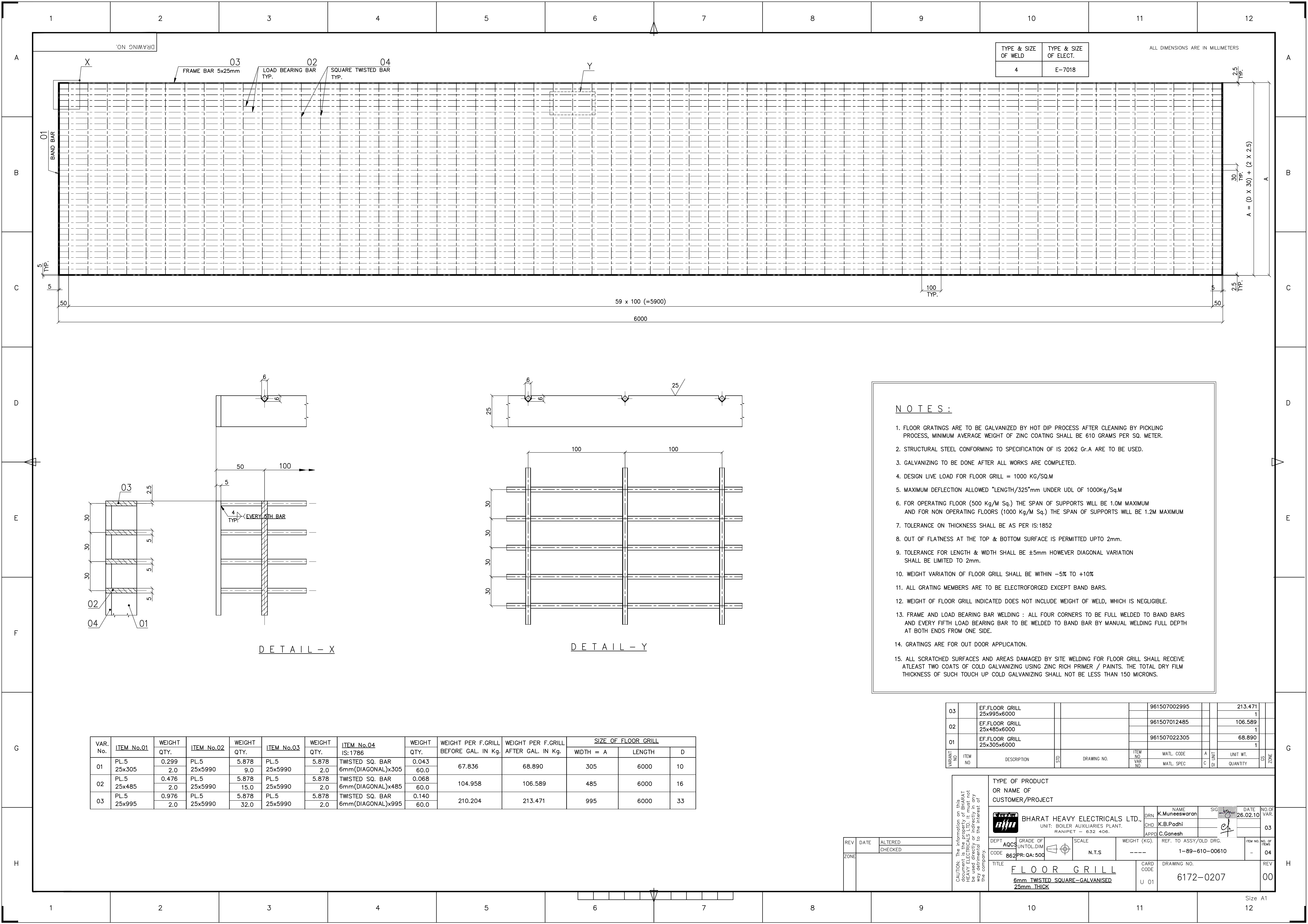




TYPE & SIZE OF WELD	TYPE & SIZE OF ELECT.
4	E-7018

ALL DIMENSIONS ARE IN MILLIMETERS

NOTES :

- FLOOR GRATINGS ARE TO BE GALVANIZED BY HOT DIP PROCESS AFTER CLEANING BY PICKLING PROCESS, MINIMUM AVERAGE WEIGHT OF ZINC COATING SHALL BE 610 GRAMS PER SQ. METER.
- STRUCTURAL STEEL CONFORMING TO SPECIFICATION OF IS 2062 Gr.A ARE TO BE USED.
- GALVANIZING TO BE DONE AFTER ALL WORKS ARE COMPLETED.
- DESIGN LIVE LOAD FOR FLOOR GRILL = 1000 KG/SQ.M
- MAXIMUM DEFLECTION ALLOWED "LENGTH/325"mm UNDER UDL OF 1000Kg/Sq.M
- FOR OPERATING FLOOR (500 Kg/M Sq.) THE SPAN OF SUPPORTS WILL BE 1.0M MAXIMUM AND FOR NON OPERATING FLOORS (1000 Kg/M Sq.) THE SPAN OF SUPPORTS WILL BE 1.2M MAXIMUM
- TOLERANCE ON THICKNESS SHALL BE AS PER IS:1852
- OUT OF FLATNESS AT THE TOP & BOTTOM SURFACE IS PERMITTED UPTO 2mm.
- TOLERANCE FOR LENGTH & WIDTH SHALL BE ±5mm HOWEVER DIAGONAL VARIATION SHALL BE LIMITED TO 2mm.
- WEIGHT VARIATION OF FLOOR GRILL SHALL BE WITHIN -5% TO +10%
- ALL GRATING MEMBERS ARE TO BE ELECTROFORGED EXCEPT BAND BARS.
- WEIGHT OF FLOOR GRILL INDICATED DOES NOT INCLUDE WEIGHT OF WELD, WHICH IS NEGLIGIBLE.
- FRAME AND LOAD BEARING BAR WELDING : ALL FOUR CORNERS TO BE FULL WELDED TO BAND BARS AND EVERY FIFTH LOAD BEARING BAR TO BE WELDED TO BAND BAR BY MANUAL WELDING FULL DEPTH AT BOTH ENDS FROM ONE SIDE.
- GRATINGS ARE FOR OUT DOOR APPLICATION.
- ALL SCRATCHED SURFACES AND AREAS DAMAGED BY SITE WELDING FOR FLOOR GRILL SHALL RECEIVE ATLEAST TWO COATS OF COLD GALVANIZING USING ZINC RICH PRIMER / PAINTS. THE TOTAL DRY FILM THICKNESS OF SUCH TOUCH UP COLD GALVANIZING SHALL NOT BE LESS THAN 150 MICRONS.

VAR. No.	ITEM No.01	WEIGHT	ITEM No.02	WEIGHT	ITEM No.03	WEIGHT	ITEM No.04	WEIGHT	WEIGHT PER F.GRILL BEFORE GAL. IN Kg.	WEIGHT PER F.GRILL AFTER GAL. IN Kg.	SIZE OF FLOOR GRILL		
		QTY.		QTY.		QTY.		QTY.			WIDTH = A	LENGTH	D
01	PL.5 25x305	0.299	PL.5 25x5990	5.878	PL.5 25x5990	5.878	TWISTED SQ. BAR 6mm(DIAGONAL)x305	0.043	67.836	68.890	305	6000	10
		2.0		9.0		2.0		60.0					
02	PL.5 25x485	0.476	PL.5 25x5990	5.878	PL.5 25x5990	5.878	TWISTED SQ. BAR 6mm(DIAGONAL)x485	0.068	104.958	106.589	485	6000	16
		2.0		15.0		2.0		60.0					
03	PL.5 25x995	0.976	PL.5 25x5990	5.878	PL.5 25x5990	5.878	TWISTED SQ. BAR 6mm(DIAGONAL)x995	0.140	210.204	213.471	995	6000	33
		2.0		32.0		2.0		60.0					

03	EF.FLOOR GRILL 25x995x6000			961507002995			213.471	1		
02	EF.FLOOR GRILL 25x485x6000			961507012485			106.589	1		
01	EF.FLOOR GRILL 25x305x6000			961507022305			68.890	1		
VARIANT NO.	ITEM NO	DESCRIPTION	STD	DRAWING NO.	ITEM NO. VAR NO	MATL. CODE	MATL. SPEC	A UNIT C	UNIT WT. QUANTITY	CS ZONE

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TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT									
BHARAT HEAVY ELECTRICALS LTD., UNIT: BOILER AUXILIARIES PLANT. RANIPET - 632 406.					DRN CHD APPD	NAME K.Muneeswaran K.B.Padhi C.Ganesh	SIG 	DATE 26.02.10	NO. OF VAR. 03
DEPT AQCS	GRADE OF UNTO.DIM PR: QA:500		SCALE N.T.S	WEIGHT (KG). ----	REF. TO ASSY/OLD DRG. 1-89-610-00610			ITEM NO. -	NO. OF THIS REV. 04
TITLE F L O O R G R I L L 6mm TWISTED SQUARE-GALVANISED 25mm THICK					CARD CODE U 01	DRAWING NO. 6172-0207			REV 00

REV	DATE	ALTERED
ZONE		CHECKED

Size A1
12