

95

	PRODUCT STANDARD		HW 7240193 ST 11001				
	STEAM TURBINE ENGINEERING		PAGE 1 OF 3				
			Based on BHEL's Experience				
LEAD DIAPHRAGM							
1.0 SCOPE: Lead Diaphragms are used in the atmospheric relief valves of Steam Turbine.							
2.0 DESIGNATION:							
2.1 In Description : Lead diaphragm of diameter ϕ 753 mm & thickness 8 mm shall be designated by: Pb.DIAPHRAGM 753X0.8.							
2.2 In Drawing : ST 11001.001							
3.0 MATERIAL: Lead sheet (Pb 99.99) as per HW 12599.							
4.0 QUALITY REQUIREMENTS: As per HW 12599. Each diaphragm shall be subjected to 100% Dye penetration test to ensure freedom from crack before despatch. The supplier shall supply DP test certificate alongwith other test certificates required as per HW 12599.							
5.0 PACKING & DESPATCH: The diaphragms shall be cut from the sheet as per sketch No.1 page No.2 or as per relevant manufacturing drg. of 200/500 MW Steam Turbine. The diaphragms should not be folded, rolled and should be handled with care so as to avoid cracks especially after the DP test before despatch. Two One set consisting of four diaphragms should be wrapped in a thick PVC sheet and packed as per sketch No.2 on page No.3. These shall packets may be suitably packed to avoid damage during handling and transportation in bigger package, if required.							
SUPERSEDES INVENTORY No.	Copyright and Confidential The information on this document is the property of BHARAT HEAVY ELECTRICALS LIMITED. It must not be used directly or indirectly in any way detrimental to the interest of the company.	AGREED:			NAME		SIGN. & DATE
		DEPTT			NAME		SIGN. & DATE
INVENTORY NO.	Revision : 02	Distribution	Qty.	Approved	ST		
REAFFIRMED	Date : 30.3.05			ENGG. DEV. MANAGER		8-20	
		Prepared	Issued	Date			
		STE (HARDWAR)		12-08-1983			



PRODUCT STANDARD
STEAM TURBINE ENGINEERING

HW 7240193
ST 11001

PAGE 02 OF 03

SIGN & DATE

INVENTORY NO.

COPYRIGHT AND CONFIDENTIAL
The information on this document is the property of BHARAT HEAVY ELECTRICALS LIMITED.
It must not be used directly or indirectly in any way detrimental to the interest of the company.

SIGN & DATE

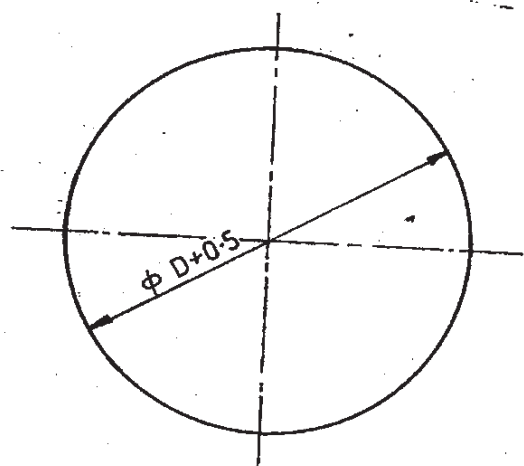
INVENTORY NO.

P-5494

REV. 02

6.0 DETAILS OF DIAPHRAGM

SL.NO.	MW STEAM TURBINE	DIAMETER ϕ D mm	THICKNESS t mm	WT./PC. KG	SIZE CODE NO.
001	200/210	753✓	0.8✓	3.5✓	001
002	500	1003	1.2	10.6	002
003					



SKETCH NO. 1



23

INVENTORY NO. P-5674	SIGN & DATE	COPYRIGHT AND CONFIDENTIAL The information on this document is the property of BHARAT HEAVY ELECTRICALS LIMITED. It must not be used directly or indirectly in any way detrimental to the interest of the company.	SUPERSEDES INVENTORY No.	SIGN & DATE		PRODUCT STANDARD STEAM TURBINE ENGINEERING		FORM HW 7240193 ST 11001
								PAGE 03 OF 03
						7. PACKING DETAILS.		

ϕD = DIAMETER OF DIAPHRAGM

SKETCH NO. 2

8. This standard has been prepared based on Pb 99.94.

9. Cross referred standards:
HW 12599.

	NAME	SIGN. & DATE
DRAWN	Q. P. DHIMAN	<i>Q.P. Dhiman</i> 15-6-83
WORKED	B. P. GUPTA	<i>B.P. Gupta</i>
CHECKED	B. P. GUPTA	<i>B.P. Gupta</i>
SUPERVISED	S. S. V.	<i>S.S.V.</i>

REV. 02