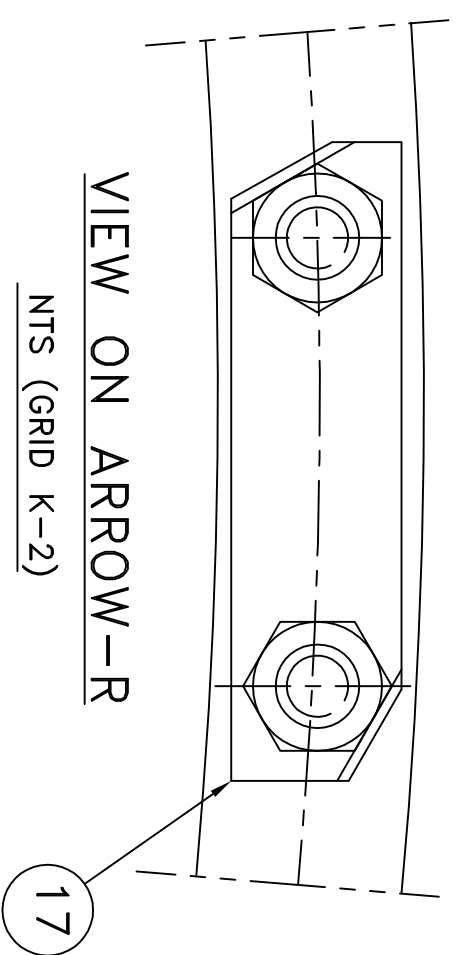
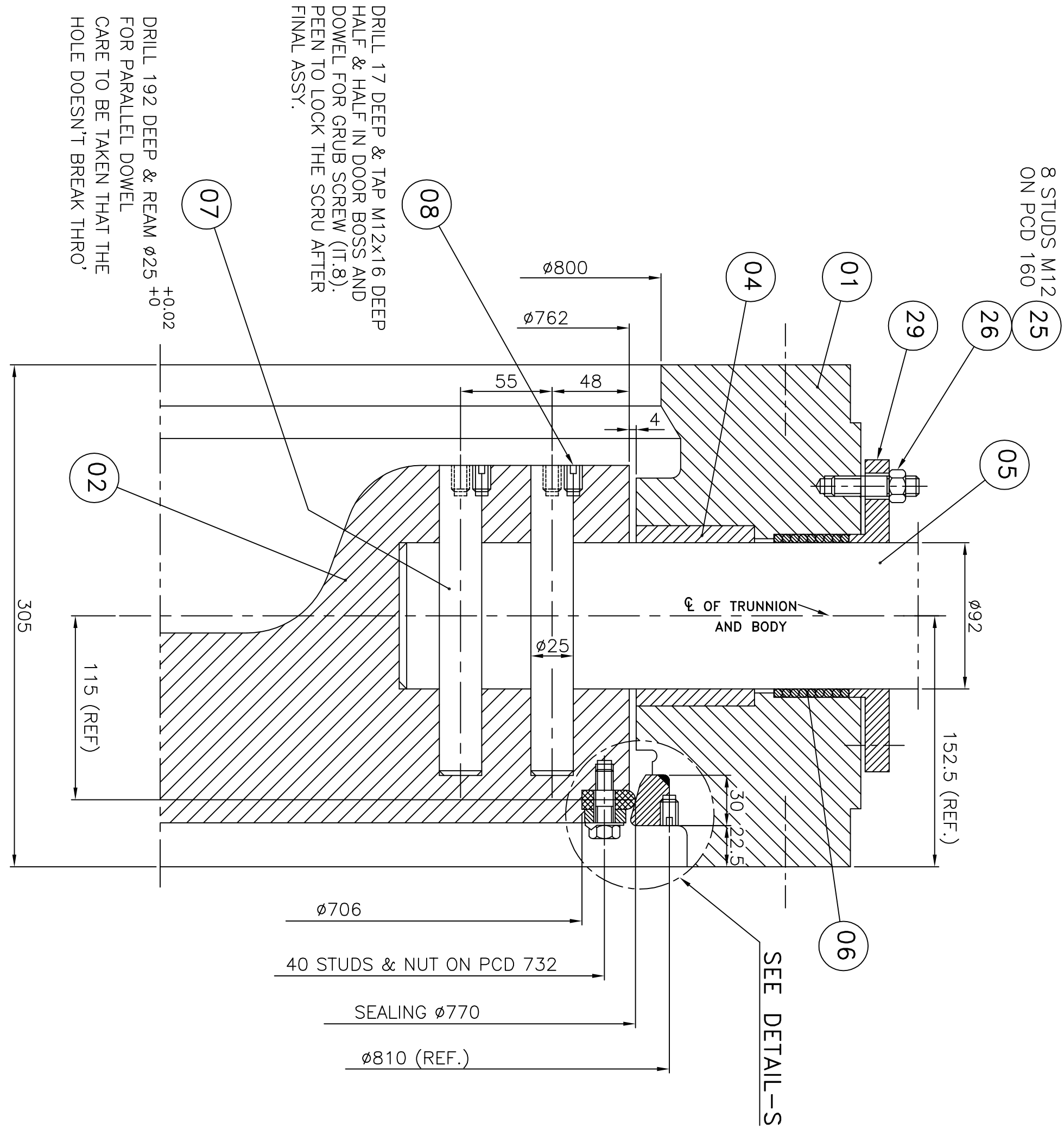
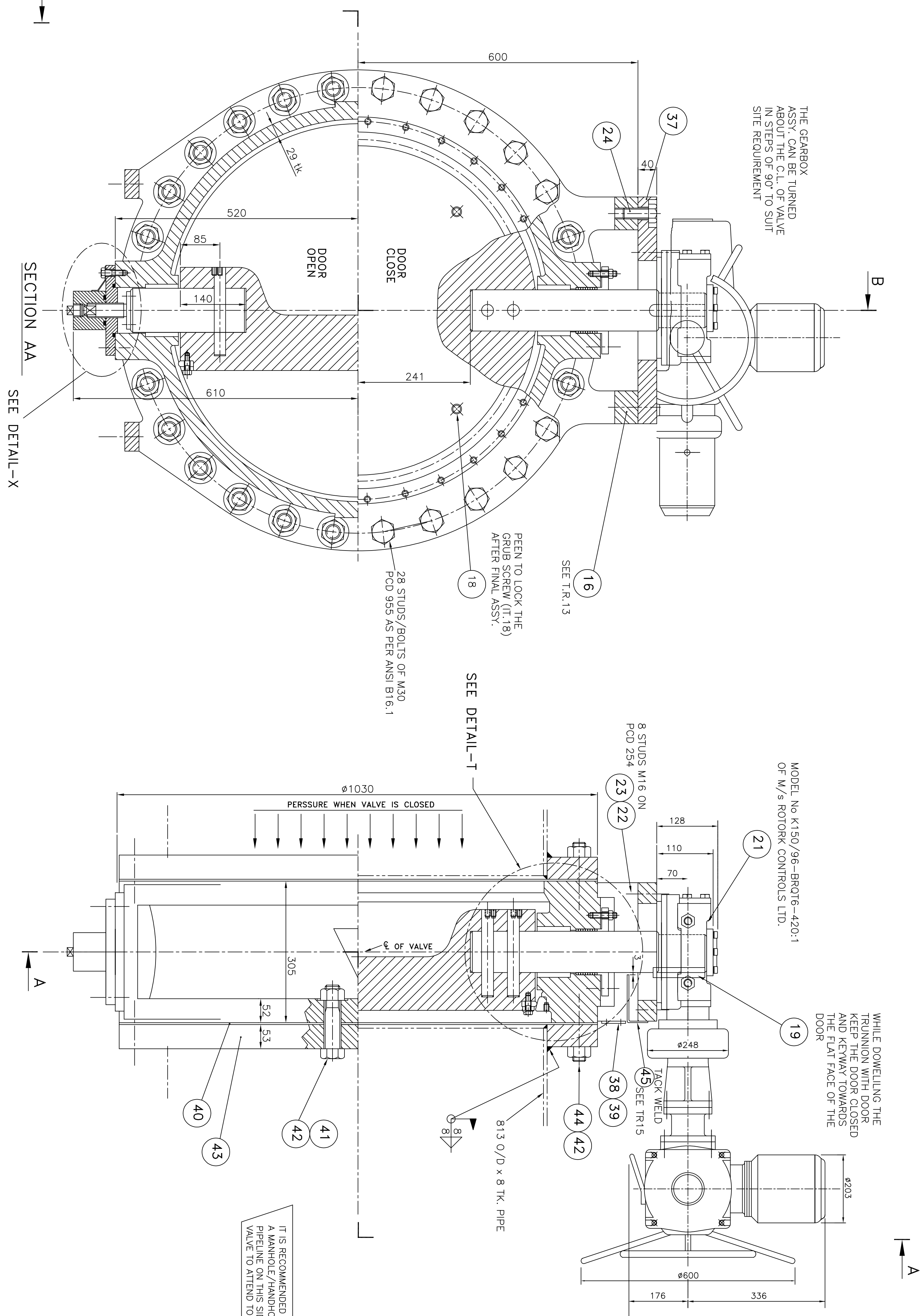


THE VALVE & ACTUATOR ARE DESPATCHED TO SITE SEPARATELY. AT SITE, THEY ARE TO BE ASSEMBLED AFTER MATCHING THE SL. NOS. PAINTED ON THEM THEREAFTER GEAR BOX IS TO BE OPERATED TO ENSURE PROPER OPENING & CLOSING OF VALVE AND ALSO THE PROPER SETTING OF MECHANICAL STOPS IN THE GEAR BOX.



QUANTITY TO BE SUPPLIED = 16 NOS



TECHNICAL REQUIREMENTS

1. CARE TO BE TAKEN TO AVOID DAMAGE WHEN PRESSING SELF LUBRICATING BUSHES IN THE BODY OF THE VALVE.
2. CLEAN THE SELF LUBRICATING BUSHES THOROUGHLY BEFORE INSERTING TRANSLATIONS, DURING ASSEMBLY.
3. AFTER DOOR HAS BEEN TESTED, FOR SOLIDNESS, VALVE DOOR SEAL (ITEM 9) TO BE RESET DOOR TIGHT AT THE TEST PRESSURE.
4. REBUILT OR REPAIR VALVE TO BE TESTED AT THE FOLLOWING PRESSURES:
 - a. DESIGN PRESSURE = 7.5 N/gsq cm (g)
 - b. TEST PRESSURE = 10 N/gsq cm (g)
 - c. VALVE BODY & DOOR = 15.0 N/gsq cm (g) FOR 10 MIN. DURATION, VALVE SEAL = 7.5 N/gsq cm (g) FOR 5 MIN. DURATION
 - d. VALVE SEAL = 15.0 N/gsq cm (g) FOR 10 MIN. DURATION
5. PLATING THICKNESS: 10-14 MICRONS.
6. PAINT AND PROTECT AS PER NIPCO'S APPROVED SPECIFICATION.
7. ALL HARDWARES (EXCEPT S.S. HARDWARES) ARE TO BE ZINC PLATED AS PER BPO73693 HAVING PLATING THICKNESS: 10-14 MICRONS.
8. DOWNLOIN ON DRIVING SIDE TRANNUON WITH DOOR TO BE DONE AFTER ASSEMBLING THE VALVE WITHIN THE TRANNUON.
9. GEAR BOX & KEETING BOTH DOOR & GEAR BOX IN FULLY CLOSED POSITION.
 - a. SPECIFICATION:-
 - i. A) TOW = 100 N/gsq cm
 - ii. B) TOW = 100 N/gsq cm
 - iii. C) DESIGN WATER TEMP = 60°C
 - iv. D) VALVE DESIGN CODE = AMVA C - 504
 - b. VALVE OPEN/CLOSE TIMINGS = 40-60 SECONDS
11. AFTER MANUALLY OPERATING THE VALVE AT WORKS THE STIFFNESS OF GEAR BOX TO BE SET TO ALLOW MAXIMUM 0.35" CORREL TRAVEL OF THE DOOR.
12. TESTING AND INSPECTION TO BE DONE AS PER AGREED QUALITY PLAN.
13. TESTING AND INSPECTION TO BE DONE AS PER AGREED QUALITY PLAN.
 - a. 15% OF SAMPLE DOWNS 50% (IT&B) TOX WELD THE DOWEL AFTER ASSEMBLY
 - b. 5% OF SAMPLE DOWNS 50% (IT&B) TOX WELD THE DOWEL AFTER ASSEMBLY
14. CONNECTION FLANGES (ITEM 4&5) ARE TO BE VALVE ROSED ASSEMBLED WITH VALVE IN THE SHIP PERFORMANCE POSITION.
15. AFTER FINAL ASY OF VALVE KEEP THE VALVE IN CLOSED POSITION AND DRILL ONE HOLE @ 3 X3 ON D/S OF SPRING TRANNUON AT SUITABLE PLACE, BEND ITEM 45 TO SUIT & WELD IT WITH THE MOUNTING PLATE.
16. D/S OF SPRING TRANNUON AT SUITABLE PLACE, BEND ITEM 45 TO SUIT & WELD IT WITH THE MOUNTING PLATE.

[illegible]

DETAIL-S
SCALE-1:1 (GRID D-11)

DETAIL-X
SCALE-1:2 (GRID H-3)

APPROVED BY BHEL

Signature
B. K. Verma
Engineer/ PDX (Engg.)
BHEL, Bhopal

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