

INVENTORY NO
SIGN AND DATE
REF. DRG. NO
COMPUTER FILE NAME
16100644.DWG

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123456789101112

DRG. NO
1-61-366-00644

WPS:WE006

VIEW-B

SECTION-CC

SECTION-AA

J3

ASSEMBLY PROCEDURE:

1. CENTER INTERMEDIATE LINER SUPPORT PLATE (ITEM 3) WITH JOURNAL OPENING MAINTAINING 65mm VERTICAL DISTANCE BEYOND SEP BODY FLANGE AND WELD AS SHOWN (TYP. 3 PLACES)

2. CENTER DEFLECTOR LINER SUPPORT PLATE (ITEM 2) BETWEEN INTERMEDIATE SUPPORT PLATES MAINTAINING 65mm VERTICAL DISTANCE BEYOND SEP BODY FLANGE AND WELD AS SHOWN (TYP. 3 PLACES)

3. INSTALL INTERMEDIATE LINER (ITEMS 12 & 13) WORKING FROM LEFT TO RIGHT.MAINTAIN APPROX. 3 mm GAP BETWEEN LINERS. (TYP 3 PLACES)

4. INSTALL DEFLECTOR SIDE LINER (ITEM 10). MAINTAIN APPROX. 3mm GAP WITH SEPARATOR BODY (ITEM 1).TRIM IF REQUIRED TO SUIT INTERMEDIATE LINER

5. INSTALL BOTTOM ROW OF DEFLECTOR LINERS (ITEM 09).WORK FROM LEFT TO RIGHT STARTING ADJACENT TO INTERMEDIATE LINER.

6. INSTALL MIDDLE ROW OF DEFLECTOR LINERS (ITEMS 07& 08) WORKING FROM LEFT TO RIGHT .

7. INSTALL TOP ROW OF DEFLECTOR LINERS (ITEMS 04,05 & 06) WORKING FROM LEFT TO RIGHT.

8. INSTALL DEFLECTOR SIDE LINER (ITEM 11). FRONT EDGES OF DEFLECTOR SIDE LINER ARE APPROX 3MM FROM BACK SIDE OF DEFLECTOR LINERS (ITEMS 04 & 08). DEFLECTOR LINERS SHOULD OVERHANG APPROX.10 MM. (TYP 3 PLACES)

9. SEE DRG 3-61-370-00838 FOR APPLICATION OF WELD PLUGS (ITEM 5)

10. AFTER WELD PLUG APPLICATION APPLY SILICONE CEMENT TO CERAMIC PLUGS AND INSTALL AS SHOWN IN SECTION BB.

11. MAINTAIN APPROX 3mm GAP BETWEEN LINERS.TRIM LINERS IF REQUIRED. FILL THE GAP BETWEEN LINERS WITH RTV SEALER OR EQUI.

12. TORQUE ALL FASTENERS AND APPLY LOCTITE AT FINAL ASSY AS PER DRG. 2-61-262-00817

REV. DATE ALTERED

CHD./APPD.

REV. DATE ALTERED

CHD./APPD.

REV. DATE ALTERED

CHD./APPD.

01 5.12.01 E.M.ASHOK

01 5.12.01 N.D.S/S/G

01 5.12.01 N.D.S/S/G

B2

ITEM No.22 DRG No.WAS 3-61-376-00060&WT.WAS 43. TOTAL WT. WAS 4524.26

VIEW -B WAS VIEW-A

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED.

1. REF. TO HY0230261 FOR UNSPECIFIED TOLERANCES.

2. CHAMFER M/CD. SHARP EDGES 1.2 TO 1.0 AT 45°.

3. INTERNAL M/CD. CORNER RADII 1 TO 0.7

4. THE SURFACE ROUGHNESS WHERE-EVER NOT SHOWN SHALL BE TAKEN FROM THE SURFACE ROUGHNESS SHOWN OUT SIDE THE BACK SLASH GIVEN OR THE TOP MOST RIGHT CORNER OF THE DRG.

TYPE OF PRODUCT

NAME OF CUSTOMER/PROJECT

663-XRP BOWL MILL

DRN. E.M.ASHOK

CHD. N.D.SAMUEL

APPD. S.CHATGE

NAME

SIGN.

DATE

NO.OF VAR.

17.5.01

17.5.01

DEPT. PULV ENGS

CODE 446

UNTOL DIMS. GR.

Q/M/F

SCALE

NTS

WEIGHT (KG)

4581.42

REF. TO ASSY DRG.

ITEM NO.

NO.OF ITEMS

1

1

TITLE

SEPARATOR BODY AND LINER ASSY

CARD CODE

DRAWING NO.

1-61-366-00644

REV.

01

SHEET NO.

NO OF SHEETS