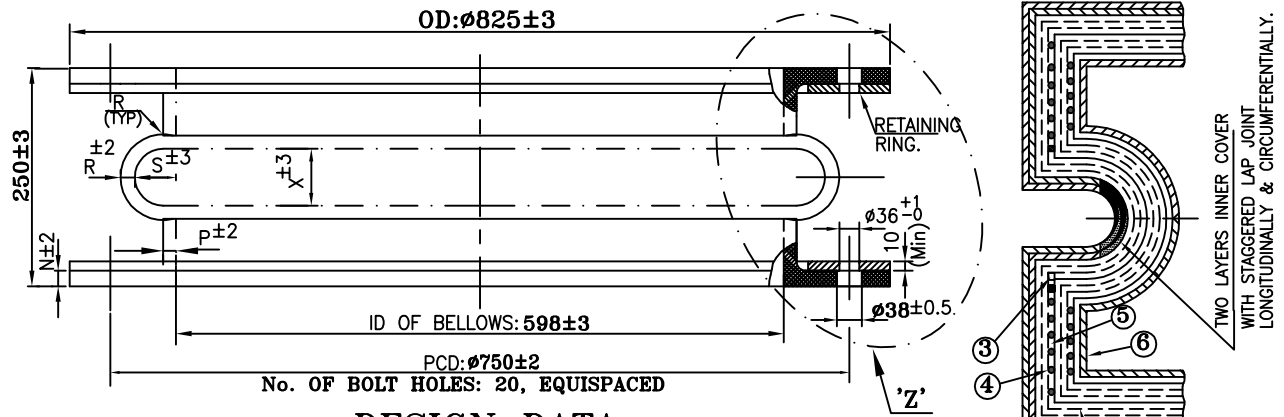


REV.	DATE	ALTERED	REV.	DATE	ALTERED	ADDITIONAL INFORMATION
		CHECKED			CHECKED	W.O.No.-10040-A-11265
		APPROVED			APPROVED	STATUS OF DRAWING
ZONE			ZONE			DRG.No.4-17053-41096
						DISTRIBUTION OF PRINTS
						CDE-2 STM-4



DESIGN DATA

- DESIGN PRESSURE ----- 5.0 Kg/sq.cm.g & FULL VACUUM.
- HYD. TEST PRESSURE ----- 7.5 Kg/sq.cm.g
- DESIGN TEMPERATURE. ----- 65 DEG. C
- VACUUM TEST ----- 30 mm Hg abs

TECHNICAL REQUIREMENTS(TR)

- VENDOR TO FURNISH DIMENSION P,R,N,T,X & S.
- MATERIAL SPECIFICATION AND OTHER TECHNICAL CONDITION AS PER TECHNICAL SPECIFICATION No.HE-54017.
- STIFFNESS OF BELLOWS AT DESIGN PRESSURE.
 - LATERAL STIFFNESS (AT 10mm DEFLECTION)----- 600 N/mm(Max.)
 - AXIAL STIFFNESS (AT 10mm DEFLECTION)----- 725 N/mm(Max.)
- AXIAL COMPRESSION ----- 12 mm
AXIAL ELONGATION ----- 12 mm
TRANSVERSE MOVEMENT ----- 12 mm
- DEFLECTION MOVEMENT TEST IN VACUUM CONDITION AT AN INTERVAL OF 5mm UPTO 25mm.
DEFLECTION MOVEMENT TEST IN PRESSURE CONDITION FROM 0 Kg/Sq.Cm TO DESIGN PRESSURE AT PRESSURE INTERVAL OF 1 Kg/sq.cm AND MOVEMENT INTERVAL OF 5mm UPTO 25mm.
- THE RETAINING RING GAP BETWEEN SEGMENTS SHOULD BE LIMITED TO 4mm max.
- RETAINING RING BOLT HOLE POSITION SHALL BE MATCH MARKED FROM RUBBER BELLOWS FLANGE BEFORE DRILLING PROPER IDENTIFICATION MARKS SHALL BE PUT ON RETAINING RINGS,WITH 'EB' NUMBER OF RESPECTIVE RUBBER BELLOWS.
- BOLT HOLES ON THE EXPANSION JOINT (RUBBER BELLOWS) FLANGE SHALL BE TREATED/COATED WITH SELF VULCANISING RUBBER.
- RETAINING RINGS MATERIAL IS:2062 Gr.B (HOT DIP GALVANISED)COATING THICKNESS: 0.100 TO 0.130 mm.
- CHLORINATED RUBBER BASED PAINT COMPATIBLE WITH NEOPRENE RUBBER SHALL BE APPLIED AS PROTECTING COATING ON INNER & OUTER SURFACE OF BELLOWS.
- BELLOWS TO HAVE HARD MARKING OF 'EB' NUMBER & DATE OF MANUFACTURE ON EACH BELLOWS.
- SHORE HARDNESS: 65±5' SHORE'A'.

FOR C - BOM REFER DRG. NO. 3 - 17053 - 41934

ITEM NO. 002

PRODUCT GROUP No.1

1X18.5 MW DAMANJODI NALCO	<div><div>बीएचईएल</div><div>BHEL</div></div>		भारत हेवी इलेक्ट्रिकल्स लिमिटेड			नाम / NAME		हस्ता / SIGN.		दि./ DATE		वेरि की संख्या	
			भोपाल			D SURWADE				02.12.21		NO. OF VAR.	
			BHARAT HEAVY ELECTRICALS LTD.			PAWAN RAI				03.12.21			
			BHOPAL			MAHOR AK				04.12.21		—	
	विभाग DEPT.CDE		अन.टोल. नाप की श्रेणी UNTOL. DIMS. GR.			उत्पात SCALE	भारत की.ग. WEIGHT(K.G.)	उसे. डाईंग का संदर्भ REF. TO ASSY. DRG.		मद क. ITEM NO.		मद संख्या NO. OF ITEM	
कोड CODE 411		M AA0230208		— 100									
शीर्षक / TITLE							डाईंग क. / DRAWING NO.					पुन./REV.	
COVENTIONAL R.E.JOINT: 600NB							4-17053-41101					00	
RUBBER BELLOWS							पृष्ठ क./ SHT. NO. 1					पृष्ठों की सं. NO. OF SHT. 1	