

326825/2024/HEP-IMM20400

INSULATION SKETCH

IN.SK. 30078

BHO PAL

INSULATION SYSTEMS ENGINEERING

Rev.No: 03

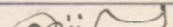
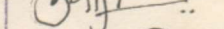
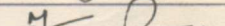
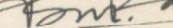
MANUFACTURE OF GLASS FIBRE SUPPORT RING

Rev.Dt: 20/08/98

Sht. 1 of 1 Sht

1. GENERAL:
Support rings will be wound on suitable former to give the section and diameters as specified in the relevant drgs.
2. MATERIALS:
 - 2.1 Glass Roving: Continuous glass roving to BP 25693 shall be used.
 - 2.2 Polyester Resin System:- Polyester resin, Catalyst and Accelerator shall be as per BP 27696.
 - 2.3 Release Agent: A suitable release agent like silicone release compound, petroleum jelly or wax can be used.
3. PREPARATION OF THE RESIN:
The mixing ratio of resin, catalyst and accelerator shall be as per BP 27696.
4. WINDING:
Mount the former on a winding machine. Apply a thin and uniform coat of release agent to the winding surfaces of the former. Wind continuous filament roving BP 25693 impregnated with the resin system, under proper tension to produce a component which after curing has a glass content of minimum 50% by weight. Allow the ring to cure at R/T in the former for 12 hours minimum. Remove the ring from the former and post cure in an oven at $100^{\circ} \pm 5^{\circ}\text{C}$ for 3 to 4 hours. Clean the high spots and loose glass fibres on the rings by sand paper. Apply a finishing coat of polyester resin (cl 2.2 and 3) on the ring and allow to dry.
5. INSPECTION:
Max permissible tolerances on nominal internal diameter and variation in flatness on the rings when laid on a smooth surface shall be as follows:
 ≤ 1000 mm ring - ± 1.5 mm.
 > 1000 mm upto 1500 mm ring - ± 2.5 mm.
 > 1500 mm ring - ± 3.0 mm.

Note: All corners of the support ring must have radii as specified in the drg.

Distribution:				Date of Rev.00:10/03/69	Name	Signature
IMM-PLANNING	1	IMM-TCX	1	Prepared by	A. Tijare	
LEM-PLANNING	1	HRP-TCX-LEM	1	Checked by	K.N.Das	
HRP-PLANNING	1	HRP-TCX-HYDRO	1	Approved by	S.Karthikeyan	
AME	1	HGE	1	Issued by	A. Tijare	

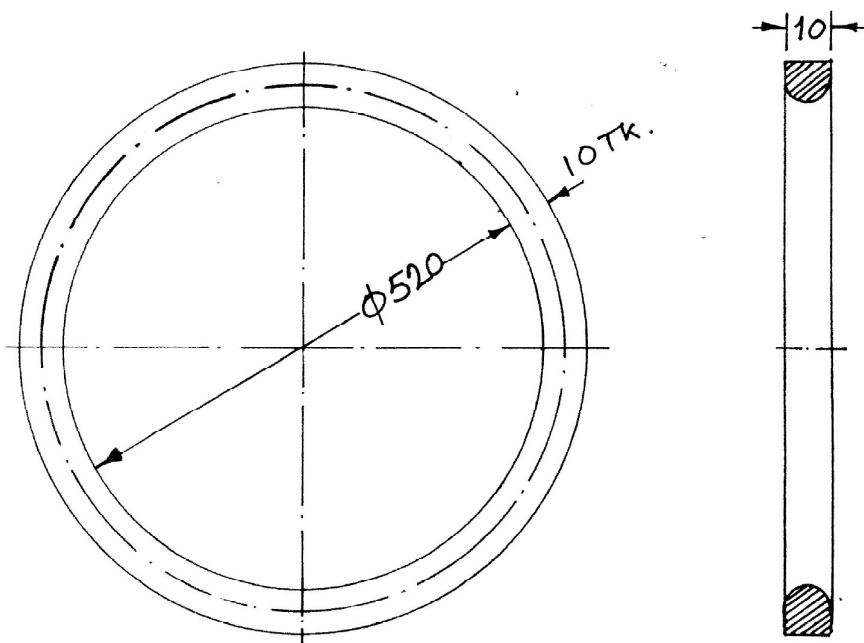
ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE STATED

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm.)

7

REV. 01	DATE 17/7/83	ALTERED	CHECKED	ADDITIONAL INFORMATION
25/2024/HBP-IMM20400				STATUS OF DRAWING
RING WT. WAS NOT ON				DISTRIBUTION OF PRINTS
				O.C-1
				IMM-4
				TCX/IMM-1
				AME-1



64	63	62	53	52	51	22	18	20	22	23	34	35	36	39	50	58	53	64	65	73	79	80
QTY.	BASIC	UNIT OF QTY.	DESCRIPTION	ITEM NO.	STD.	DRAWING NO.	MATERIAL CODE	MATERIAL SPECN	UNIT WT (Kg)	QTY	RM/GSP	DI										
235.58			Glass Reinforced Polyester Moulding	1			IN-SK.30078-A															

CARD TYPE 2

CARD TYPE 1



BHARAT HEAVY ELECTRICALS LIMITED
BHOPAL

DEPT. ISE	CODE 419	SCALE NTS.	WEIGHT (Kg.)	REF. TO ASSY. DRG.	ITEM NO.
TITLE			DRAWN	NAME	SIGN.
WINDING SUPPORT RING			CHECKED	NK	12.85
DIMENSIONS TO BE CONTROLLED WITHIN LIMITS AS SHOWN			DRAWING NO.		
MACHINING TOLERANCE $\pm .25$ mm., UNLESS OTHERWISE SHOWN.			44026146042		
NON-MACHINING TOLERANCE \pm			SHEET NO.		
			NO. OF SHEETS :-		

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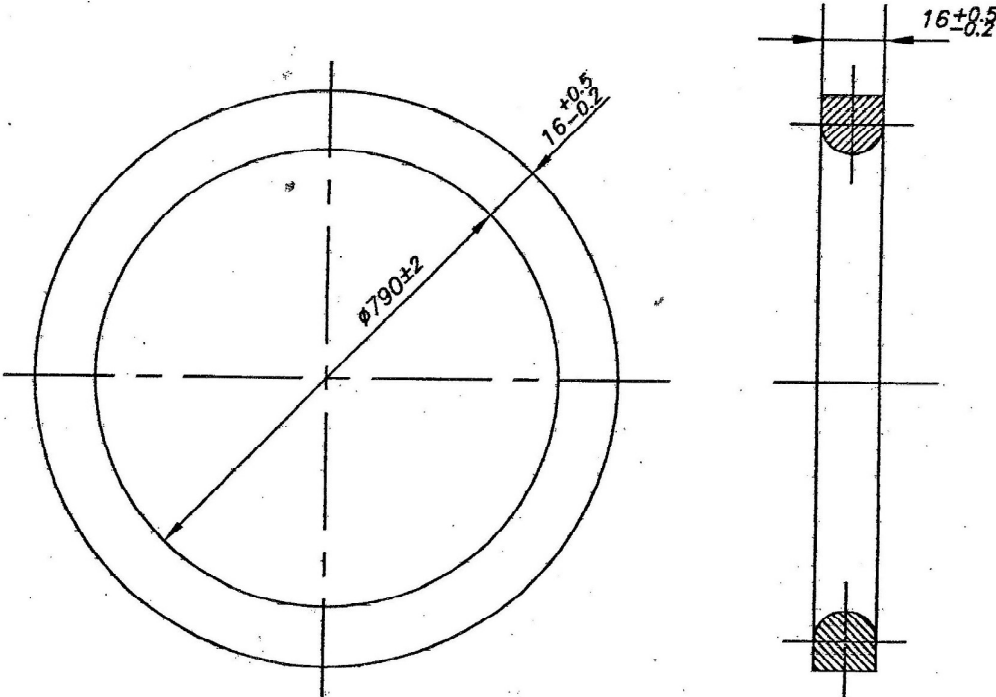
REF. DRG. NO.

SIGN & DATE

INVENTORY NO.

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm.)

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			CHECKED			CHECKED	W.O. 47132A401-21	
			APPROVED			APPROVED	STATUS OF DRAWING	
							DISTRIBUTION OF PRINTS	
						AME - 1 TEX (IMM) - 1		
						IMM - 3 CIM - 1		
								
USER2VX/HMA44026147125 REF. DRG. NO.	001	SUPPORT RING GLASS REINFORCED POLYESTER MOULDING			INSK 30078		106	
	REMARKS	ITEM NO.	DESCRIPTION			MATL. CODE	A UNIT	UNIT WT.
SIGN & DATE				MATL. SPECN.	C	QTY.		
INVENTORY NO.	BHARAT HEAVY ELECTRICALS LTD. BHOPAL			DRN	NAME	SIGN.	DATE	NO. OF ITEM
				CHD	MONU JHA	MJha	12-12-07	
			APPD	MKM	MKM	12-12-07		
				BA	BA	14/12/07		
DEPT. AME			UNTOL DIMS GR.	SCALE	WEIGHT(KG.)	REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEM
CODE 404				NTS	1.06		025	
TITLE			DRAWING NO.			REV		
WINDING SUPPORT RING			4 40261 47125			00		
1RC7563-6			SHEET NO. 1			NO. OF SHEETS 1		