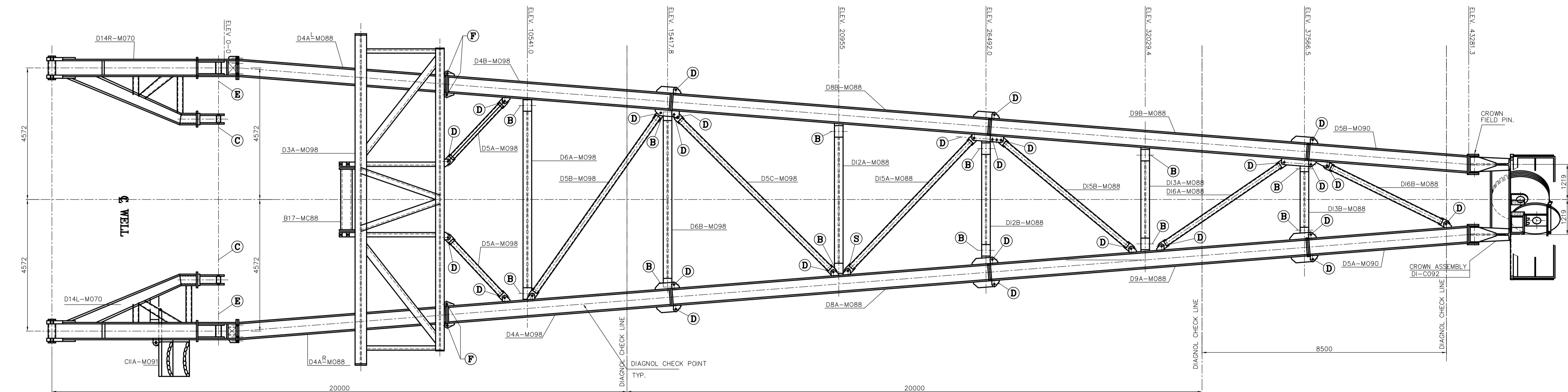


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DRAWWORKS SIDE

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MK NO.	DESCRIPTION	WT.	PAINT AREA IN SQ.M
D12B-M088	GRIT	445	9.8
D13A-M088	do	316	6.9
D13B-M088	do	226	4.90
D5A-M098	BRACE	181	3.98
D5B-M098	do	347	7.6
D5C-M098	do	339	7.45
D15A-M088	do	321	7.0
D15B-M088	do	229	5.0
D16A-M088	do	194	4.2
D16B-M088	do	186	4.0
C11A-M091	DEADLINE ANCHOR WORK PLAT.	105	2.1
D3A ^B M091	BOTTOM SECTION (D.S)	4533	90.70
D3A ^B M091	BOTTOM SECTION (O.D.S)	4533	90.70
D5A-M090	TOP SECTION (D.S)	1477	29.70
D5B-M090	TOP SECTION (O.D.S)	1477	29.70

PK NO.	QTY.	FIELD DRIVE PINS/W/6 SAFETY PINS	WT.
B	24	51 x 108 GRIP	104
C	2	51 x 356 GRIP	33
D	29	64 x 153 GRIP	448
E	2	51 x 508 GRIP	73
F	8	64 x 178 GRIP	136
G	2	64 x 267 GRIP	44
H	12	64 x 324 GRIP	304
K	4	76 x 159 GRIP	98
N	4	89 x 197 GRIP	150
S	1	64 x 203 GRIP	18
T	2	39 x 140 GRIP	10
U	4	39 x 58 GRIP	8

FIELD BOLTS A325 GALV. UNL. NTD.			
10	16	31 x 146 W/ H.N.N & H.W	56

1. ENSURE LEVEL BED FOR THE ENTIRE LENGTH OF MAST.BED HEIGHT MIN 300 MM. LEVEL THE BED WITHIN 6MM FORM ONE END TO OTHER AND THE OTHER END.
2. MARK LAYOUT ON THE BED WITH DIMENSION AS PER DRG. MARK CENTRELINE OF WELL.
3. PLACE THE BOTTOM SECTION DS / ODS ON THE LAYOUT. ENSURE SIDE PANEL VERTICALITY WITHIN 3 MM. ENSURE WATERLEVEL OF MARKED WELL CENTRE LINE ON THE BOTTOM SECTION.
4. PLACE THE STUB SECTION AS PER LAYOUT AND BOLT STUB DS/ODS TO BOTTOM SECTION. CHECK FOR VERTICALITY AND DIAGNOL DISTANCE.
5. PLACE STUB SECTION SPREADER WITHOUT DISTURBING THE STUB SECTION AND PIN.
6. PLACE LOWER SECTION DS&ODS AND PIN TO STUB SECTION. ENSURE SIDE VERTICALITY AND DIAGNOL DISTANCE. ASSEMBLE GIRTS & BRACES.
7. PLACE INTERM. SECTION DS & ODS AND PIN TO LOWER SECTION.ENSURE SIDE VERTICALITY AND DIAGNOL DISTANCE.ASSEMBLE GIRTS & BRACES.
8. PLACE UPPER SECTION DS & ODS AND PIN TO INTERMEDIATE SECTION.ENSURE SIDE VERTICALITY AND DIAGNOL DISTANCE. ASSEMBLE GIRTS & BRACES.
9. PLACE TOP SECTION DS & ODS AND PIN TO LOWER SECTION.ENSURE SIDE VERTICALITY AND DIAGNOL DISTANCE.ASSEMBLE GIRTS & BRACES.
10. PLACE CROWN ASSEMBLY & PIN TO TOP SECTION.ENSURE SIDE VERTICALITY AND DIAGNOL DISTANCE.
11. AFTER TRAIL ASSEMBLY OF ENTIRE MAST, ENSURE DIAGNOL DISTANCE BETWEEN DIAG. CHECK POINTS AS SHOWN IN DRG. ENSURE DIAGONAL DISTANCE WITH IN $\pm 3\text{mm}$.
12. DISMANTLE AFTER CLEARANCE BY QC AND WELD ALL LUGS.
13. INSPECTION OF ALL LUGS BY MPI AS PER MPI HY0850180.
14. BLAST CLEAR ALL SECT: 1/2 AND SPRAY GALVANISE TO 100 MICRONS.
15. PAINT 1 COAT OF 1R2Z EPOXY FOR MAST SECTION AND GOLDEN YELLOW FOR CROWN BLOCK.

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT										<div>RESTRICTED</div>	
<div>BHARAT HEAVY ELECTRICALS LTD HYDERABAD</div>											
DEPT.	UNITS	DIMS		SCALE	WEIGHT	NO. OF REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEMS			
415	4	4 1/2 x 1 1/2		1:50		D2-M099		N.A.	N.A.		
TITLE MASTER TRIAL ASS'LY 142-0 CANTILEVER MAST 1.00PK HOOK						CARD CODE N.A.	DRAWING NO. 1-98510-38182		REV. 01		
						SHT. NO. 01	NO. OF SHTS. 01				

