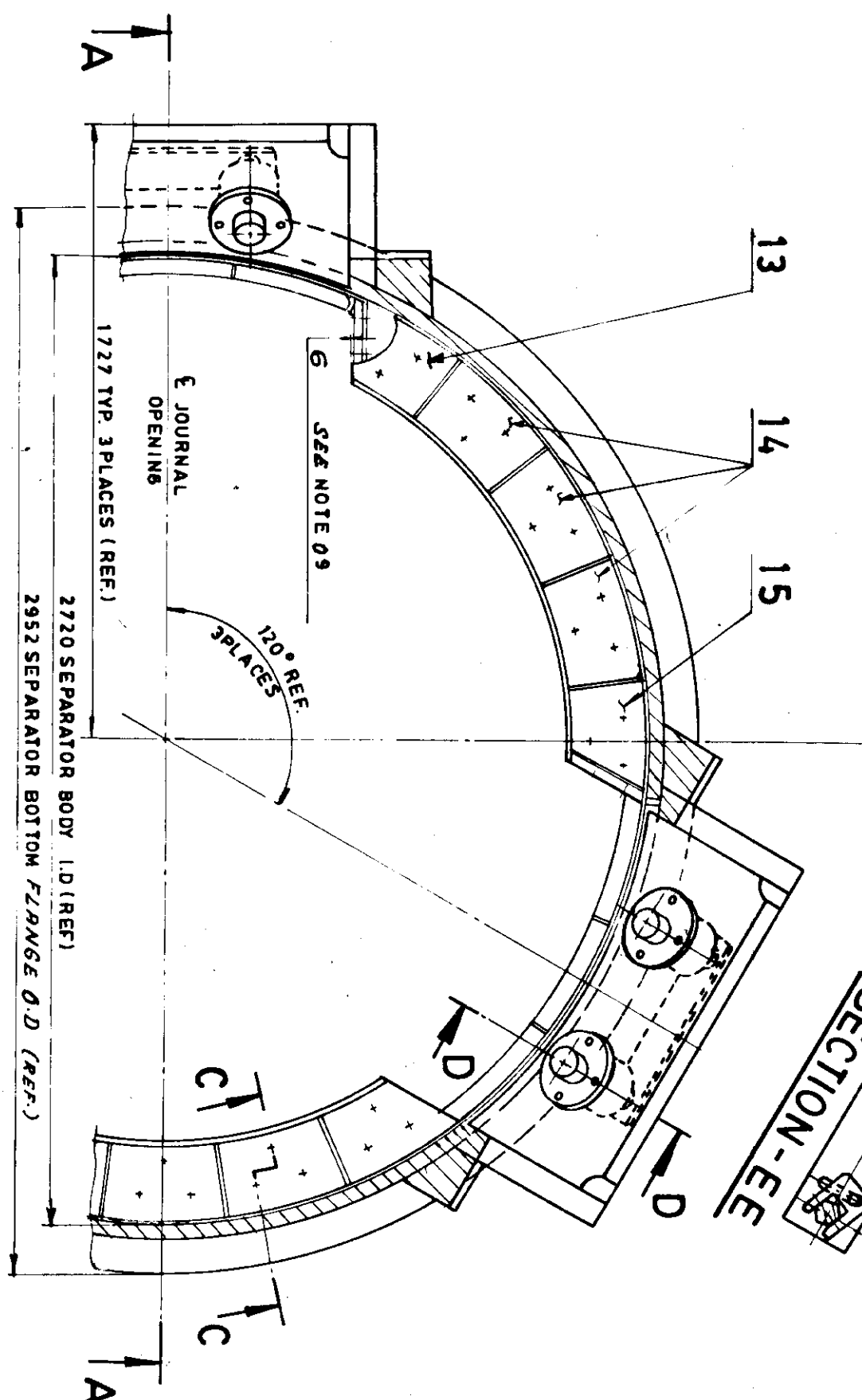
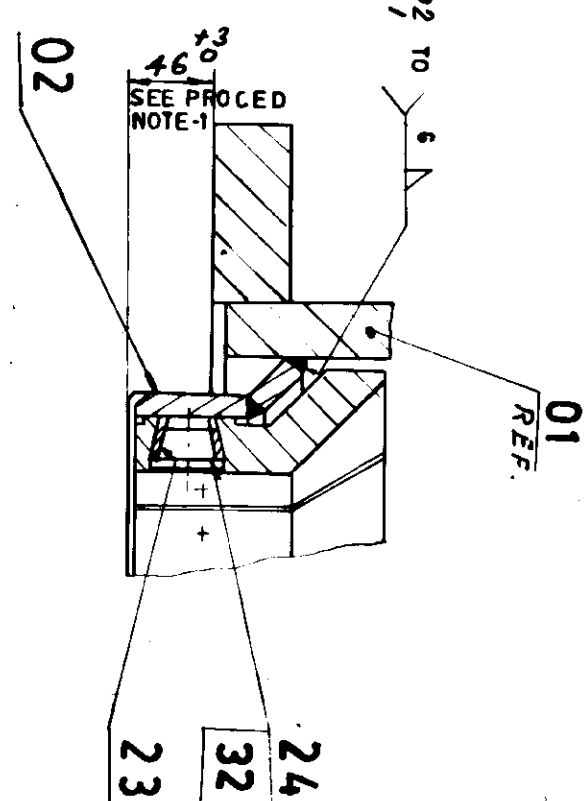


SECTION-AA

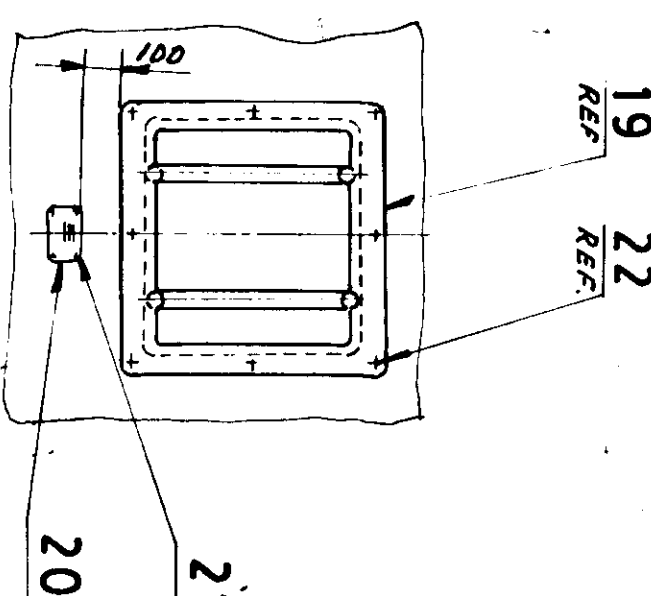


SECTION-BB

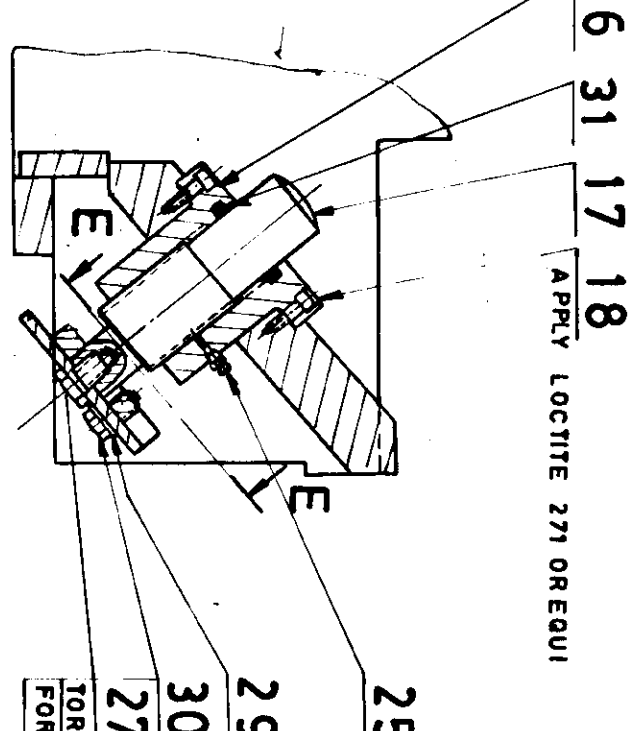
DETAIL-H



VIEW-GG



SECTION-DD



LINER INSTALLATION PROCEDURE

1. CENTER INTERMEDIATE SUPPORT PLATE (ITEM 02) WITH JOURNAL OPENING. MAINTAIN VERTICAL DIMENSION BEYOND SEPARATOR BODY FLANGE AS SHOWN & WELD INDICATED (TYP. 3 PLACES).
2. CENTER DEFLECTOR LINER SUPPORT PLATE (ITEM 03) BETWEEN INTERMEDIATE LINER SUPPORT PLATES (ITEM 02). MAINTAIN VERTICAL DIMENSION BEYOND SEPARATOR BODY FLANGE AS SHOWN & WELD AS INDICATED (TYP. 3 PLACES).
3. SEE DRG-M/3-61-370-00838 FOR APPLICATION OF WELD PLUGS (ITEM 23) STRICT COMPLIANCE IS REQUIRED.
4. INSTALL INTERMEDIATE LINERS (ITEMS 04, 05 & 06) WORKING FROM LEFT TO RIGHT MAINTAIN 4.2 GAP BETWEEN LINERS (TYP. 3 PLACES).
5. INSTALL DEFLECTOR SIDE LINER (ITEM 12) MAINTAIN 3.15 GAP FROM SEPARATOR BODY (ITEM 01) & INTERMEDIATE LINER (ITEM 04) LOWER FACE OF SIDE LINER SHOULD BE FLUSH WITH INNER RADIUS OF ITEM 04 (TYP. 3 PLCS).
6. INSTALL BOTTOM ROW OF DEFLECTOR LINERS (ITEM 07) INSTALL LINER (ITEM 07) ADJACENT TO INTERMEDIATE LINER (ITEM 04) & WORK FROM RIGHT TO LEFT. MAINTAIN A 4.2 GAP BETWEEN LINERS. TRIM LEFT LINER (ITEM 07) IF NECESSARY (TYP. 3 PLACES).
7. INSTALL CENTER ROW OF DEFLECTOR LINERS (ITEMS 09, 10 & 11) WORKING FROM RIGHT TO LEFT STARTING WITH ITEM 11 MAINTAIN A 4.2 GAP BETWEEN LINERS. TRIM LEFT LINER (ITEM 09) IF NECESSARY (TYP. 3 PLACES).
8. INSTALL TOP ROW OF DEFLECTOR LINERS (ITEMS 13, 14 & 15) WORKING FROM RIGHT TO LEFT STARTING WITH ITEM 15 MAINTAIN A 4.2 GAP BETWEEN LINERS. TRIM LEFT LINER (ITEM 13) IF NECESSARY (TYP. 3 PLACES).
9. INSTALL DEFLECTOR SIDE LINER (ITEM 08) MAINTAIN A 3.15 GAP BETWEEN THE FRONT EDGES OF THE DEFLECTOR SIDE LINER & THE BACKSIDE OF DEFLECTOR LINER (ITEMS 09 & 13). THE SEPARATOR BODY DEFLECTOR LINER EDGES SHOULD OVERHANG THE DEFLECTOR SIDE LINER BY APPROX. 61TYP. 3 PLACES).
10. FILL ALL GAPS BETWEEN LINERS WITH RIV SEALER (ITEM 33) OR EQUI.
11. AFTER WELD PLUG APPLICATION APPLY SILICONE CEMENT OR EQUI. TO CERAMIC PLUG (ITEM 24) AND INSTALL AS SHOWN.
12. TORQUE ALL HEX HD. CAP SCREWS AND APPLY LOCITITE PER DWG. 2.61-162-00817/01 AT FINAL ASSEMBLY.

CAUTION TO INSTALLER

STRICT COMPLIANCE WITH ASSEMBLY PROCEDURE 3.61-170-00838 IS MANDATORY. FAILURE TO DO SO MAY RESULT IN DAMAGE TO THESE AND OTHER THE COMPONENTS DURING OPERATION. FOR WHICH THE INSTALLER MUST ACCEPT FULL RESPONSIBILITY.

ITEM NO.	DESCRIPTION	STU.	DRAWING NO.	ITEM NO.	DESCRIPTION	STU.	DRAWING NO.
01	SEPARATOR BODY		0.61-380-00286	01	SEPARATOR BODY		0.61-380-00286
02	INTERMEDIATE LINER		1.61-380-00586	02	INTERMEDIATE LINER		1.61-380-00586
03	DEFLECTOR LINER		2.61-380-00832	03	DEFLECTOR LINER		2.61-380-00832
04	DEFLECTOR LINER		2.61-380-00832	04	DEFLECTOR LINER		2.61-380-00832
05	DEFLECTOR LINER		2.61-380-00832	05	DEFLECTOR LINER		2.61-380-00832
06	DEFLECTOR LINER		2.61-380-00832	06	DEFLECTOR LINER		2.61-380-00832
07	DEFLECTOR LINER		2.61-380-00832	07	DEFLECTOR LINER		2.61-380-00832
08	DEFLECTOR LINER		2.61-380-00832	08	DEFLECTOR LINER		2.61-380-00832
09	DEFLECTOR LINER		2.61-380-00832	09	DEFLECTOR LINER		2.61-380-00832
10	DEFLECTOR LINER		2.61-380-00832	10	DEFLECTOR LINER		2.61-380-00832
11	DEFLECTOR LINER		2.61-380-00832	11	DEFLECTOR LINER		2.61-380-00832
12	DEFLECTOR LINER		2.61-380-00832	12	DEFLECTOR LINER		2.61-380-00832
13	DEFLECTOR LINER		2.61-380-00832	13	DEFLECTOR LINER		2.61-380-00832
14	DEFLECTOR LINER		2.61-380-00832	14	DEFLECTOR LINER		2.61-380-00832
15	DEFLECTOR LINER		2.61-380-00832	15	DEFLECTOR LINER		2.61-380-00832
16	DEFLECTOR LINER		2.61-380-00832	16	DEFLECTOR LINER		2.61-380-00832
17	DEFLECTOR LINER		2.61-380-00832	17	DEFLECTOR LINER		2.61-380-00832
18	DEFLECTOR LINER		2.61-380-00832	18	DEFLECTOR LINER		2.61-380-00832
19	DEFLECTOR LINER		2.61-380-00832	19	DEFLECTOR LINER		2.61-380-00832
20	DEFLECTOR LINER		2.61-380-00832	20	DEFLECTOR LINER		2.61-380-00832
21	DEFLECTOR LINER		2.61-380-00832	21	DEFLECTOR LINER		2.61-380-00832
22	DEFLECTOR LINER		2.61-380-00832	22	DEFLECTOR LINER		2.61-380-00832
23	DEFLECTOR LINER		2.61-380-00832	23	DEFLECTOR LINER		2.61-380-00832
24	DEFLECTOR LINER		2.61-380-00832	24	DEFLECTOR LINER		2.61-380-00832
25	DEFLECTOR LINER		2.61-380-00832	25	DEFLECTOR LINER		2.61-380-00832
26	DEFLECTOR LINER		2.61-380-00832	26	DEFLECTOR LINER		2.61-380-00832
27	DEFLECTOR LINER		2.61-380-00832	27	DEFLECTOR LINER		2.61-380-00832
28	DEFLECTOR LINER		2.61-380-00832	28	DEFLECTOR LINER		2.61-380-00832
29	DEFLECTOR LINER		2.61-380-00832	29	DEFLECTOR LINER		2.61-380-00832
30	DEFLECTOR LINER		2.61-380-00832	30	DEFLECTOR LINER		2.61-380-00832
31	DEFLECTOR LINER		2.61-380-00832	31	DEFLECTOR LINER		2.61-380-00832
32	DEFLECTOR LINER		2.61-380-00832	32	DEFLECTOR LINER		2.61-380-00832
33	DEFLECTOR LINER		2.61-380-00832	33	DEFLECTOR LINER		2.61-380-00832
34	DEFLECTOR LINER		2.61-380-00832	34	DEFLECTOR LINER		2.61-380-00832

TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT

Bharat Heavy Electricals Ltd.
BOLAR PLANT UNIT
TIRUCHIRAPPALLI - 620 014

DATE
17/03/2016
CHECKED
S. S. S. S.
ITEM NO. 34 ADDED

SEPARATOR BODY
ASSEMBLY

1.61-380-00547 01

REPLACED