
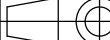


TOOL LIST		
IT. NO.	TOOL NO.	DESCRIPTION

[illegible]

ADDITIONAL INFORMATION				mRkn dk i-dkj;k xk-gd@fj;ktuk dk uke TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT				HMS-713/170-24K PALAMURU RANGAREDDY LIS STAGE-2&3 (MEIL/TSGENCO)			
W.O. 36201 TO 09 A 23157 STAGE-2 W.O. 36210 TO 18 A 23157 STAGE-3											
STATUS OF DRAWING											
DISTRIBUTION OF PRINTS											
HGE - 2 HGM - 4 FWM - 4 TEX - 1											
				HAkR gsoh bysfDV&dYl fyfeVsM HAKSISI BHARAT HEAVY ELECTRICALS LTD. BHOPAL				uke# NAME glr_kc_6SIGnInaukaDATE asfj... CURN BKS Wtqsk NG/AS wugokst RG/AD APPD		laq_ NO. OF 00	
REV.	DATE	ALTERED CHECKED	DEPT. HXG	no_yky_uji_dn_jshkh UNTOL DWS GR	vugkr SOLE	Wtqsk NG/AS	Pwss_M8kbbx db lanHAZ REF. TO ASSY DRG.	en d-- ITEM NO.	en laq_	ITEM NO.	
ZONE		APPROVED	dkSM CODE 403	3 250 00 01404		1:15	NA	NA	016		
'An' AZURE				M&kbox dB&AWING NO.							
TOT BRACKET CENTRE ASSY. (FAB. & M/C)						1 256 01 89601 DRAFT					
						a="B a-SHT. NO. 01 en"Bksa db laq_ MB OF SHT. 01					

TECHNICAL REQUIREMENTS :-

1. WELDING INSTRUCTION :-
 - A. ALL WELDS ARE 15 MM FILLET OF GR.-III TO AA0622101 UNLESS OTHERWISE STATED.
 - B. ALL WELDS TO BE CRACK DETECTED BY D.P./MCD. TO BP 0850199.
 - C. STRESS RELIEVE ASSY. TO BP 0640299 BEFORE MACHINING. THREADS OF IT.5,11&12 TO BE PROTECTED DURING S.R.
 - D. ALL WELDS SHOWN THUS 'LEAK TIGHT' TO BE D.P. TESTED AFTER FIRST ROOT RUN AND ALSO AFTER COMPLETE WELDING.
 - E. ALL WELDS ARE CONTINUOUS UNLESS OTHERWISE STATED,
2. PAINTING SHALL BE CARRIED OUT AS PER HG12007.
3. DIMENSIONS MARKED THUS * ARE FOR D.O. REF. ONLY.
4. SURFACE FINISH OF MACHINED SURFACE SHALL BE 3.2 MICRONS OR BETTER
5. ITEM 7 TO BE WELDED TO HOUSING AFTER THE BRACKET HAS BEEN STRESS RELIEVED.
6. MACHINED FACES OF COOLER FLANGE ITEM 7 TO BE KEPT PARALLEL TO THE BRACKET AXIS DURING WELDING (VERTICALITY WITH IN 2 mm.)
7. ALL MACHINED SURFACES TO BE COATED WITH T.R.P. TO BP 0690084.
8. ALL WELDS, WHICH REQUIRE LEAK PROOF TIGHTNESS, SHOULD BE PAINTED ONLY AFTER OIL LEAKAGE TEST BY GRAVITY TO BP 0850095. REFER DRG. TO 22635289601 FOR GRAVITY TEST.
9. PRE MACHINED FACES OF GUIDE BEARING SUPPORT RING ITEM 5 TO BE LEVELLED WITH WATER LEVEL & TACK WELD. RECHECK BEFORE FINAL WELDING WITH RESPECT TO SUCTION END MARK.
10. DP TEST TO BP0850199 OF THE COMPLETE LENGTH OF EACH WELD SHALL BE CARRIED OUT AFTER S.R.
 1. THE VOLUME OF WATER REQUIRED FOR GRAVITY TESTING IS 1600 LTRS. (APPROX.)
 2. ALL FLANGES TO BE WELDED IN ACCORDANCE WITH DRG. 3 263 03 01005.

FABRICATED WEIGHT FOR ORDERING PURPOSES IS 7062 Kg.
WHICH INCLUDES WELDING WEIGHT.