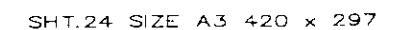


ALL DIMENSIONS ARE IN mm.

ORG No.

INVENTOR: No.



FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm.

3-986-01-09761

19260-10-986-E

DRG No.

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SL. No.	DU No.	ASSY. No.	SEGMENTS FOR ASSY.	L1 ± 2	L2 ± 2	Y	T.E.S.	A.H.S.	Qty No's per Unit	Weight kgs./Bend
03	CLCP009	G 78 - 4	1 2 3 4 5 6 7	1066.8	2458.6	1391.83	V	V	1	442.0
02	CLCP008	C 56 - 4	1 2 3 4 5 6 7	1066.8	2454.3	1387.47	V	V	1	441.5
01	CLCP004	G56-4, H12-4, H34-4, H56-4, H78-4, F34-4, F56-4, F78-4, G12-4, G34-4, E12-4, E34-4, E56-4, E78-4, F12-4, C78-4, D12-4, D34-4, D56-4, D78-4, B34-4, B56-4, B78-4, C12-4, C34-4, A12-4, A34-4, A56-4, A78-4, B12-4,	1 2 3 4 5 6 7	1066.8	2489.2	1422.4	V	V	30	446.5
END DETAIL										

TABLE - 1

Name of Customer/Project

BHARAT HEAVY ELECTRICALS LTD.,
ELECTROPORCELAINS DIVISION
BANGALORE - 560 012

	NAME	SIGN	DATE
DRN	Arasan.B	<i>Arasan</i>	10-06-2013
CHD	M.Vinod	<i>Vinod</i>	09.07.16
APPD	Felix.J	<i>Felix</i>	09.7.16

DEPT	GRADE OF TOL DIM C/M/F	SCALE	WEIGHT (kg)	REF TO ASSY.DRG	ITEM No.	No. OF ITEMS
CODE		N.T.S.	(Approx)	3-986-01-09760 (7131-SHT-1)		
TITLE				CARD CODE	DRAWING No.	REV.
CASING FOR PIPE BENDS - 700NB(10.686)					3-986-01-09761	03
				SHEET No.	No. OF SHEETS	
				2	4	

SUPERSEDES DRG. No.

SHT.24 SIZE A3 420 x 297

ALL DIMENSIONS ARE IN mm.

3-986-01-09761



DETAIL FOR SUPPORT LUG



DEPT	GRADE OF TOL DIM		SCALE	WEIGHT (kg)	REF TO ASSY.DRG	ITEM No.	No.OF ITEMS
CODE	C/M/F		N.T.S.	— (Approx)	3-986-01-09760 (7131- SHT-1)		
TITLE				CARD CODE	DRAWING No.		REV.
CASING FOR PIPE BENDS - 700NB (I.D. 686)					3-986-01-09761		0
					SHEET No. 3	No.OF SHEETS	4

SHT.24 SIZE A3 420 x 297

FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm.

DRG No. 19260-10-986-3

19260-10-986-3

NOTES:-

1. FOR CONSTRUCTION MATERIAL REFER TABLE-2
2. DURING ASSY. LONGITUDINAL WELDING BETWEEN SEGMENTS TO BE STAGGERED.
3. ALL SUPPLIES TO CONFORM CLN:QP:01/00. WELDING AS PER WP:CL001A & AWS:D 1.1.
4. DIMENSIONS INDICATED ARE FINISHED SIZE ONLY.
5. ASSEMBLY No., DU No., AND ARROW HEAD TO BE WELD DEPOSITED OVER CASING AS SHOWN , AS PER CE:1501:21
6. BASE PLATE FOR NAME PLATE TO BE WELDED ON TO CASING, AT LOCATION SHOWN,
FOR BASE PLATE & WELDING DETAILS REF DRG : 4 986 99 07720
7. FACE ANGLES TO BE MATCHED DURING ASSY.
8. ALL OVER MACHINING 6.3/ FOR STOPPER RINGS.
9. A.H.S. =ARROW HEAD SIDE T.E.S. = TAIL END SIDE, V= SHOULDER FOR VICTAULIC COUPLING.
10. FOR CASING Wt. REFER TABLE -1
FOR Wt. OF SUPPORT LUG, LIFTING LUG, EARTH LUG & END RING (STOPPER RING)
REFER TABLE - 2
11. WHERE "Y" IS GREATER THAN 1000, ONE CIRCUMFERENTIAL JOINT IS ALLOWED ON "Y", OUTSIDE SEGMENT TOWARDS A.H.S.
12. CONTROL DURING WELDING OF SHOULDER TO CASING :-
 - a] OVALITY OF CASING ON OUTER DIAMETER TO BE MAINTAINED WITHIN 1.0 MM
 - b] WELDING OF SHOULDER TO CASING AS PER DETAIL-A, TO BE DONE IN SUCH A WAY AS TO ENSURE THAT DISTORTION OF COLLAR IS LIMITED SUCH THAT DIM. Ø787.4 mm IS STRICTLY WITHIN THE RANGE SPECIFIED IN SHEET 1 OF 4
VENDOR TO DO THE NEEDFUL TO ACHIEVE 12(a) AND 12(b).
13. SURFACE PREPARATION AND PAINTING: REF PAINTING SCHEME DOC. No. : PS- L&T - TANDA. BENDS.
14. OVERALL BEND TOLERANCE:-
 - a]. AXIAL SHIFT: ± 3 MM
 - b]. RADIAL SHIFT: ± 3 MM
 - c]. OUT OF SQUARENESS: ± 3 MM.
15. ALL PARTS HAVE TO BE 6mm FILLET WELDED . IF NOT SPECIFIED

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SIGN AND DATE REF. DRG. No.

INVENTORY No.

REV	DATE	ALTERED	REV	DATE	ALTERED	REV	DATE	ALTERED
		CHECKED			CHECKED			CHECKED

Name of Customer/Project

BHARAT HEAVY ELECTRICALS LTD.,
ELECTROPORCELAINS DIVISION
BANGALORE - 560 012

	NAME	SIGN	DATE
DRN	Arasan.B	Arasan	10-06-2016
CHD	M.Vinod	Vinod	09/07/16
APPD	Felix.J	Felix	09.7.2016

WT (kg) - (Approx)	REF TO ASSY.DRG	ITEM No.	No.OF ITEMS
	3-986-01-09760 (7131- SHT-1)		

CARD CODE	DRAWING No.	REV.
	3-986-01-09761	

SHEET No.	4	No.OF SHEETS	4
-----------	---	--------------	---

SUPERSEDES DRG. No.

SHT.24 SIZE A3 420 x 297

ALL DIMENSIONS ARE IN mm.

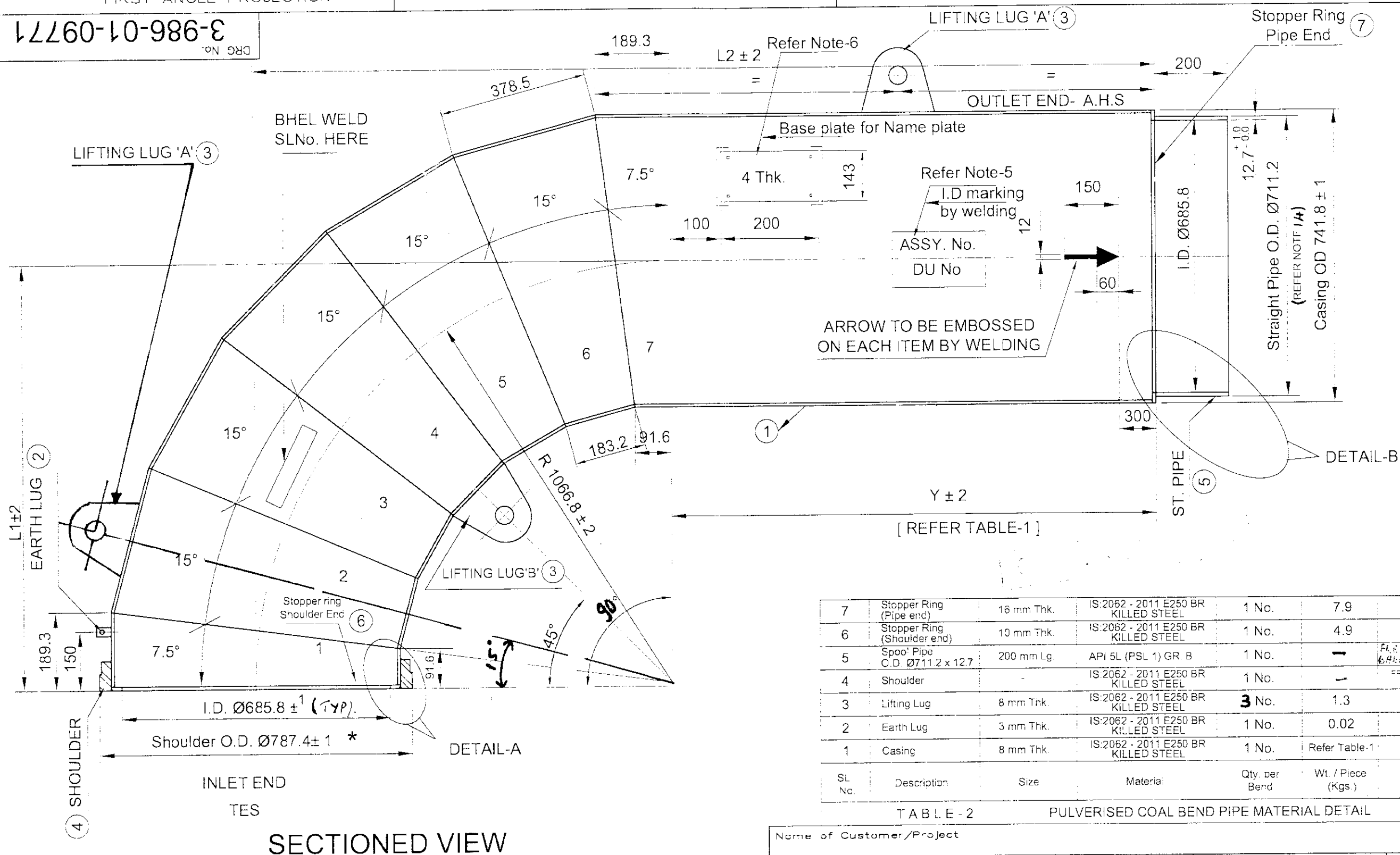
REV
70

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REF. DRG. NO.

SIGN AND DATE

INVENTORY No.



7	Stopper Ring (Pipe end)	16 mm Thk.	IS:2062 - 2011 E250 BR KILLED STEEL	1 No.	7.9	
6	Stopper Ring (Shoulder end)	10 mm Thk.	IS:2062 - 2011 E250 BR KILLED STEEL	1 No.	4.9	
5	Spoof Pipe O.D. Ø711.2 x 12.7	200 mm Lg.	API 5L (PSL 1) GR. B	1 No.	—	FREE ISSUE BY BHEL TO VENDOR
4	Shoulder	-	IS:2062 - 2011 E250 BR KILLED STEEL	1 No.	—	FREE ISSUE BY BHEL TO VENDOR
3	Lifting Lug	8 mm Thk.	IS:2062 - 2011 E250 BR KILLED STEEL	3 No.	1.3	
2	Earth Lug	3 mm Thk.	IS:2062 - 2011 E250 BR KILLED STEEL	1 No.	0.02	
1	Casing	8 mm Thk.	IS:2062 - 2011 E250 BR KILLED STEEL	1 No.	Refer Table-1	

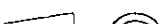
TABLE-2 PULVERISED COAL BEND PIPE MATERIAL DETAIL

Name of Customer/Project



BHARAT HEAVY ELECTRICALS LTD.,
ELECTROPORCELAINS DIVISION
BANGALORE - 560 012

	NAME	SIGN	DATE
DRN	Arasan B	<i>Arasan</i>	10-06-2016
CHD	M Vinod	<i>Vinod</i>	09/07/16
APPD	Felix J	<i>Felix</i>	09.7.2016

DEPT	GRADE OF TOL DIM		SCALE N.T.S.	WEIGHT (kg) — (Approx)	REF TO ASSY.DRG EL-DG-3-986-01-09770 (7131-SHT-2)	ITEM No.	No. OF ITEM
CODE	C/M/F						
TITLE CASING FOR PIPE BENDS - 700NB (I.D 686)				CARD CODE	DRAWING No. 3-986-01-09771		REV 0
					SHEET No. 1	No. OF SHEETS 4	

SUPERSEDES DRG. No.

SHT.24 SIZE A3 420 x 297

FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm.

DRG No. 3-986-01-09771

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REF. DRG. No.

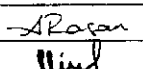
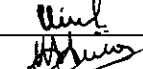
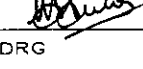
SIGN AND DATE

INVENTORY No.

01	CLCP005	H78-10 H34-18,H56-8,H56-10,H78-8, H34-10,H34-12,H34-14,H34-16, G78-10,H12-11,H12-13,H12-15, G34-17,G56-9,G56-11,G78-8, G34-9,G34-11,G34-13,G34-15, F78-13,G12-10,G12-12,G12-14, F56-11,F56-13,F78-8,F78-11, F34-12,F34-14,F34-16,F56-8, F12-11,F12-13,F34-8,F34-10, E78-9,E78-12,E78-14,F12-9, E34-12,E56-9,E56-12,E56-14, E12-10,E12-12,E34-8,E34-10, D34-11,D34-18,D78-10,E12-8, D12-10,D12-12,D12-14,D12-22, C12-21,C34-10,C34-17,C78-11, B78-13,C12-9,C12-11,C12-13, B12-20,B34-9,B34-16,B56-8,B78-8, A78-9,A78-14,B12-8,B12-10,B12-12, A12-8,A12-16,A34-8,A34-15,A56-9,	1 2 3 4 5 6 7	1066.8	2489.2	1422.4	V	W	80	446.0
VAR. No.	DU No.	Assy. No.	SEGMENTS FOR ASSY.	L1 ± 2	L2 ± 2	Y	T.E.S.	A.H.S.	Qty No's per Unit	Approx. Unit Wt. (kgs.)
END DETAIL										

TABLE - 1

Name of Customer/Project

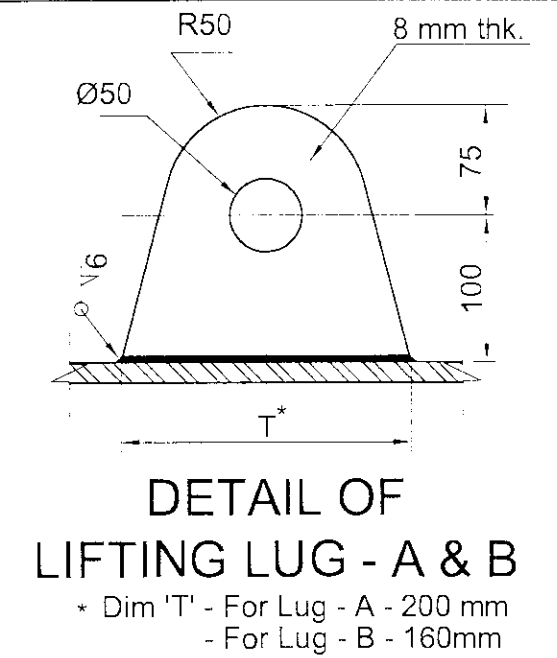
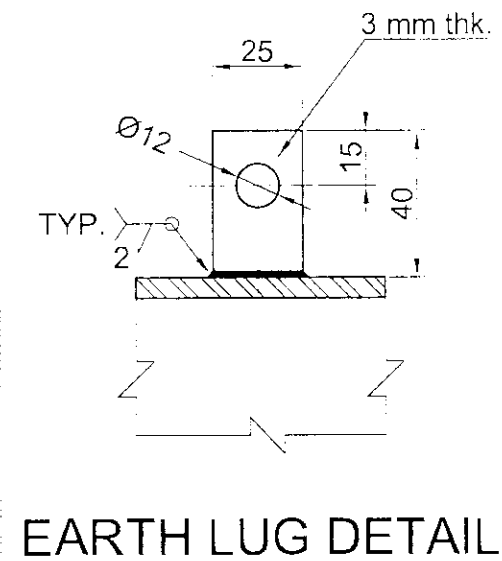
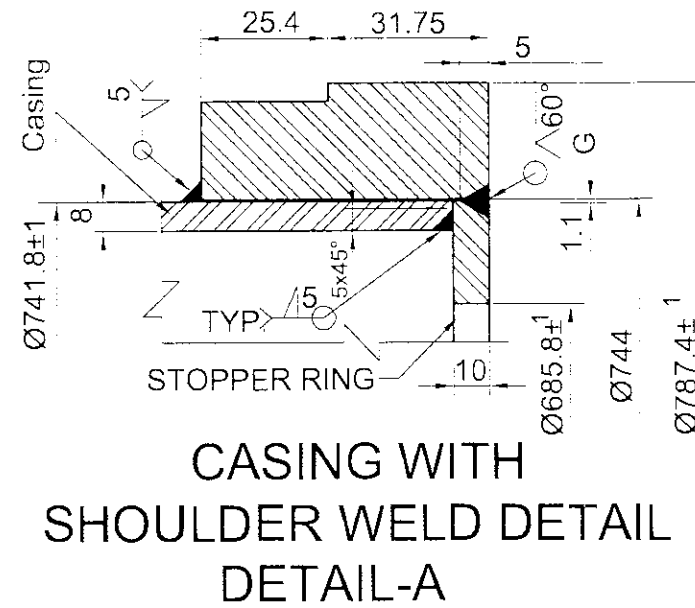
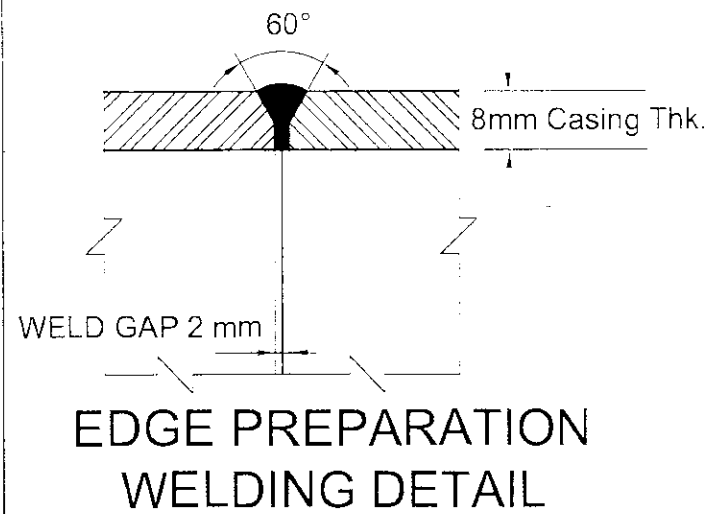
		BHARAT HEAVY ELECTRICALS LTD., ELECTROPORCELAINS DIVISION BANGALORE - 560 012		NAME	SIGN	DATE	
DRN	Arasan.B					10-06-2016	
CHD	M.Vinod					09/07/16	
APPD	Felix.J					09.7.2016	
DEPT	GRADE OF TOL DIM	SCALE	WEIGHT (kg)	REF TO ASSY.DRG		ITEM No.	No.OF ITEMS
CODE	C/M/F	N.T.S.	(Approx)	EL-DG-3-986-01-09770 (7131-SHT-2)			
TITLE				CARD CODE	DRAWING No.		REV.
CASING FOR PIPE BENDS - 700NB (I.D 686)					3-986-01-09771		02
					SHEET No. 2		No.OF SHEETS 4

SUPERSEDES DRG. No.

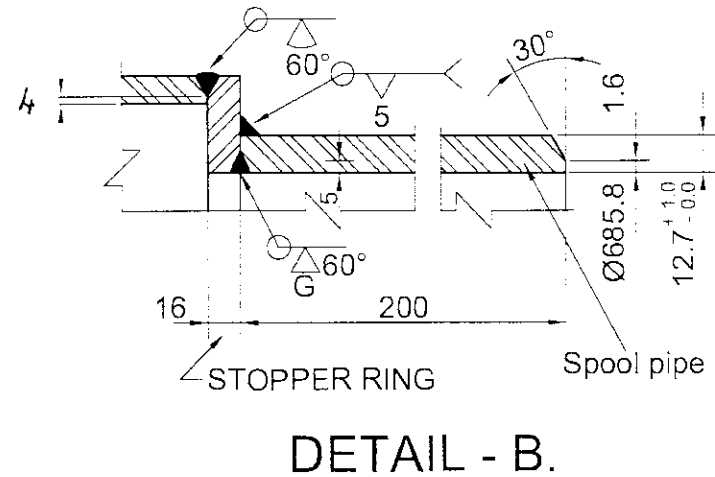
SHT.24 SIZE A3 420 x 297

FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm.

3-986-01-09771
DRG No.

* Dim 'T' - For Lug - A - 200 mm
- For Lug - B - 160mm



Name of Customer/Project



BHARAT HEAVY ELECTRICALS LTD.,
ELECTROPORCELAINS DIVISION
BANGALORE - 560 012

	NAME	SIGN	DATE
DRN	Arasan B	<i>Arasan B</i>	10-06-2016
CHD	M.Vinod	<i>M.Vinod</i>	09/07/16
APPD	Felix.J	<i>Felix.J</i>	09/07/16

DEPT	GRADE OF TOL DIM	SCALE	WEIGHT (kg)	REF TO ASSY.DRG	ITEM No.	No.OF ITEMS
CODE	C/M/F	N.T.S.	(Approx)	EL-DG-3-986-01-09770 (7:31-SHT-2)		
TITLE	CASING FOR PIPE BENDS - 700NB (I.D 686)	CARD CODE		DRAWING No.	REV.	
				3-986-01-09771	02	
				SHEET No. 3	No.OF SHEETS 4	

SUPERSEDES DRG. No.

SHT.24 SIZE A3 420 x 297

REV 0

12260-10-986-3

DRG No.

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NOTE:-

1. FOR CONSTRUCTION MATERIAL REFER TABLE-2
2. DURING ASSY. LONGITUDINAL WELDING BETWEEN SEGMENTS TO BE STAGGERED.
3. ALL SUPPLIES TO CONFORM CLN:QP:01/00. WELDING AS PER WP:CL001A & AWS:D 1.1.
4. DIMENSIONS INDICATED ARE FINISHED SIZE ONLY.
5. ASSEMBLY No., DU No., AND ARROW HEAD TO BE WELD DEPOSITED OVER CASING AS SHOWN , AS PER CE:1501:21
6. BASE PLATE FOR NAME PLATE TO BE WELDED ON TO CASING, AT LOCATION SHOWN,
FOR BASE PLATE & WELDING DETAILS REF DRG : 4 986 99 07720
7. FACE ANGLES TO BE MATCHED DURING ASSY.
8. ALL OVER MACHINING 6.3/ FOR STOPPER RINGS.
9. A.H.S. =ARROW HEAD SIDE T.E.S. = TAIL END SIDE, V= SHOULDER FOR VICTAULIC COUPLING, W = SPOOL PIPE.
10. FOR CASING Wt. REFER TABLE -1
FOR Wt. OF LIFTING LUG, EARTH LUG, STOPPER RINGS
REFER TABLE - 2
11. WHERE "Y" IS GREATER THAN 1000, ONE CIRCUMFERENTIAL JOINT IS ALLOWED ON "Y", OUTSIDE SEGMENT TOWARDS A.H.S.
12. CONTROL DURING WELDING OF SHOULDER TO CASING :-
 - a) OVALITY OF CASING ON OUTER DIAMETER TO BE MAINTAINED WITHIN 1.0 MM
 - b) WELDING OF SHOULDER TO CASING AS PER DETAIL-A, TO BE DONE IN SUCH A WAY AS TO ENSURE THAT DISTORTION OF COLLAR IS LIMITED SUCH THAT DIM Ø 787.4 mm IS STRICTLY WITHIN THE TOLERANCE SPECIFIED IN SHT 1 OF 4.
VENDOR TO DO THE NEEDFUL TO ACHIEVE 12(a) AND 12(b).
13. SURFACE PREPARATION AND PAINTING: REF PAINTING SCHEME DOC. No. : PS- L&T - TANDA. BENDS.
14. TOLERANCE FOR SPOOL PIPE AS PER API-5L-(PSLI)-GR:B STANDARD.
15. OVERALL BEND TOLERANCE:-
 - a). AXIAL SHIFT: ± 3 MM
 - b). RADIAL SHIFT: ± 3 MM
 - c). OUT OF SQUARENESS: ± 3 MM.

Name of Customer/Project

	BHARAT HEAVY ELECTRICALS LTD.,		NAME	SIGN	DATE
	ELECTROPORCELAINS DIVISION		DRN	Arasan.B	10-06-2016
	BANGALORE - 560 012		CHD	M.Vinod	09-07-16
			APPD	Felix.J	09-7-16
DEPT	GRADE OF TOL DIM	SCALE	WEIGHT (kg)	REF TO ASSY.DRG	
CODE	C/M/F	N.T.S.	(Approx)	EL-DG-3-986-01-09770 (7131- SHT-2)	
TITLE			CARD CODE	DRAWING No.	
CASING FOR PIPE BENDS - 700NB (I.D 686)				3-986-01-09771	
				SHEET No.	No.OF SHEETS
				4	4

SUPERSEDES DRG. No.

SHT.24 SIZE A3 420 x 297

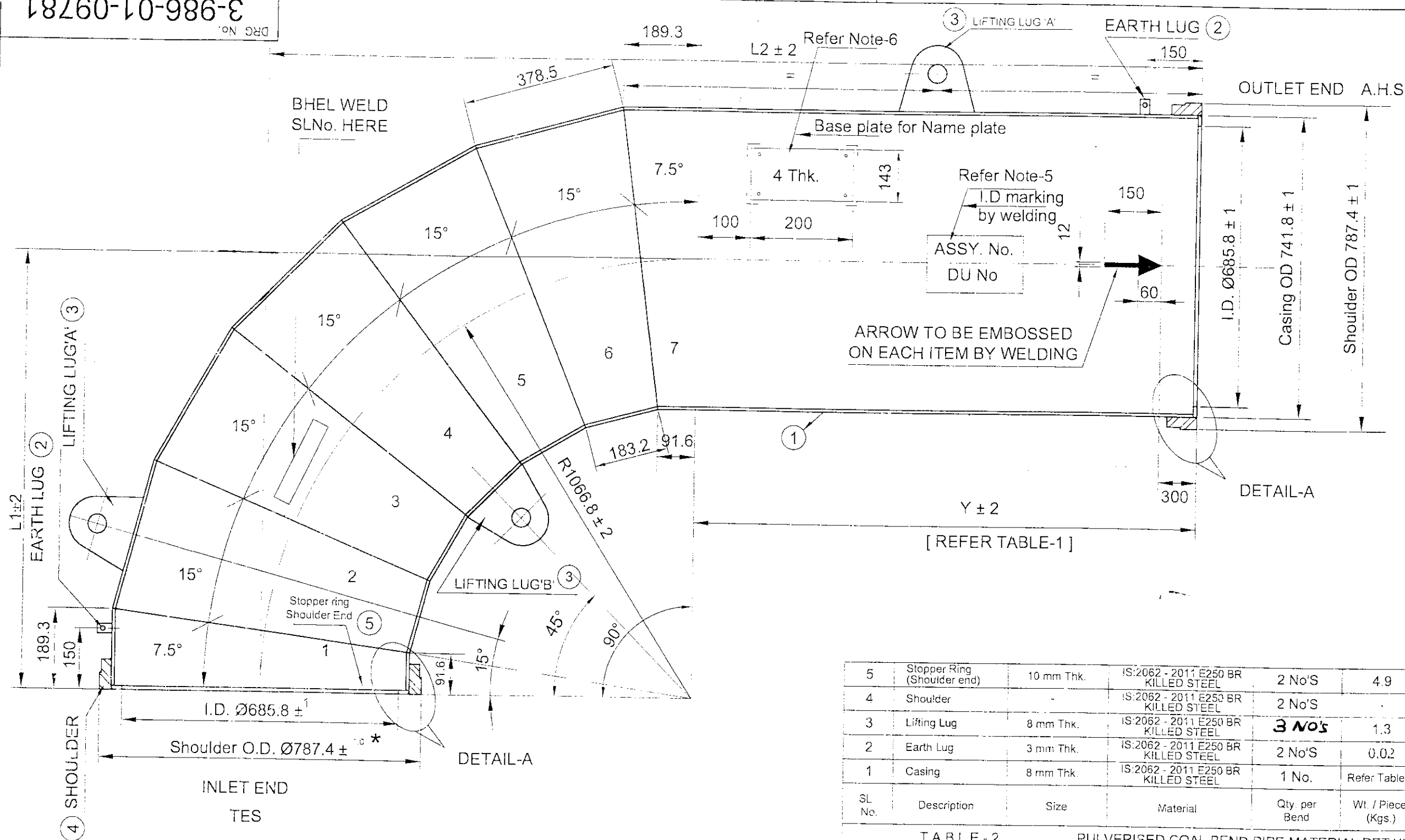
ALL DIMENSIONS ARE IN mm.

3-986-01-09781

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SIGN AND DATE	REF. DRG. No.

INVENTORY No.



SECTIONED VIEW

* This dimension to be maintained strictly as per tolerance indicated.

5	Stopper Ring (Shoulder end)	10 mm Thk.	IS:2062 - 2011 E250 BR KILLED STEEL	2 No'S	4.9	(FREE ISSUE BY BHEL TO VENDOR)
4	Shoulder	-	IS:2062 - 2011 E250 BR KILLED STEEL	2 No'S	-	
3	Lifting Lug	8 mm Thk.	IS:2062 - 2011 E250 BR KILLED STEEL	3 No's	1.3	
2	Earth Lug	3 mm Thk.	IS:2062 - 2011 E250 BR KILLED STEEL	2 No'S	0.02	
1	Casing	8 mm Thk.	IS:2062 - 2011 E250 BR KILLED STEEL	1 No.	Refer Table-1	
SL No.	Description	Size	Material	Qty per Bend	Wt. / Piece (Kgs.)	Remarks

TABLE -2 PULVERISED COAL BEND PIPE MATERIAL DETAIL

Name of Customer/Project



BHARAT HEAVY ELECTRICALS LTD.,
ELECTROPORCELAINS DIVISION
BANGALORE - 560 012

	NAME	SIGN	DATE
DRN	S.Murali		09/07/16
GHD	M.Vinod		09/07/16
APPD	Felix.J		09/07/16

DEPT	GRADE OF		SCALE	WEIGHT (kg)	REF TO ASSY.DRG	ITEM	No.OF
CODE	TOL DIM C/M/F		N.T.S.	— (Approx)	3-986-01-09780 (3/31-SHT-C)	No.	ITEMS

TITLE CASING FOR
PIPE BENDS - 700NB (I.D 686)

CARD CODE	DRAWING No.		REV.
	3-986-01-09781		02 nd
	SHEET No. 1	No. OF SHEETS	4

SUPERSEDES ORG. No.

SHT.24 SIZE A3 420 x 297 J

FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm.

18260-10-986-3
REV
DRG No.

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REF. DRG. No.

SIGN AND DATE

INVENTORY No.

05	CLCP-014	E78-16, F78-15, G78-12, H78-12	1 2 3 4 5 6 7	1066.8	1519.85	453.05	V	V	4	306.2
04	CLCP-013	E56-17, F56-16, G56-14, H56-13	1 2 3 4 5 6 7	1066.8	2619.85	1553.05	V	V	4	465.5
03	CLCP-012	E34-19, F34-23, G34-24, H34-25	1 2 3 4 5 6 7	1066.8	2484.85	1418.05	V	V	4	446.0
02	CLCP-011	E12-18, F12-19, G12-20, H12-21	1 2 3 4 5 6 7	1066.8	1384.85	318.05	V	V	4	286.7
01	CLCP-010	A56 -12, B56-11, C56-8, D56-9	1 2 3 4 5 6 7	1066.8	2519.85	1453.05	V	V	4	451.0
SL. No.	DU No.	ASSEMBLY NO.	SEGMENTS FOR ASSY.	L1 ± 2	L2 ± 2	Y	T.E.S.	A.H.S.	Qty No's per Unit	Approx. Unit Wt. (kgs.)
END DETAIL										

TABLE - 1

Name of Customer/Project



BHARAT HEAVY ELECTRICALS LTD.,
ELECTROPORCELAINS DIVISION
BANGALORE - 560 012

	NAME	SIGN	DATE
DRN	S.Murali	12	09/07/16
CHD	M.Vinod	<i>[Signature]</i>	09/07/16
APPD	Felix.J	<i>[Signature]</i>	09/07/16

REV	DATE	ALTERED	REV	DATE	ALTERED	REV	DATE	ALTERED
		CHECKED			CHECKED			CHECKED

DEPT	GRADE OF TOL DIM C/M/F	SCALE N.T.S.	WEIGHT (kg) — (Approx)	REF TO ASSY.DRG 3-986-01-09780 (7131-SHT-5)	ITEM No.	No.OF ITEMS
CODE	TITLE CASING FOR PIPE BENDS - 700NB (I.D 686)			CARD CODE	DRAWING No. 3-986-01-09781	
				SHEET No. 2		No.OF SHEETS 4

REV. 02

SUPERSEDES DRG. No.

SHT.24 SIZE A3 420 x 297

DRG No.

18760-10-986-E

DRG No.

NOTE:-

1. FOR CONSTRUCTION MATERIAL REFER TABLE-2
2. DURING ASSY. LONGITUDINAL WELDING BETWEEN SEGMENTS TO BE STAGGERED.
3. ALL SUPPLIES TO CONFORM CLN:QP:01/00. WELDING AS PER WP:CL001A & AWS:D 1.1.
4. DIMENSIONS INDICATED ARE FINISHED SIZE ONLY.
5. ASSEMBLY No., DU No., AND ARROW HEAD TO BE WELD DEPOSITED OVER CASING AS SHOWN , AS PER CE:1501:21
6. BASE PLATE FOR NAME PLATE TO BE WELDED ON TO CASING, AT LOCATION SHOWN,
FOR BASE PLATE & WELDING DETAILS REF DRG : 4 986 99 07720
7. FACE ANGLES TO BE MATCHED DURING ASSY.
8. ALL OVER MACHINING 6.3/ FOR STOPPER RINGS.
9. A.H.S. =ARROW HEAD SIDE T.E.S. = TAIL END SIDE, V= SHOULDER FOR VICTAULIC COUPLING.
10. FOR CASING Wt. REFER TABLE -1
FOR Wt. OF LIFTING LUG, EARTH LUG, STOPPER RING.
REFER TABLE - 2
11. WHERE "Y" IS GREATER THAN 1000, ONE CIRCUMFERENTIAL JOINT IS ALLOWED ON "Y", OUTSIDE SEGMENT TOWARDS A.H.S.
12. CONTROL DURING WELDING OF SHOULDER TO CASING :-
 - a] OVALITY OF CASING ON OUTER DIAMETER TO BE MAINTAINED WITHIN 1.0 MM
 - b] WELDING OF SHOULDER TO CASING AS PER DETAIL-A, TO BE DONE IN SUCH A WAY AS TO ENSURE THAT DISTORTION OF COLLAR IS LIMITED SUCH THAT DIMØ787.4mm IS
STRICTLY WITHIN THE TOLERANCE SPECIFIED IN SHT 10F 4.
VENDOR TO DO THE NEEDFUL TO ACHIEVE 12(a) AND 12(b).
13. SURFACE PREPARATION AND PAINTING: REF PAINTING SCHEME DOC. No. : PS- L&T -TANDA. BENDS.
14. OVERALL BEND TOLERANCE:-
 - a]. AXIAL SHIFT: ± 3 MM
 - b]. RADIAL SHIFT: ± 3 MM
 - c]. OUT OF SQUARENESS: ± 3 MM.
15. ALL PARTS HAVE TO BE 6mm FILLET WELDED, IF NOT SPECIED.

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 AND DATE

REF. DRG. No.

INVENTORY No.

REV	DATE	ALTERED	REV	DATE	ALTERED	REV	DATE	ALTERED
		CHECKED			CHECKED			CHECKED

Name of Customer/Project

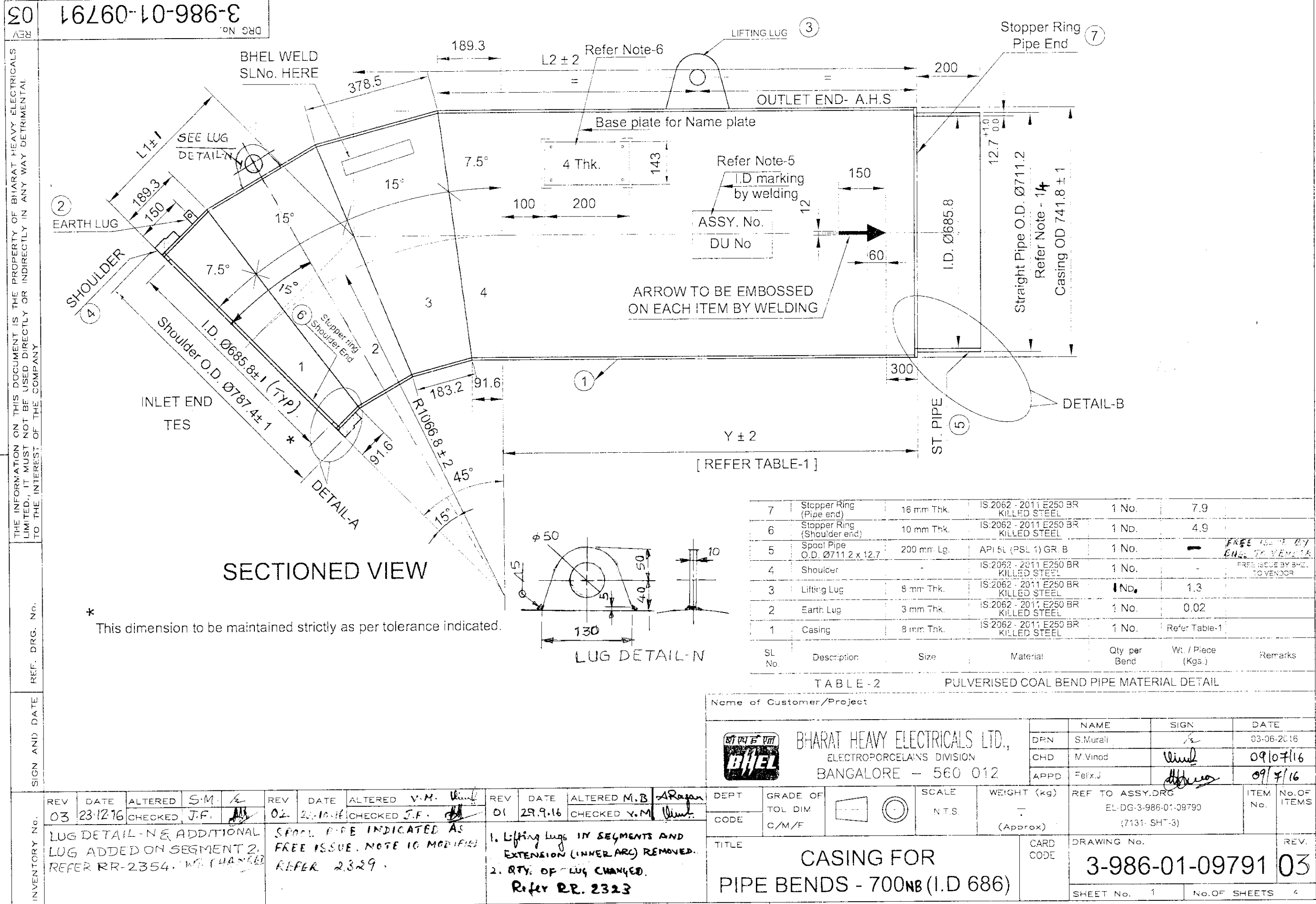


BHARAT HEAVY ELECTRICALS LTD.,
ELECTROPORCELAINS DIVISION
BANGALORE - 560 012

DEPT	GRADE OF TOL DIM C/M/F	SCALE	WEIGHT (kg)	REF TO ASSY.DRG	ITEM No.	No.OF ITEMS
		N.T.S.	(Approx)	3-986-01-09780 (7131-SHT-5)		
TITLE				CARD CODE	DRAWING No.	REV.
CASING FOR PIPE BENDS - 700NB (I.D 686)					3-986-01-09781	02
				SHEET No.	No.OF SHEETS	
				4	4	

SUPERSEDES DRG. No.

SHT.24 SIZE A3 420 x 297



FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm.

20
REV
16260-10-986-3
DRG No.

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

01	CLCP006	A12-11,A12-13,A34-6,A34-11, A34-13,A56-6,A78-6,B12-6,B12-15, B12-17,B34-6,B34-12,B34-14,B56-6 B78-6,C12-6,C12-16,C12-18,C34-6, C34-13,C34-15,C56-5,C78-6,D12-6, D12-17,D12-19,D34-14,D34-16,E12-6, E12-14,E12-16,E34-14,E34-16,E56-6, E78-6,F12-6,F12-15,F12-17,F34-6, F34-18,F34-20,F56-6,F78-6,G12-6, G12-16,G12-18,G34-6,G34-19, G34-21,G56-6,G78-5,H12-17,H12-19, H34-6,H34-20,H34-22	1	2	3	7	441.88	1864.28	1422.4	V	W	56	325.0
VAR. No.	DU No.	ASSEMBLY No.	SEGMENTS FOR ASSY.	L1 ± 2	L2 ± 2	Y	T.E.S.	A.H.S.	Qty No's per Unit	Approx. Unit Wt. (kgs.)	END DETAIL		

TABLE - 1

Name of Customer/Project

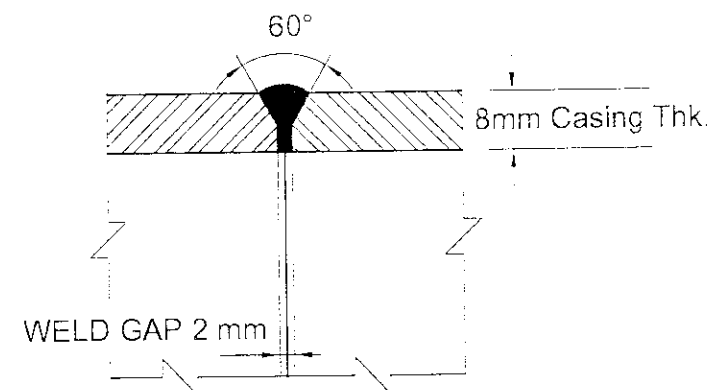
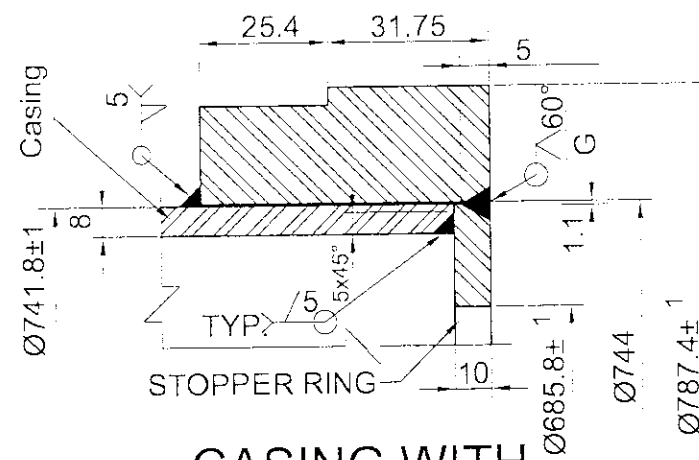
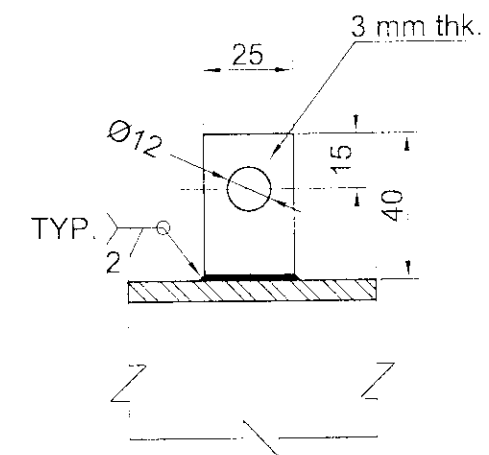
INVENTORY No.	SIGN AND DATE	REF. DRG. No.	REV	DATE	ALTERED	REV	DATE	ALTERED	REV	DATE	ALTERED	DEPT	GRADE OF	SCALE	WEIGHT (kg)	REF TO ASSY.DRG	ITEM	No. OF	
					CHECKED			CHECKED			CHECKED		TOL DIM	N.T.S.	--	EL-DG-3-986-01 09790	No.	ITEMS	
													C/M/F			(Approx)	(7131- SHT-3)		
												TITLE	CASING FOR PIPE BENDS - 700NB (I.D 686)			CARD CODE	DRAWING No. 3-986-01-09791		REV. 03
																SHEET No. 2	No. OF SHEETS 4		

SUPERSEDES DRG. No.

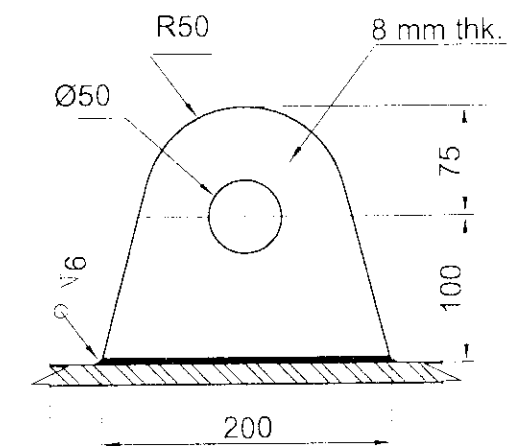
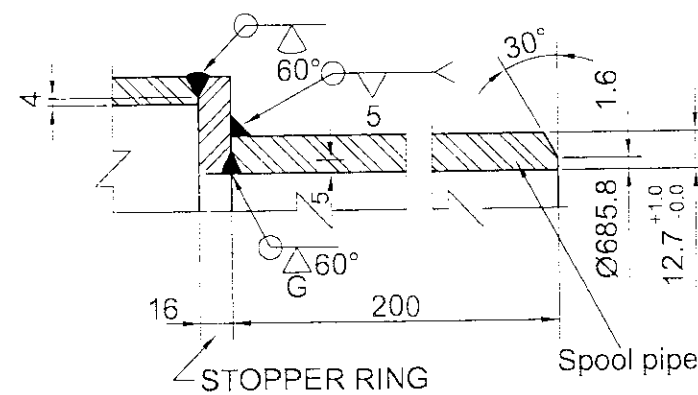
SHT.24 SIZE A3 420 x 297

FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm.

16260-10-986-3
REV 03EDGE PREPARATION
WELDING DETAILCASING WITH
SHOULDER WELD DETAIL
DETAIL-A

EARTH LUG DETAIL

DETAIL OF
LIFTING LUG

DETAIL - B.

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SIGN AND DATE REF. DRG. No.

INVENTORY No.

REV	DATE	ALTERED	REV	DATE	ALTERED	REV	DATE	ALTERED
		CHECKED			CHECKED			CHECKED

Name of Customer/Project

	BHARAT HEAVY ELECTRICALS LTD., ELECTROPORCELAINS DIVISION BANGALORE - 560 012			NAME	SIGN	DATE
	DEPT	GRADE OF	SCALE	DRN	S. Murali	03-06-2016
	CODE	TOL DIM	WEIGHT (kg)	CHD	M. Vinod	09/10/16
	TITLE	C/M/F	(Approx)	APPD	Felix J	09/11/16
CASING FOR PIPE BENDS - 700NB(I.D 686)			CARD CODE	REF TO ASSY.DRG EL-DG-3-986-01-09790 (7131-SHT-3)		ITEM No.
				DRAWING No. 3-986-01-09791		REV. 03
				SHEET No. 3		No. OF SHEETS 4

SUPERSEDES DRG. No.

SHT.24 SIZE A3 420 x 297

20

16760-10-986-3

DRG No.

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

NOTE:-

1. FOR CONSTRUCTION MATERIAL REFER TABLE-2
2. DURING ASSY. LONGITUDINAL WELDING BETWEEN SEGMENTS TO BE STAGGERED.
3. ALL SUPPLIES TO CONFORM CLN:QP:01/00. WELDING AS PER WP:CL001A & AWS:D 1.1.
4. DIMENSIONS INDICATED ARE FINISHED SIZE ONLY.
5. ASSEMBLY No., DU No., AND ARROW HEAD TO BE WELD DEPOSITED OVER CASING AS SHOWN , AS PER CE:1501:21
6. BASE PLATE FOR NAME PLATE TO BE WELDED ON TO CASING, AT LOCATION SHOWN,
FOR BASE PLATE & WELDING DETAILS REF DRG : 4 986 99 07720
7. FACE ANGLES TO BE MATCHED DURING ASSY.
8. ALL OVER MACHINING 6.3/ FOR STOPPER RINGS.
9. A.H.S. =ARROW HEAD SIDE T.E.S. = TAIL END SIDE, V= SHOULDER FOR VICTAULIC COUPLING, W = SPOOL PIPE.
10. FOR CASING Wt. REFER TABLE -1
FOR Wt. OF LIFTING LUG, EARTH LUG, STOPPER RINGS
REFER TABLE - 2
11. WHERE "Y" IS GREATER THAN 1000, ONE CIRCUMFERENTIAL JOINT IS ALLOWED ON "Y", OUTSIDE SEGMENT TOWARDS A.H.S.
12. CONTROL DURING WELDING OF SHOULDER TO CASING :-
 - a) OVALITY OF CASING ON OUTER DIAMETER TO BE MAINTAINED WITHIN 1.0 MM
 - b) WELDING OF SHOULDER TO CASING AS PER DETAIL-A, TO BE DONE IN SUCH A WAY AS TO ENSURE THAT DISTORTION OF COLLAR IS LIMITED SUCH THAT DIMØ787.4mm IS STRICTLY WITHIN THE TOLERANCE SPECIFIED IN SHT 1OF 4.
VENDOR TO DO THE NEEDFUL TO ACHIEVE 12(a) AND 12(b).
13. SURFACE PREPARATION AND PAINTING: REF PAINTING SCHEME DOC. No. : PS- L&T - TANDA. BENDS.
14. TOLERANCE FOR SPOOL PIPE AS PER API-5L-(PSL 1)-GR:B STANDARD.
15. OVERALL BEND TOLERANCE:-
 - a). AXIAL SHIFT: ± 3 mm
 - b). RADIAL SHIFT: ± 3 mm
 - c). OUT OF SQUARENESS: ± 3 mm.

Name of Customer/Project

BHARAT HEAVY ELECTRICALS LTD.,
ELECTROPORCELAINS DIVISION
BANGALORE - 560 012

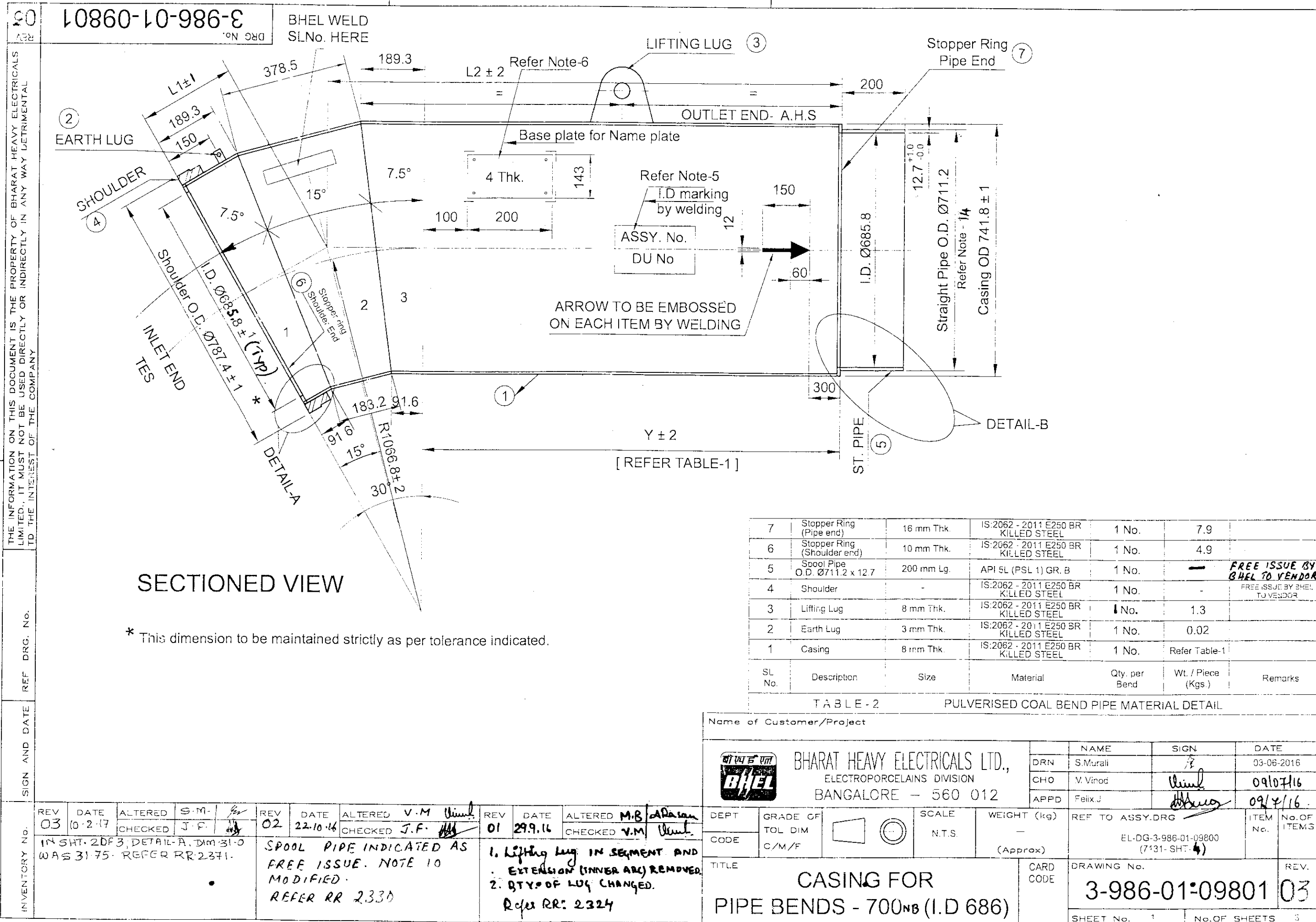
DEPT	GRADE OF TOL DIM	SCALE	WEIGHT (kg)	REF TO ASSY.DRG	ITEM No.	No. of TENS
CODE	C/M/F	N.T.S	(Approx)	EL-DG-3-986-01-09790 (7131-SHT-3)		
TITLE				CARD CODE	REV	
CASING FOR PIPE BENDS - 700NB (I.D 686)					3-986-01-09791	03
SHEET No. 4				No. OF SHEETS 4		

SUPERSEDES DRG. No.

SHT.24 SIZE A3 420 x 297

FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm.



FIRST ANGLE PROJECTION

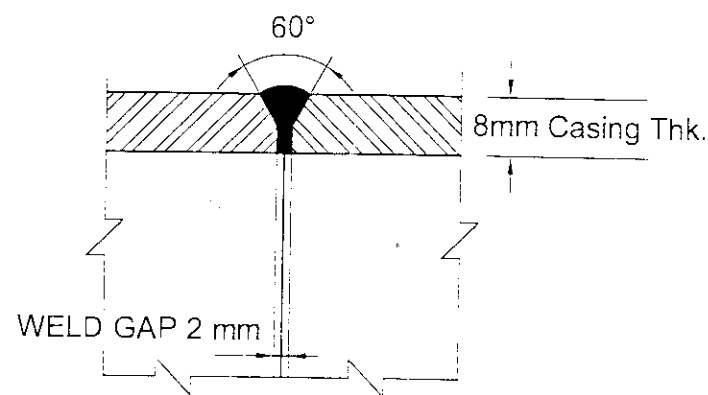
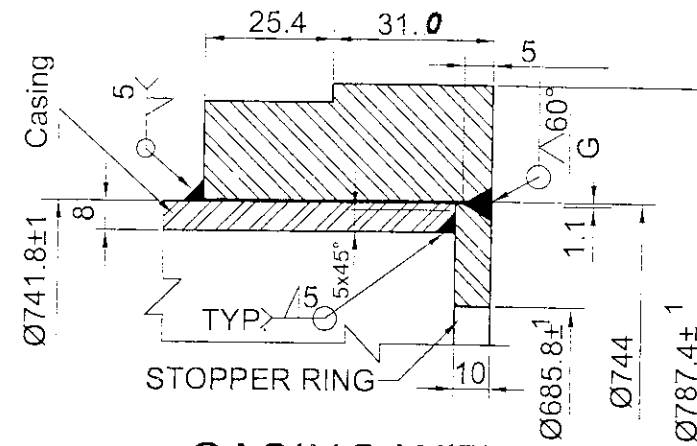
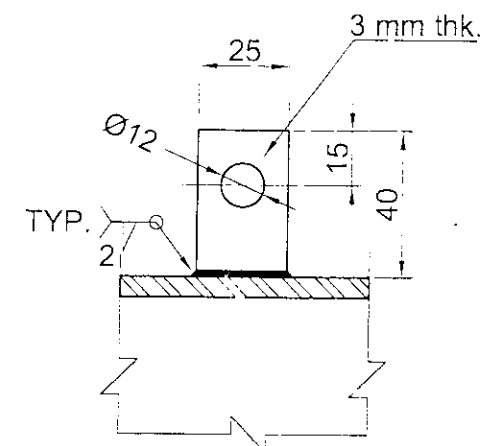
ALL DIMENSIONS ARE IN mm.

REV

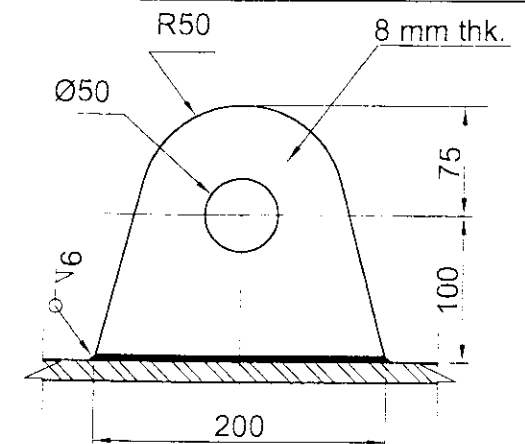
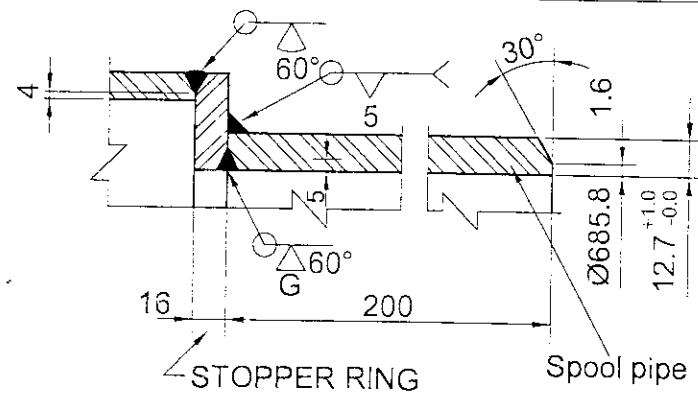
10860-10-986-E

DRG No.

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EDGE PREPARATION
WELDING DETAILCASING WITH
SHOULDER WELD DETAIL
DETAIL-A

EARTH LUG DETAIL

DETAIL OF
LIFTING LUG

DETAIL - B.

01	CLCP007	H12-6, H56-6, H78-6 A12-6, D34-6, D56-6, D78-6, E34-6,	127	285.85	1708.25	1422.4	V	W	8	284.0
VAR. No.	DU No.	ASSEMBLY No.	SEGMENTS FOR ASSY.	L1 ± 2	L2 ± 2	Y	T.E.S.	A.H.S.	Qty No's per Unit	Wt. (kgs.)/ Bend
							END DETAIL			

TABLE - 1

Name of Customer/Project

BHARAT HEAVY ELECTRICALS LTD.,
ELECTROPORCELAINS DIVISION
BANGALORE - 560 012

NAME	SIGN	DATE
DRN: S.Murali	<i>[Signature]</i>	03-06-16
CHD: M.Vinod	<i>[Signature]</i>	09-07-16
APPD: Felix.J	<i>[Signature]</i>	09-07-16

DEPT	GRADE OF TOL DIM	SCALE	WEIGHT (kg)	REF TO ASSY.DRG	ITEM No.	No. OF ITEMS
CODE	C/M/F	N.T.S.	(Approx)	EL-DG-3-986-01-09803 (7131-SHT-4)		
TITLE • CASING FOR PIPE BENDS - 700NB (I.D 686)				CARD CODE	DRAWING No. 3-986-01-09801	REV. 03
					SHEET No. 2	No. OF SHEETS 3

SUPERSEDES DRG. No.

SHT.24 SIZE A3 420 x 297

10860-10-986-3

DRG No.

NOTE:-

1. FOR CONSTRUCTION MATERIAL REFER TABLE-2
2. DURING ASSY. LONGITUDINAL WELDING BETWEEN SEGMENTS TO BE STAGGERED.
3. ALL SUPPLIES TO CONFORM CLN:QP:01/00. WELDING AS PER WP:CL001A & AWS:D 1.1.
4. DIMENSIONS INDICATED ARE FINISHED SIZE ONLY.
5. ASSEMBLY No., DU No., AND ARROW HEAD TO BE WELD DEPOSITED OVER CASING AS SHOWN , AS PER CE:1501:21
6. BASE PLATE FOR NAME PLATE TO BE WELDED ON TO CASING, AT LOCATION SHOWN,
FOR BASE PLATE & WELDING DETAILS REF DRG : 4 986 99 07720
7. FACE ANGLES TO BE MATCHED DURING ASSY.
8. ALL OVER MACHINING 6.3/ FOR STOPPER RINGS.
9. A.H.S. =ARROW HEAD SIDE T.E.S. = TAIL END SIDE, V= SHOULDER FOR VICTAULIC COUPLING, W = SPOOL PIPE.
10. FOR CASING Wt. REFER TABLE -1
FOR Wt. OF LIFTING LUG, EARTH LUG, STOPPER RINGS
REFER TABLE - 2
11. V:HERE "Y" IS GREATER THAN 1000, ONE CIRCUMFERENTIAL JOINT IS ALLOWED ON "Y", OUTSIDE SEGMENT TOWARDS A.H.S.
12. CONTROL DURING WELDING OF SHOULDER TO CASING :-
 - a) OVALITY OF CASING ON OUTER DIAMETER TO BE MAINTAINED WITHIN 1.0 MM
 - b) WELDING OF SHOULDER TO CASING AS PER DETAIL-A, TO BE DONE IN SUCH A WAY AS TO ENSURE THAT DISTORTION OF COLLAR IS LIMITED SUCH THAT DIMØ787.4mm IS
STRICTLY WITHIN THE TOLERANCE SPECIFIED IN SHT 1OF 3.
VENDOR TO DO THE NEEDFUL TO ACHIEVE 12(a) AND 12(b).
13. SURFACE PREPARATION AND PAINTING: REF PAINTING SCHEME DOC. No. : PS- L&T - TANDA. BENDS.
14. TOLERANCE FOR SPOOL PIPE AS PER API-5L-(PSL-1)-GR:B STANDARD.
15. OVERALL BEND TOLERANCE:-
 - a). AXIAL SHIFT: ± 3 mm
 - b). RADIAL SHIFT: ± 3 mm
 - c). OUT OF SQUARENESS: ± 3 mm.
16. ALL PARTS HAVE TO BE 6mm FILLET WELDED, IF NOT SPECIFIED.

Name of Customer/Project

BHARAT HEAVY ELECTRICALS LTD.,
ELECTROPORCELAINS DIVISION
BANGALORE - 560 012

	NAME	SIGN	DATE
DRN	S.Murali		03-06-2016
CHD	M.Vinod		09/07/16
APPD	Felix.J		09.07.16

DEPT	GRADE OF TOL DIM	SCALE	WEIGHT (kg)	REF TO ASSY.DRG	ITEM No.	No.OF ITEMS
CODE	C/M/F	N.T.S.	(Approx)	EL-DG-3-986-01-09790 (7131- SHT-4)		
TITLE				CARD CODE	DRAWING No.	REV.
CASING FOR PIPE BENDS - 700NB (I.D 686)					3-986-01-09801	03
				SHEET No.	3	No.OF SHEETS 3

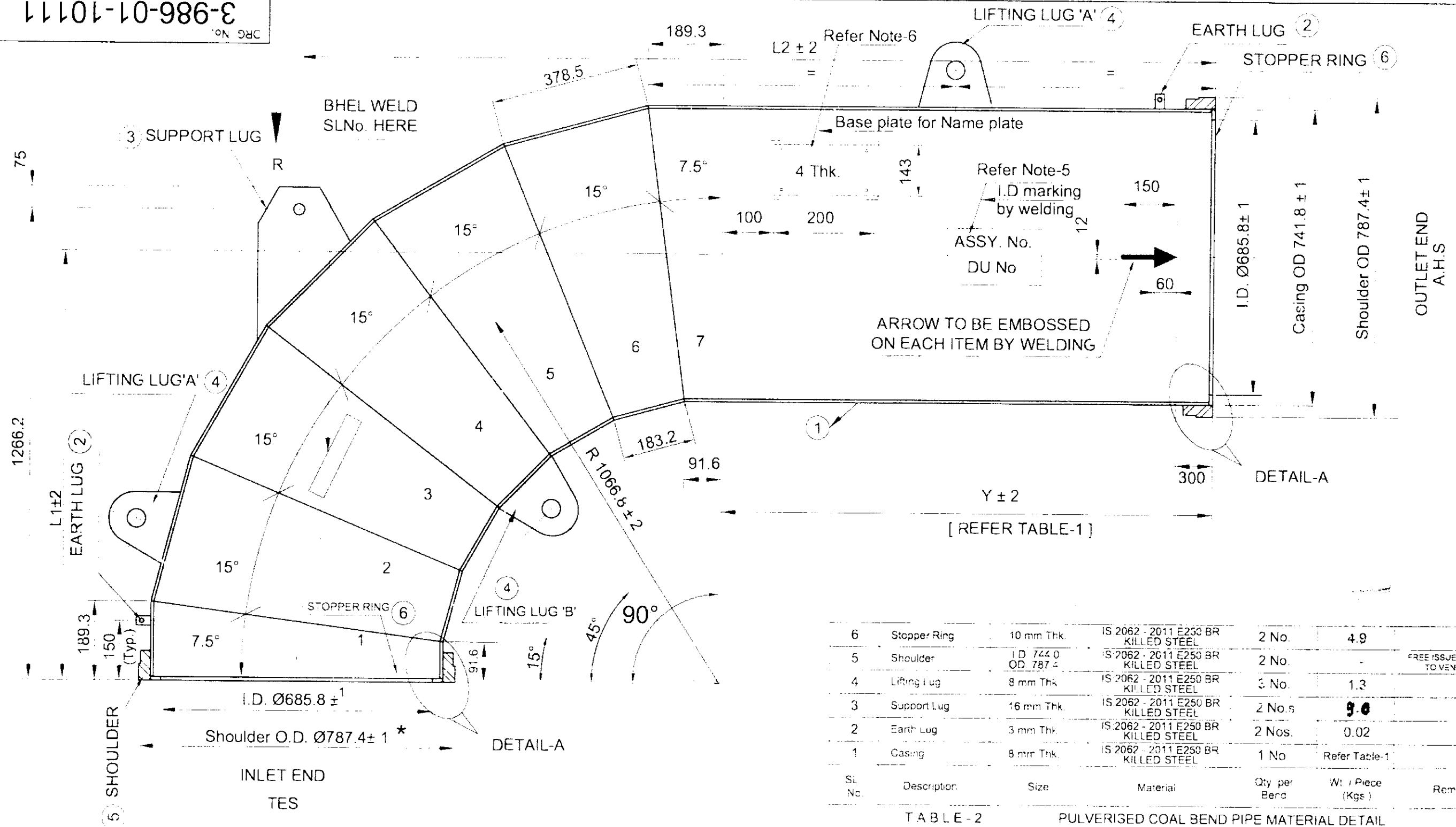
SUPERSEDES DRG. No.

SHT.24 SIZE A3 420 x 297

ALL DIMENSIONS ARE IN mm.

3-986-01-10111

INVENTORY No.



SECTIONED VIEW

* This dimension to be maintained strictly as per tolerance indicated.

6	Stopper Ring	10 mm Thk.	IS 2062 - 2011 E250 BR KILLED STEEL	2 No.	4.9	
5	Shoulder	ID 744.0 OD 787.4	IS 2062 - 2011 E250 BR KILLED STEEL	2 No.	-	FREE ISSUE BY BH&L TO VENDOR
4	Lifting Lug	8 mm Thk.	IS 2062 - 2011 E250 BR KILLED STEEL	3 No.	1.3	
3	Support Lug	16 mm Thk.	IS 2062 - 2011 E250 BR KILLED STEEL	2 Nos.	9.0	
2	Earth Lug	3 mm Thk.	IS 2062 - 2011 E250 BR KILLED STEEL	2 Nos.	0.02	
1	Casing	8 mm Thk.	IS 2062 - 2011 E250 BR KILLED STEEL	1 No	Refer Table-1	
Sl. No.	Description	Size	Material	Qty per Bend	Wt. / Piece (Kgs.)	Remarks

TABLE-2 PULVERISED COAL BEND PIPE MATERIAL DETAIL

Name of Customer/Project



BHARAT HEAVY ELECTRICALS LTD.,
ELECTROPORCELAINS DIVISION
BANGALORE - 560 012

	NAME	SIGN	DATE
DRN	Kaushik k		08-11-2016
CHD	M Vinod		08-11-16
APPO	Felix J		08-11-16

DEPT	GRADE OF TOL DIM			SCALE	WEIGHT (kg)	REF TO ASSY.DRG	ITEM No.	No.OF ITEM.
CODE	C/M/F			N.T.S.	---	3-986-01-10111 (7131-SHT-1)		
TITLE					CARD CODE	DRAWING No.		REV.
CASING FOR PIPE BENDS - 700NB(I.D 686)						3-986-01-10111		0
						SHEET No. 1	No.OF SHEETS 4	

SUPERSEDES DRG. No

SHT 24 SIZE A3 A20 W 207

FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm.

REV	DATE	ALTERED	CHECKED	REV	DATE	ALTERED	CHECKED	REV	DATE	ALTERED	CHECKED	DEPT	GRADE OF TOL DIM	SCALE	WEIGHT (kg)	REF TO ASSY.DRG	ITEM No.	No.OF ITEMS
01																		
03																		
02																		
01																		
SL. No.	DU No.	ASSY No.	SEGMENTS FOR ASSY.	L1 ± 2	L2 ± 2	Y	T.E.S. A.H.S.	Qty No s per Unit	Weight kgs./Bend									
TABLE - 1																		
Name of Customer/Project																		
BHARAT HEAVY ELECTRICALS LTD., ELECTROPORCELAINS DIVISION BANGALORE - 560 012																		
NAME SIGN DATE																		
DRN Kaushik.k 08-11-2016																		
CHD M.Vinod 08-11-16																		
APPD Felix.J 08-11-16																		
DEPT GRADE OF TOL DIM SCALE WEIGHT (kg) REF TO ASSY.DRG ITEM No. No.OF ITEMS																		
CODE C/M/F N.T.S. (Approx) 3-986-01-10110 (7131-SHT-1)																		
TITLE CASING FOR PIPE BENDS - 700NB(I.D 686) CARD CODE DRAWING No. 3-986-01-10111 REV. 01																		
SHEET No. 2 No.OF SHEETS 4																		

SUPERSEDES DRG. No.

SHT.24 SIZE A3 420 x 297

FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm.

0
REV
3-986-01-10111
DRG No.

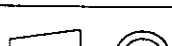
NOTES:-

1. FOR CONSTRUCTION MATERIAL REFER TABLE-2
2. DURING ASSY. LONGITUDINAL WELDING BETWEEN SEGMENTS TO BE STAGGERED.
3. ALL SUPPLIES TO CONFORM CLN:QP:01/00. WELDING AS PER WP:CL001A & AWS:D 1.1.
4. DIMENSIONS INDICATED ARE FINISHED SIZE ONLY.
5. ASSEMBLY No., DU No., AND ARROW HEAD TO BE WELD DEPOSITED OVER CASING AS SHOWN , AS PER CE:1501:21
6. BASE PLATE FOR NAME PLATE TO BE WELDED ON TO CASING, AT LOCATION SHOWN,
FOR BASE PLATE & WELDING DETAILS REF DRG : 4 986 99 07720
7. FACE ANGLES TO BE MATCHED DURING ASSY.
8. ALL OVER MACHINING 6.3/ FOR STOPPER RINGS.
9. A.H.S. =ARROW HEAD SIDE T.E.S. = TAIL END SIDE, V= SHOULDER FOR VICTAULIC COUPLING.
10. FOR CASING Wt. REFER TABLE -1
FOR Wt. OF SUPPORT LUG, LIFTING LUG, EARTH LUG & END RING (STOPPER RING)
REFER TABLE - 2
11. WHERE "Y" IS GREATER THAN 1000, ONE CIRCUMFERENTIAL JOINT IS ALLOWED ON "Y", OUTSIDE SEGMENT TOWARDS A.H.S. *THIS JOINT SHOULD NOT FOUL WITH LUG.*
12. CONTROL DURING WELDING OF SHOULDER TO CASING :-
 - a) OVALITY OF CASING ON OUTER DIAMETER TO BE MAINTAINED WITHIN 1.0 MM
 - b) WELDING OF SHOULDER TO CASING AS PER DETAIL-A, TO BE DONE IN SUCH A WAY AS TO ENSURE THAT DISTORTION OF COLLAR IS LIMITED SUCH THAT DIM. Ø787.4 mm IS STRICTLY WITHIN THE RANGE SPECIFIED IN SHEET 1 OF 4.
VENDOR TO DO THE NEEDFUL TO ACHIEVE 12(a) AND 12(b).
13. SURFACE PREPARATION AND PAINTING: REF PAINTING SCHEME DOC. No. : PS- L&T - KHARGONE. BENDS.
14. OVERALL BEND TOLERANCE:-
 - a). AXIAL SHIFT: ± 3 MM
 - b). RADIAL SHIFT: ± 3 MM
 - c). OUT OF SQUARENESS: ± 3 MM.
15. *ALL PARTS HAVE TO BE 6 mm FILLET WELDED, IF NOT SPECIFIED.*

Name of Customer/Project

BHARAT HEAVY ELECTRICALS LTD.,
ELECTROPORCELAINS DIVISION
BANGALORE - 560 012

	NAME	SIGN	DATE
DRN	Kaushik.k		08-11-2016
CHD	M.Vinod		08-11-16
APPD	Felix.J		08.11.16

DEPT	GRADE OF TOL DIM		SCALE	WEIGHT (kg)	REF TO ASSY.DRG	ITEM No.	No.OF ITEMS
COOE	C/M/F		N.T.S.	— (Approx)	3-986-01-10110 (7131- SHT-1)		
TITLE CASING FOR PIPE BENDS - 700NB(I.D 686)				CARD CODE	DRAWING No.		REV.
					3-986-01-10111		01
					SHEET No. 4		No.OF SHEETS 4

SUPERSEDES DRG. No.

SHT.24 SIZE A3 420 x 297

ALL DIMENSIONS ARE IN mm.

DRG No. 3-986-01-10121

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REF. DRG. No.

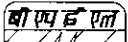
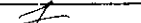
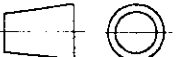
SIGN AND DATE

INVENTORY No.

01	CLCP005	H78-10 H34-18,H56-8,H56-10,H78-8, H34-10,H34-12,H34-14,H34-16, G78-10,H12-11,H12-13,H12-15, G34-17,G56-9,G56-11,G78-8, G34-9,G34-11,G34-13,G34-15, F78-13,G12-10,G12-12,G12-14, F56-11,F56-13,F78-8,F78-11, F34-12,F34-14,F34-16,F56-8, F12-11,F12-13,F34-8,F34-10, E78-9,E78-12,E78-14,F12-9, E34-12,E56-9,E56-12,E56-14, E12-10,E12-12,E34-8,E34-10, D34-11,D34-18,D78-10,E12-8, D12-10,D12-12,D12-14,D12-22, C12-21,C34-10,C34-17,C78-11, B78-13,C12-9,C12-11,C12-13, B12-20,B34-9,B34-16,B56-8,B78-8, A78-9,A78-14,B12-8,B12-10,B12-12, A12-8,A12-16,A34-8,A34-15,A56-9,	1 2 3 4 5 6 7	1066.8	2489.2	1422.4	V	W		446.0
VAR. No.	DU No.	Assy. No.	SEGMENTS FOR ASSY.	L1 ± 2	L2 ± 2	Y	T.E.S.	A.H.S.	Qty No's per Unit	Approx. Unit Wt. (kgs.)
							END DETAIL			

TABLE - 1

Name of Customer/Project

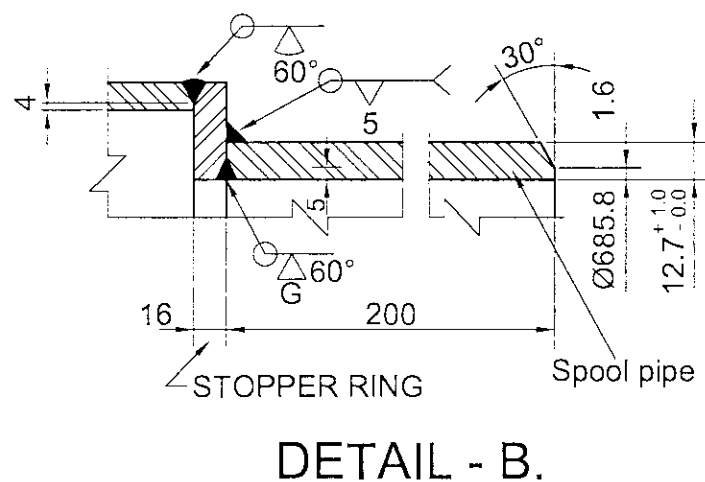
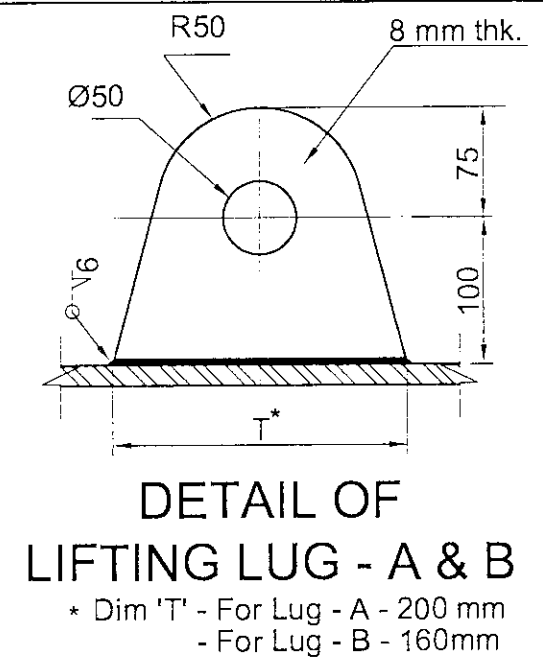
		BHARAT HEAVY ELECTRICALS LTD., ELECTROPORCELAINS DIVISION BANGALORE - 560 012		NAME Kaushik.k	SIGN 	DATE 08-11-2016
DEPT CODE		GF. ADE OF TOL. DIM C/M/F		SCALE N.T.S. WEIGHT (kg) — (Approx)	REF TO ASSY.DRG EL-DG-3-986-01-10120 (7131-SHT-2)	ITEM No. No. OF I.T. AS
TITLE CASING FOR PIPE BENDS - 700NB(I.D 686)				CARD CODE	DRAWING No. 3-986-01-10121	REV. 00
				SHEET No. 2	No. OF SHEETS 4	

SUPERSEDES DRG. No.

SHT.24 SIZE A3 420 x 297

ALL DIMENSIONS ARE IN mm.

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



INVENTORY No.	REV	DATE	ALTERED	REV	DATE	ALTERED	REV	DATE	ALTERED	DEPT	GRADE OF	 	SCALE	WEIGHT (kg)	REF TO ASSY.DRG	ITEM	No.OF
			CHECKED			CHECKED			CHECKED	CODE	TOL DIM		N.T.S	—	EL-DG-3-986-01-10120 (7131- SHT-2)	No.	ITEMS
											C/M/F		(Approx)				
											TITLE			CARD	DRAWING No.		REV.
											CASING FOR PIPE BENDS - 700NB(I.D 686)			CODE	3-986-01-10121		00
															SHEET No. 3	No.OF SHEETS 4	

SUPERSEDES DRG. No.

SHT.24 SIZE A3 420 x 297

FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm.

00
REV

3-986-01-10121

DRG No.

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NOTE:-

1. FOR CONSTRUCTION MATERIAL REFER TABLE-2
2. DURING ASSY. LONGITUDINAL WELDING BETWEEN SEGMENTS TO BE STAGGERED.
3. ALL SUPPLIES TO CONFORM CLN:QP:01/00. WELDING AS PER WP:CL001A & AWS:D 1.1.
4. DIMENSIONS INDICATED ARE FINISHED SIZE ONLY.
5. ASSEMBLY No., DU No., AND ARROW HEAD TO BE WELD DEPOSITED OVER CASING AS SHOWN , AS PER CE:1501:21
6. BASE PLATE FOR NAME PLATE TO BE WELDED ON TO CASING, AT LOCATION SHOWN,
FOR BASE PLATE & WELDING DETAILS REF DRG : 4 986 99 07720
7. FACE ANGLES TO BE MATCHED DURING ASSY.
8. ALL OVER MACHINING 6.3/ FOR STOPPER RINGS.
9. A.H.S. =ARROW HEAD SIDE T.E.S. = TAIL END SIDE, V= SHOULDER FOR VICTAULIC COUPLING, W = SPOOL PIPE.
10. FOR CASING Wt. REFER TABLE -1
FOR Wt. OF LIFTING LUG, EARTH LUG, STOPPER RINGS AND SPOOL PIPE.
REFER TABLE - 2
11. WHERE "Y" IS GREATER THAN 1000, ONE CIRCUMFERENTIAL JOINT IS ALLOWED ON "Y", OUTSIDE SEGMENT TOWARDS A.H.S. THIS JOINT SHOULD NOT FOUL WITH LUG.
12. CONTROL DURING WELDING OF SHOULDER TO CASING :-
 - a] OVALITY OF CASING ON OUTER DIAMETER TO BE MAINTAINED WITHIN 1.0 MM
 - b] WELDING OF SHOULDER TO CASING AS PER DETAIL-A, TO BE DONE IN SUCH A WAY AS TO ENSURE THAT DISTORTION OF COLLAR IS LIMITED SUCH THAT DIM Ø 787.4 mm IS STRICTLY WITHIN THE TOLERANCE SPECIFIED IN SHT 10F 4.
VENDOR TO DO THE NEEDFUL TO ACHIEVE 12(a) AND 12(b).
13. SURFACE PREPARATION AND PAINTING: REF PAINTING SCHEME DOC. No. : PS- L&T - KHARGONE. BENDS.
14. TOLERANCE FOR SPOOL PIPE AS PER API-5L-(PSLI)-GR:B STANDARD.
15. OVERALL BEND TOLERANCE:-
 - a]. AXIAL SHIFT: ± 3 MM
 - b]. RADIAL SHIFT: ± 3 MM
 - c]. OUT OF SQUARENESS: ± 3 MM.
16. ALL PARTS HAVE TO BE 6 mm FILLET WELDED, IF NOT SPECIFIED.

Name of Customer/Project

BHARAT HEAVY ELECTRICALS LTD.,
ELECTROPORCELAINS DIVISION
BANGALORE - 560 012

	NAME	SIGN	DATE
ORN	Kaushik.k		08-11-2016
CHD	M.Vinod		08.11.16
APPD	Felix.J		08.11.16

DEPT	GRADE OF TOL DIM	SCALE	WEIGHT (kg)	REF TO ASSY.DRG	ITEM No.	No.OF ITEMS
CODE	C/M/F	N.T.S.	(Approx)	EL-DG-3-986-01-10120 (7131- SHT-2)		
TITLE				CARD CODE	DRAWING No.	REV.
CASING FOR PIPE BENDS - 700NB(I.D 686)					3-986-01-10121	00
				SHEET No.	No.OF SHEETS	
				4	4	

SUPERSEDES DRG. No.

SHT.24 SIZE A3 420 x 297

10

3-986-01-10131

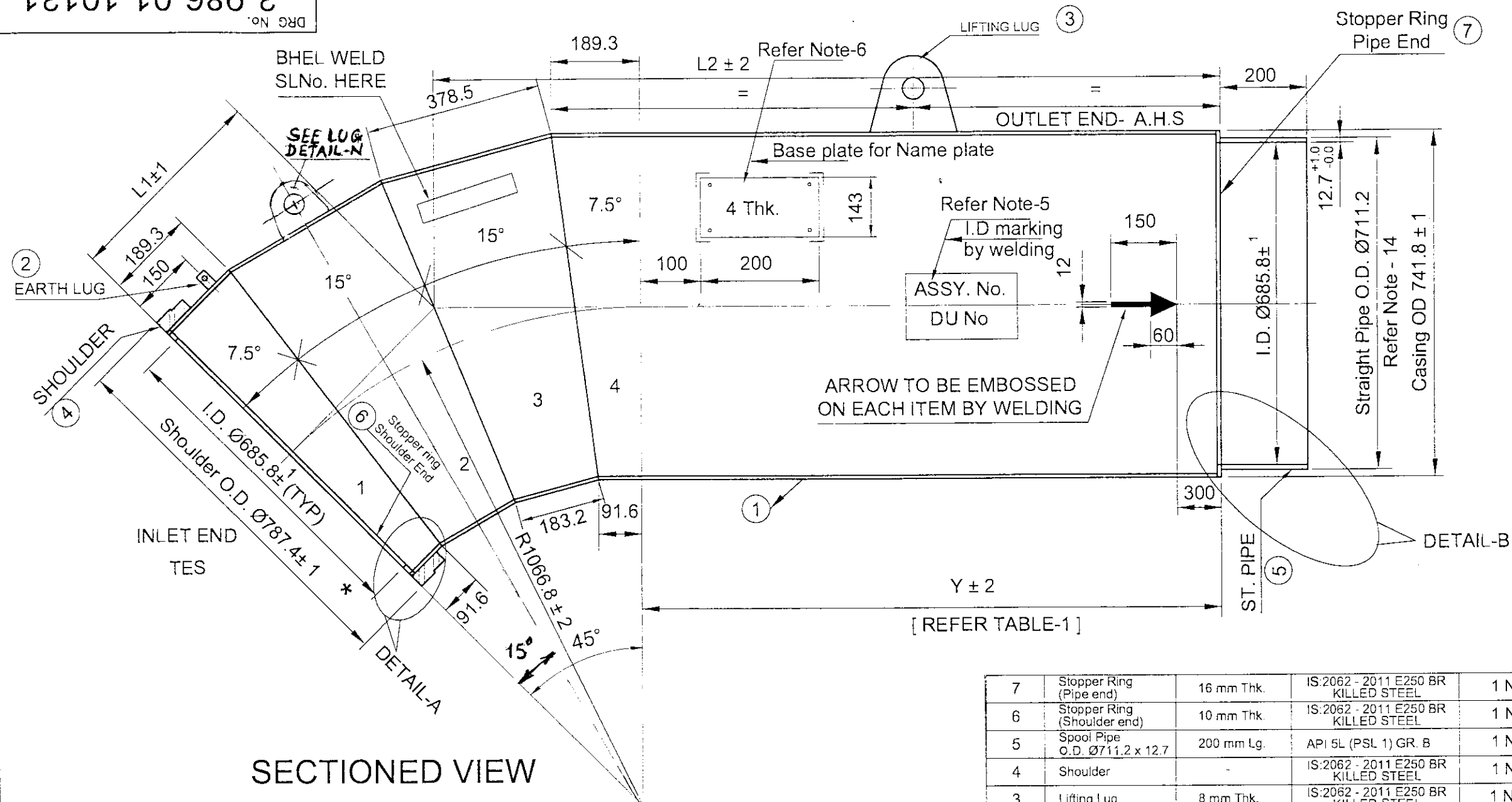
REV

DRG No.

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

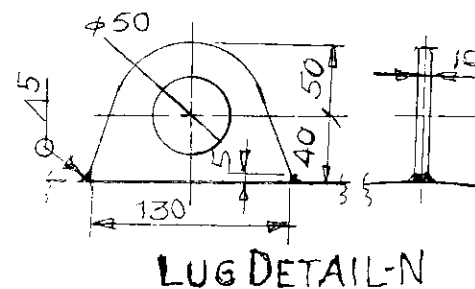
SIGN AND DATE REF. DRG. No.

INVENTORY I.S.



SECTIONED VIEW

* This dimension to be maintained strictly as per tolerance indicated.



SL. No.	Description	Size	Material	Qty. per Bend	Wt. / Piece (Kgs.)	Remarks
7	Stopper Ring (Pipe end)	16 mm Thk.	IS:2062 - 2011 E250 BR KILLED STEEL	1 No.	7.9	
6	Stopper Ring (Shoulder end)	10 mm Thk.	IS:2062 - 2011 E250 BR KILLED STEEL	1 No.	4.9	
5	Spool Pipe O.D. Ø711.2 x 12.7	200 mm Lg.	API 5L (PSL 1) GR. B	1 No.	-	FREE ISSUE BY BHEL TO VENDOR
4	Shoulder	-	IS:2062 - 2011 E250 BR KILLED STEEL	1 No.	-	FREE ISSUE BY BHEL TO VENDOR
3	Lifting Lug	8 mm Thk.	IS:2062 - 2011 E250 BR KILLED STEEL	1 Nos	1.3	Lug-N additional
2	Earth Lug	3 mm Thk.	IS:2062 - 2011 E250 BR KILLED STEEL	1 No.	0.02	
1	Casing	8 mm Thk.	IS:2062 - 2011 E250 BR KILLED STEEL	1 No.	Refer Table-1	

TABLE - 2

PULVERISED COAL BEND PIPE MATERIAL DETAIL

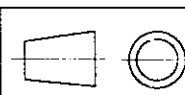
Name of Customer/Project



BHARAT HEAVY ELECTRICALS LTD.,
ELECTROPORCELAINS DIVISION
BANGALORE - 560 012

DEPT
CODE

GRADE OF
TOL DIM
C/M/F



SCALE
N.T.S.

WEIGHT (kg)
-
(Approx)

REF TO ASSY.DRG
EL-DG-3-986-01-10130
(7131-SHT-3)

ITEM No.
No. OF ITEMS

TITLE
CASING FOR
PIPE BENDS - 700NB (I.D 686)

CARD CODE

DRAWING No.
3-986-01-10131 01

SHEET No. 1 No. OF SHEETS 4

FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm.

REV 01
DRG No. 3-986-01-10131

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REF. DRG. No.

SIGN AND DATE

INVENTORY No.

REV	DATE	ALTERED	REV	DATE	ALTERED	REV	DATE	ALTERED
		CHECKED			CHECKED			CHECKED

01	CLCP006	A12-11,A12-13,A34-6,A34-11, A34-13,A56-6,A78-6,B12-6,B12-15, B12-17,B34-6,B34-12,B34-14,B56-6, B78-6,C12-6,C12-16,C12-18,C34-6, C34-13,C34-15,C56-5,C78-6,D12-6, D12-17,D12-19,D34-14,D34-16,E12-6, E12-14,E12-16,E34-14,E34-16,E56-6, E78-6,F12-6,F12-15,F12-17,F34-6, F34-18,F34-20,F56-6,F78-6,G12-6, G12-16,G12-18,G34-6,G34-19, G34-21,G56-6,G78-5,H12-17,H12-19, H34-6,H34-20,H34-22	1 2 3 7	441.88	1864.28	1422.4	V	W		325.0
VAR. No.	DU No.	ASSEMBLY No.	SEGMENTS FOR ASSY.	L1 ± 2	L2 ± 2	Y	T.E.S.	A.H.S.	Qty No's per Unit	Approx. Unit Wt. (kgs.)
END DETAIL										

TABLE - 1

Name of Customer/Project

BHARAT HEAVY ELECTRICALS LTD.,
ELECTROPORCELAINS DIVISION
BANGALORE - 560 012

DEPT	GRADE OF TOL DIM C/M/F	SCALE N.T.S.	WEIGHT (kg) (Approx)	REF TO ASSY.DRG EL-DG-3-986-01-10130 (7131-SHT-3)	ITEM No.	No. OF ITEMS
CODE						
TITLE	CASING FOR PIPE BENDS - 700NB(I.D 686)			CARD CODE	DRAWING No. 3-986-01-10131	REV. 01
		SHEET No. 2	No. OF SHEETS 4			

SUPERSEDES DRG. No.

FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm.

REV

3-986-01-10131

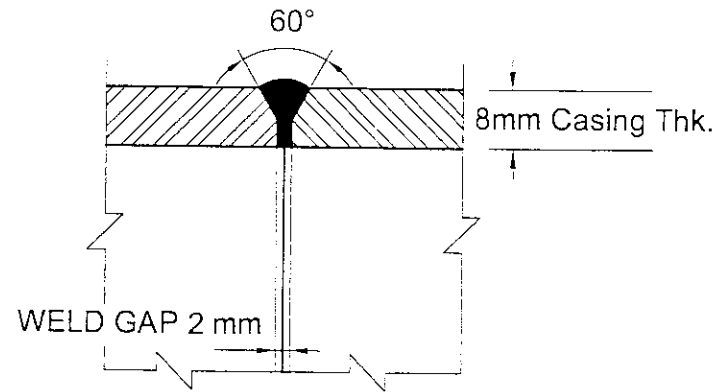
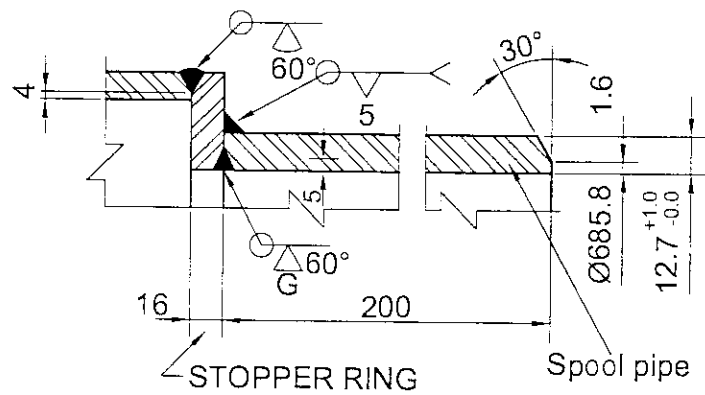
DRG No.

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

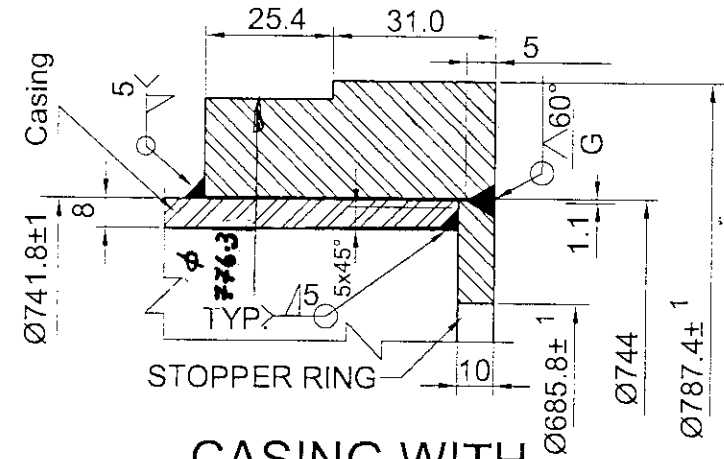
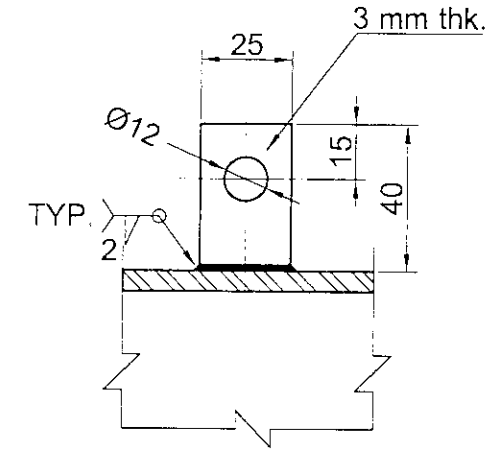
REF. DRG. No.

SIGN AND DATE

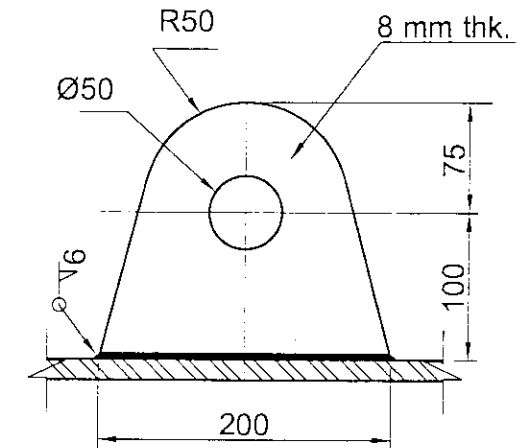
INVENTORY No.

EDGE PREPARATION
WELDING DETAIL

DETAIL - B.

CASING WITH
SHOULDER WELD DETAIL
DETAIL-A

EARTH LUG DETAIL

DETAIL OF
LIFTING LUG

Name of Customer/Project

BHARAT HEAVY ELECTRICALS LTD.,
ELECTROPORCELAINS DIVISION
BANGALORE - 560 012

OR	NAME	SIGN	DATE
OR	Kaushik.K		08-11-2016
CHD	M.Vinod		08-11-16
APPD	Felix.J		08-11-16

DEPT	GRADE OF TOL DIM C/M/F	SCALE	WEIGHT (kg)	REF TO ASSY.DRG	ITEM No.	No. OF ITEMS
CODE		N.T.S.	(Approx)	EL-DG-3-986-01-10130 (7131-SHT-3)		
TITLE	CASING FOR PIPE BENDS - 700NB(I.D 686)			CARD CODE	DRAWING No.	REV.
					3-986-01-10131	01
					SHEET No. 3	No. OF SHEETS 4

SUPERSEDES DRG. No.

SHT.24 SIZE A3 420 x 297

REV
10

3-986-01-10131

DRG No.

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NOTE:-

1. FOR CONSTRUCTION MATERIAL REFER TABLE-2
2. DURING ASSY. LONGITUDINAL WELDING BETWEEN SEGMENTS TO BE STAGGERED.
3. ALL SUPPLIES TO CONFORM CLN:QP:01/00. WELDING AS PER WP:CL001A & AWS:D 1.1.
4. DIMENSIONS INDICATED ARE FINISHED SIZE ONLY.
5. ASSEMBLY No., DU No., AND ARROW HEAD TO BE WELD DEPOSITED OVER CASING AS SHOWN , AS PER CE:1501:21
6. BASE PLATE FOR NAME PLATE TO BE WELDED ON TO CASING, AT LOCATION SHOWN,
FOR BASE PLATE & WELDING DETAILS REF DRG : 4 986 99 07720
7. FACE ANGLES TO BE MATCHED DURING ASSY.
8. ALL OVER MACHINING 6.3/ FOR STOPPER RINGS.
9. A.H.S. =ARROW HEAD SIDE T.E.S. = TAIL END SIDE, V= SHOULDER FOR VICTAULIC COUPLING, W = SPOOL PIPE.
10. FOR CASING Wt. REFER TABLE -1
FOR Wt. OF LIFTING LUG, EARTH LUG, STOPPER RINGS AND SPOOL PIPE.
REFER TABLE - 2
11. WHERE "Y" IS GREATER THAN 1000, ONE CIRCUMFERENTIAL JOINT IS ALLOWED ON "Y", OUTSIDE SEGMENT TOWARDS A.H.S. *THIS JOINT SHOULD NOT FOUL WITH LUG.*
12. CONTROL DURING WELDING OF SHOULDER TO CASING :-
 - a] OVALITY OF CASING ON OUTER DIAMETER TO BE MAINTAINED WITHIN 1.0 MM
 - b] WELDING OF SHOULDER TO CASING AS PER DETAIL-A, TO BE DONE IN SUCH A WAY AS TO ENSURE THAT DISTORTION OF COLLAR IS LIMITED SUCH THAT DIMØ787.4mm IS
STRICTLY WITHIN THE TOLERANCE SPECIFIED IN SHT 1OF 4.
VENDOR TO DO THE NEEDFUL TO ACHIEVE 12(a) AND 12(b).
13. SURFACE PREPARATION AND PAINTING: REF PAINTING SCHEME DOC. No. : PS- L&T - KHARGONE. BENDS.
14. TOLERANCE FOR SPOOL PIPE AS PER API-5L-(PSL 1)-GR:B STANDARD.
15. OVERALL BEND TOLERANCE:-
 - a]. AXIAL SHIFT: ± 3 mm
 - b]. RADIAL SHIFT: ± 3 mm
 - c]. OUT OF SQUARENESS: ± 3 mm.
16. *ALL PARTS HAVE TO BE 6mm FILLET WELDED, IF NOT SPECIFIED.*

Name of Customer/Project

BHARAT HEAVY ELECTRICALS LTD.,
ELECTROPORCELAINS DIVISION
BANGALORE - 560 012

	NAME	SIGN	DATE
DRN	Kaushik K		08-11-2016
CHD	M.Vinod		08-11-16
APPD	Felix.J		08-11-16

DEPT	GRADE OF	SCALE	WEIGHT (kg)	REF TO ASSY.DRG	ITEM	No.OF
CODE	TOL DIM	N.T.S.	—	EL-DG-3-986-01-10130	No.	ITEMS
	C/M/F		(Approx)	(7131- SHT-3)		
TITLE	CARD	DRAWING No.	REV.			
CASING FOR	CODE	3-986-01-10131	01			
PIPE BENDS - 700NB(I.D 686)		SHEET No. 4	No.OF SHEETS 4			

SUPERSEDES DRG. No.

SHT.24 SIZE A3 420 x 297

FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm.

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REV

3-986-01-10141

DRG No.

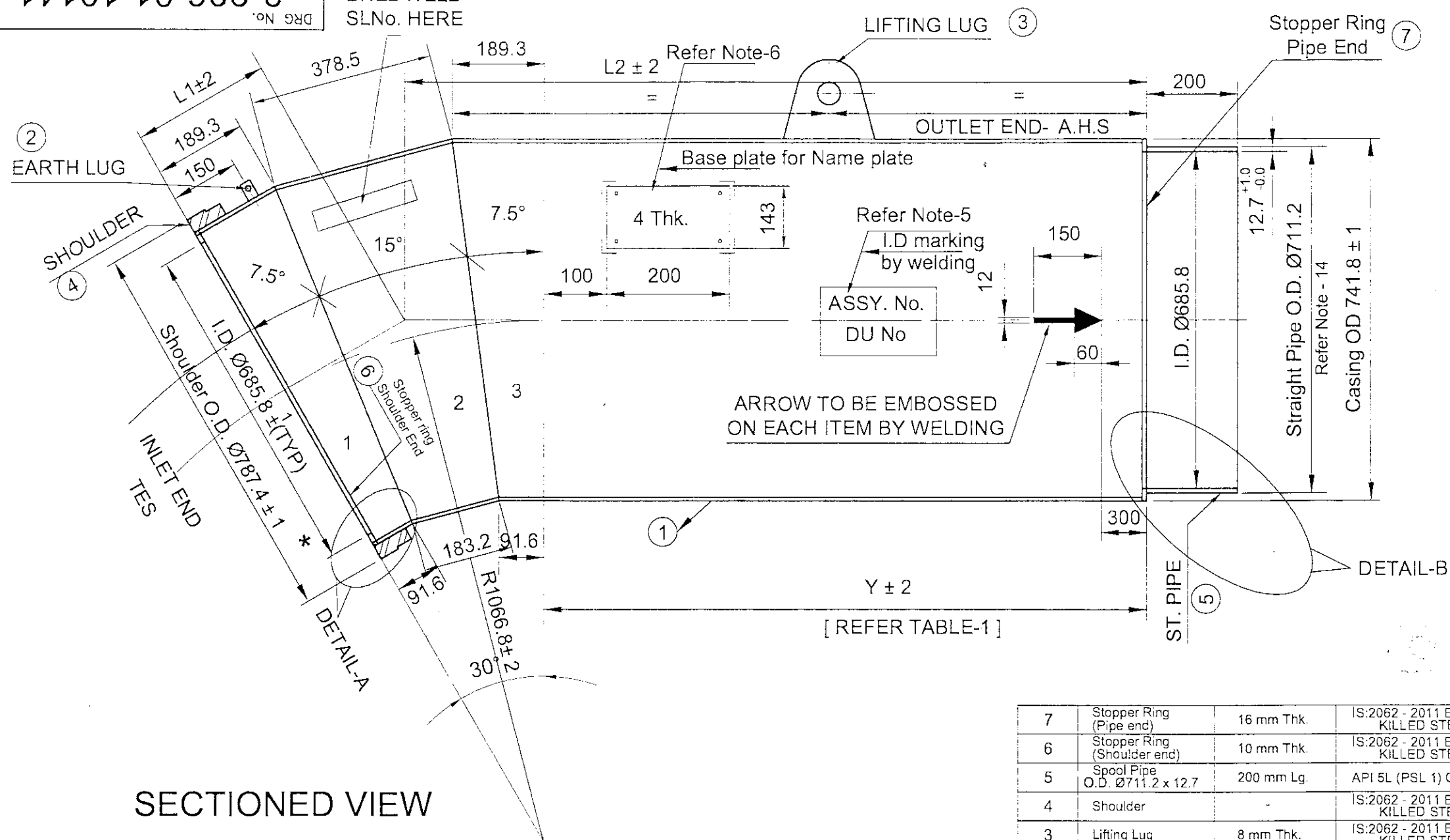
BHEL WELD
SLNo. HERE

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REF. DRG. No.

SIGN AND DATE

INVENTORY No.



SECTIONED VIEW

* This dimension to be maintained strictly as per tolerance indicated.

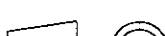
7	Stopper Ring (Pipe end)	16 mm Thk.	IS:2062 - 2011 E250 BR KILLED STEEL	1 No.	7.9	
6	Stopper Ring (Shoulder end)	10 mm Thk.	IS:2062 - 2011 E250 BR KILLED STEEL	1 No.	4.9	
5	Spool Pipe O.D. Ø711.2 x 12.7	200 mm Lg.	API 5L (PSL 1) GR. B	1 No.	-	FREE ISSUE BY BHEL TO VENDOR
4	Shoulder	-	IS:2062 - 2011 E250 BR KILLED STEEL	1 No.	-	FREE ISSUE BY BHEL TO VENDOR
3	Lifting Lug	8 mm Thk.	IS:2062 - 2011 E250 BR KILLED STEEL	1 No's	1.3	
2	Earth Lug	3 mm Thk.	IS:2062 - 2011 E250 BR KILLED STEEL	1 No.	0.02	
1	Casing	8 mm Thk.	IS:2062 - 2011 E250 BR KILLED STEEL	1 No.	Refer Table-1	
SL No	Description	Size	Material	Qty. per Bend	Wt. / Piece (Kgs.)	Remarks

TABLE - 2

PULVERISED COAL BEND PIPE MATERIAL DETAIL

Name of Customer/Project

BHARAT HEAVY ELECTRICALS LTD.,
ELECTROPORCELAINS DIVISION
BANGALORE - 560 012

DEPT	GRADE OF TOL DIM		SCALE	WEIGHT (kg)	REF TO ASSY.DRG	ITEM No.	No.OF ITEMS
CODE	C/M/F		N.T.S.	— (Approx)	EL-DG-3-986-01-10140 (7131-SHT-4)		
TITLE				CARD CODE	DRAWING No.		REV.
CASING FOR PIPE BENDS - 700NB(I.D 686)					3-986-01-10141		00
					SHEET No. 1	No.OF SHEETS 3	

SUPERSEDES DRG. No.

SHT.24 SIZE A3 420 x 297

ALL DIMENSIONS ARE IN mm.

00
REV

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

1. FOR CONSTRUCTION MATERIAL REFER TABLE-2

2. DURING ASSY. LONGITUDINAL WELDING BETWEEN SEGMENTS TO BE STAGGERED.

3. ALL SUPPLIES TO CONFORM CLN:QP:01/00. WELDING AS PER WP:CL001A & AWS:D 1.1.

4. DIMENSIONS INDICATED ARE FINISHED SIZE ONLY.

5. ASSEMBLY No., DU No., AND ARROW HEAD TO BE WELD DEPOSITED OVER CASING AS SHOWN , AS PER CE:1501:21

6. BASE PLATE FOR NAME PLATE TO BE WELDED ON TO CASING, AT LOCATION SHOWN,
FOR BASE PLATE & WELDING DETAILS REF DRG : 4 986 99 07720

7. FACE ANGLES TO BE MATCHED DURING ASSY.

8. ALL OVER MACHINING 6.3/FOR STOPPER RINGS.

9. A.H.S. =ARROW HEAD SIDE T.E.S. = TAIL- END SIDE, V= SHOULDER FOR VICTAULIC COUPLING, W = SPOOL PIPE.

10. FOR CASING Wt. REFER TABLE -1
FOR Wt. OF LIFTING LUG, EARTH LUG, STOPPER RINGS AND SPOOL PIPE.
REFER TABLE - 2

11. WHERE "Y" IS GREATER THAN 1000, ONE CIRCUMFERENTIAL JOINT IS ALLOWED ON "Y", OUTSIDE SEGMENT TOWARDS A.H.S. THIS JOINT SHOULD NOT FOUL WITH LUG.

12. CONTROL DURING WELDING OF SHOULDER TO CASING :-
a] OVALITY OF CASING ON OUTER DIAMETER TO BE MAINTAINED WITHIN 1.0 MM
b] WELDING OF SHOULDER TO CASING AS PER DETAIL-A, TO BE DONE IN SUCH A WAY AS TO ENSURE THAT DISTORTION OF COLLAR IS LIMITED SUCH THAT DIMØ787.4mm IS STRICTLY WITHIN THE TOLERANCE SPECIFIED IN SHT 1OF 3.
VENDOR TO DO THE NEEDFUL TO ACHIEVE 12(a) AND 12(b).

13. SURFACE PREPARATION AND PAINTING: REF PAINTING SCHEME DOC. No. : PS- L&T - KHARGONE. BENDS.

14. TOLERANCE FOR SPOOL PIPE AS PER API-5L-(PSL-1)-GR:B STANDARD.

15. OVERALL BEND TOLERANCE:-
a]. AXIAL SHIFT: ± 3 mm
b]. RADIAL SHIFT: ± 3 mm
c]. OUT OF SQUARENESS: ± 3 mm.

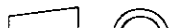
16. ALL PARTS HAVE TO BE 6 mm FILLET WELDED, IF NOT SPECIFIED.

Name of Customer/Project		NAME	SIGN	DA
BHARAT HEAVY ELECTRICALS LTD				

Name of Customer/Project:

BHARAT HEAVY ELECTRICALS LTD.,
ELECTROPORCELAINS DIVISION
BANGALORE - 560 012

	NAME	SIGN	DATE
DRN	Kaushik.K		08-11-2016
CHD	M.Vinod		08-11-16
APPO	Felix.J		08-11-16

DEPT	GRADE OF TOL DIM		SCALE	WEIGHT (kg)	REF TO ASSY.DRG	ITEM No.	No. OF ITEMS
CODE	C/M/F		N.T.S.	— (Approx)	EL-DG-3-986-01-10140 (7131- SHT-4)		
TITLE				CARD CODE	DRAWING No.		REV.
CASING FOR PIPE BENDS - 700NB(I.D 686)					3-986-01-10141		00
					SHEET No. 3	No. OF SHEETS 3	

SUPERSEDES DRG. No.

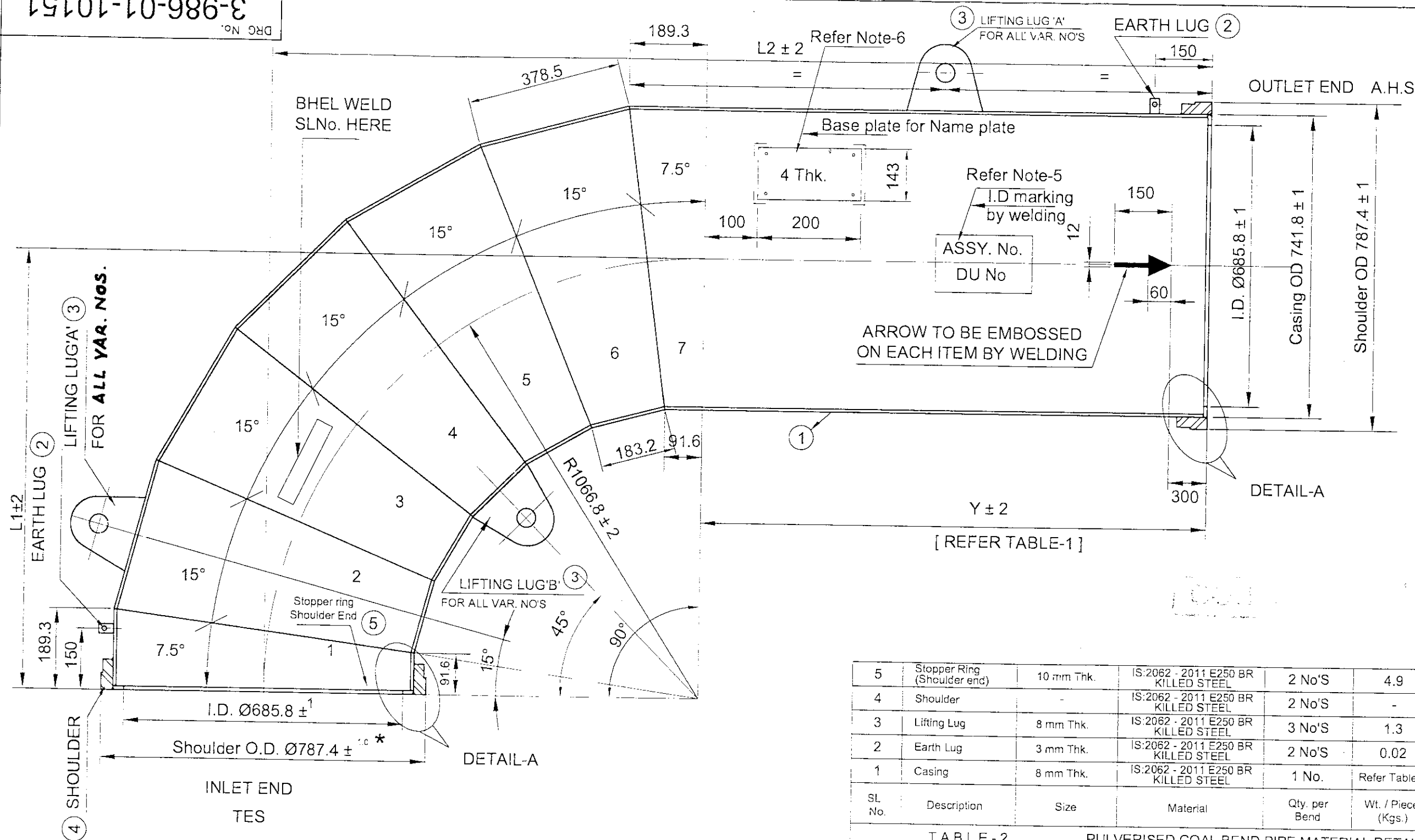
SHT.24 SIZE A3 420 x 297

ALL DIMENSIONS ARE IN mm.

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SIGN AND DATE	REF. DRG. No.

INVENTORY No.



SECTIONED VIEW

* This dimension to be maintained strictly as per tolerance indicated.

5	Stopper Ring (Shoulder end)	10 mm Thk.	IS:2062 - 2011 E250 BR KILLED STEEL	2 No'S	4.9	
4	Shoulder	-	IS:2062 - 2011 E250 BR KILLED STEEL	2 No'S	-	(FREE ISSUE BY BHEL TO VENDOR)
3	Lifting Lug	8 mm Thk.	IS:2062 - 2011 E250 BR KILLED STEEL	3 No'S	1.3	
2	Earth Lug	3 mm Thk.	IS:2062 - 2011 E250 BR KILLED STEEL	2 No'S	0.02	
1	Casing	8 mm Thk.	IS:2062 - 2011 E250 BR KILLED STEEL	1 No.	Refer Table-1	
SL No.	Description	Size	Material	Qty. per Bend	Wt. / Piece (Kgs.)	Remarks

TABLE - 2 PULVERISED COAL BEND PIPE MATERIAL DETAIL

Name of Customer/Project



BHARAT HEAVY ELECTRICALS LTD.,
ELECTROPORCELAINS DIVISION
BANGALORE - 560 012

	NAME	SIGN	DATE
DRN	Kaushik.K		08-11-2016
CHD	M.Vinod		08-11-16
APPD	Felix.J		08-11-16

DEPT	GRADE OF TOL DIM		SCALE	WEIGHT (kg)	REF TO ASSY.DWG	ITEM	Na.OF
CODE	C/M/F		N.T.S.	— (Approx)	3-986-01-10150 (7131-SHT-5)	No.	ITEMS
TITLE				CARD CODE	DRAWING No.	REV.	
CASING FOR PIPE BENDS - 700NB(I.D 686)					3-986-01-10151	01	
					SHEET No. 1	No.OF SHEETS 4	

SUPERSEDES DRG. No.

SHT.24 SIZE A3 420 x 297

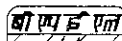
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05	CLCP-014	E78-16, F78-15, G78-12, H78-12	1 2 3 4 5 6 7	1066.8	1519.85	453.05	V	V		306.2
04	CLCP-013	E56-17, F56-16, G56-14, H56-13	1 2 3 4 5 6 7	1066.8	2619.85	1553.05	V	V		465.5
03	CLCP-012	E34-19, F34-23, G34-24, H34-25	1 2 3 4 5 6 7	1066.8	2484.85	1418.05	V	V		446.0
02	CLCP-011	E12-18, F12-19, G12-20, H12-21	1 2 3 4 5 6 7	1066.8	1384.85	318.05	V	V		286.7
01	CLCP-010	A56 -12, B56-11, C56-8, D56-9	1 2 3 4 5 6 7	1066.8	2519.85	1453.05	V	V		451.0
SL. No.	DU No.	ASSEMBLY NO.	SEGMENTS FOR ASSY.	L1 ± 2	L2 ± 2	Y	T.E.S.	A.H.S.	Qty No's per Unit	Approx. Unit Wt. (kgs.)
							END DETAIL			

TABLE - 1

Name of Customer/Project

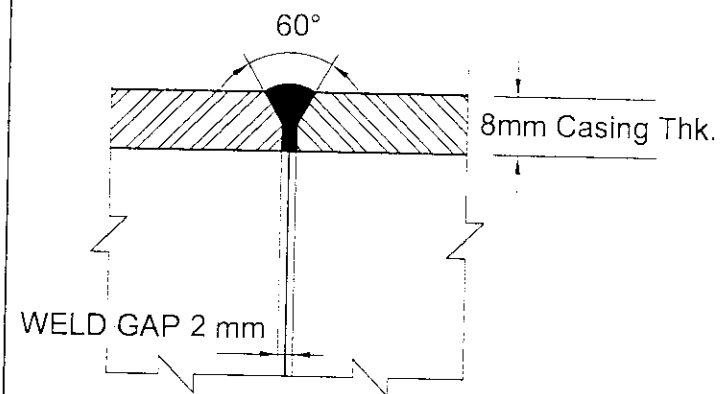
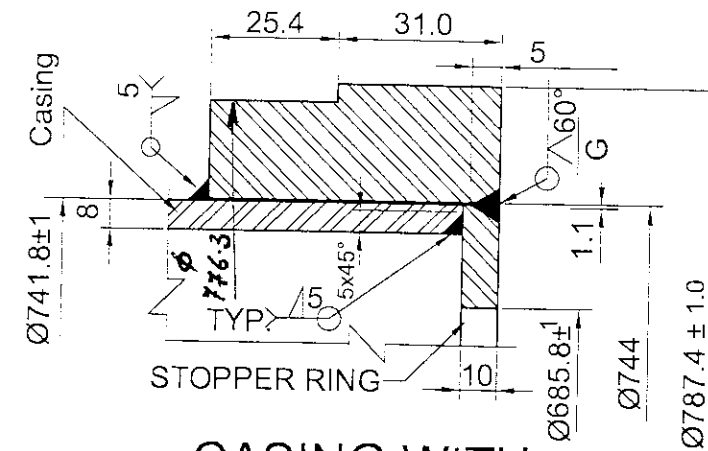
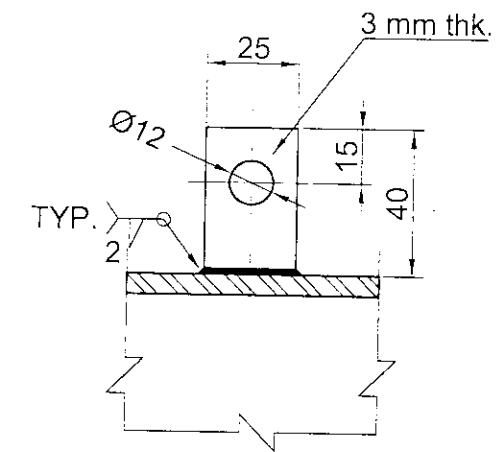
		BHARAT HEAVY ELECTRICALS LTD., ELECTROPORCELAINS DIVISION BANGALORE - 560 012		NAME		SIGN	DATE	
				DRN	Kaushik.K		08-11-2016	
				CHD	M.Vinod		08-11-16	
				APPD	Felix.J		08-11-16	
DEPT	GRADE OF		SCALE	WEIGHT (kg)	REF TO ASSY.DRG 3-986-01-10150 (7131- SHT-5)		ITEM No.	No.OF ITEMS
CODE	TOL D:M C/M/F		N.T.S.	— (Approx)				
TITLE CASING FOR PIPE BENDS - 700NB(I.D 686)				CARD CODE	DRAWING No.		REV.	
					3-986-01-10151		01	
				SHEET No. 2		No.OF SHEETS 4		

SUPERSEDES DRG. No.

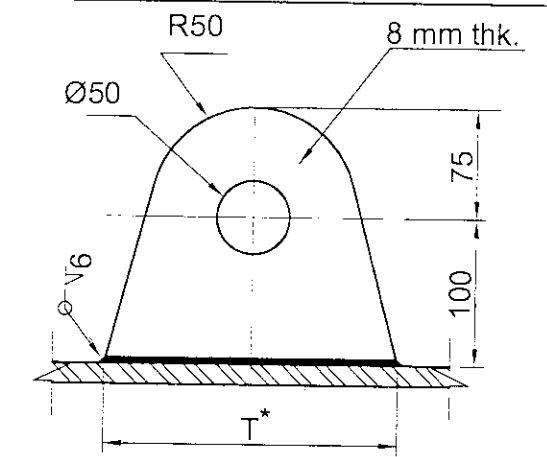
SHT.24 SIZE A3 420 x 297

FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm.

10
REV
3-986-01-10151
DRG No.EDGE PREPARATION
WELDING DETAILCASING WITH
SHOULDER WELD DETAIL
DETAIL-A

EARTH LUG DETAIL

DETAIL OF
LIFTING LUG - A & B* Dim 'T' - For Lug - A - 200 mm
- For Lug - B - 160 mm

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SIGN AND DATE
REF. DRG. No.SIGN AND DATE
REF. DRG. No.

INVENTORY No.

REV	DATE	ALTERED	REV	DATE	ALTERED	REV	DATE	ALTERED
		CHECKED			CHECKED			CHECKED

Name of Customer/Project

BHARAT HEAVY ELECTRICALS LTD.,
ELECTROPORCELAINS DIVISION
BANGALORE - 560 012

DEPT	GRADE OF	SCALE	WEIGHT (kg)	REF TO ASSY.DRG	ITEM	No. OF
CODE	TOL DIM	N.T.S.	(Approx)	3-986-01-10150 (7131-SHT-5)	No.	ITEMS
C/M/F						
TITLE	CARD	DRAWING No.	REV.			
CASING FOR PIPE BENDS - 700NB(I.D 686)	CODE	3-986-01-10151	01			
		SHEET No. 3	No. OF SHEETS 4			

SUPERSEDES DRG. No.

SHT.24 SIZE A3 420 x 297

FIRST ANGLE PROJECTION

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10
REV

3-986-01-10151

DRG No.

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SIGN AND DATE
REF. DRG. No.

INVENTORY No.

NOTE:-

1. FOR CONSTRUCTION MATERIAL REFER TABLE-2
2. DURING ASSY. LONGITUDINAL WELDING BETWEEN SEGMENTS TO BE STAGGERED.
3. ALL SUPPLIES TO CONFORM CLN:QP:01/00. WELDING AS PER WP:CL001A & AWS:D 1.1.
4. DIMENSIONS INDICATED ARE FINISHED SIZE ONLY.
5. ASSEMBLY No., DU No., AND ARROW HEAD TO BE WELD DEPOSITED OVER CASING AS SHOWN , AS PER CE:1501:21
6. BASE PLATE FOR NAME PLATE TO BE WELDED ON TO CASING, AT LOCATION SHOWN,
FOR BASE PLATE & WELDING DETAILS REF DRG : 4 986 99 07720
7. FACE ANGLES TO BE MATCHED DURING ASSY.
8. ALL OVER MACHINING 6.3/ FOR STOPPER RINGS.
9. A.H.S. =ARROW HEAD SIDE T.E.S. = TAIL END SIDE, V= SHOULDER FOR VICTAULIC COUPLING.
10. FOR CASING Wt. REFER TABLE -1
FOR Wt. OF LIFTING LUG, EARTH LUG, STOPPER RING.
REFER TABLE - 2
11. WHERE "Y" IS GREATER THAN 1000, ONE CIRCUMFERENTIAL JOINT IS ALLOWED ON "Y", OUTSIDE SEGMENT TOWARDS A.H.S. THIS JOINT SHOULD NOT FOUL WITH LUG.
12. CONTROL DURING WELDING OF SHOULDER TO CASING :-
 - a) OVALITY OF CASING ON OUTER DIAMETER TO BE MAINTAINED WITHIN 1.0 MM
 - b) WELDING OF SHOULDER TO CASING AS PER DETAIL-A, TO BE DONE IN SUCH A WAY AS TO ENSURE THAT DISTORTION OF COLLAR IS LIMITED SUCH THAT DIMØ787.4mm IS STRICTLY WITHIN THE TOLERANCE SPECIFIED IN SHT 10F 4.
VENDOR TO DO THE NEEDFUL TO ACHIEVE 12(a) AND 12(b).
13. SURFACE PREPARATION AND PAINTING: REF PAINTING SCHEME DOC. No. : PS- L&T -KHARGONE. BENDS.
14. OVERALL BEND TOLERANCE:-
 - a). AXIAL SHIFT: ± 3 MM
 - b). RADIAL SHIFT: ± 3 MM
 - c). OUT OF SQUARENESS: ± 3 MM.
15. ALL PARTS HAVE TO BE 6mm FILLET WELDED, IF NOT SPECIFIED.

Name of Customer/Project

K

BHARAT HEAVY ELECTRICALS LTD.,
ELECTROPORCELAINS DIVISION
BANGALORE - 560 012

	NAME	SIGN	DATE
DRN	Kaushik.K		08-11-2016
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DEPT	GRADE OF TOL DIM		SCALE	WEIGHT (kg)	REF TO ASSY.DRG	ITEM No.	No.OF ITEMS
CODE	C/M/F		N.T.S.	— (Approx)	3-986-01-10150 (7131- SHT-5)		
TITLE CASING FOR PIPE BENDS - 700NB(I.D 686)				CARD CODE	DRAWING No.		REV.
					3-986-01-10151		01
					SHEET No. 4	No.OF SHEETS 4	

SUPERSEDES DRG. No.

SHT.24 SIZE A3 420 x 297