

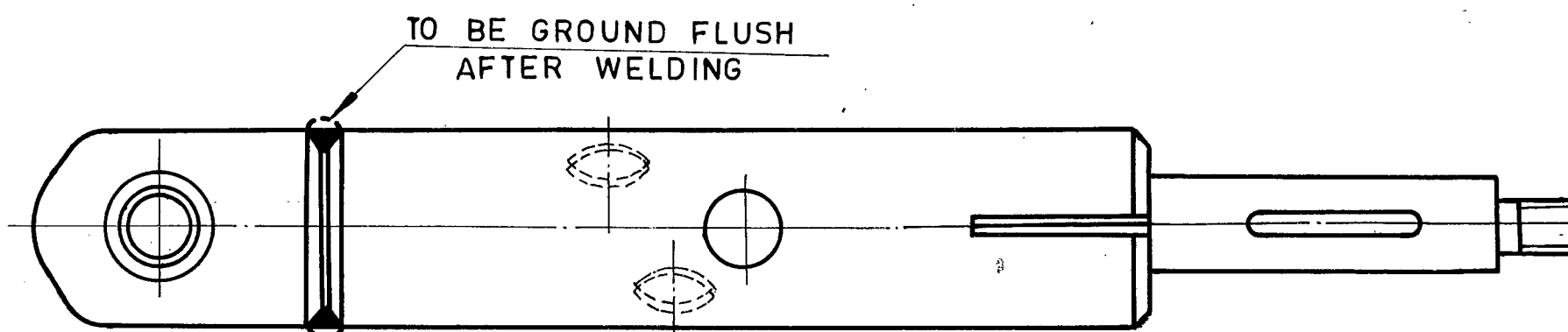
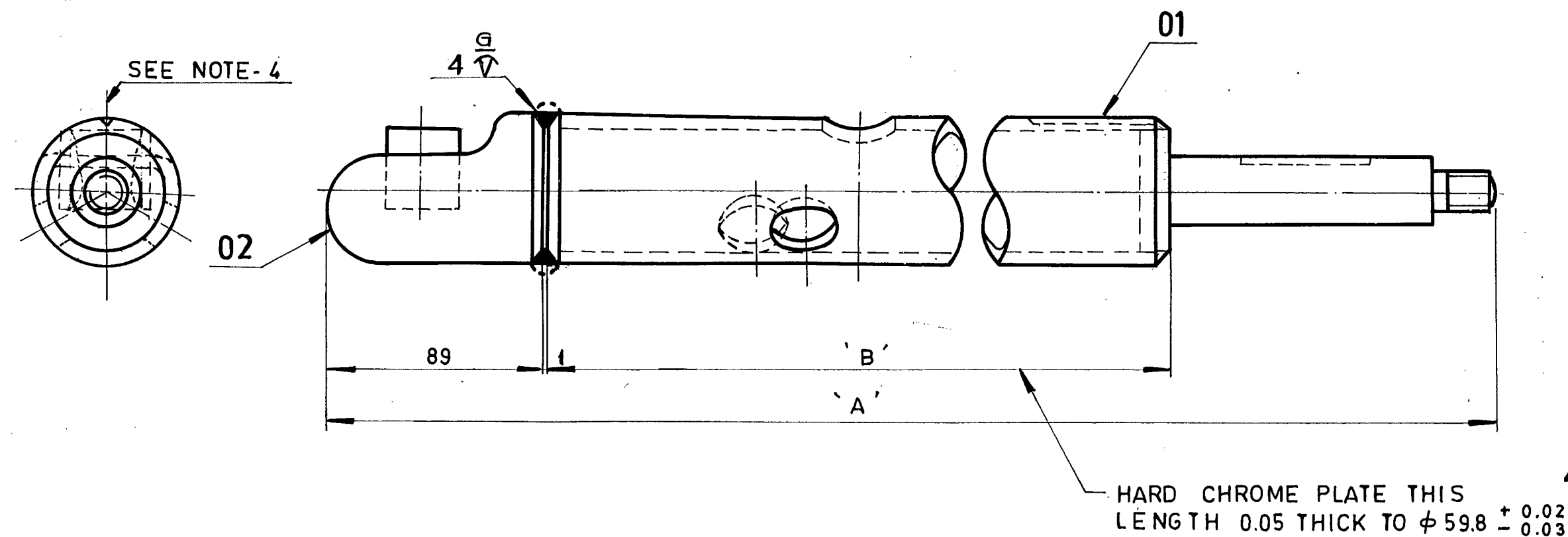
08200-102-02-2

DRAWING NO.

CAUTION THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LTD. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

NOTE:

1. WELDING TO BE CARRIED OUT BY TIG WELDING.
2. CHECK SOUNDNESS OF WELD BY ULTRASONIC AND LIQUID PENETRANT TEST.
3. HEAT TREATMENT TO BE FOLLOWED AS PER THE REQUIREMENT OF METAL.
4. WELD NOZZLE HEAD ASSY WITH SWIVEL TUBE IN SUCH A WAY THAT THE 'V' GROOVE PROVIDED ON SWIVEL TUBE SHOULD BE IN LINE WITH CENTRE LINE OF NOZZLE.
5. VARIANT NO 02,03&04 MEANT FOR COPES VULCON SWIVEL TUBE ASSY REPLACEMENT.



TYPE OF WELD	TYPE OF ELECTRODE	LENGTH OF WELD
4V	E. 309	0.200 m

VARIANT	DIMENSION 'A'	DIMENSION 'B'
01	1308	1088
02	1187	967
03	1308	1088
04	1221	1001

REV	DATE	ALTD: <u>3.3.87</u>	REV	DATE	ALTERED: <u>PRK</u>	REV	DATE	ALTERED <u>NG</u>	REV	DATE	ALTERED <u>NG</u>
<u>04</u>	<u>16.7.87</u>	<u>CKD: 88</u>	<u>03</u>	<u>11.04.85</u>	<u>CHECKED 88</u>	<u>02</u>	<u>15.5.84</u>	<u>CHECKED</u>	<u>01</u>	<u>16.9.83</u>	<u>CHECKED KTC</u>
<u>EC NO. 872</u>	<u>VARIANT 04 INTRODUCED</u>			<u>STYLE 03 ADDED</u> <u>DRG. REDRAWN</u> <u>EC. NO. 756</u>		<u>B</u> <u>1,2</u> <u>3&4</u>	<u>E.C</u> <u>709</u>	<u>VARIANT NO. 02</u> <u>INTRODUCED.</u>	<u>ZONE</u> <u>D 6</u>	<u>E.C</u> <u>676</u>	<u>DIMENSION 1088 AND</u> <u>1308 WERE 1098 AND</u> <u>1316 RESPECTIVELY</u>

VARIANT NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	ITEM NO.	MATL CODE	A	UNIT	UNIT WT	CS	ZONE
02	NOZZLE HEAD ASSY	4.20.201.00164		WELDMENT		0.920			1		
01	SWIVEL TUBE	3.20.201.00903		WELDMENT		8.436			1		
04	SWIVEL TUBE ASSY	2.20.201.00280		WELDMENT		9.356			1		
02	NOZZLE HEAD ASSY	4.20.201.00164		WELDMENT		0.920			1		
01	SWIVEL TUBE	3.20.201.00846		WELDMENT		8.580			1		
03	SWIVEL TUBE ASSY	2.20.201.00280		WELDMENT		9.500			1		
02	NOZZLE HEAD ASSY	4.20.201.00164		WELDMENT		0.920			1		
01	SWIVEL TUBE	3.20.201.00810		WELDMENT		8.186			1		
02	SWIVEL TUBE ASSY	2.20.201.00280		WELDMENT		9.106			1		
02	NOZZLE HEAD ASSY	4.20.201.00164		WELDMENT		0.920			1		
01	SWIVEL TUBE	3.20.201.00699		WELDMENT		8.580			1		
01	SWIVEL TUBE ASSY	2.20.201.00280		WELDMENT		9.500			1		

TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT

MICROFILMED ON

ROLL 00391 FRAME 010

Bharat Heavy Electricals Ltd.,
BOILER PLANT UNIT
TIRUCHIRAPALLI-620 014DRN NAME SIGN DATE NO. OF VAR
CHD P. Ramanikaran / P. Ramanikaran 08-04-85
APPD G. S. S. 10/4/85DEPT SB
CODE 330

GRADE OF UNTOOL DIM C/M/F

SCALE NTS

WEIGHT (kg)

REF TO ASSY / OLD DRG 2.20.201.00066

TITLE SWIVEL TUBE ASSEMBLY

CARD CODE U 01
DRAWING NO. 2.20.201.00280
REV 04