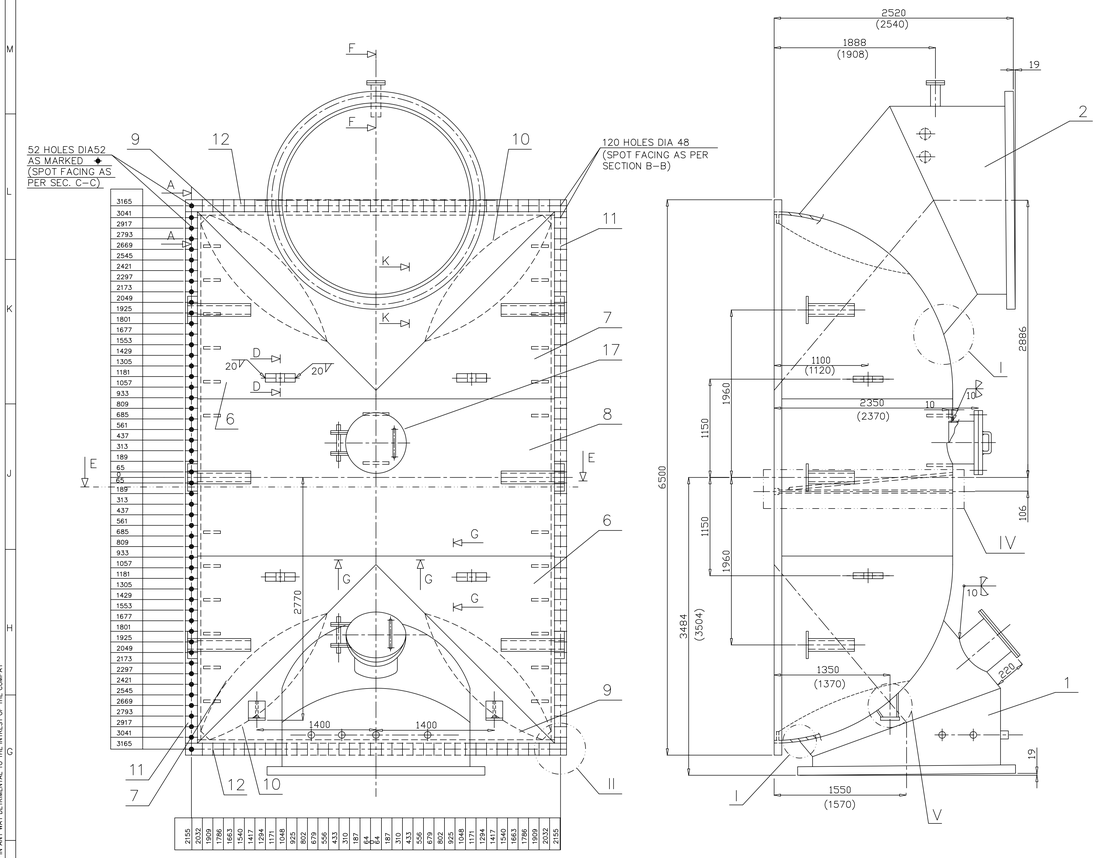
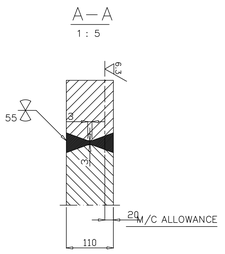
FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

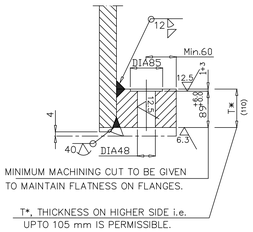
DRG. NO. 0-160-31-70039



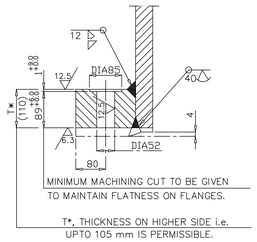
I
1 : 5



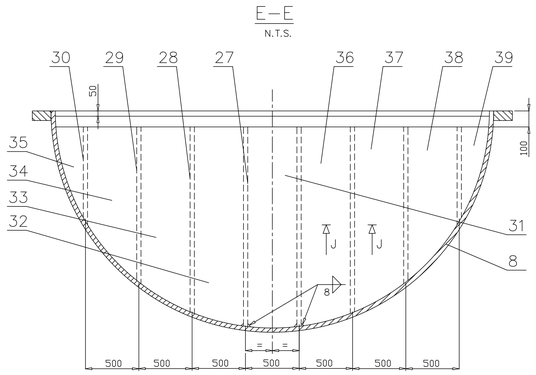
A–A
1 : 5



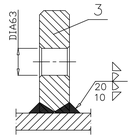
B–B
1 : 5



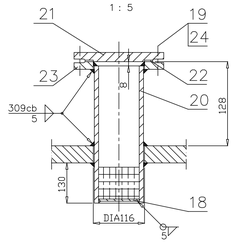
C–C
1 : 5



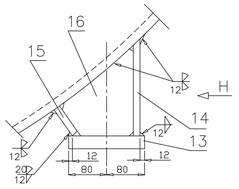
E–E
N.T.S.



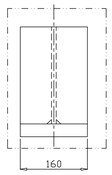
D–D
1 : 5



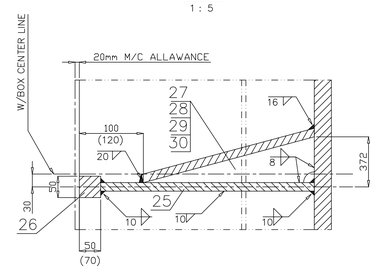
F–F
1 : 5



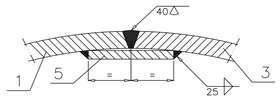
V
1:5



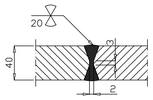
H



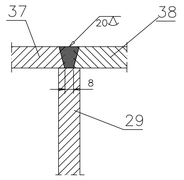
IV
1 : 5



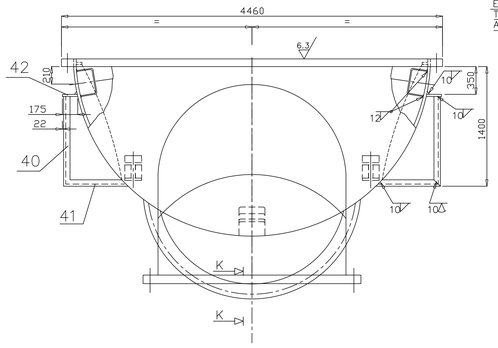
H–H
1 : 5



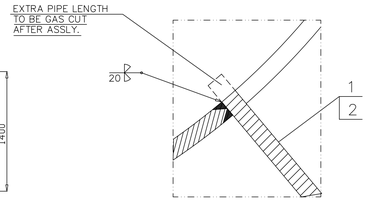
G–G
1 : 2.5



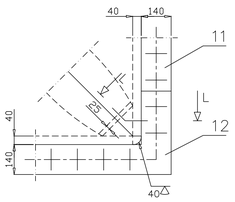
J–J
1 : 5



SETTING DETAIL OF WATER BOX FOR CW INLET/OUTLET FLANGES MACHINING

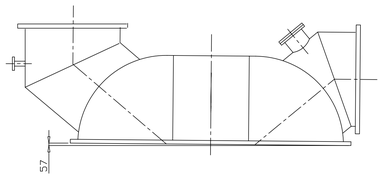


II
1 : 10

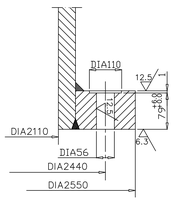


III

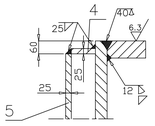
SETTING DETAIL OF WATER BOX FOR MACHINING OF BRANCH PIPE FLANGE

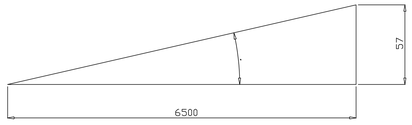


K–K
N.T.S.



L–L
1:10





TECHNICAL REQUIREMENTS

1. VISUAL INSPECTION OF WELD SEAMS AS PER HW0620099.
   CLASSIFICATION GROUPS :–
   I) FOR ITEM NOS. 9,10,11,19 & 40 BS/BK.
   II) CS/BK FOR OTHER ITEMS.
2. NON DESTRUCTIVE EXAMINATION OF WELD SEAMS AS PER HW 0850199 PART 10.
3. WELD EDGE PREPARATION AS PER AA0620502.
4. THE GENERAL TOLERANCES OF STRAIGHTNESS, FLATNESS AND PARALLELISM SHALL BE MAINTAINED AS PER AA0621105 GRADE–F.
5. PAINTING IS TO BE DONE AS PER HE77001.
6. ITEM NOS. 40, 41 & 42 ARE TO BE REMOVED PRIOR TO FINAL DESPATCH.
7. LIFTING TO BE DONE USING ALL THE FOUR LIFTING LUGS
8. IDENTIFICATION MARKING :–
   THE WORD " FRONT WATER BOX (R.S.) " SHOULD BE PAINTED ATLEAST AT TWO PLACES ON OPPOSITE SIDES.
9. DURING FITTING AND ASSEMBLY OF ITEM 27 TO 39 NECESSARY GRINDING MAY BE DONE ON THESE ITEMS TO SUIT THE REQUIRED PROFILE.
10. DIMENSIONS GIVEN IN BRACKET ARE BEFORE MACHINING.
11. DIMENSIONS GIVEN FROM MACHINED FACE OF RECTANGULAR FLANGE ARE THEORETICAL. ACTUAL DIMENSIONS SHALL BE AS PER MACHINING CARRIED OUT ON FLANGE (SEC. X–X).

5	16	55	40	40	20	12	20	20	20	12	12	12	10	10	10	10	10	8	8	WELD SIZE & SYMBOL
1.70	28.26	0.44	36.61	2.15	14.6	21.4	15.6	17.0	19.2	1.70	18.18	3.0	4.10	0.30	2.40	0.15	14.80	16.2	3.30	SEAM LENGTH IN M.
0.23	36.73	10.0	222.6	13.5	64.5	38.5	68.3	43.0	37.20	1.20	13.54	2.25	6.50	0.15	1.17	0.16	8.02	10.90	1.11	WT. OF DEPOSITED METAL
E-7018											E-7018									TYPE OF ELECTRODE

GRADE OF UNTOL. DIM. :–
M / CG – C / M / F AA 0230208
WELDING – A/B/C/D – AA 0621104
GAS CUTTING– "T3" AA 0621101

REV.	DATE	ALTERED / CHECKED
ZONE		

GMS NO./GR.SP.NO. 0–160–31–70039 — STATUS OF DRG. — AGREED WT. — NAME — SIGN — DATE

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT: 4X500MW TALCHER TPP

BHARAT HEAVY ELECTRICALS LTD. HARDWAR

	NAME	SIGN	DATE	NO.OF VAR.
DRN.	A.K.K.			
CHD.	P.K.G.		19/4/99	
APPD.	K.N.M.		25/6/99	

DEPT. HXE — CODE 4222 — SCALE 1.25 — WEIGHT (KG) 27900.00 — REF. TO ASSY DRG. — ITEM NO. — NO.OF ITEMS

TITLE: FRONT WATER BOX (R.S) — CARD CODE — DRAWING NO. 0–160–31–70039 — REV.

SHEET NO. 01 — NO OF SHEETS

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