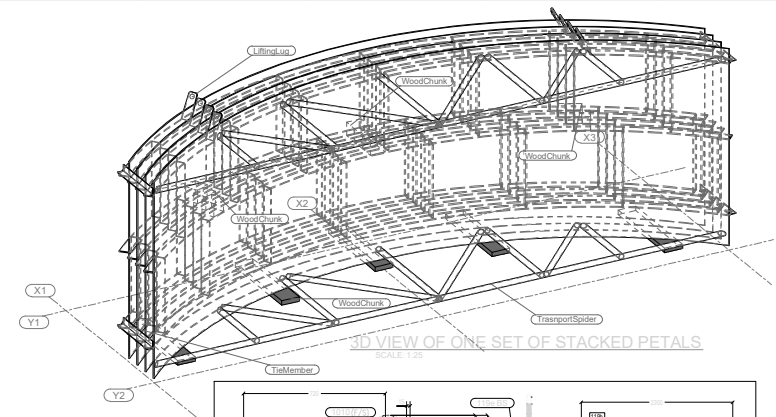
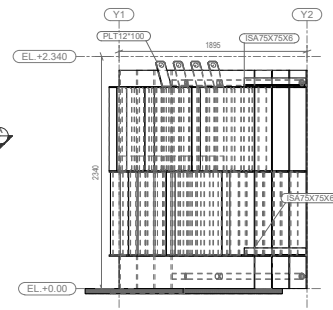
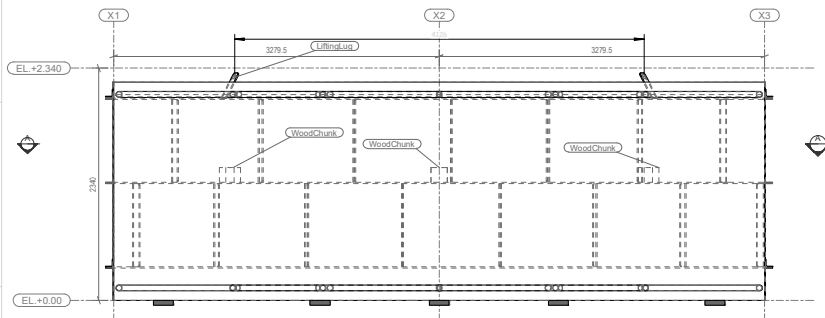
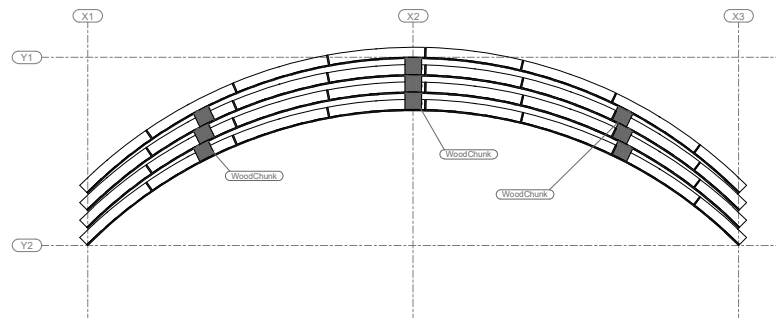
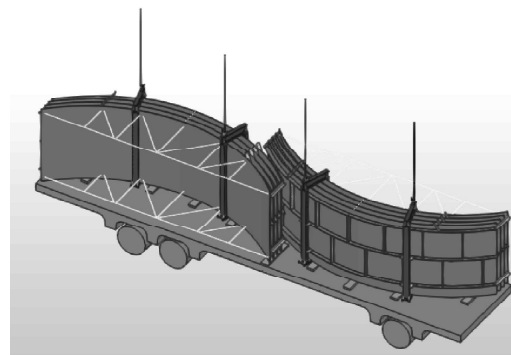
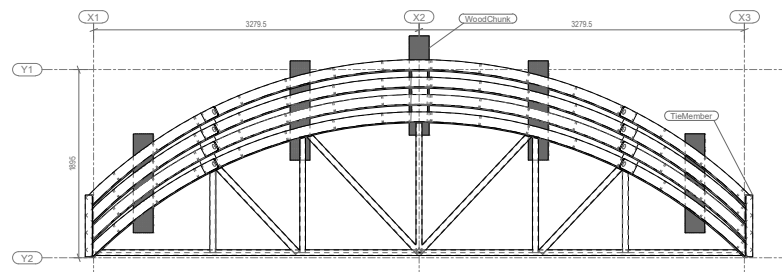




3D VIEW OF ONE SET OF STACKED PETALS



$\frac{A-A}{1.25}$ (SECURE THE WOOD BLOCKS BETWEEN PETALS TO MAKE THE STACK TIGHT AND SOUND)

TRANSPORT MATERIAL SUMMARY PER STACK OF CYLINDRICAL PETALS					
S/N	material	Grade	Weight(kg)/length(m)	PURPOSE	COMMENT
1	SA75X7SX6	IS2062	172/5	Petal end ties (4 nos per stack)	Higher size angle is also acceptable
2	PL12/16/20	IS2062/SA516	22/0.5	Lifting lugs(2 nos per petal)	Weight & length of lug varies depending on location of top covered stiffener
3	NB508	IS1511/IS1239/SA106	215/35	Spider for one petal of stacked petals	Min Dia of 60mm to be ensured
Total weight of transportation steel			254 (Refer note No-08)	Kg	
NOTE:					
(i) The weights are for cylindrical petals whose diameter is between 4.6 to 4.8m and 4 petals are stacked in one set.					
(ii) 2 SETS of stacked petals can be shipped in one normal trailer.					
(iii) <u>Depending on trailer and petal condition, more than 4 petals can be stacked in one set.</u>					
(iv) The wood chunk MTD is not included in the above table However wood chunk is must between trailer bed and petals bottom edges.					
(v) Tie angles to be welded with curved stiffeners without damaging the edge preparation of the petals.					
(vi) All transport material to be distinguished with yellow paints/ strips					

NOTE:

1. ALL WELDS ARE 4MM FILLET UNLESS NOTED OTHERWISE.
2. REFER DRG NO. 1-66-102-U0037 FOR STYLE 1 OF TRANSPORTATION PHILOSOPHY

ADOPTED WITH PRIOR INTIMATION TO ENGINEERING

3. AVOID METAL TO METAL CONTACT OF THE CONSIGNMENT
- I) WOOD CHUNK CAN BE ADOPTED BETWEEN PETALS
 - II) RUBBER SHEET OR ANY PROTECTIVE SHEET TO BE USED

4. WOOD BETWEEN THE PETALS TO BE SECURED TIGHTLY TO AVOID ANY LOOSE STACKING.

5. IF STEP 4 IS NOT VIABLE SUITABLE TIGHT PACKING TO BE ENSURED TO AVOID ANY TRANSIT DAMAGES.
6. THE DOCUMENT CAN BE USED FOR OTHER PROJECTS WITH PRIOR INTIMATION TO HPVP-ENGINEERING

7. FOR BUNCH LIFTING OF STACKED PETALS REFER DOCUMENT NO: 66-102-Handling-001 rev 1.

The drawing illustrates the construction of a petal frame. It includes several views:

- Elevations:** Top and side views showing the frame's profile and internal components like the '119a' and '119b' parts.
- Section A-A:** A cross-section showing the internal structure and the placement of the '119a' and '119b' parts.
- Section B-B:** Another cross-section showing the internal structure and the placement of the '119a' and '119b' parts.
- Section C-C:** A cross-section showing the internal structure and the placement of the '119a' and '119b' parts.

BILL OF MATERIAL FOR ONE BUILD FRAME OF PETALS

Part No.	Part Name	Part Size	Part Qty	Part Unit	Part Weight	Part Volume	Part Cost
119a	PLT1075	1075	1	mm	1.00	1.00	1.00
119b	PLT1075	1075	1	mm	1.00	1.00	1.00
119c	PLT1075	1075	1	mm	1.00	1.00	1.00
119d	PLT1075	1075	1	mm	1.00	1.00	1.00
119e	PLT1075	1075	1	mm	1.00	1.00	1.00
119f	PLT1075	1075	1	mm	1.00	1.00	1.00
119g	PLT1075	1075	1	mm	1.00	1.00	1.00
119h	PLT1075	1075	1	mm	1.00	1.00	1.00
119i	PLT1075	1075	1	mm	1.00	1.00	1.00
119j	PLT1075	1075	1	mm	1.00	1.00	1.00
119k	PLT1075	1075	1	mm	1.00	1.00	1.00
119l	PLT1075	1075	1	mm	1.00	1.00	1.00
119m	PLT1075	1075	1	mm	1.00	1.00	1.00
119n	PLT1075	1075	1	mm	1.00	1.00	1.00
119o	PLT1075	1075	1	mm	1.00	1.00	1.00
119p	PLT1075	1075	1	mm	1.00	1.00	1.00
119q	PLT1075	1075	1	mm	1.00	1.00	1.00
119r	PLT1075	1075	1	mm	1.00	1.00	1.00
119s	PLT1075	1075	1	mm	1.00	1.00	1.00
119t	PLT1075	1075	1	mm	1.00	1.00	1.00
119u	PLT1075	1075	1	mm	1.00	1.00	1.00
119v	PLT1075	1075	1	mm	1.00	1.00	1.00
119w	PLT1075	1075	1	mm	1.00	1.00	1.00
119x	PLT1075	1075	1	mm	1.00	1.00	1.00
119y	PLT1075	1075	1	mm	1.00	1.00	1.00
119z	PLT1075	1075	1	mm	1.00	1.00	1.00

PRINCIPLE: Petals with spider arrangement give shape in position for other parallelly placed petals with tie members

STEPS TO BE FOLLOWED:

- 1) Prepare one petal with spider sturdy arrangement .
- 2) Other petals which will be placed parallel to step-1 petal need not have spider arrangement.
- 3) Place bed wood sleepers on trailer for protect the L-seam edge preparation of petals.
- 4) Load the step-1 petal on trailer in such a way that the ring stiffener is close to bed.
- 5) Place step-2 petals parallel to step-1 petal & secure the petals with wood churk in between.
- 6) Tie the unsipder petals with spidred petals by the members as shown. (2 Locations on each end of petals)
- 7) Individual petals to be lay arrangement for handling (At least two numbers to match CG of petals).
- 8) Lash tighten the entire consignment with trailer.

1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100	PROJECT	8032/8043/8044/8045/8047 TO 8050			
		BHARAT HEAVY ELECTRICALS LTD., PLATES & VESSELS PLANT UNIT, VISAKHAPATNAM-530012			
	DRAWN CHECKED APPROVED DATE	TITLE COAL BUNKER CYLINDRICAL PORTION TRACTION ARRANGMENT STYLE-2 FOR ADANI 800MW			
	05.07.2025	DRG NO. 1-66-102-U0038			
		SCALE: 1:25 T.S.			02