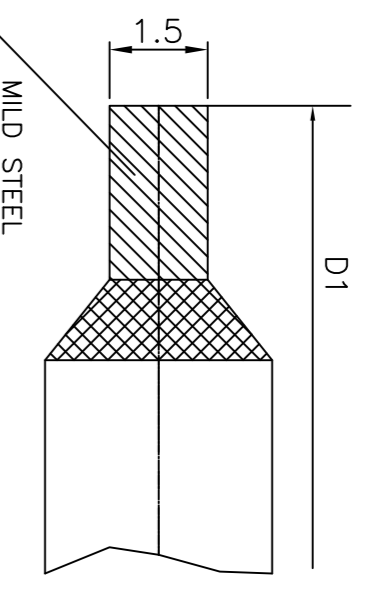
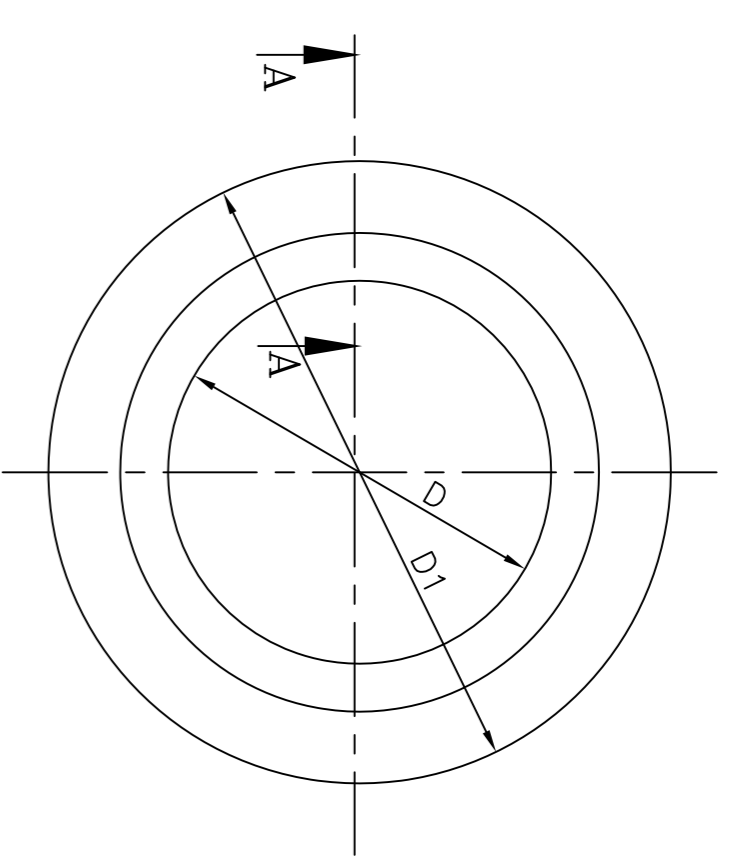


ITEM NO.	DESCRIPTION	QTY
1	O-RING	01
2	U-RING	01

ITEM NO. 02 HYDRAULIC CYLINDER
SCALE 1:2

PRESSURE FORCE, NOM. VALUE	1000KN
PRESSURE EFFECTIVE	1005KN
IMPACT SURFACE (PISTON)	201CM ²
OPERATING PRESSURE MAX	500BAR
REQUIRED OIL VOLUME MAX	0.643L
STROKE	32MM
WEIGHT	35KG
MATERIAL	STEEL

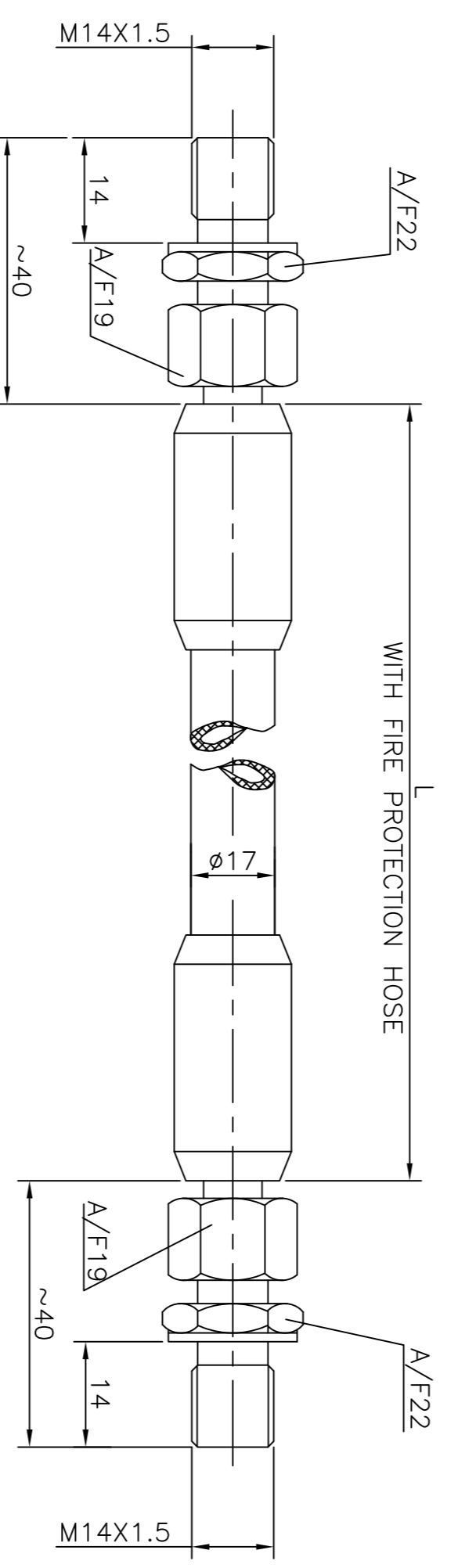


SECTION AA

ITEM NO.	D	D1	VAR.
ITEM NO.10	14.7	22	01
ITEM NO.03	18.7	22	00

MATERIAL DESCRIPTION:-
SEALING RING -MILD STEEL RING PLATED WITH BRASS OR CADMIUM.
VULCANISED DOUBLE LIP SEAL-SMIRT .70 NBR/120 OR EQUIVALENT
BASE: ACRYLONITRIL-BUTADIENE RUBBER
HARDNESS@ 70 SHORE A

ITEM NO 03.10
(SEALING RING)

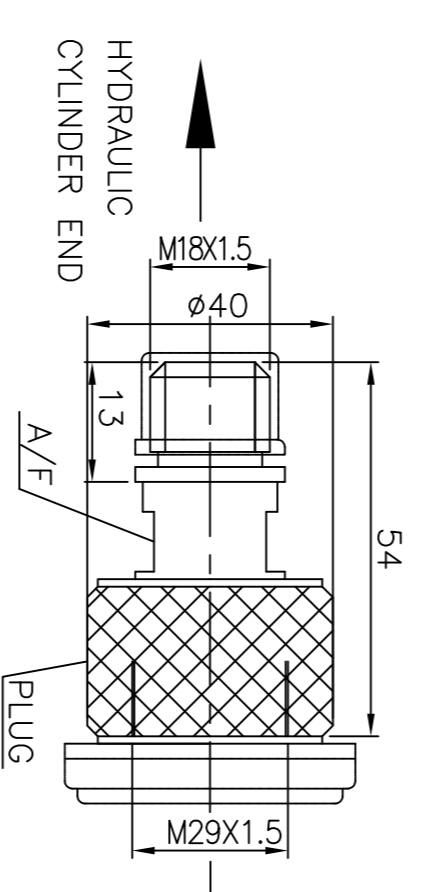


MATERIAL OF UNION NUT AND
NIPPLE: STEEL

THE HOSE SHOULD BE WITH FIRE PROTECTION COVER &
SUITABLE FOR AN OPERATIONAL PRESSURE OF 700BAR
HYDRAULIC TEST PRESSURE 1000BAR FOR 30MINUTES.

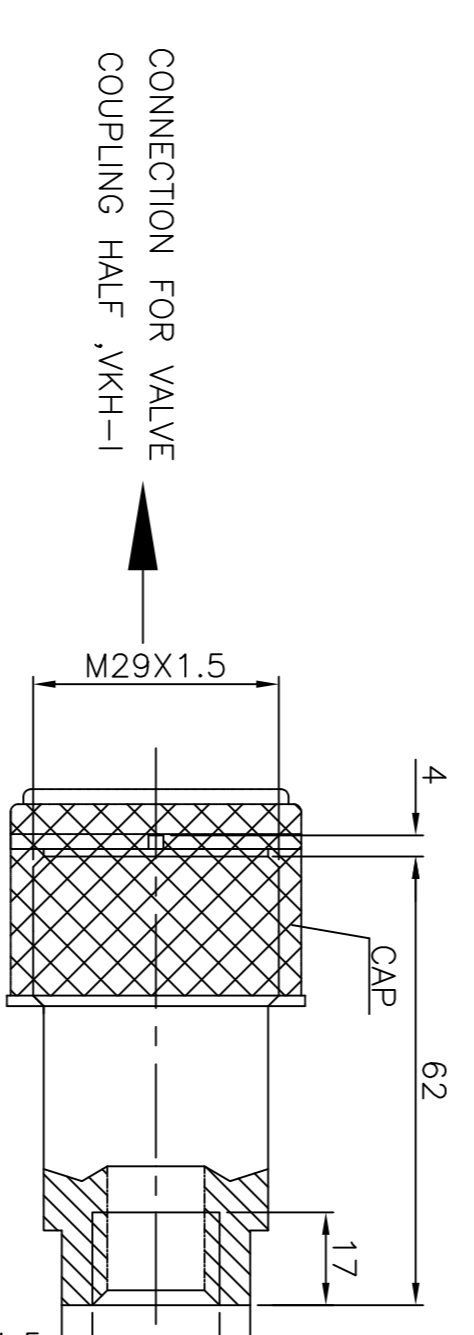
ITEM NO.4.5

ITEM NO.	L (M)	VAR.
ITEM 04.	5(M)	00
ITEM 05.	12(M)	01



OPERATIONAL PRESSURE = 500BAR
TEST PRESSURE = 750BAR
FLOW RATE = 15 L/min.
MATERIAL = STEEL

ITEM NO 06 (VALVE COUPLING HALF-I)



OPERATIONAL PRESSURE = 500BAR
TEST PRESSURE = 750BAR
FLOW RATE = 15L/min.
MATERIAL = STEEL

ITEM NO 07 (VALVE COUPLING HALF-II)

PURCHASED

W90413902617

INVENTORY NO.	SIGN & DATE	REF. DRG NO.

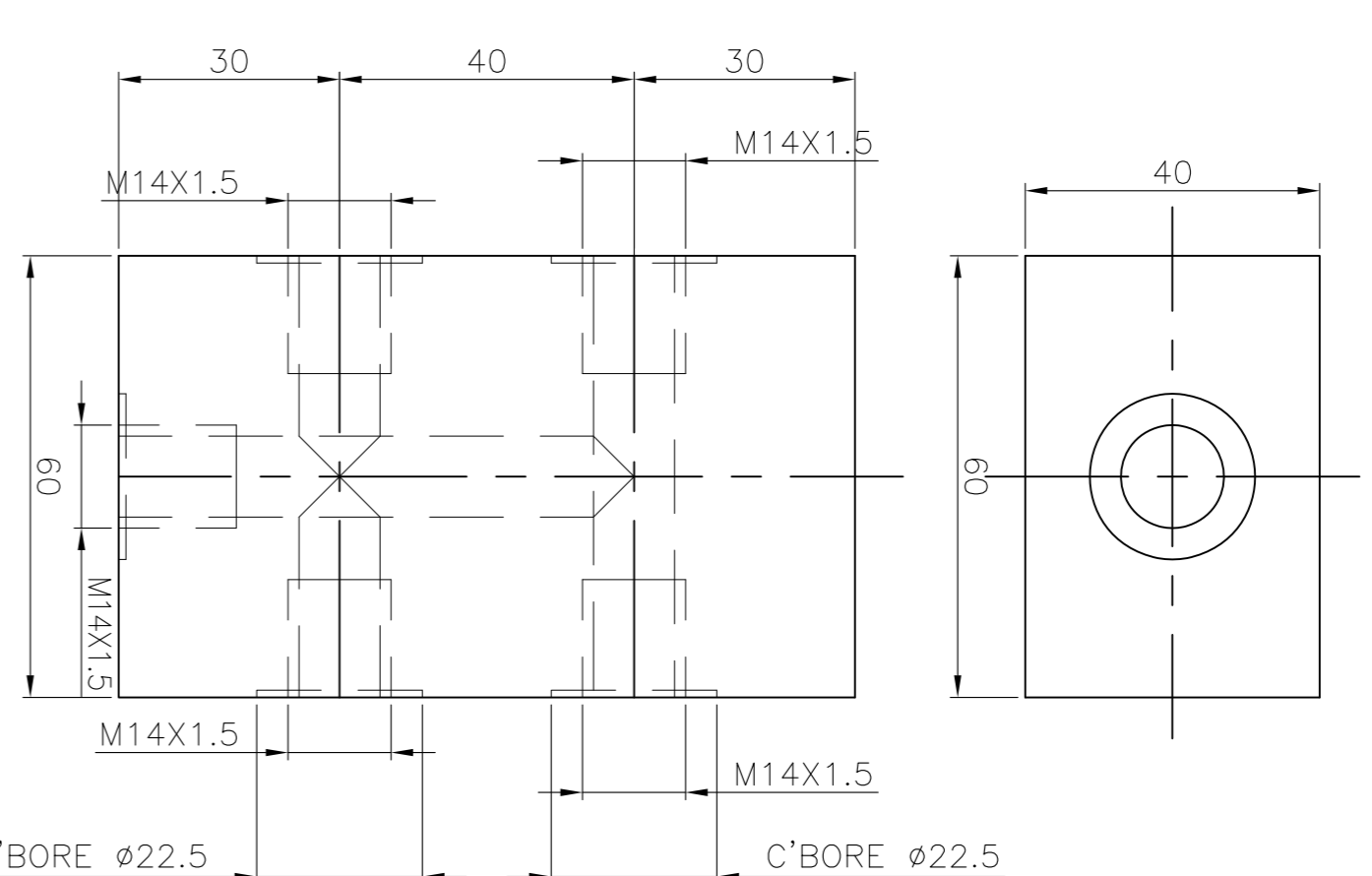
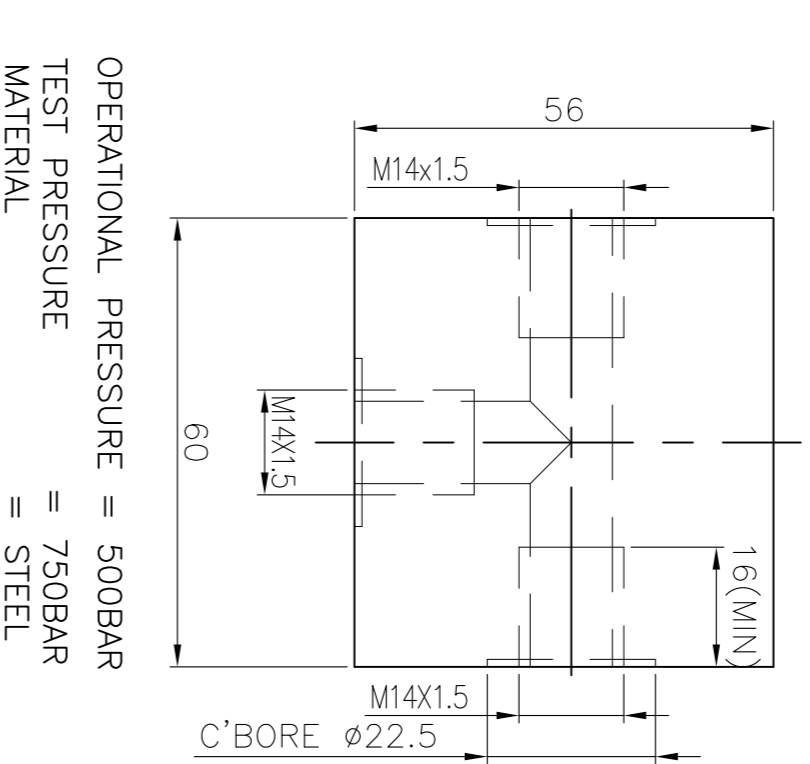
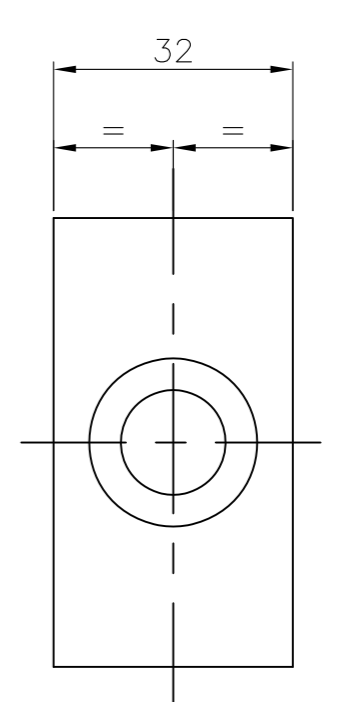
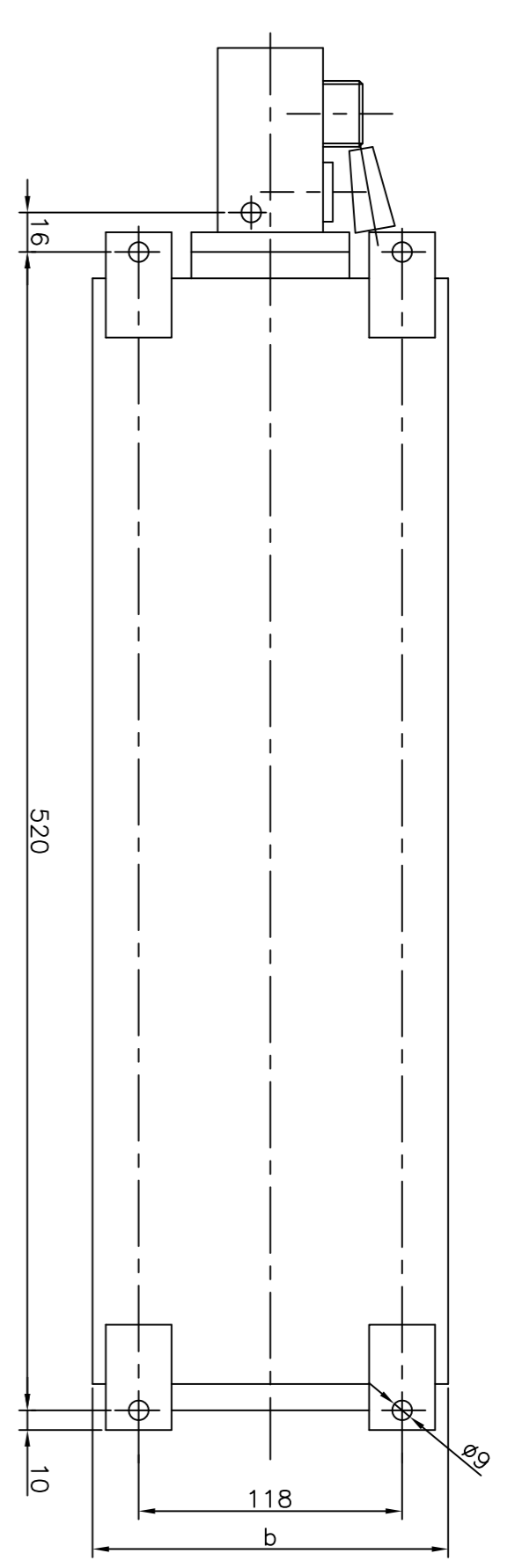
REV	DATE	DESCRIPTION	BY	CHKD
01	27.5.14	CHECKED/AMISHRA sd/-		
		ALTERED/AMISHRA sd/-		
		CHECKED		

GRADE OF UNITOL. DIM:-	W/CG- V/C/N/F AA 0230208
WELDING-A/B/C/D-AA621104	
GAS CUTTING-T3AA082101	
REV DATE	ALTERED/AMISHRA sd/-
01 27.5.14	CHECKED/AMISHRA sd/-
CHANGES DONE AS PER	
CHANGE ADVICE NO TGE-14-r0159	

REV	DATE	DESCRIPTION	BY	CHKD
01	27.5.14	CHECKED/AMISHRA sd/-		
		ALTERED/AMISHRA sd/-		
		CHECKED		

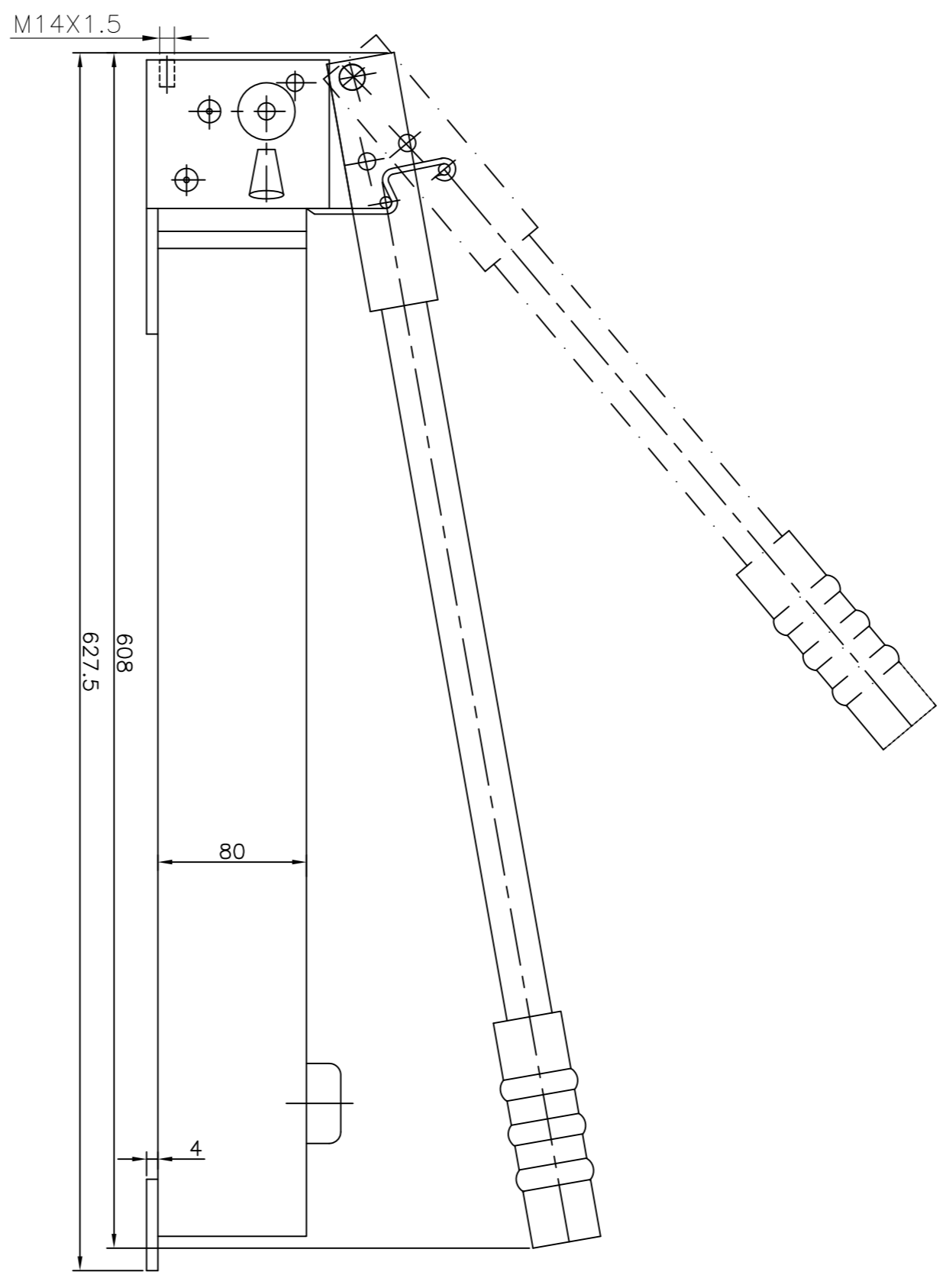
REV	DATE	DESCRIPTION	BY	CHKD
01	27.5.14	CHECKED/AMISHRA sd/-		
		ALTERED/AMISHRA sd/-		
		CHECKED		

REV	DATE	DESCRIPTION	BY	CHKD
01	27.5.14	CHECKED/AMISHRA sd/-		
		ALTERED/AMISHRA sd/-		
		CHECKED		



ITEM NO 8 (OIL DISTRIBUTOR)
OPERATIONAL PRESSURE = 500BAR
TEST PRESSURE = 750BAR
MATERIAL = STEEL

ITEM NO 9 (OIL DISTRIBUTOR)
OPERATIONAL PRESSURE = 500BAR
TEST PRESSURE = 750BAR
MATERIAL = STEEL



ITEM NO.-1(HYDRAULIC PUMP)

TECHNICAL DATA

OIL CAPACITY	5.2L
USABLE OIL CAPACITY	4.5L
OPERATING PRESSURE	800 BAR
DELIVERY/PISTON STROKE LP	10 CM3
AUTOMATIC SWITCH OVER AT	100 BAR
DELIVERY/PISTON STROKE HP	1.6 CM3
WEIGHT INCL. OIL	13.4
TEST PRESSURE	970 BAR

TECHNICAL REQUIREMENTS:-

1. THE SCHEME PROVIDED HERE IS FOR GUIDANCE. SUPPLIER TO PROVIDE THEIR OWN DETAILED DRAWINGS WITH SCHEME AT THE TIME OF OFFER FOR APPROVAL OF BHEL.
2. VENDOR TO PROVIDE GENERAL ARRANGEMENT DRAWING OF THE ASSEMBLY WITH BILL OF MATERIAL AT THE TIME OF OFFER.
3. TESTING OF INDIVIDUAL COMPONENTS IS TO BE DONE AS PER DETAILS ON SHEET-2&3.
4. THE COMPLETE HYDRAULIC UNIT AFTER ASSEMBLY AT VENDOR WORKS TO BE HYDRAULICALLY TESTED AT 540kg/cm² FOR 10min. NO LEAKAGE IS ALLOWED (WORKING PRESSURE=450kg/cm²).

PURCHASED

W90413902617

S.NO.	ITEM DESCRIPTION	QTY.	REMARKS
10	SEALING RING VAR 01	20	REFER SHEET 1 FOR DETAILS
09	OIL DISTRIBUTOR(1X4)	2	REFER SHEET 2 FOR DETAILS
08	OIL DISTRIBUTOR(1X2)	2	REFER SHEET 2 FOR DETAILS
07	VALVE COUPLING HALF-II	13	REFER SHEET 1 FOR DETAILS(INCLUDE 3 NOS SPARE)
06	VALVE COUPLING HALF-I	13	REFER SHEET 1 FOR DETAILS(INCLUDE 3 NOS SPARE)
05	SUPER PRESS HOSE VAR 01	5	L=12M
04	SUPER PRESS HOSE VAR 00	10	L=4M
03	SEALING RING VAR 00	16	REFER SHEET 1 FOR DETAILS
02	HYDRAULIC CYLINDER WITH SPARE PARTS	10	REFER SHEET 1 FOR DETAILS
01	HYDRAULIC PUMP	4	REFER SHEET 3 FOR DETAILS

THDF 115/67

TYPE OF PRODUCT OR NAME OF CUSTOMER/ PROJECT
BHARAT HEAVY ELECTRICALS LTD. HARDWAR

GRADE OF UNTOL. DIM:-	W/CG- V/C/N/F AA 0230208
WELDING-A/B/C/D-AA621104	
GAS CUTTING-T3AA082101	
REV/ DATE	ALTERED AMISHRA sd/-
01	27.5.14 CHECKED AMISHRA sd/-
CHANGES DONE AS PER CHANGE ADVISE NO TGE-14-10159	
DEPT. TGE	SCALE
CODE 4133	507
DRN STGEAST	STGEAST
CHD STGERLV	STGERLV
APD ATGEAKM	ATGEAKM
REF. TO ASSY. DRG.	01394501007
ITEM NO. OF NOS	01
NO. OF SHEETS	3

TITLE
HYDRAULIC UNIT ASSEMBLY