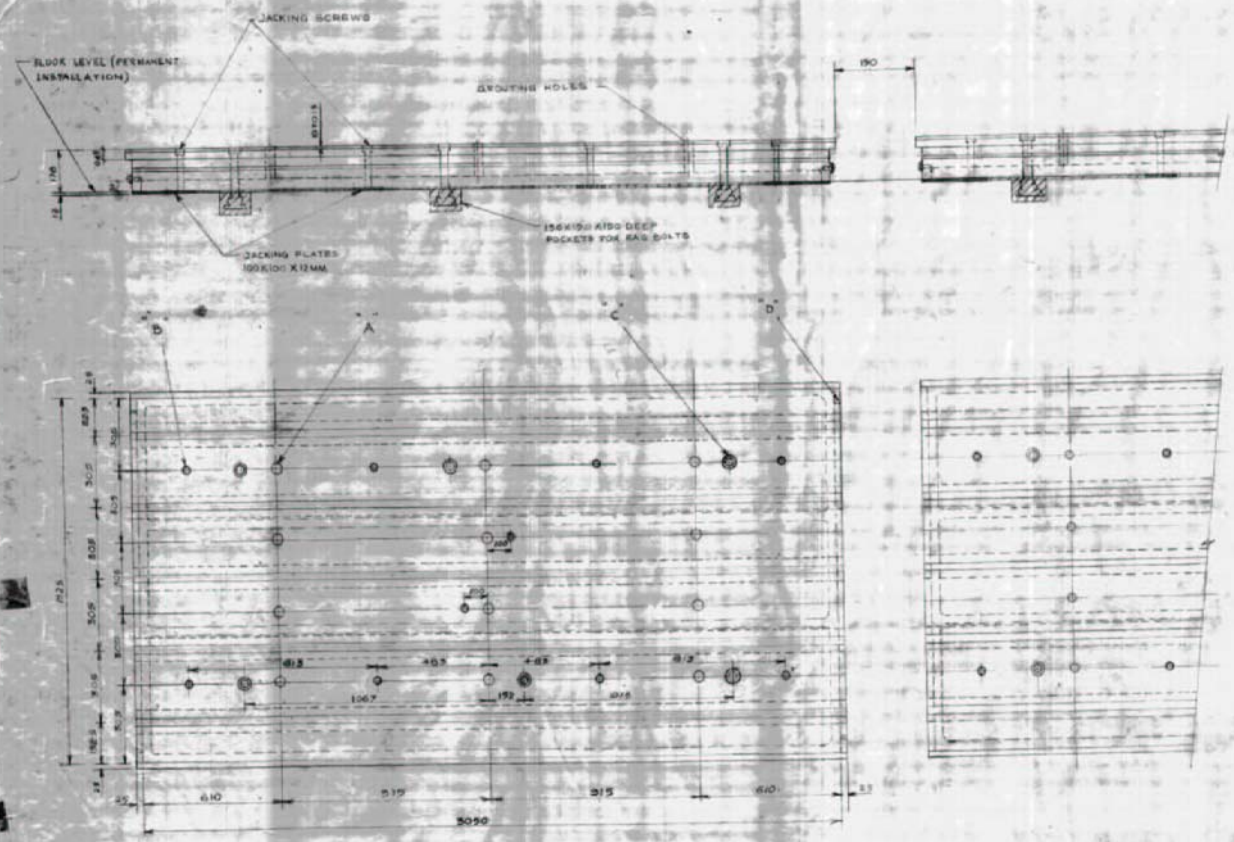


REFERENCE FOR DRILLED AND CORED HOLES		
REF.	DESCRIPTION	REMARKS
A.	12-56 DIA. CORED HOLES IN CASTING	FOR GROUTING
B.	10-HOLES DRILL THROUGH AND TAP M20 COUNTER BORE DIA 24 X 25 DEEP.	FOR LEVELLING SCREWS
C	6-HOLES DRILL THROUGH 26 DIA. COUNTER BORE DIA 50X25 DEEP.	FOR HOLDING 24MM BOLTS
D.	4 HOLES TAP M12 X 20 DEEP.	FOR LACKING STRAPS

INSTALLATION PROCEDURE

1. PLACE RAG BOLTS IN BED PLATES AND POSITION EACH BED PLATE ON FOUR CORNER [illegible]KING PIECES.
2. LOCATE EACH BED PLA[illegible] EXACTLY TO LAYOUT DRAWING. NO. [illegible] PROJECT: J 2070 [illegible]ORDINATED LAYOUT OF MACHINE TOOLS AND MANUFACTURING [illegible]QUIPMENTS IN BAY 1 & 2.
3. PLACE TEN JACKING PLA[illegible] (100 X100 X12MM) IN POSITION UNDER EACH BED PLALE AND INSERT JACKING SCREWS.
4. GROUT RAG BOLTS IN POSITION. POUR THROUGH GROUTING HOLES SUFFICIENT CEMENT TO FILL THE RAG BOLT HOLES AND ALLOW TO SET.
5. FIX COPPER EARTHING STRAPS. ALL JOINTS TO BE TINNED
6. SELECT BED PLATE IN HIGHEST POSITION, SET LEVEL USING JACKING SCREWS TO WITHIN 0.25 MM BETWEEN ANY TWO POINTS ON INDIVIDUAL BED PLATES.
7. LEVEL OTHER BED PLATES USING HIGHEST AS A DATUM. ALL BED PLATES TO BE IN THE SAME PLANE, LOCAL VARIATION BETWEEN ANY POINT AND THE DATUM IS NOT TO EXCEED 0.25 MM OVER A SPAN OF 1 METER.
8. FILL IN SURROUNDS WITH CONCRETE AT EACH END OF "T" SLOTS AS PER THE DRAWING.
9. CHECK ALIGNMENT AND FLATNESS AFTER CONCRETE SURROUNDS HAVE SET, ADJUST JACKING SCREWS IF NECESSARY BEFORE CONCRETE HARDENS.
10. POUR GROUT THROUGH CORED HOLES TO FILL IN CAVITIES BENEATH CENTRE PORTION OF BED PLATES.
11. ALLOW CONCRETE TO SET AND HARDEN AT LEAST FOR FOUR DAYS.

A	DATE 21-6-76 CKD. APPD.	ALL BED PLATES WERE 25MM BELOW FLOOR LEVEL.

DRAWING ISSUED BY: PROJECT DEPTT. D.O.

DRN. [illegible] 4.5.76

CKD. [illegible]

DRG. APPD. [illegible]

DESN. APPD.

BHARAT HEAVY ELECTRICALS LIMITED
JHANSI

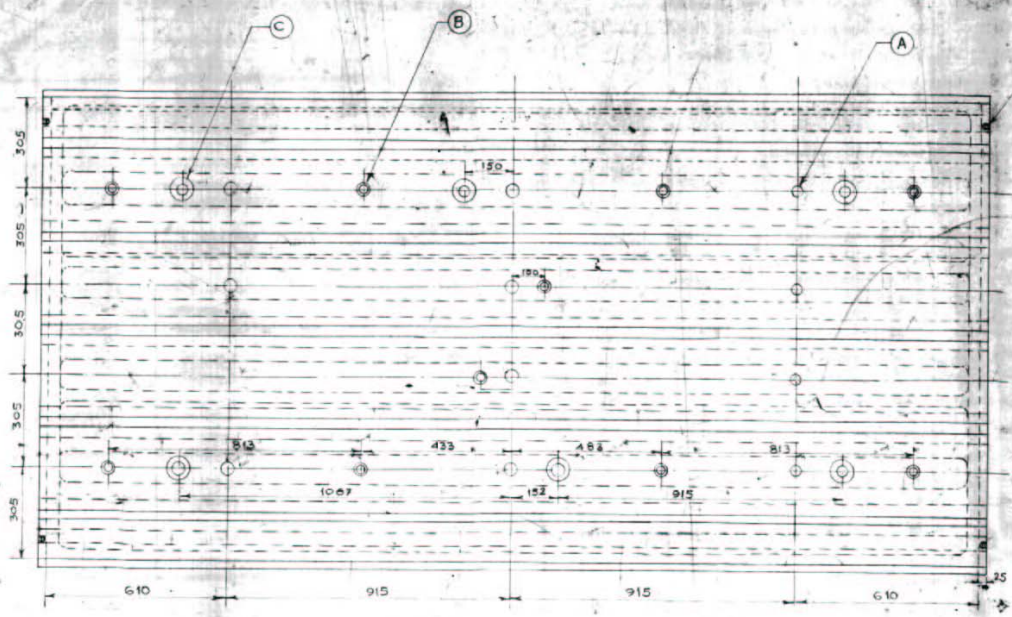
FOUNDATION & INSTALLATION DETAILS FOR BED PLATES (3050X1525) IN BAY 1 & 2

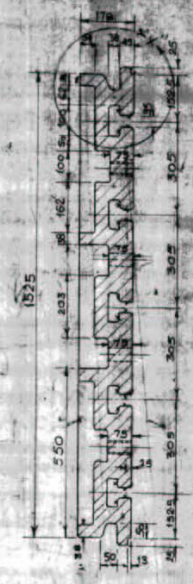
SCALE:

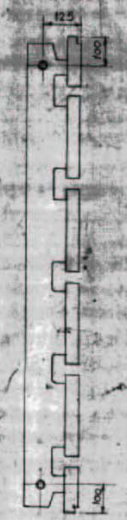
DRG. NO. BHEL/JHS/PROJ-E 2087

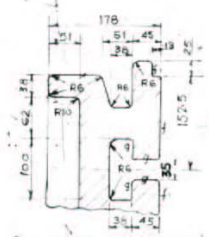
FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)









ENLARGED DETAILS AT 'X'

SCALE 1:2.5

MATERIAL :- CAST IRON IS 210-1970 Gr. 20 OR ALTERNATIVELY BS14-52-1961 Gr 14 (MV PATTERN NO. 12590)

CAST WEIGHT ≐ 3820 kg (8400 lbs)

SYMBOLS :- f INDICATES FACES TO BE FINISHED MACHINED

g- FACES TO BE ROUGH MACHINED

REFERENCE FOR DRILLED AND CORED HOLES		
REF.	DESCRIPTION	REMARKS
A	12-38 dia CORED HOLES IN CASTING	FOR GROUTING PURPOSES
B	10-HOLES DRILL THRU & TAP M-20 COUNTER BORE dia 24 X 25 DEEP	FOR LEVELLING SCREWS
C	6-HOLES DRILL THRD. 28 dia COUNTER BORE dia 30 X 25 DEEP	FOR HOLDING DOWN BOLTS
D	4-HOLES TAP M12 X 20 DEEP	FOR EARTHING STRAPS

FOR INSTALLATION OF BEDPLATES SEE DRG. NO. PE4596 (BPL. UNIT)

FOR INSTALLATION PROCEDURE SEE DRG. NO. PE.4595 (BPL. UNIT)

NOTE :- DEVIATION IN FLATNESS NOT TO EXEED ± 0.125 MM MEASURED ALONG LENGTH & ACROSS DIAGONALS AFTER MACHINE CLAMPS ARE RELEASED

STRESS RELIEVING HAS TO BE DONE BEFORE FINISHED MACHINING

FOR FOUNDATION INSTALLATION DETAILS TO REFER DRG. BHEL/JHS/PROJ/E/001

M.V. DRG. & SK- 1652024 SPEC. NO. 1058 & BHE/BPL/PE-4590

BHARAT HEAVY ELECTRICALS LIMITED JHANSI

DEPT. CODE | SCALE | WEIGHT (kg) | REF. TO ASSY. DRG. | REMARKS

TITLE TRANSFORMER FABRICATION SECTION STD. 3050 X 1525 BED PLATE

DRAWN | NAME | SIGN. | DATE

CHECKED

APPROVED

DIMENSIONS TO BE CONTROLLED WITHIN LIMITS AS SHOWN. MACHINING TOLERANCE ± 25 mm UNLESS OTHERWISE SHOWN. FOR MACHINING TOLERANCE

DRAWING NO. BHEL/JHS/WE&S/A10.1066 | REV.

SHEET NO. | OF SHEETS | SIZE A1

REV.	DATE	ALTERED	REV	DATE	ALTERED	REV.	DATE	ALTERED
		CHECKED			CHECKED			CHECKED
ZONE			ZONE			ZONE		

TRACED FROM ORIGINAL DRG. NO. JHS/SK-F 10028

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INVENTORY NO. | DATE & DATE | REF. DRG. NO.