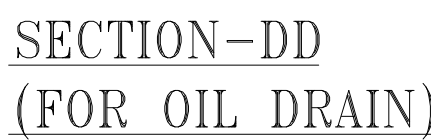




FABRICATED WEIGHT INCLUDING WELDMENT = 30610 KG.

[illegible]

ADDITIONAL INFORMATION WDO 36201 TO OR A 23157 WDO 36210 TO OR A 23157 STAGE-3			mRfkn dk i-dwJ jk xx-ggshvngvdk dk uke PALAMURU RANGAREDDY LHS STAGE-2A			HMS-713710-124K RANGAREDDY LHS STAGE-2A (MEIL/TSGENCO)					
STATUS OF DRAWING U			NAME OF CUSTOMER/PROJECT HAsP gsh vbydV&Yt (yefw)H HAskisy BHARAT HEAVY ELECTRICALS LTD. BHOPAL			USED NAME RKP N/S /AKV RC			USED PRODUCT (fused) (fused) (fused) 00.09.20 00.09.20 00.09.20		
DISTRIBUTION OF PRINTS HGE - 1 TEX - 1 HGM - 2 FWM - 2			DATE 403 3 250 00 01 404			HAsP HAsP RET. TO ADDY 350 1 257 01 89604			001		
REV. DATE CHECKED APPROVED			DATE 403 3 250 00 01 404			HAsP HAsP RET. TO ADDY 350 1 257 01 89604			001		
BOTTOM BRACKET CENTRE ASSEMBLY (FABRICATION)			0 257 01 89601			001			001		



TECHNICAL REQUIREMENTS:-

1. ALL WELDS ARE CONTINUOUS AND 15 MM FILLET UNLESS OTHERWISE STATED.
2. ALL WELDS SHALL BE AS PER GR-III OF AA0622101 UNLESS OTHERWISE STATED.
3. ALL OIL-TIGHT WELDS SHALL UNDERGO D.P. TESTING AS PER BP0850199 AFTER FIRST ROOT RUN AND AFTER COMPLETE WELDING. THE OIL-TIGHT WELDS SHALL BE PROTECTED WITH TRP BHARAT TC PF 4 AS PER BP05188. THE OIL-TIGHT WELDS SHALL BE PAINTED ONLY AFTER THE COMPLETION OF GRAVITY TESTING AS PER BP0850095.
4. FOR GRAVITY TESTING, REFER DRG.NO. 1 263 52 89611.
5. THE MACHINED FACES OF ITEM 5 ARE TO BE KEPT PARALLEL TO THE BRACKET AXIS DURING WELDING (VERTICALLY WITHIN 2 MM).
6. THE PRE-MACHINED FACES OF ITEM 13 ARE TO BE LEVELLED USING A WATER LEVEL AND TACK WELDS. RE-CHECK THE LEVELLING BEFORE FINAL WELDING.
7. BEFORE WELDING ITEMS 5, 21, 22, 23, & 24, STRESS RELIEVE THE ASSEMBLY AS PER BP0640299. ALL TAPPED HOLES AND MACHINED SURFACES ARE TO BE PROTECTED DURING STRESS RELIEVING.
8. ALL FLANGES TO BE WELDED IN ACCORDANCE WITH DRG. 3 263 03 01005.
9. DIMENSIONS MARK THUS * ARE FOR D.O. REFERENCE ONLY.
10. APPLY TRP ON MACHINED SURFACES TO BP 0690084.
11. ALL PLATES (40 MM AND ABOVE) TO BE ULTRASONICALLY TESTED TO AA0850120 BEFORE WELDING.
12. PAINTING SHALL BE CARRIED OUT AS PER HG12007.
13. DP TEST TO BP 0850199 OF THE COMPLETE LENGTH OF EACH WELD SHALL BE CARRIED OUT AFTER S.R.
14. DIMENSIONS MARKED (C/Q) ARE CRITICAL AND MUST BE MAINTAINED.

[illegible]

DRAWING NO. OF GRAVITY
TESTING UPDATED.