

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

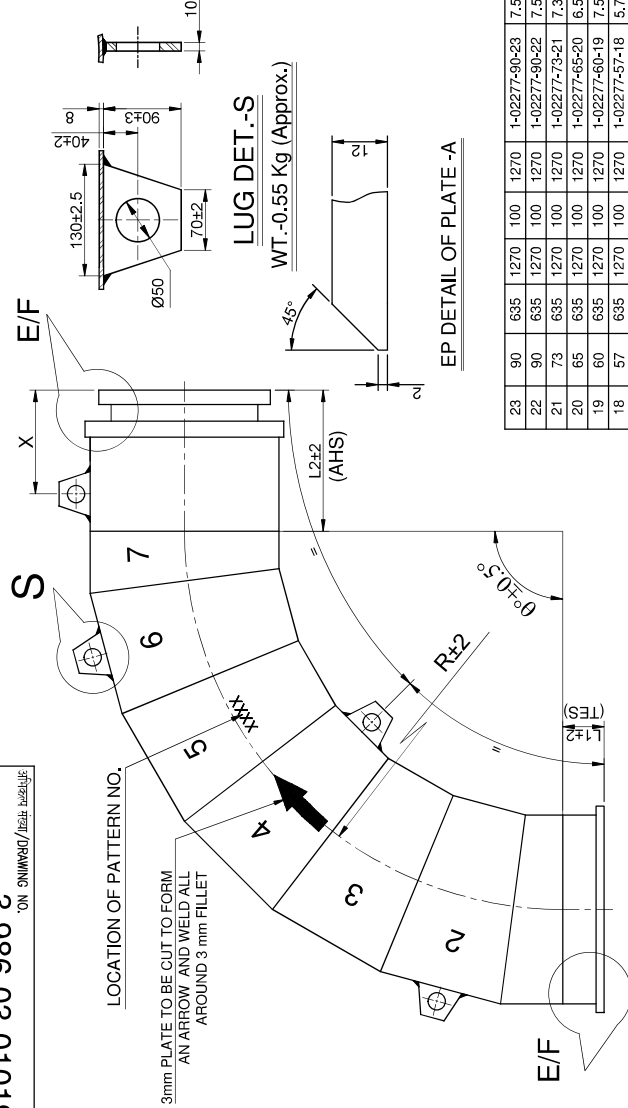
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INDIRECTLY IN ANY WAY DETRIMENTAL TO THE

स्वाध्यायिकार एवं गान्ध्यायिकार
इदं सर्वान् भारतं दत्तं इति विदितव्यं निमित्तं कं
कं प्रत्यक्षं या अप्रत्यक्षं स्वं न किंचिद् गान्ध्यायिकार

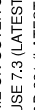
DIMENSIONS TO BE CONTROLLED
WITHIN LIMITS AS SHOWN
MACHINING TOLERANCE ± 0.25 mm
UNLESS OTHERWISE SHOWN
NON-MACHINING TOLERANCE ± 0.5 mm

DATE _____
REFERENCE DRG. NO. _____

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NOTES:-

- 01 MATERIAL M.S. TO CONFORM TO IS:2082 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:1982 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.

LUG DET.-S

WT.-0.55 Kg (Approx.)

1-02277-90-22

EP DETAIL OF PLATE -A

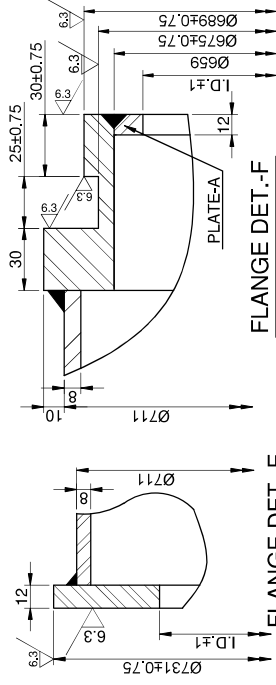
VAR. NO.	θ°	I.D.	R	L1	L2	PATTERN NO.	SEGMENTS ANGLE	SEG. NO.	TES FLANGE TYPE	TES AHS LUG POSITION	X	WT./UNIT Kg (Approx.)			
23	90	635	1270	100	1270	1-02277-90-23	7.5°, 15°, 15°, 15°, 15°, 15°, 7.5°	1, 2, 3, 4, 5, 6, 7	E	F	C-2	500	497		
22	90	635	1270	100	1270	1-02277-90-22	7.5°, 15°, 15°, 15°, 15°, 15°, 7.5°	1, 2, 3, 4, 5, 6, 7	E	E	C-6	500	485		
21	73	635	1270	100	1270	1-02277-73-21	7.3°, 14.6°, 14.6°, 14.6°, 14.6°, 14.6°, 7.3°	1, 2, 3, 4, 5, 7	E	E	C-2	500	433		
20	65	635	1270	100	1270	1-02277-65-20	6.5°, 13°, 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°, 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°, 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°, 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°, 10.6°, 5.3°	1, 2, 3, 4, 5, 7	E	E	C-2	C-7	500	372	
15	50	635	1270	100	1270	1-02277-50-15	6.25°, 12.5°, 12.5°, 12.5°, 12.5°, 6.25°	1, 2, 3, 4, 7	E	E	C-1	C-6	500	362	
14	45	635	1270	100	1270	1-02277-45-14	7.5°, 15°, 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°, 15°, 7.5°	1, 2, 3, 7	F	E	C-1	C-7	500	365.5	
12	45	635	1270	100	1270	1-02277-45-12	7.5°, 15°, 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°, 15°, 7.5°	1, 2, 3, 7	F	F	C-1	C-7	-	147.5	331
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	330	
09	32	635	1270	100	1270	1-02277-32-09	4° 8' 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	

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.-F

WT.-31 Ka (Approx.)

FLANGE DET.-E

WT.-9.7 Kg (Approx.)

[illegible]

A3 मासु/ A3 SIZE

02010-90-986-3
ON DRAWING/दिखावट में

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संप्रतिगतात एव नोपयोग्यता

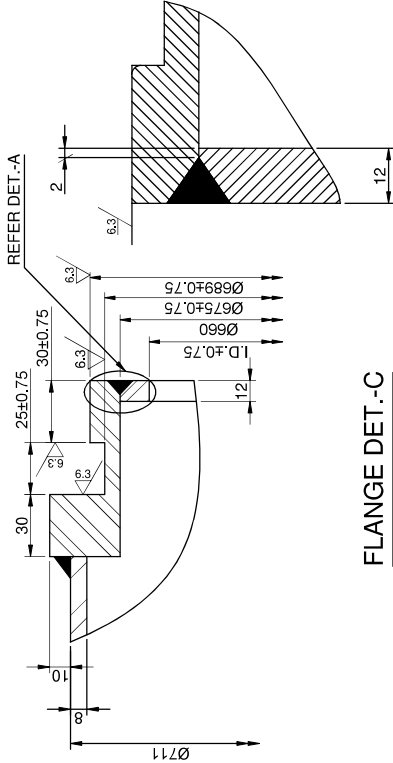
इस दस्तावेज में दी गई जानकारी का उपयोग किसी भी प्रकार से, बिना भारत भारी इलेक्ट्रिकल्स लिमिटेड की अनुमति के, किया नहीं जा सकता है।

आवृत्ति पर नोपयोग्यता

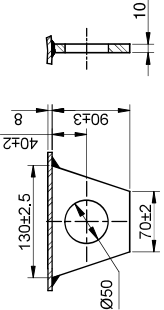
DIMENSIONS TO BE CONTROLLED WITHIN LIMITS AS SHOWN UNLESS OTHERWISE SHOWN MACHINING TOLERANCE ± 0.25 mm NON-MACHINING TOLERANCE ± 0.5 mm

REFERENCE DRG. NO. भारतीय भारी इलेक्ट्रिकल्स लिमिटेड

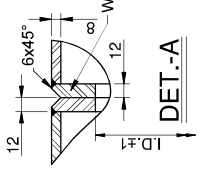
FLANGE DET.-C
WT. - 30.9 Kg (Approx.)



DETAIL-A



LUG DET.-S
WT.-0.55 Kg (Approx.)



LOCATION FOR PATTERN NO./PART NO.
REFER NOTE NO. 05

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

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:-
- 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.

3-01863-07 / 4

12	635	8546 $\pm$ 2	3-01863-12	1,2,3,4,5,6	1597	1524	1524	1524	1524	853	1289.5
11	635	8366 $\pm$ 2	3-01863-11	1,2,3,4,5,6	1597	1524	1524	1524	1524	673	1264.5
10	635	7656 $\pm$ 2	3-01863-10	1,2,3,4,6	1597	1524	1524	1524	1524	1487	1153
09	635	7476 $\pm$ 2	3-01863-09	1,2,3,4,6	1597	1524	1524	1524	1524	1307	1131
08	635	6766 $\pm$ 2	3-01863-08	1,2,3,4,6	1597	1524	1524	1524	1524	597	1030
07	635	6566 $\pm$ 2	3-01863-07	1,2,3,4,6	1597	1524	1524	1524	1524	417	1005
06	635	5876 $\pm$ 2	3-01863-06	1,2,3,6	1597	1524	1524	1524	1524	1231	893.5
05	635	5696 $\pm$ 2	3-01863-05	1,2,3,6	1597	1524	1524	1524	1524	1051	868.5
04	635	4986 $\pm$ 2	3-01863-04	1,2,3,6	1597	1524	1524	1524	1524	341	770
03	635	4806 $\pm$ 2	3-01863-03	1,2,3,6	1597	1524	1524	1524	1524	161	745
02	635	4096 $\pm$ 2	3-01863-02	1,2,6	1597	1524	1524	1524	1524	975	633.5
01	635	3916 $\pm$ 2	3-01863-01	1,2,6	1597	1524	1524	1524	1524	795	608.5
VAR. NO.	I.D.	L	PATTERN NO.	PART NO.	NO.-1	PART NO.-2	PART NO.-3	PART NO.-4	PART NO.-5	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 भारी इलेक्ट्रिकल्स लिमिटेड, जगदीशपुर, अमरी
BHARAT HEAVY ELECTRICALS LIMITED,
JAGDISHPUR, AMETHI

सिमा	अंश	भाग	माप	वजन	माप	माप	माप	माप	माप	माप	माप
DEPT.	ENGS.	CODE	400	400	400	400	400	400	400	400	400
REV.	REV.	REV.	REV.	REV.	REV.	REV.	REV.	REV.	REV.	REV.	REV.
REV.	REV.	REV.	REV.	REV.	REV.	REV.	REV.	REV.	REV.	REV.	REV.

STRAIGHT PIPE (I.D.-635)

REV. 00
3-986-03-01020
A3 माप/3 SIZE

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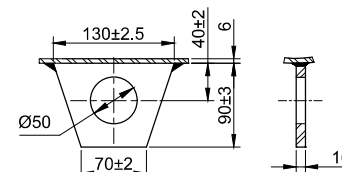
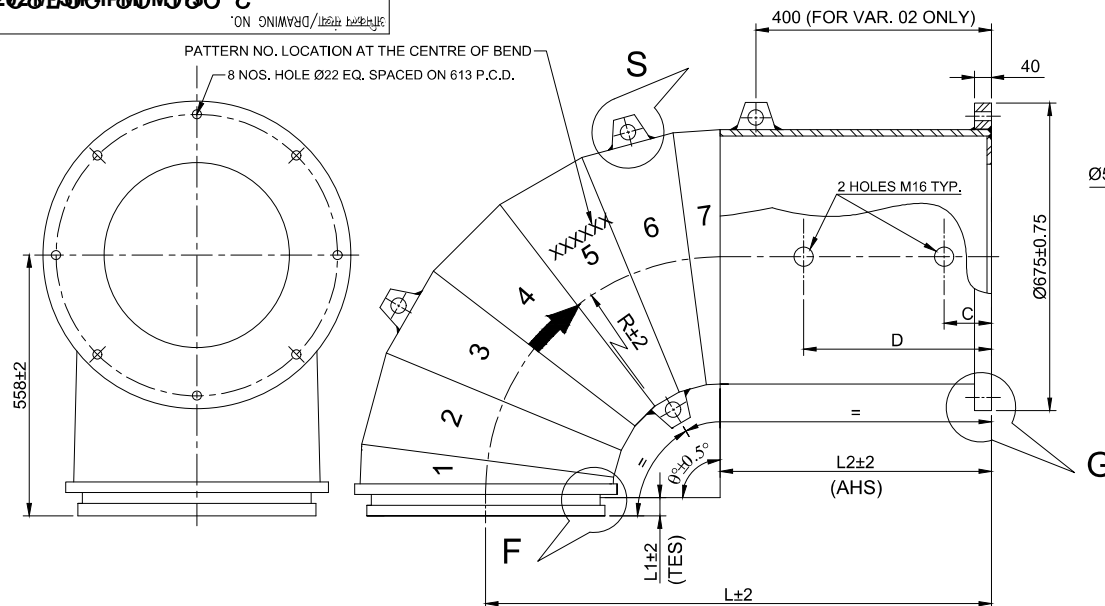
स्वत्वाधिकार एवं गोपनीय
इस प्रलेख में दी गई सूचना भारत हेवी इलेक्ट्रिकल्स लिमिटेड की
सम्पत्ति है। इसका प्रत्यक्ष या अप्रत्यक्ष रूप में किसी भी तरह
प्रयोग नहीं किया जाए जो कम्पनी के हित में हानिकार हो।

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

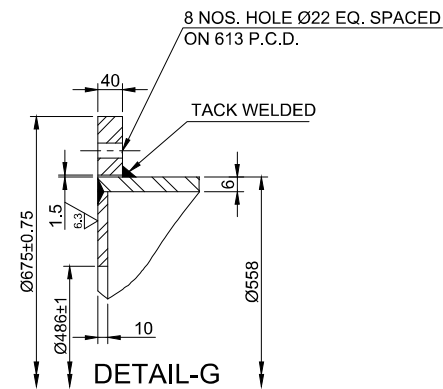
तत्त अभिकल्प संख्या
ENCE DRG. NO.

हस्ताक्षर और दिनांक/SIGN & DATE

यामगी सूची संख्या
INVENTORY NO.



LUG DET.-S
WT.-0.67 Kg (Approx.)



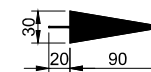
WT.-38.5 Kg (Approx.)

NOTES :-

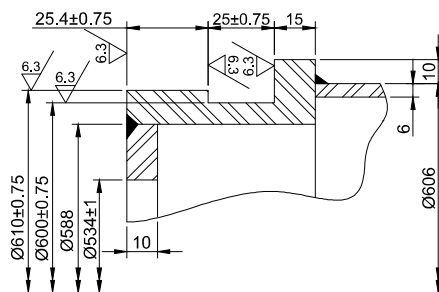
- 01 MATERIAL M.S. CONFORM TO IS:2062 Gr.-A (LATEST REV.)
02 CASING TO BE CLEANED & PAINTED WITH RED-OXIDE ON OUTSIDE ONLY.
03 TOLERANCE ON THICKNESS OF CASING AS PER IS:1852 CLAUSE 7.3 (LATEST REV.)
04 D.P. TEST ON WELDED JOINT TO BE CARRIED OUT AS PER E&D:331(LATEST REV.)
05 PATTERN NO. TO BE WELD DEPOSITED OF HEIGHT 5 mm AS GIVEN IN THE CHART
FOR EXAMPLE FOR VAR. NO.- 01 :-

06-558-508

- 06 ARROW TO BE WELD DEPOSITED OF HEIGHT 5 mm AS FOLLOWS:-



- 07 FLANGE-C IS TO BE FULL WELDED & FLANGE-D TO BE TACK WELDED ON 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.)
10 ALL SEGMENTS TO BE FULL WELDED.



FLANGE DET.-F

WT.-14.3 Kg (Approx.)

A.H.S. = ARROW HEAD SIDE

T.E.S. = TAIL END SIDE

*C-6 = CENTER OF 6TH SEGMENT

02	90	514	1294	44	780	150	610	07-558-508	7.5,15,15,15,15,15,7.5	1,2,3,4,5,6,7	C-2	C-6	F	G	184
01	90	514	584	44	70	-	-	06-558-508	7.5,15,15,15,15,15,7.5	1,2,3,4,5,6,7	C-2	★C-6	F	G	125
VAR. NO.	θ°	R	L	L1	L2	C	D	PATTERN NO.	SEGMENTS ANGLE	SEG. NO.	TES	AHS	TES	AHS	WT./UNIT Kg (Approx.)
											LUG POSITION		FLANGE DET		

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

 भारत हेवी इलेक्ट्रिकल्स लिमिटेड, जगदीशपुर, सुल्तानपुर BHARAT HEAVY ELECTRICALS LIMITED, JAGDISHPUR, SULTANPUR	नाम/NAME	हस्ताक्षर/SIGN	दिनांक/DATE	वॉटरमार्क सं. No. of W	
	मिनांककत DRN.	C.S.JOSHI			08.11.11
	जगदीशपुर CHD	S.YADAV			08.11.11
	वॉटरमार्क S.YADAV		08.11.11		

विभाग DEPTT.	अभियांत्रिकी ENGG.		पैमाना/SCALE N.T.S.	भार कि. गा. WEIGHT (KG) --	असेम्बली अभिकल्प का संदर्भ REFER TO ASSLY. DRG.	नग क्रमांक ITEM NO.	नगों की सं. No. of ITEMS
कोड / CODE	400						

शीर्षक/TITLE	FUEL INLET ELBOW	कार्ड कोड CARD CODE	अभिकल्प संख्या/DRAWING NO. 3-986-03-00583	REV 00
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(REDUCER TYPE)	0000		
		पृष्ठ संख्या/Sheets No. 01	पृष्ठों की संख्या/No. of Sheets 01