

FIRST ANGLE PROJECTION

2

3

4

5

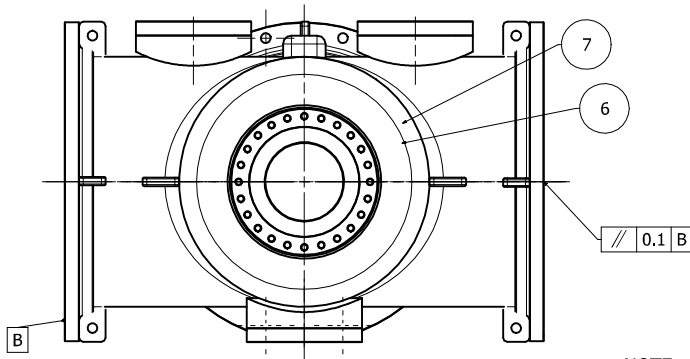
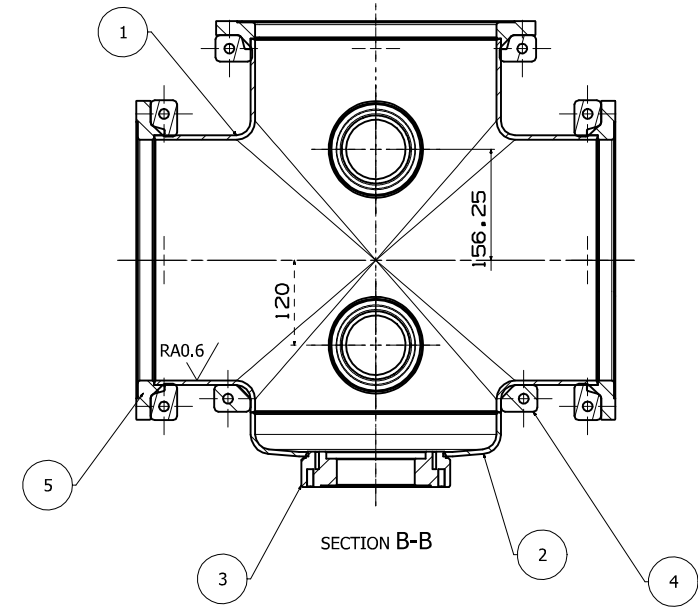
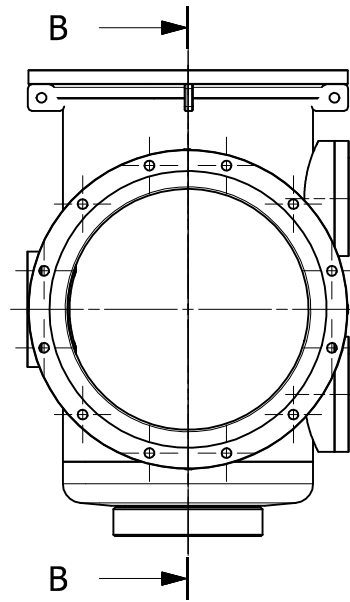
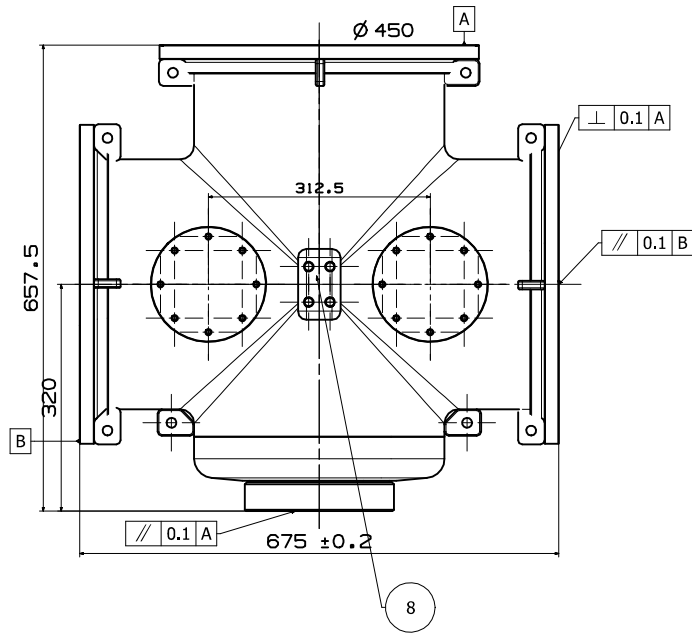
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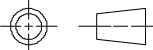
DRG NO.

ALL DIMENSIONS ARE IN MM

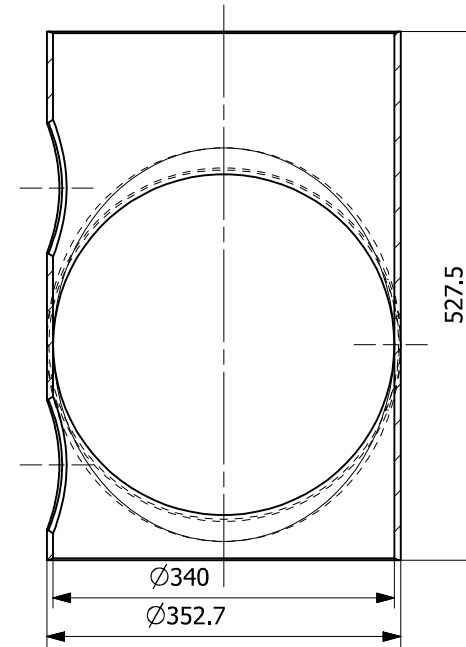
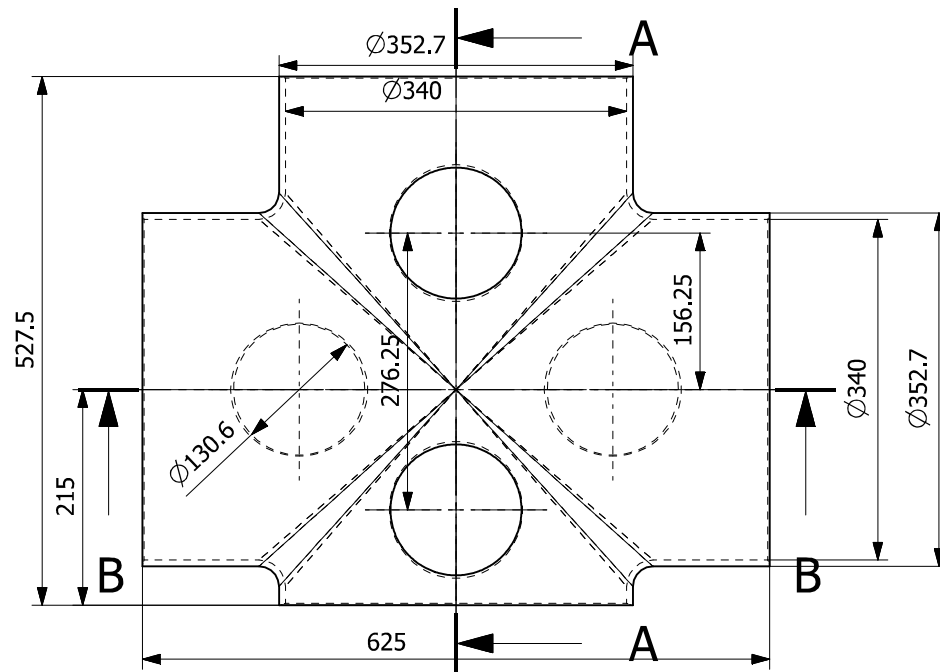


NOTE:

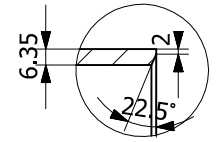
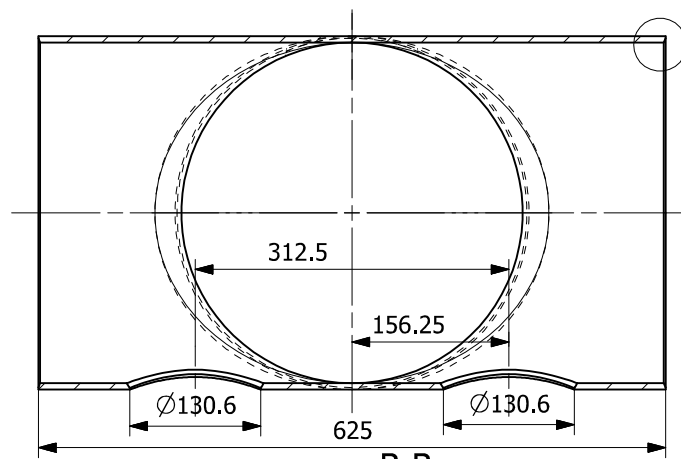
1. PIPE AND FLANGE TO BE MIG/TIG WELDED WITH SUITABLE SS ELECTRODE
2. THE ROOT SHOULD BE HOMOGENEOUS AND CONTINUOUS.
3. TESTED ASSEMBLIES TO BE DEGREASED, SAND BLASTED AND POWDER COATED ON OUTSIDE.
4. ELECTRO POLISH INSIDE SURFACE.

		8	EARTHING PLATE		RDDG43505170080				SS304L				1		
		7	GAS VALVE COVER		RDDG43506170983A				SS304L				2		
		6	FLANGE III		RDDG43511334160				SS304L				4		
		5	FLANGE II		RDDG43505681013				SS304L				3		
		4	LIFTING LUGS		RDDG43505172013				SS304L				16		
		3	FLANGE VI		RDDG43505172133				SS304L				1		
		2	DISH		RDDG43505172134				SS304L				1		
		1	PIPE		RDDG43505172132				SS304L				1		
VAR. NO.	REMARKS	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT. NO.	VAR .	MATL. CODE	MATL. SPCLN.	Δ C	UNIT	UNIT WT.	QTY	GS	ZONE
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT						GSM - 245									
BHARAT HEAVY ELECTRICALS LIMITED, CORPORATE R & D, HYDERABAD									NAME	SIGN.	DATE	NO. OF VAR			
								DRN.	NSK		06.11.19				
								CKD.	NT		06.11.19				
								APPD.	MMR		06.11.19				
DPT.GSG		UNTOL. DMS. GR.				SCALE	WEIGHT(K.G.)	REF. TO ASSY. DRG.		ITEM NO.		NO. OF ITEMS			
CODE 35		NTS				RDDG4350517 2130									
TITLE								DRAWING NO.				REV NO.			
ES ENCLOSURE								RD DG 4 35 1131 2131				-			
								SHT NO. 2		NO. OF SHT. 4					

DRAWING NO.

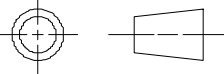


SECTION A-A

DETAIL C
SCALE 1:2

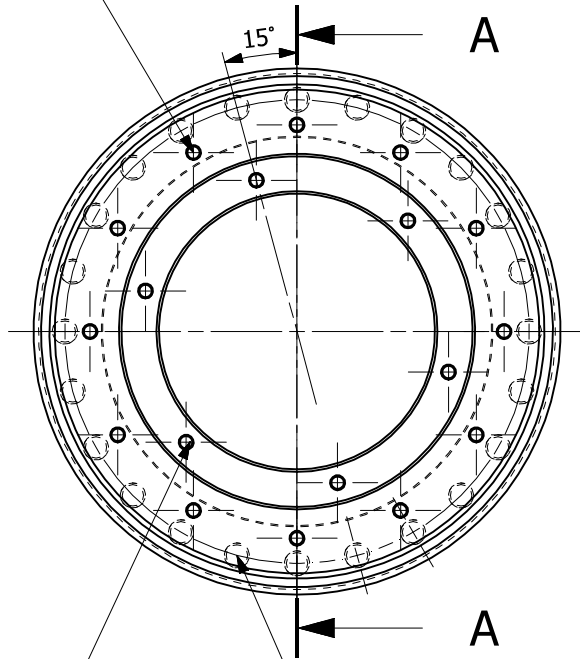
SECTION B-B

C

		PIPE		RDDG43505172132						SS304 L							
VAR. NO.	REMARKS	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT. NO.	VAR.	MATL. CODE	MATL. SPCN.	A/C	UNIT	UNIT WT.	QTY	GS	ZONE		
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT						GSM - 245											
 BHARAT HEAVY ELECTRICALS LIMITED, CORPORATE R & D, HYDERABAD						DRN.		NAME		SIGN.		DATE		NO. OF VAR			
								NSK				06.11.19					
								CKD.		NT		06.11.19					
						APPD.		MMR				06.11.19					
DPT.GSG		UNTOL. DMS. GR.				SCALE		WEIGHT(K.G.)		REF. TO ASSY. DRG.		ITEM NO.		NO. OF ITEMS			
CODE 35		NTS															
TITLE										DRAWING NO.				REV NO.			
PIPE										RD DG 435 0517 2132				-			
										SHT NO. 1				NO. OF SHT. 1			

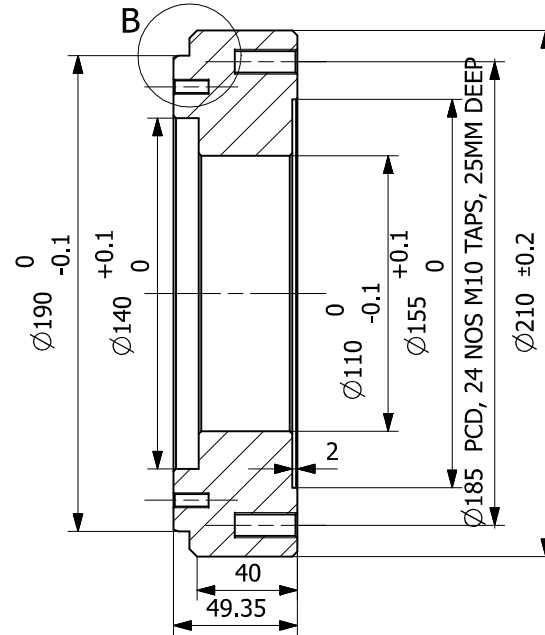
DRAWING NO.

12 NO. M6 TAPS AT 165 PCD, 14 DEEP

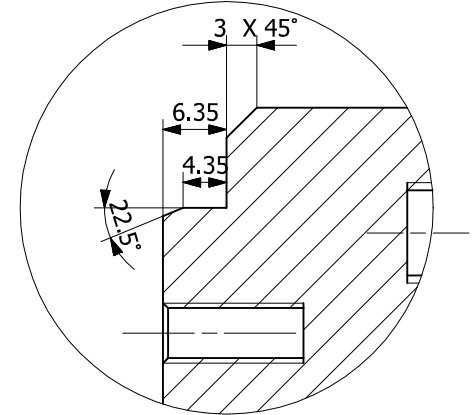


24 NO. M10 TAPS AT 185 PCD, 25 DEEP

6 NO. M6 TAPS AT 125PCD, 15 DEEP

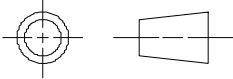


SECTION A-A

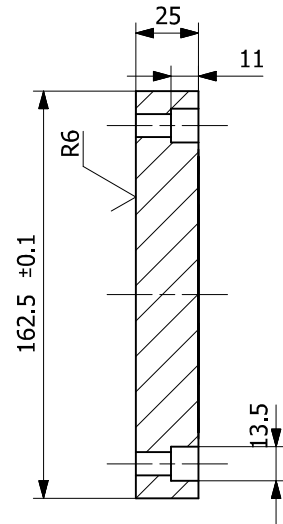
DETAIL B
SCALE 2:1

NOTE:

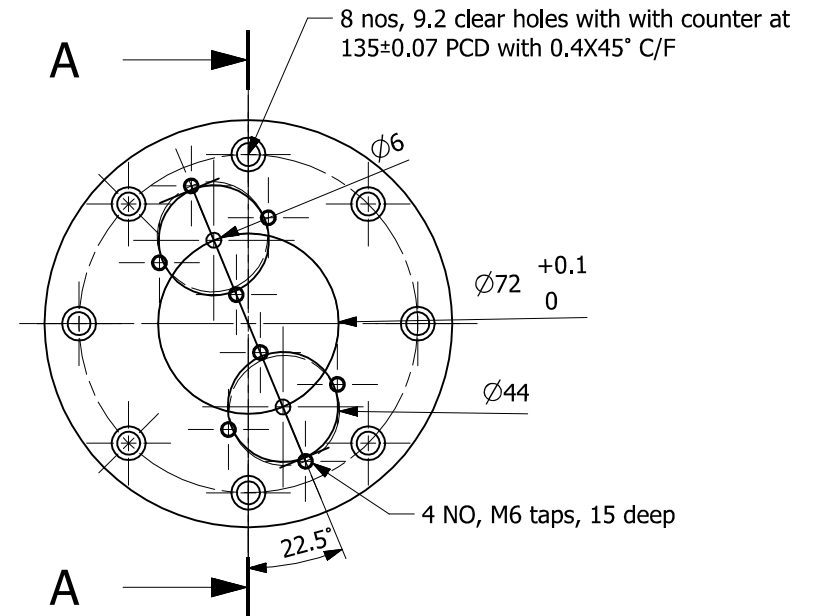
1. SEALING AREA SHALL BE POLISHED TO RA0.8 OR BETTER.
2. HOLES SHALL BE CHAMBERED UNIFORMLY (0.8X45°).
3. PCD AND FLANGE CENTRE SHALL BE CONCENTRIC WITHIN ± 0.5 .
4. FINISHED FLANGE SHALL BE DEGREASED AND PACKED IN 125 MICRON POLY BAG AND SEALED.
5. COMPONENT SHALL BE MACHINED TO DIMENTIONS AFTER WELDING TO SPHERICAL PIPE.

		SS BLOCK		Ø350X45				SS304L							
VAR. NO.	REMARKS	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT. NO.	VAR.	MATL. CODE	MATL. SPCN.	A/C	UNIT	UNIT WT.	QTY	GS	ZONE
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT															
 BHARAT HEAVY ELECTRICALS LIMITED, CORPORATE R & D, HYDERABAD										NAME	SIGN.	DATE	NO. OF VAR		
									DRN.	NSK		10.01.20			
									CKD.	NT		10.01.20			
									APPD.	MMR		10.01.20			
DPT.GSG		UNTOL. DMS. GR.				SCALE	WEIGHT(K.G.)		REF. TO ASSY. DRG.		ITEM NO.		NO. OF ITEMS		
CODE 35						NTS	8.5								
TITLE									DRAWING NO.				REV NO.		
FLANGE VI									RD DG 435 0517 2133				-		
									SHT NO. 1		NO. OF SHT. 1				

DRAWING NO.



SECTION A-A

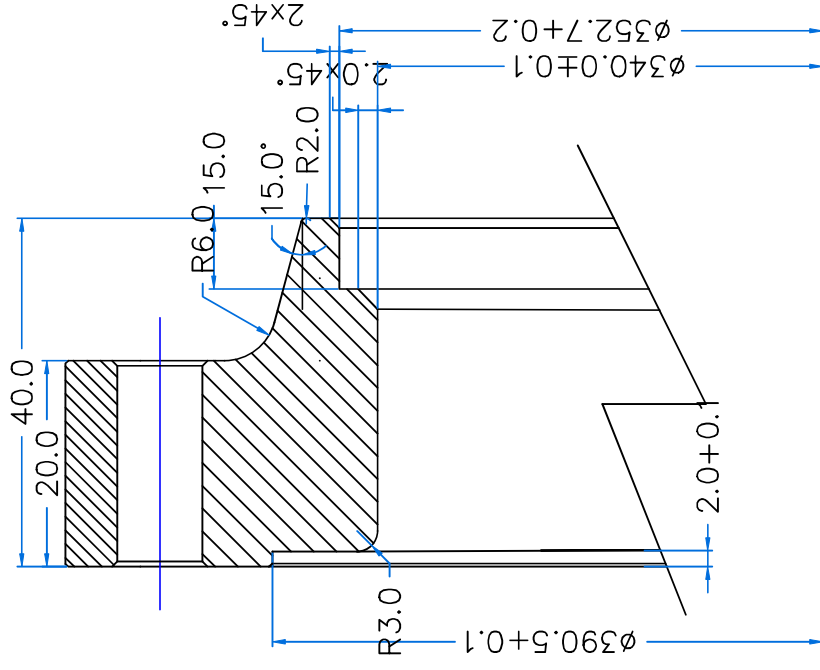
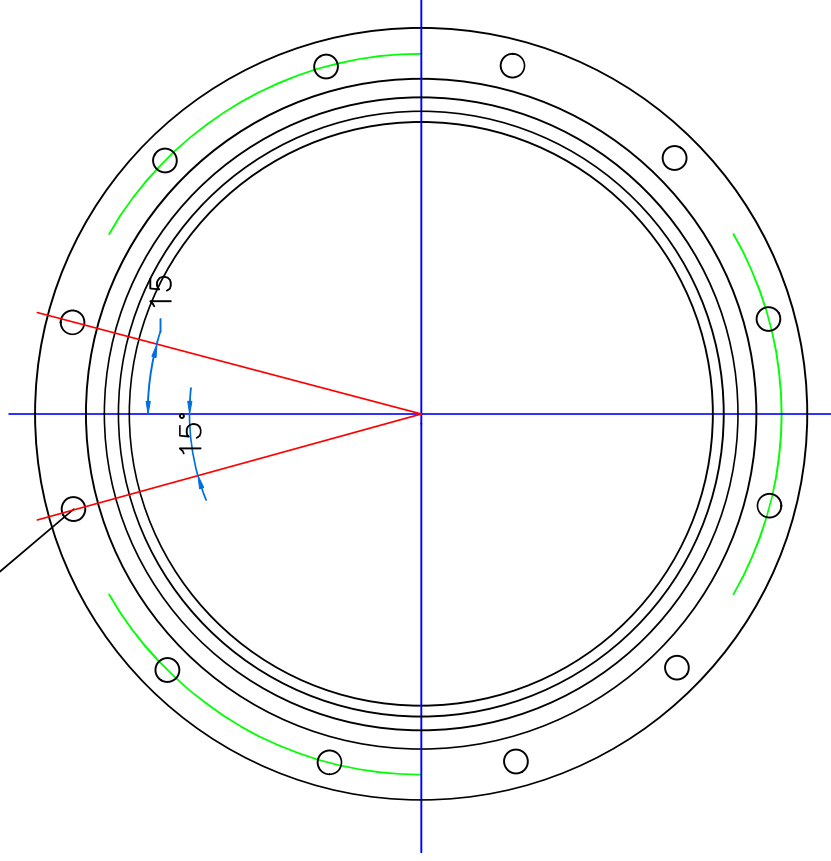
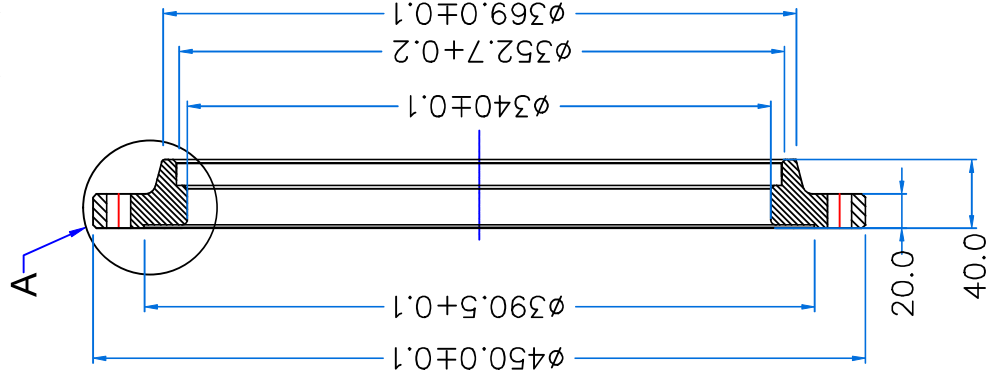


NOTE:

1. ALL SHARP EDGES SHALL BE MACHINED TO 0.4X45°

VAR. NO.	REMARKS	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT. NO.	VAR.	MATL. CODE	MATL. SPCN.	SS 304	A	C	UNIT	WT.	QTY	GS	ZONE
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT										GSM - 245							
 BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL										DRN.	NAME	SIGN.	DATE	NO. OF VAR			
										CKD.	NT		11.11.19				
										APPD.	MM RAO		11.11.19				
										DPT.GSG					UNTOL. DMS. GR.		
CODE 35								NTS			RDDG43505170001						
TITLE										DRAWING NO.		REV NO.					
GAS VALVE COVER										RD DG 435 0617 0983A							
										SHT NO. 1		NO. OF SHT. 3					

12 Nos ø14 Clear holes @PCD 420.0±0.1



ENLARGED VIEW 'A'

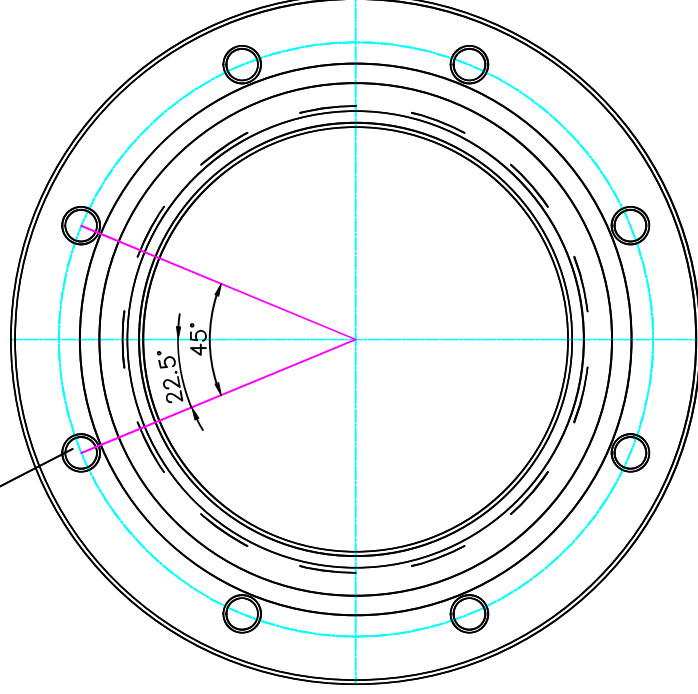
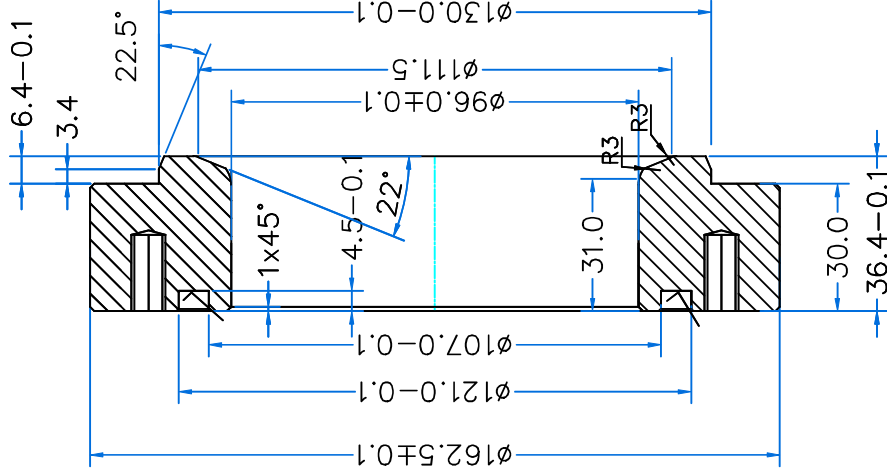
INVENTORY NO.	SIGN. AND DATE	REF. DRG. NO.
_____	_____	_____

[illegible]

(ALL DIMENSIONS ARE IN mm)

DRG. NO.
RD DG 4 35 1133 4160

8 No. M8 TAPS @ 135.0 PCD, 20.0 deep



ALL SHARP EDGES SHALL BE MACHINED TO 0.4x45°.
MARKED SURFACE SHALL BE FINISHED TO RA0.8

INVENTORY NO.	SIGN. AND DATE	REF. DRG. NO.

	VAR.00
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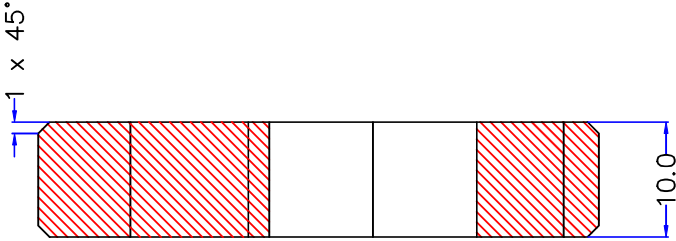
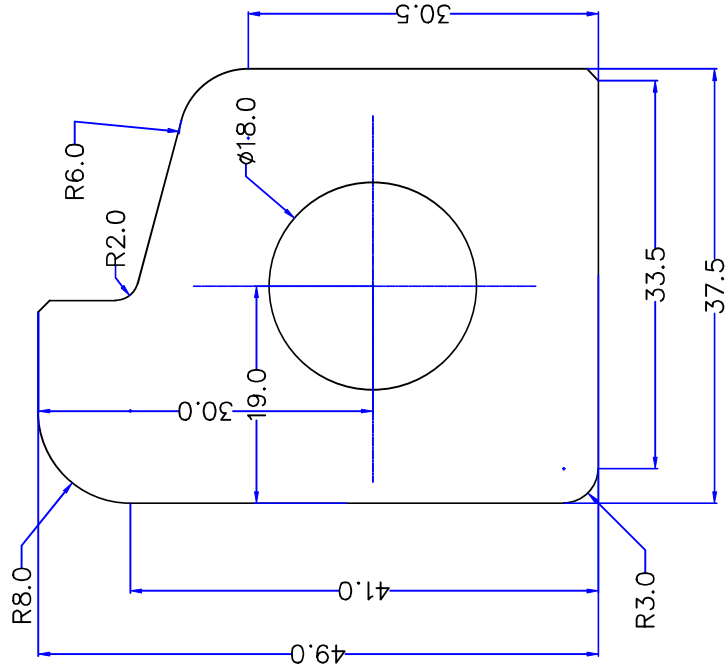
			01
		VAR NO.	ITEM NO.

DESCRIPTION	SS BLANK	Q18
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	DRAWING NO.
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		SS-304L	
	IT.NO.	MATL. CODE	
	VAR	MATL. SPECN.	

[illegible][illegible]



01	SS PLATE	SS-304L	08
VAR. NO.	ITEM NO.	DESCRIPTION	DRAWING NO.
REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION
IT. NO.	MATL. CODE	MATL. SPECN.	UNIT WT.
ZONE	VAR.	C	QTY.

GSM-245

TYPE OF PRODUCT
NAME OF CUSTOMER

NAME	DRN	SIGN.	DATE	NO. OF
NSK	NSK		23.05.13	VAR.
BSM	BSM		23.05.13	01
IMRAO	IMRAO		23.05.13	NO. OF
REF. TO	REF. TO	REF. TO	REF. TO	ITEM
RD DG 4 35 0517 2000	RD DG 4 35 0517 2000	RD DG 4 35 0517 2000	RD DG 4 35 0517 2000	5
CARD CODE	CARD CODE	CARD CODE	CARD CODE	REV.
RD DG 4 35 0517 2013	RD DG 4 35 0517 2013	RD DG 4 35 0517 2013	RD DG 4 35 0517 2013	
SHEET NO.	SHEET NO.	SHEET NO.	SHEET NO.	NO. OF SHEETS

ALL SHARP EDGES SHALL BE MACHINED TO 0.4x45°

BHARAT HEAVY ELECTRICALS LTD.
HYDERABAD

SCALE
NTS

WEIGHT(KG)

REF. TO

REF. TO

REF. TO

REF. TO

DRG. NO.
RD DG 4 35 0517 2134

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IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

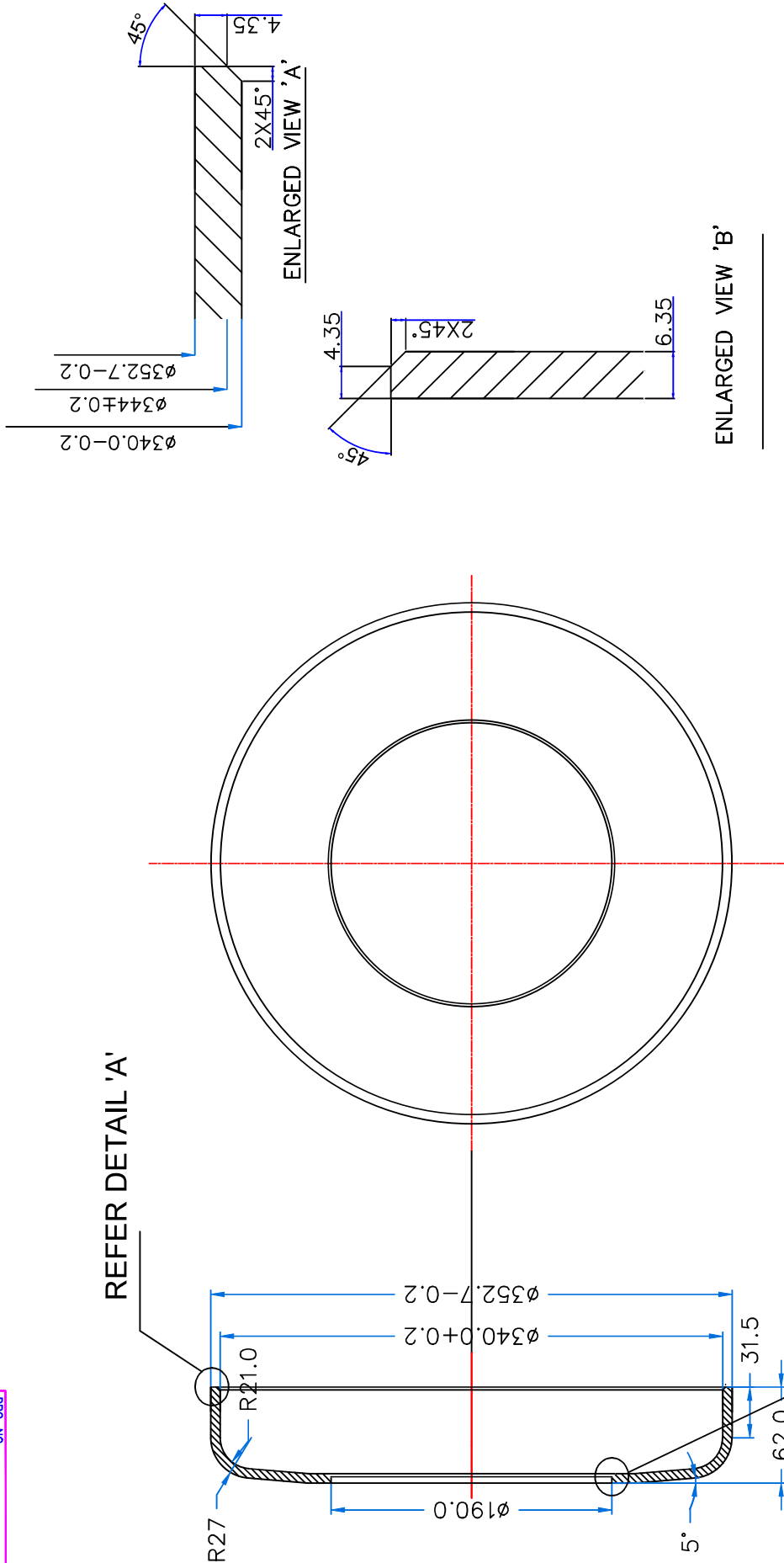
REF. DRG. NO.

SIGN. AND DATE

INVENTORY NO.

REFER DETAIL 'A'

REFER DETAIL 'B'



REV.	DATE	ALTERED	CHECKED	ZONE	REV.	DATE	ALTERED	CHECKED	ZONE
01					01				

VAR. NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	VAR.	IT. NO.	MATL. CODE	SS-304L	UNIT WT.	QTY.	ZONE

ALL SHARP EDGES SHALL BE MACHINED TO 0.4x45°
DISH SHALL BE PREPARED WITH SUITABLE DIE.

GSM-245

TYPE OF PRODUCT	NAME OF CUSTOMER	DRN	NAME	SIGN.	DATE	NO. OF
		CKD	NSK		14.10.13	VAR.
		APPD	BSM		14.10.13	
			MMRAO		14.10.13	01

DEPT.	GRADE OF	SCALE	WEIGHT(KG)	REF. TO	ITEM NO.	NO. OF
	TOL. DIM.					ITEMS
	C/M/F					

TITLE	CARD CODE	DRAWING NO.	REV.
DISHI		RD DG 4 35 0517 2131	1

MODIFIED ON 28/10/17	ZONE	NO. OF SHEETS
		RD DG 4 35 0517 2134