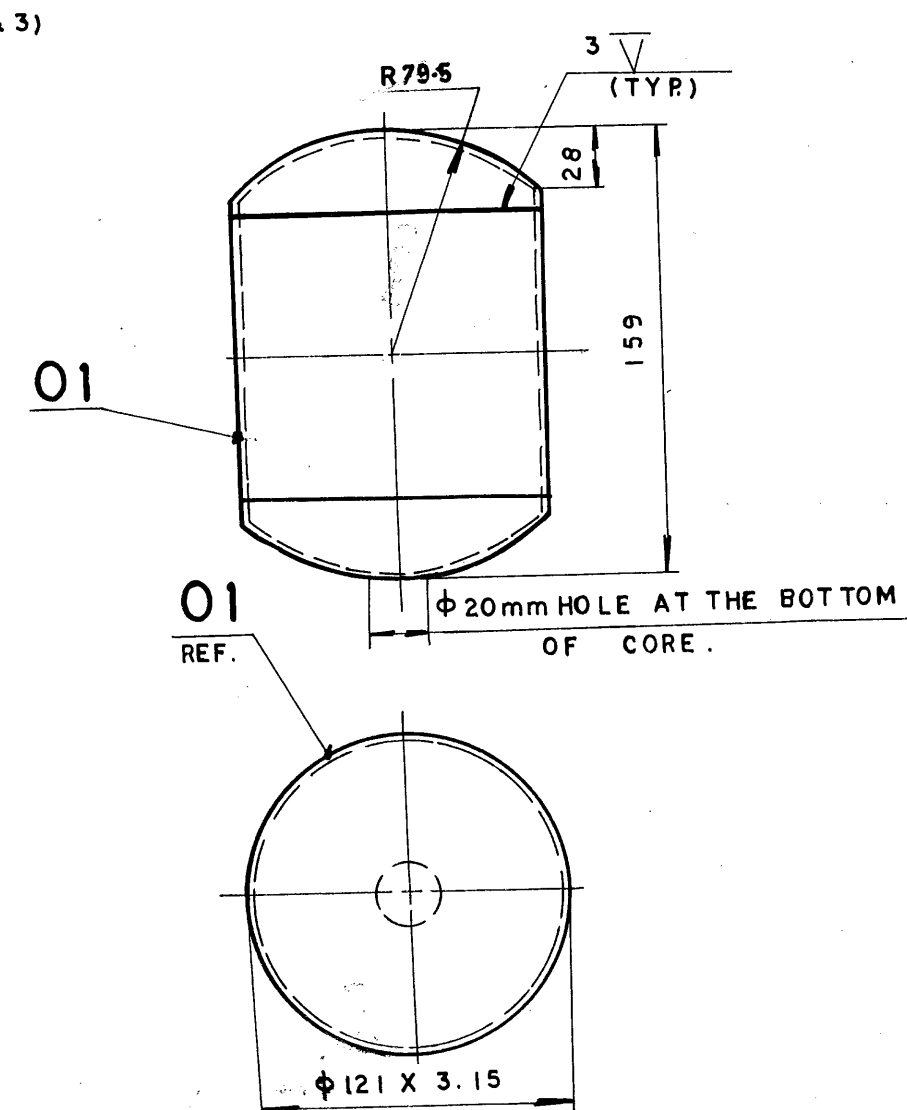


1-03-000-00003

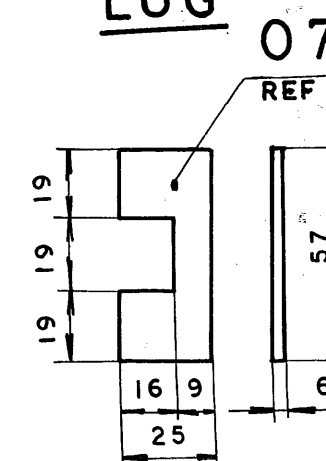
CORE



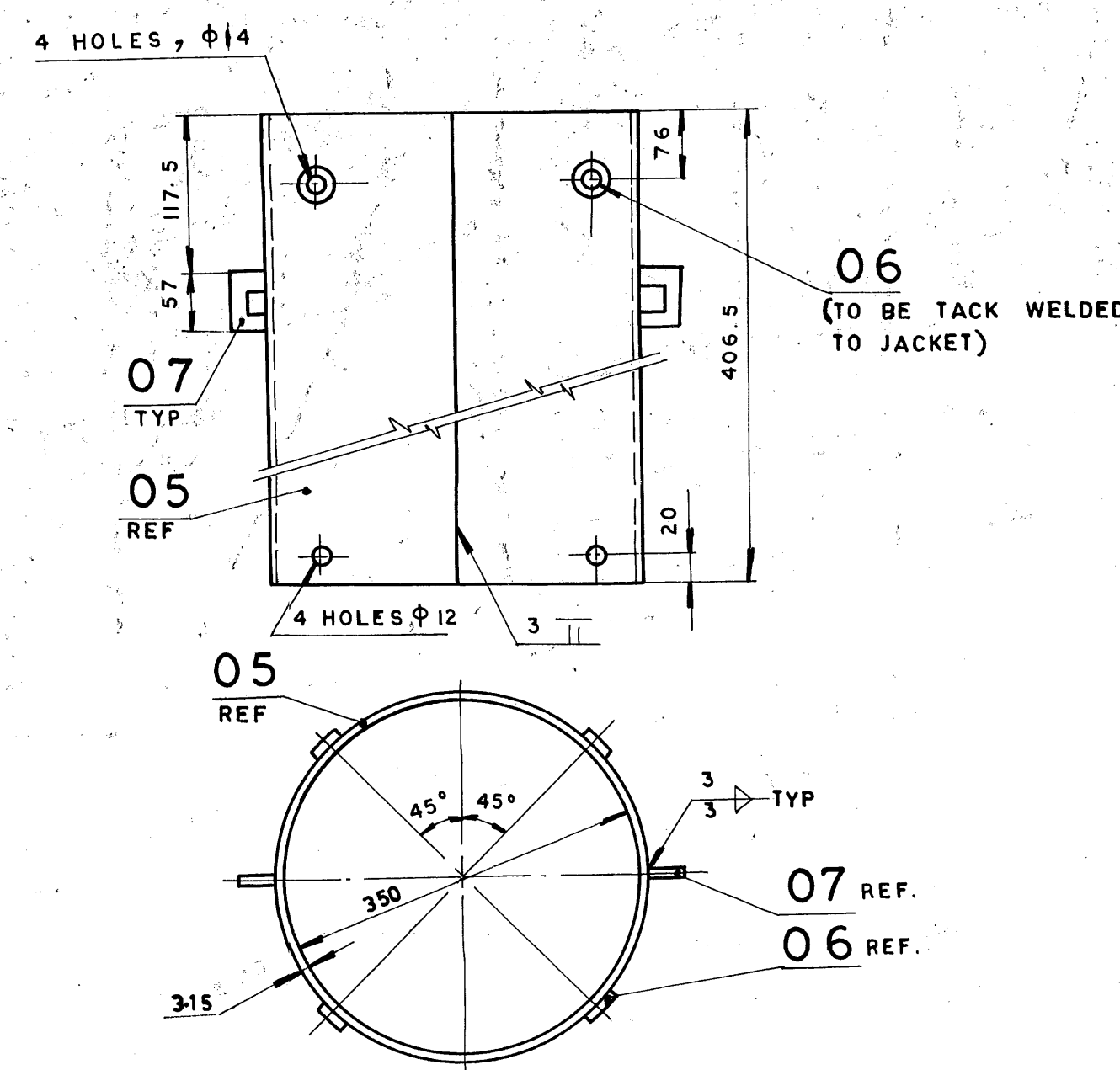
AFTER BOLTS (PART No. 8) HAVE BEEN ADJUSTED
FOR UNIFORM CLEARANCE BETWEEN STEAM
COLLECTOR NOZZLE AND PRIMARY TUBE (PART Nos. 9 & 3)
AT ☒ TACK WELD HEAD OF THE BOLT TO WASHER
(PART No. 6)

AFTER ADJUSTMENT HAS BEEN MADE AT ☒
 INSERT SPACER ROD #10 (PART No. 10) AND TACK
 WELD TO JACKET (PART No. 5) TO MAINTAIN UNIFORM
 CLEARANCE BETWEEN JACKET & PRIMARY TUBE
 (PART No. 3)

LUG



JACKET

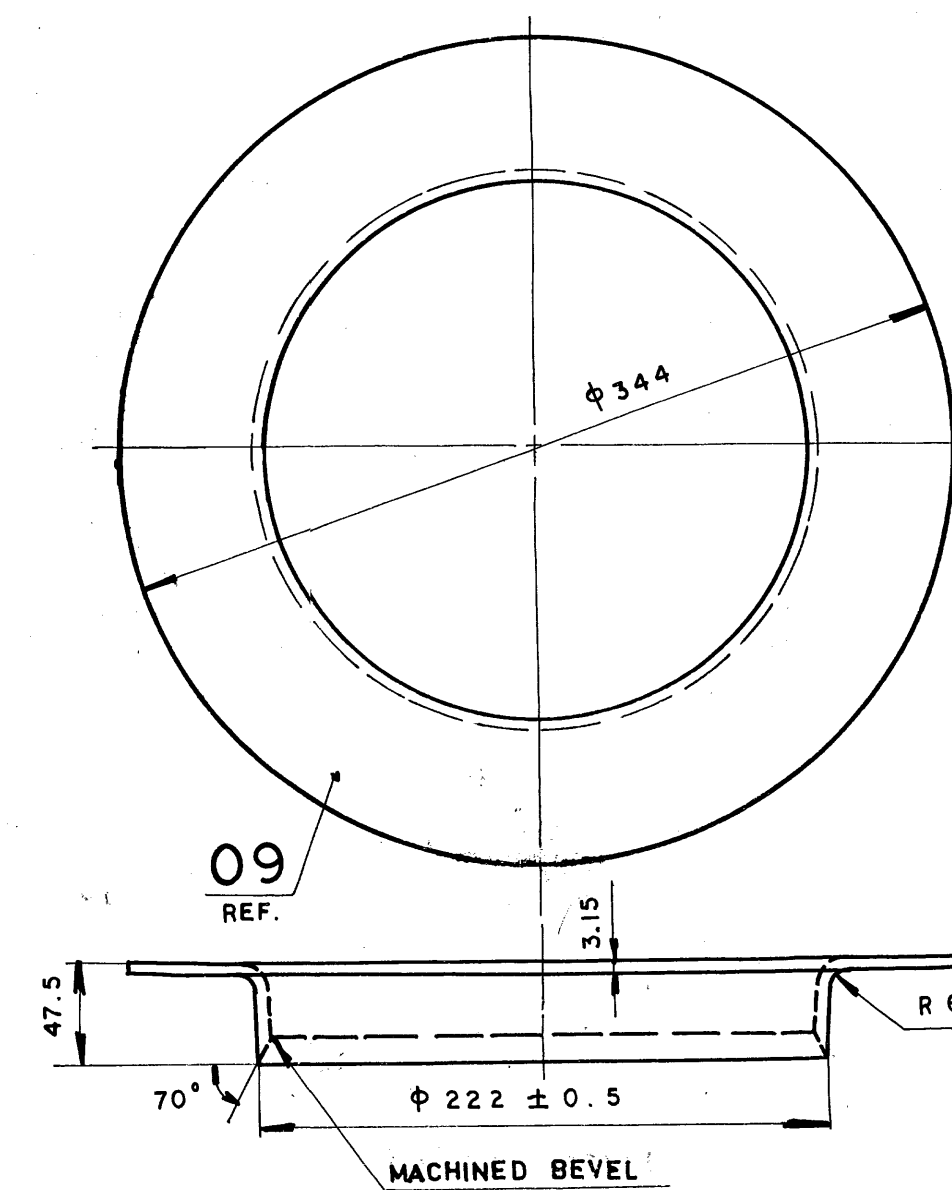


TYPE OF WELD	ELECTRODE SPECN.	LENGTH OF WELD IN M
3 II	E 6013	0.839
3 V	E 6013	0.760
3 D	E 6013	2.800

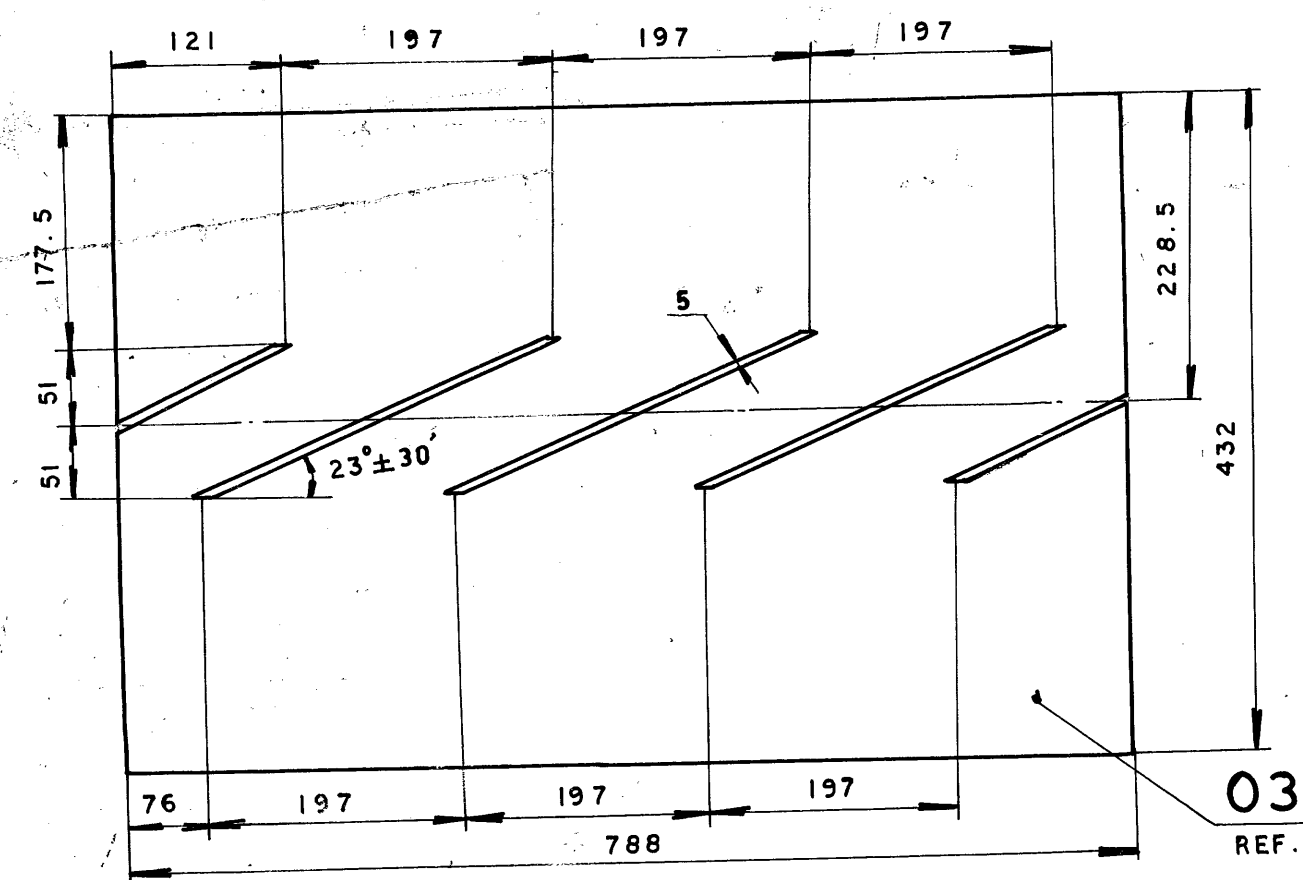
NOTE

1. CORE IS SHOWN AS 3 PIECE DESIGN. USE SUITABLE BLANK SIZE FOR THE END CLOSURES & A SUITABLE TUBE MACHINED TO SIZE FOR THE CYLINDERICAL PORTION.
2. ANY OTHER METHOD TO OBTAIN THE GIVEN CONFIGURATION FOR CORE MAY BE DECIDED BY THE SHOP.
3. APPLY A CONTINUOUS WELD FOR THE FULL LENGTH OF SPINNER BLADE WHERE IT TOUCHES THE CORE AS INDICATED.
4. AFTER ASSEMBLY SPINNER BLADES WILL PROJECT THROUGH TUBE. WELD BLADES TO PRIMARY TUBE INSIDE (PART NO 03). MAX ALLOWABLE PROJECTION IS 1.5mm (GRIND IF NECESSARY).

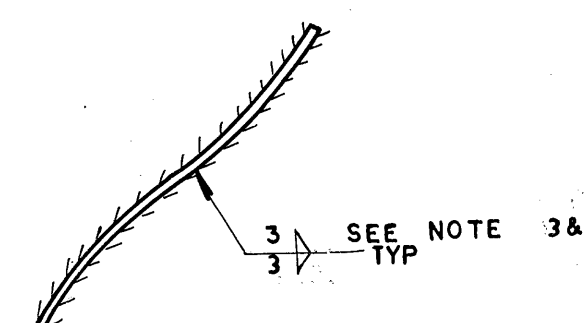
STEAM COLLECTOR NOZZLE



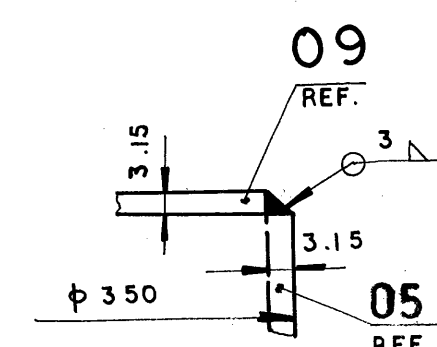
PRIMARY TUBE DEVELOPMENT



WELDING DETAIL OF SPINNER
BLADE



DETAIL - 'A'
[H-11]



VARIANT NO.	ITEM NO.	DESCRIPTION	PID	DRAWING NO./ BPS CODE	ITEM NO.	MATL. CODE	A	C	UNIT	QTY	CS	SOME
									D/			
	10	SPACER ROD Φ10; L = 58	-			15 004 042 IS : 226 FE 410S	C			0 030 4	F	12
	09	STEAM COLLECTOR NOZZLE SH. 3.15	-			15 011 182 IS : 1079 ST.34	C			1 800 I	H	12
	08	BOLT HEX. B 4.6 M 12 X 50	412 21 12050			41211 12050 -				0 059 4	G	12
	07	LUG. PL.6	-			15 011 092 IS : 226 FE 410S	C			0 050 2	H	7
	06	WASHER PNCHD A12	414 08 12000			414 0800012 -				0 006 4	H	5
	05	JACKET SH. 3.15	-			15 011 182 IS : 1079 ST.34	C			1 100 I	F	11
	04	NUT HEX. B4 M12	413 04 12000			413 04 00012 -				0 017 4	G	11
	03	PRIMARY TUBE SH. 3.15	-			15 011 182 IS : 1079 ST.34	C			8 500 I	F	11
	02	SPINNER BLADE SH.3.15 X 230 X 100	-			15 011 182 IS : 1079 ST.34	C			0 600 4	E	11
	01	CORE	-			15 011 182 IS : 1079 ST.34	C			1 880 I	G	10
01		PRIMARY SEPARATOR ASSY. 254 MM	-			ASSY				2 612 8		

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT	
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DRUM INTERNALS



Bharat Heavy Electricals Ltd.,
BOILER PLANT UNIT
TIRUCHIRAPALLI-620 014

STO	NAME	SIGN	DATE	NO IT
	S.K	<i>S. K. Subbiah</i>		
CHD	R. SRINI VASAN	<i>R. Srinivasan</i>	18.04.83	
APPD	S. V.	<i>S. V.</i>	18.04.83	

REV 01	DATE 27 08 84	ALTERED A. K. [Signature]
		CHECKED S. K. [Signature]
ZONE	ELECTRODE SPECIFICATION WAS E 7018. NOTE 4 ALTERED	
DCN APPROVED BY DESIGN		

DEPT	SS	GRADE OF UNTOOL DIM		SCALE	W
CODE	8 50	C/M/F		NTS	
TITLE PRIMARY SEPARATOR					

WEIGHT (kg)	REF TO ASSY (OLD ORG)	17
26*128	6101 - 3073 - 00	N
	ASSY: 6101 - 3071	
CARD CODE	DRAWING NO.	R
U 01	1-03-000-00003	

L.G.A.K	EC	008	Size
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