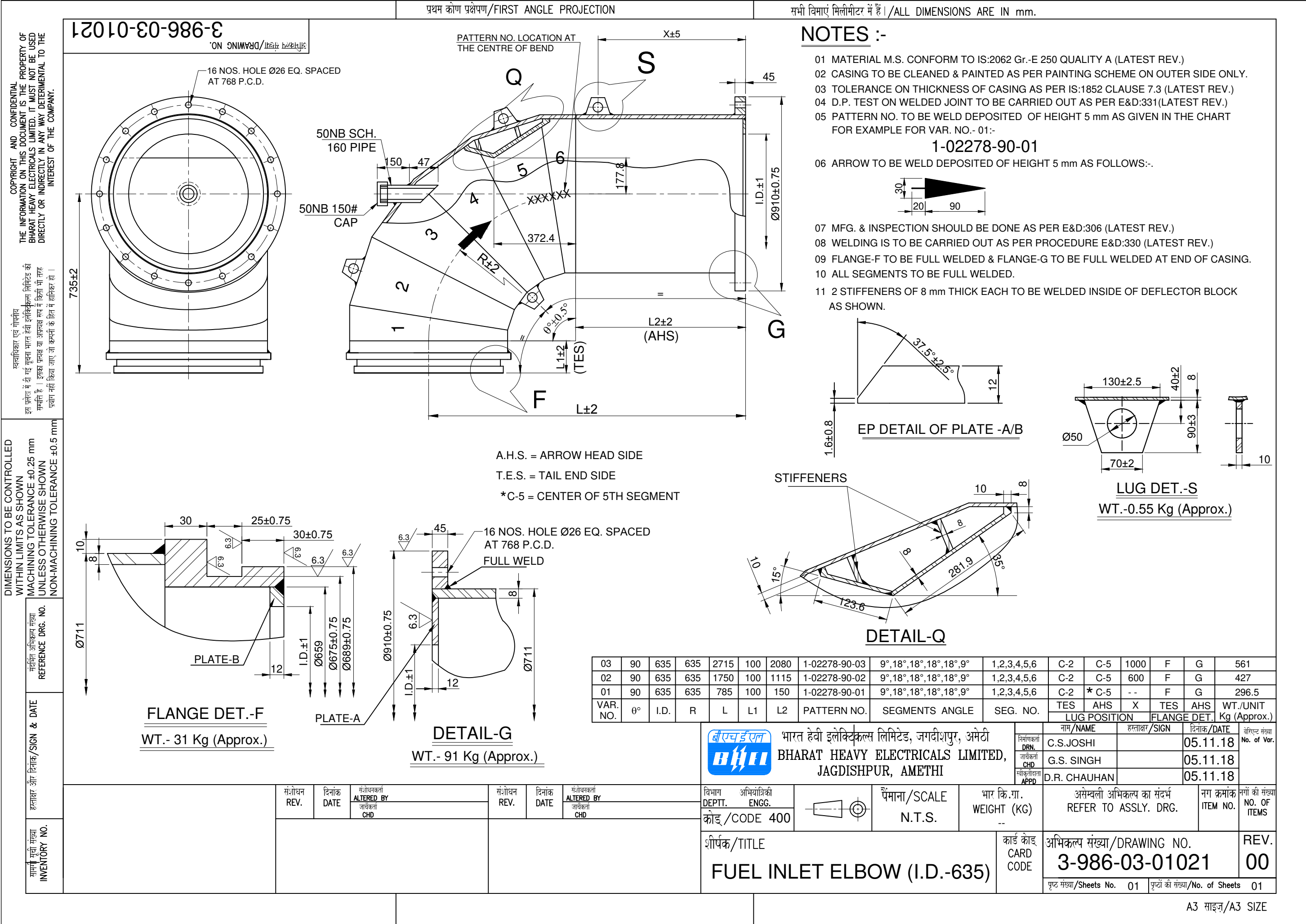
WT.- 30.9 Kg (Approx.)

DETAIL-A

12	635	8546±2	3-01863-12	1,2,3,4,5,6	1597	1524	1524	1524	1524	853	1289.5
11	635	8366±2	3-01863-11	1,2,3,4,5,6	1597	1524	1524	1524	1524	673	1264.5
10	635	7656±2	3-01863-10	1,2,3,4,6	1597	1524	1524	1524		1487	1153
09	635	7476±2	3-01863-09	1,2,3,4,6	1597	1524	1524	1524		1307	1131
08	635	6766±2	3-01863-08	1,2,3,4,6	1597	1524	1524	1524		597	1030
07	635	6586±2	3-01863-07	1,2,3,4,6	1597	1524	1524	1524		417	1005
06	635	5876±2	3-01863-06	1,2,3,6	1597	1524	1524			1231	893.5
05	635	5696±2	3-01863-05	1,2,3,6	1597	1524	1524			1051	868.5
04	635	4986±2	3-01863-04	1,2,3,6	1597	1524	1524			341	770
03	635	4806±2	3-01863-03	1,2,3,6	1597	1524	1524			161	745
02	635	4096±2	3-01863-02	1,2,6	1597	1524				975	633.5
01	635	3916±2	3-01863-01	1,2,6	1597	1524				795	608.5
VAR. NO.	I.D.	L	PATTERN NO.	PART NO.	PART NO.-1	PART NO.-2	PART NO.-3	PART NO.-4	PART NO.-5	PART NO.-6	WT./UNIT Kg (Approx.)
					PART LENGTH ±2						

उत्पाद का प्रकार या ग्राहक/परियोजना का नाम
TYPE OF PRODUCT OR NAME OF
CUSTOMER/PROJECT

		भारत हेवी इलेक्ट्रिकल्स लिमिटेड, जगदीशपुर, अमेठी BHARAT HEAVY ELECTRICALS LIMITED, JAGDISHPUR, AMETHI		नाम/NAME निर्माणकर्ता DRN.		हस्ताक्षर/SIGN C.S.JOSHI		दिनांक/DATE 05.11.18		वेगिएट संख्या No. of Var.	
विभाग DEPTT.		अभियंत्रिकी ENGG.		जांचकर्ता CHD		G.S. SINGH		05.11.18			
कोड/ CODE 400				पैमाना/SCALE N.T.S.		भार कि.गा. WEIGHT (KG) --		असेम्बली अभिकल्प का संदर्भ REFER TO ASSLY. DRG.		नग क्रमांक ITEM NO.	
शीर्षक/TITLE STRAIGHT PIPE (I.D.-635)						कार्ड कोड CARD CODE		अभिकल्प संख्या/DRAWING NO. 3-986-03-01020		REV. 00	
						पृष्ठ संख्या/Sheets No. 01		पृष्ठों की संख्या/No. of Sheets 01			



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INTEREST OF THE COMPANY.

संस्थाधिकार एवं गोपनीय
इस प्रलेख में दी गई सूचना भारत हेवी इलेक्ट्रिकल्स लिमिटेड की
संपत्ति है। इसका प्रत्यक्ष या अप्रत्यक्ष रूप में किसी भी तरह
प्रयोग नहीं किया जाए जो कम्पनी के हित में हानिकार हो।

DIMENSIONS TO BE CONTROLLED
WITHIN LIMITS AS SHOWN
MACHINING TOLERANCE ± 0.25 mm
UNLESS OTHERWISE SHOWN
NON-MACHINING TOLERANCE ± 0.5 mm

संदर्भित अभिकल्प संख्या
REFERENCE DRG. NO.

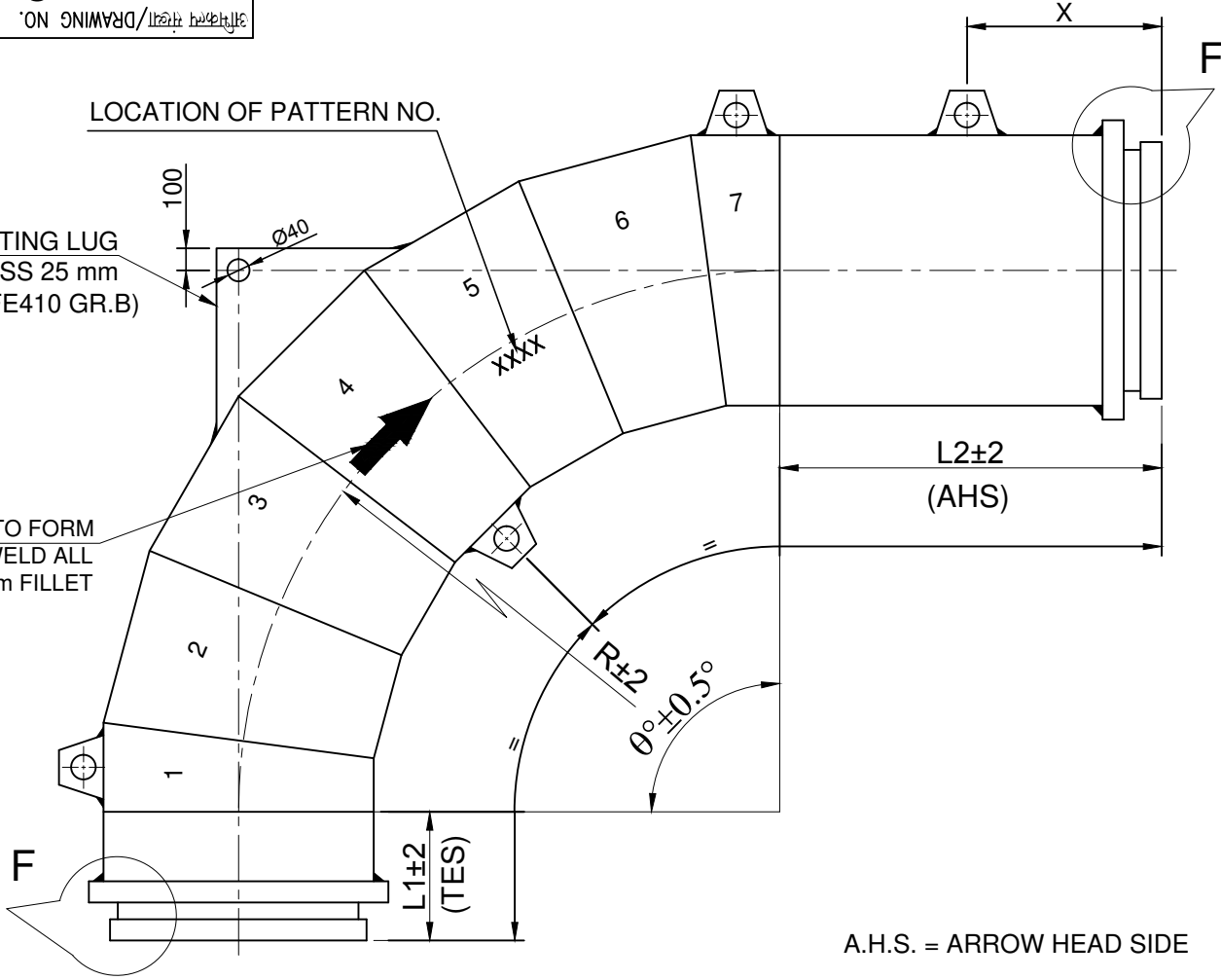
हस्ताक्षर और दिनांक / SIGN & DATE

सामग्री सूची संख्या
INVENTORY NO.

LOCATION OF PATTERN NO.

SUPPORTING LUG
THICKNESS 25 mm
(MAT.-IS:2062 FE410 GR.B)

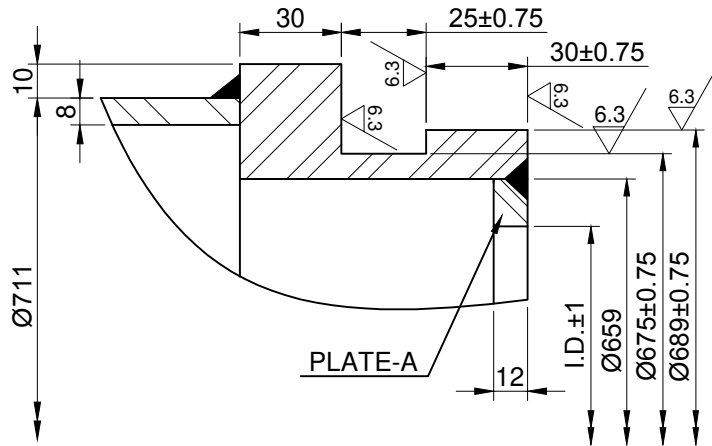
3mm PLATE TO BE CUT TO FORM
AN ARROW AND WELD ALL
AROUND 3 mm FILLET



A.H.S. = ARROW HEAD SIDE

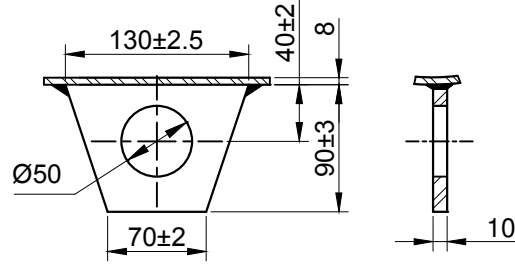
T.E.S. = TAIL END SIDE

* C-1 = CENTER OF 1ST SEGMENT



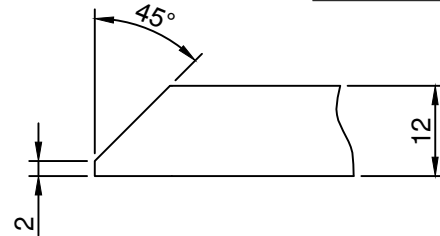
FLANGE DET.-F

WT.- 31 Kg (Approx.)

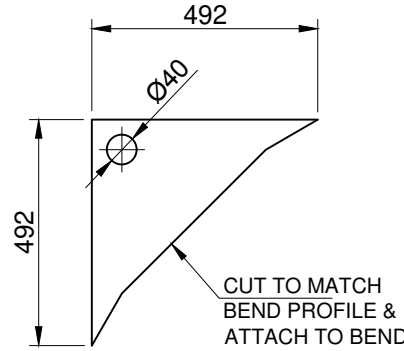


LUG DET.-S

WT.-0.55 Kg (Approx.)

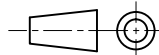


EP DETAIL OF PLATE -A



SUPPORTING LUG DETAIL

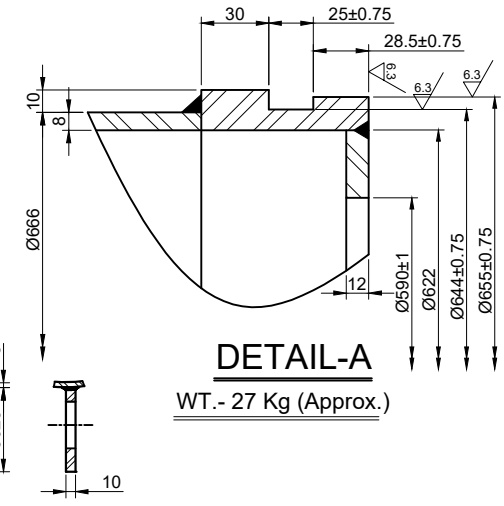
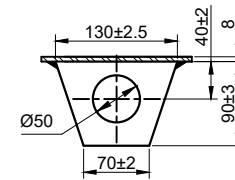
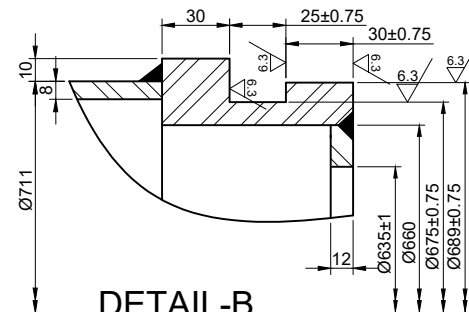
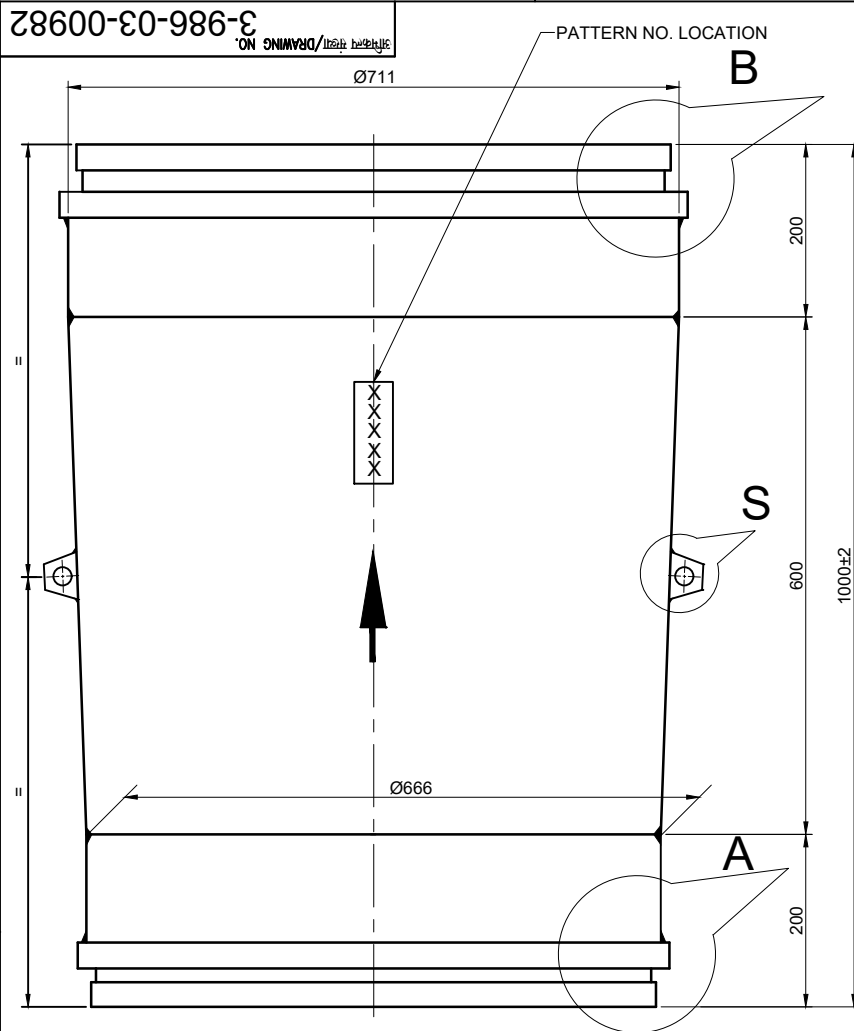
WT.- 23.74 Kg (Approx.)

24	90	635	1270	100	1270	1-02277-90-24	7.5,15,15,15,15,15,7.5	1,2,3,4,5,6,7	*C-1	C-7	600	F	F	532.5			
VAR. NO.	θ°	I.D.	R	L1	L2	PATTERN NO.	SEGMENTS ANGLE	SEG. NO.	TES	AHS	X	TES	AHS	WT./UNIT			
									LUG POSITION		FLANGE DET.		Kg (Approx.)				
									नाम/NAME		हस्ताक्षर/SIGN		दिनांक/DATE	वैरिएंट संख्या No. of Var.			
									C.S.JOSHI		Sd/-		05.11.18				
									G.S. SINGH		Sd/-		05.11.18				
									D.R. CHAUHAN		Sd/-		05.11.18				
संशोधनकर्ता ALTERED BY				Sd/-		विभाग अभियांत्रिकी DEPTT. ENGG.			पैमाना/SCALE N.T.S.		भार कि.ग्रा. WEIGHT (KG)		असेम्बली अभिकल्प का संदर्भ REFER TO ASSLY. DRG.		नग क्रमांक ITEM NO.	नगों की संख्या NO. OF ITEMS	
जांचकर्ता CHD				Sd/-		कोड /CODE 400											
NO.- 2849						शीर्षक/TITLE MILL OUTLET ELBOW(I.D.-635)						कार्ड कोड CARD CODE		अभिकल्प संख्या/DRAWING NO. 3-986-03-01022		REV. 01	
												पृष्ठ संख्या/Sheets No.		01	पृष्ठों की संख्या/No. of Sheets		01

982952/2022/FSIP-IPQAX000

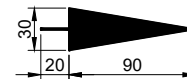
प्रथम कोण प्रक्षेपण/FIRST ANGLE PROJECTION

सभी विमाणें मिलीमीटर में हैं। /ALL DIMENSIONS ARE IN mm.



NOTES:-

- 01 MATERIAL M.S. CONFORM TO IS:2062-2011 Gr.-E250 QUALITY A . (LATEST REV.)
- 02 CASING TO BE CLEANED & PAINTED WITH GENERAL PURPOSE ALUMINIUM PAINT AS PER IS:2339 ON OUTER SIDE ONLY. TOTAL DFT= 40 µm (MIN.)
- 03 TOLERANCE ON THICKNESS OF CASING AS PER IS:1852 CLAUSE 7.3 (LATEST REV.)
- 04 D.P. TEST ON WELDED JOINT TO BE CARRIED OUT AS PER E&D:331 (LATEST REV.)
- 05 ARROW TO BE WELD DEPOSITED OF HEIGHT 5 mm AS FOLLOWS:-



- 06 PATTERN NO. TO BE WELD DEPOSITED OF HEIGHT 5 mm AS FOLLOWS:-

14702241

- 07 FLANGE IS TO BE FULL WELDED ON EACH END OF CASING.
- 08 MFG. & INSPECTION SHOULD BE DONE AS PER E&D:306 (LATEST REV.)
- 09 WELDING TO BE CARRIED OUT AS PER PROCEDURE E&D:330 (LATEST REV.)

उत्पाद का प्रकार या ग्राहक/परियोजना का नाम
TYPE OF PRODUCT OR NAME OF
CUSTOMER/PROJECT

भारत हेवी इलेक्ट्रिकल्स लिमिटेड, जगदीशपुर, अमेठी
BHARAT HEAVY ELECTRICALS LIMITED,
JAGDISHPUR, AMETHI

नाम/NAME	हस्ताक्षर/SIGN	दिनांक/DATE	संख्या/No. of Var.
DRN	C.S. JOSHI	Sd/-	31.03.17
जांचकर्ता/CHK	G.S. SINGH	Sd/-	31.03.17
अनुमोदित/APPD	G.S. SINGH	Sd/-	31.03.17

विभाग/DEPTT.	अभियंता/ENG.	पैमाना/SCALE	भार कि.ग्रा./WEIGHT (KG)	असेम्बली अभिकल्प का संदर्भ/REFER TO ASSLY. DRG.	नग क्रमांक/ITEM NO.	संख्या/NO. OF ITEMS
कोड/400		N.T.S.	171 (Approx.)			
शीर्षक/TITLE			कार्ड कोड/CARD CODE	अभिकल्प संख्या/DRAWING NO.		
TRANSITION PIECE				3-986-03-00982		
				पृष्ठ संख्या/Sheets No.	पृष्ठों की संख्या/No. of Sheets	REV.
				01	01	01

REF.NO. :- 2675

A3 साइज़/A3 SIZE

