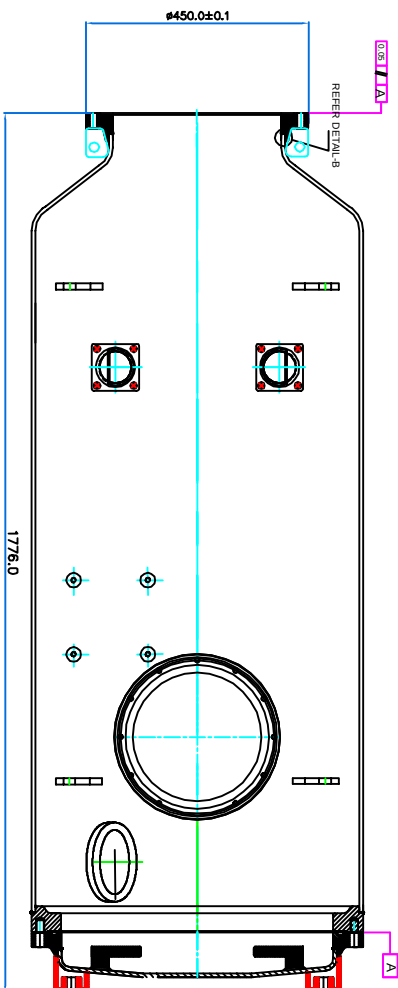
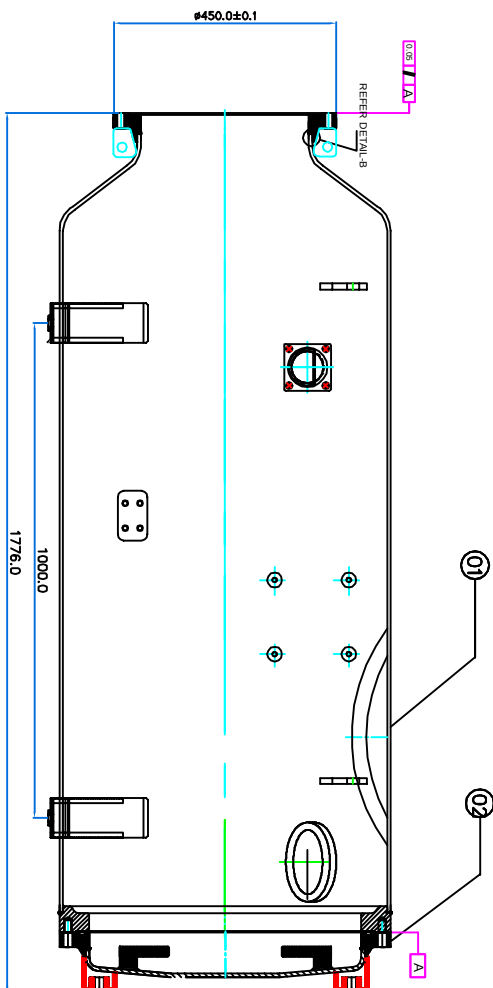


THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED.

INVENTORY NO.	SIGN. AND DATE	REF. DRG. NO.
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02	DISH ASSY	RD 06 + 35 0520 6620			SS-304L			01
01	SA ENCLOSURE	RD 06 + 35 0520 6610			SS-304L			01
ITEM NO.	DESCRIPTION	DRAWING NO.	ITNO.	MATL. CODE	MATL. SPECN.	A	UNIT	UNIT WGT.
			WAR			Q	QTY.	GS

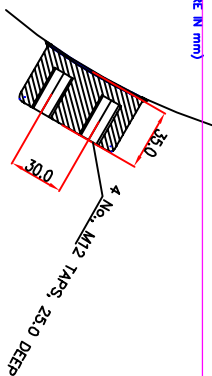
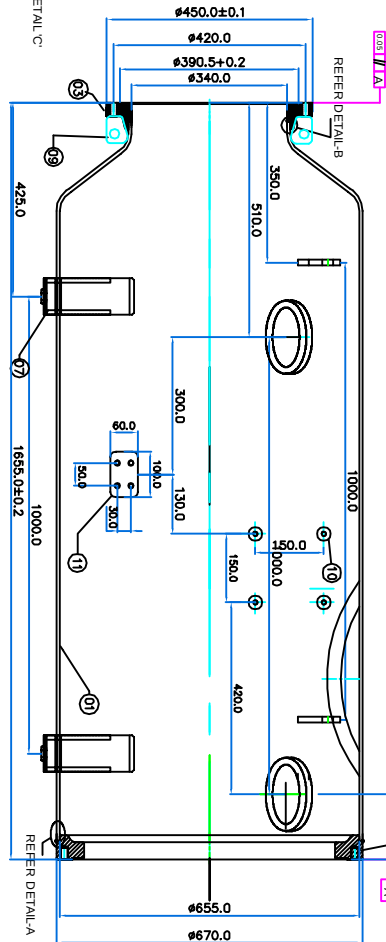
TYPE OF PRODUCT						NAME OF CUSTOMER					
GSM-245											
BHARAT HEAVY ELECTRICALS LTD.											
HYDERABAD											
DEPT.		GRADE OF TOL. DIM. C/M/F		SCALE		WEIGHT(KG)		DIN		NAME	
								QND		AL	
								APPD		MMRAO	
TITLE		SA HOUSING								REF. TO	
										RD DG 4 35 0520 6000	
CADD CODE		DRAWING NO.								DATE	
		RD DG 4 35 0520 6600								07.02.15	
SHEET NO.		NO. OF SHEETS								NO. OF	
										ITEMS	
REV.										NO. OF	
										ITEMS	

BHARAT HEAVY ELECTRICALS LIMITED

REF. DRG. NO.

SIGN. AND DATE

INVENTORY NO.



DETAIL-B



ITEM NO.	DESCRIPTION	STD.	DRAWING NO.	ITEM NO.	UNIT	QTY.	GS
13	FLANGE V COVER		RD 06 x 35 0817 02728		SS-304L	01	
12	FLANGE VI		RD 06 x 35 0817 02728		SS-304L	01	
11	EARTHING PLATE		100060x35		SS-304L	02	
10	GUIDE RODS		25x3x30.0		SS-304L	04	
09	LIFTING LUG I		RD 06 x 35 0520 6614		SS-304L	04	
08	LIFTING BRACKET		RD 06 x 35 1133 4140		SS-304L	04	
07	SUPPORT BRACKET ASSY.		RD 06 x 35 1133 4130		SS-304L	04	
06	RUPTURE DISK COVER		RD 99 320 690		SS-304L	01	
05	FLANGE V		RD 06 x 35 0817 9834		SS-304L	03	
04	FLANGE III		RD 06 x 35 1133 4160		SS-304L	04	
03	FLANGE-II		RD 06 x 35 0520 6613		SS-304L	01	
02	FLANGE-I		RD 06 x 35 0520 6612		SS-304L	01	
01	PIPE		RD 06 x 35 0520 6611		SS-304L	01	

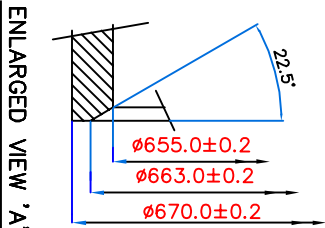
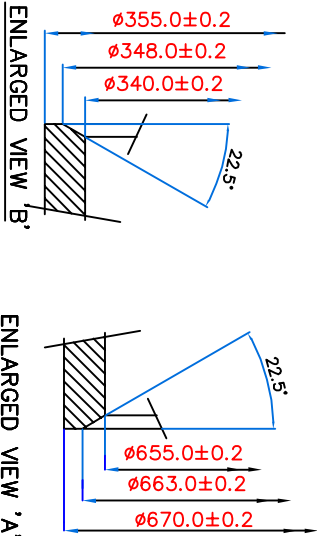
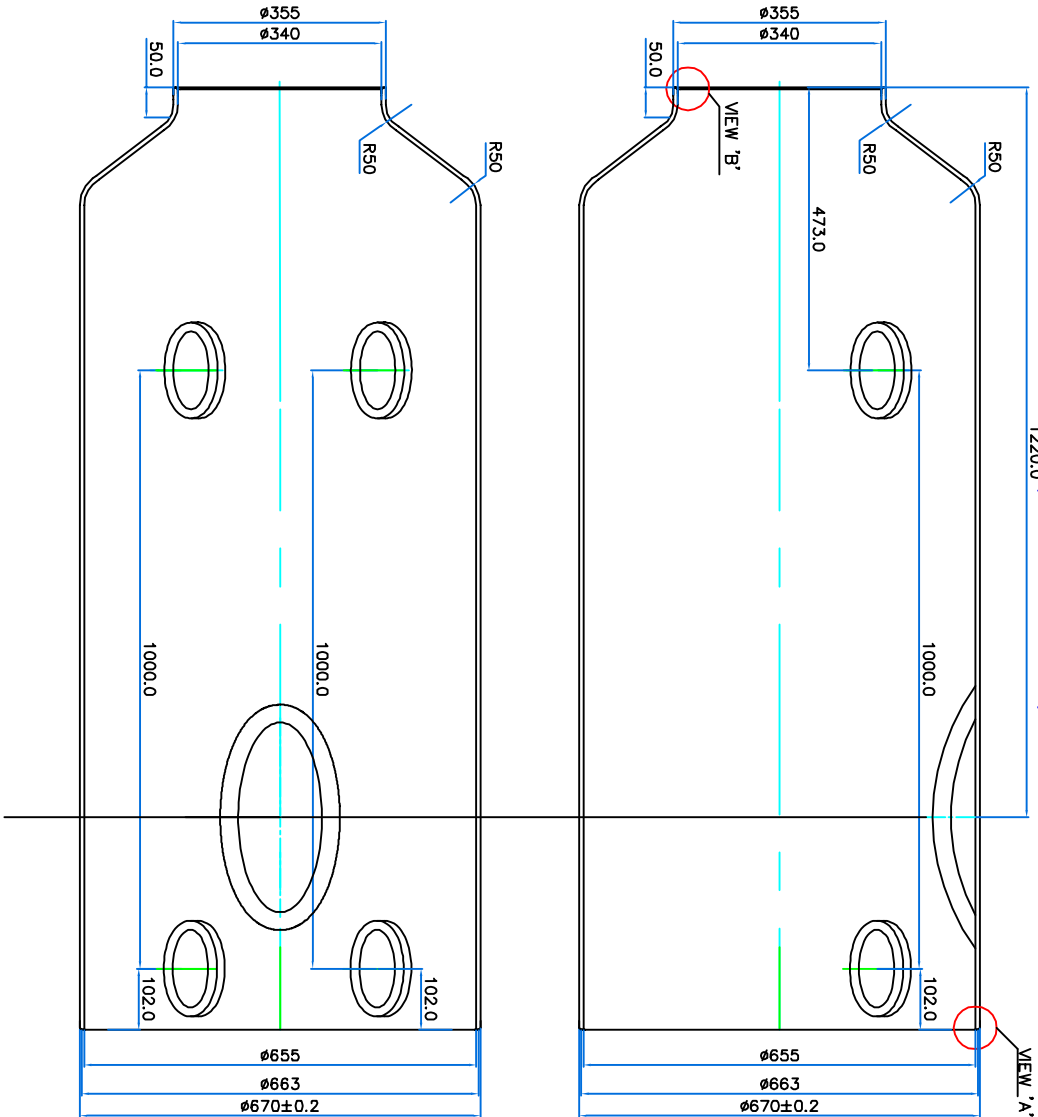
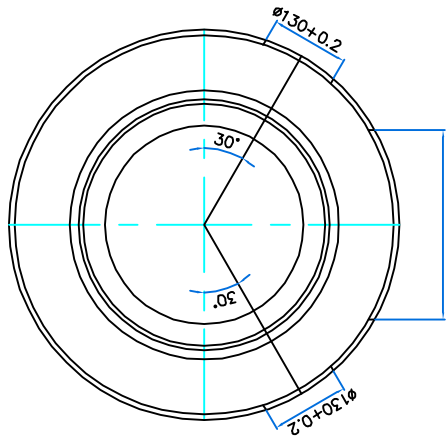
Note:

1. FLANGE TO BE TIG / MIG WELDING WITH SUITABLE SS ELECTRODE
2. THE ROOT SHOULD BE HOMOGENEOUS AND CONTINUOUS.
3. PRESSURE TEST AS PER ENCLOSED SPECIFICATION.
4. TESTED ASSEMBLIES TO BE DEGREASED, SAND BLASTED AND POWDER COATED ON OUTSIDE.
5. ELECTRO POLISH INSIDE SURFACE.
6. LIFTING LUGS AND SUPPORT BRACKETS SHALL BE FULLY WELDED TO PIPE AND FLANGE.
7. ALL WELDINGS SHALL BE GROUNDED TO DIMENSIONS.
8. FLANGES SHALL BE MACHINED TO DRAWING AFTER WELDING TO PIPE.

REV.	DATE	ALTERED		REV.	DATE	ALTERED	
		CHECKED				CHECKED	
ZONE				ZONE			

		PARATI HEAVY ELECTRICALS LTD. HYDERABAD	
DEPT.	GRADE OR TOL. DIM.	SCALE	WEIGHT(S)
CODE			
TITLE		CARD CODE	
SA ENCLOSURE			
DRAWING NO.		REF. TO:	
RD DG 4 35 0520 6600		DRN AL NAME MIRAOK APPD	SIGN. DATE 15.02.16 15.02.16 15.02.16
SHEET NO.		NO. OF ITEMS	REV.
NO. OF SHEETS			
RD DG 4 35 0520 6610			

GSM-245

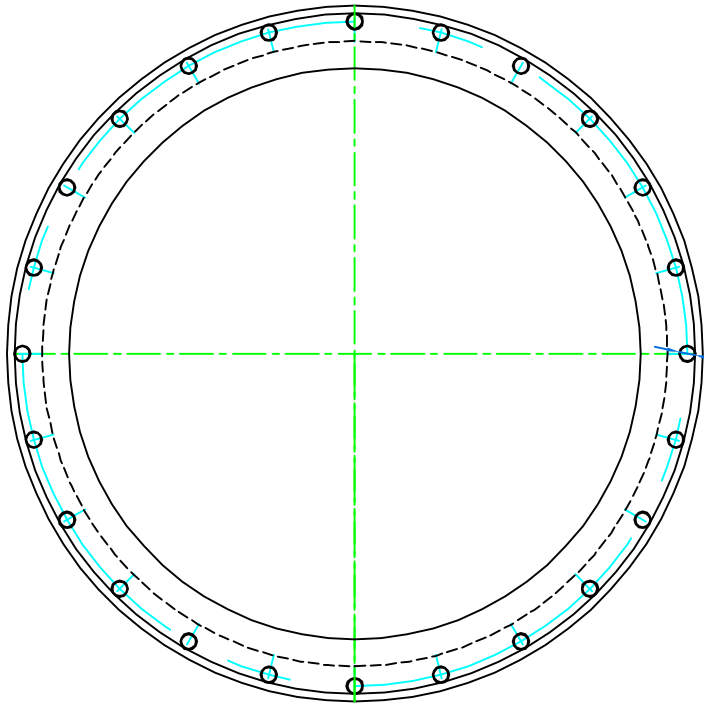


VAR.00	REMARKS	VAR. NO.	ITEM NO.	1	PIPE	STD	DRAWING NO.	SS-304L	UNIT WGT.	1	GS
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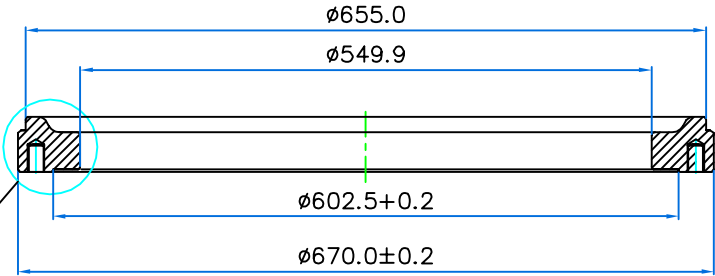
TYPE OF PRODUCT
NAME OF CUSTOMER
GSM-245

DEPT.	GRADE OF	SCALE	WEIGHT(KG)	REF. TO	ITEM NO.	NO. OF
RD DG 4	RD DG 4	RD DG 4	RD DG 4	RD DG 4	RD DG 4	RD DG 4

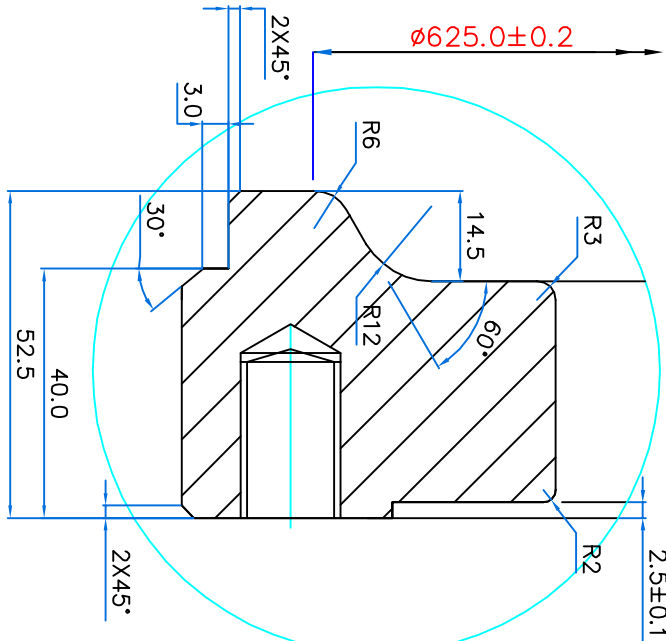
REV.	DATE	ALTERED	CHECKED	REV.	DATE	ALTERED	CHECKED	ZONE	ZONE	TITLE	CARD CODE	DRAWING NO.	SHEET NO.	NO. OF SHEETS
										PIPE	RD DG 4 35 0520 6611			



24 No. , M16 TAPS @ 635.0 PCD, 25 DEEP



REFER DETAIL 'A'



DETAIL 'A'

Note:

1. Sealing area shall be plosished to RA 0.8 or better.
2. M 16.0 Taps shall be chamfered uniformly (0.8x45°).
3. PCD and flange centre shall be concentric within ± 0.05
4. Finished flange shall be degreased and packed in 125 micron poly bag and sealed.
5. Component shall be Machined to dimensions after welding to pipe

VAR/D	REMARKS	VAR NO.	ITEM NO.	01	BLOCK	STD	DRAWING NO.	VAR	IT NO.	MATL. CODE	A	UNIT	WT.	QTY.	SS	ZONE
										SS-304L					01	

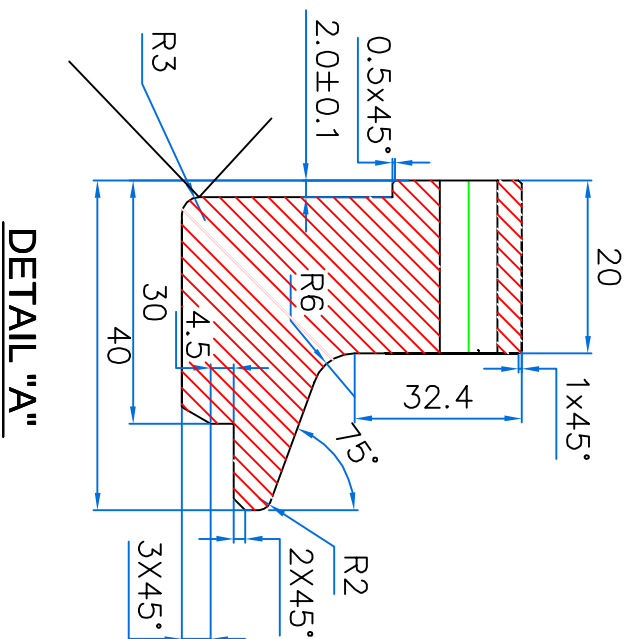
TYPE OF PRODUCT	NAME OF CUSTOMER	GSM-245
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DEPT.	GRADE OF	DRN	NAME	SIGN.	DATE	NO. OF
CODE	TOL. DIM.	AL	HYDERABAD		15.02.15	YAK.

REV.	DATE	ALTERED	REV.	DATE	ALTERED	DEPT.	GRADE OF	DRN	NAME	SIGN.	DATE	NO. OF
ZONE		CHECKED	ZONE		CHECKED	CODE	TOL. DIM.	AL	HYDERABAD		15.02.15	YAK.

TITLE	CARD CODE	DRAWING NO.	REV.
FLANGE I	RD DG 4 35 0520 6612	RD DG 4 35 0520 6610	
	SHEET NO.	NO. OF SHEETS	

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

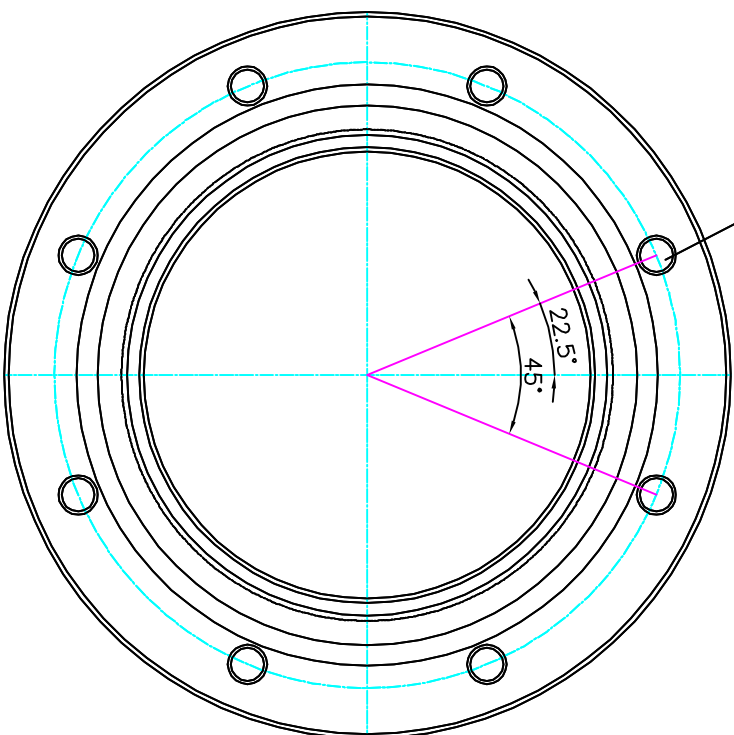


1. Sealing area shall be polished to RA 0.8 or better.
2. All sharp edges shall be machined to 0.4x45°.
3. PCD and flange centre shall be concentric within ± 0.05
4. Finished flange shall be degreased and packed in 125 micron poly bag and sealed.
5. Component shall be Machined to dimensions after welding to pipe

UPDATED FOR DIMENSION DT 19.11.15

REV.	DATE	ALTERED	REV.	DATE	ALTERED	DEPT.	GRADE OF TOL. DIM.	SCALE	WEIGHT(KG)	REF. TO	ITEM NO.	ITEM NO.
		CHECKED			CHECKED	CODE				RD DG 4 35 0520 6610		
ZONE			ZONE			TITLE			CARD CODE	DRAWING NO.		REV.
						FLANGE II				RD DG 4 35 0520 6613		
										SHEET NO.	NO. OF SHEETS	

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



8 No. M8 TAPS @ 135.0 PCD, 20.0 deep

REV.	DATE	ALTERED	REV.	DATE	ALTERED	DEPT.	GRADE OF TOL. DIM. C/M/J		SCALE	WEIGHT(KG)	REF. TO	NO. OF ITEMS	NO. OF SHEETS
		CHECKED			CHECKED	CODE			NTS		RD DG 4 35	1133	4100
ZONE			ZONE			TITLE			CARD CODE		RD DG 4 35	1133	4160
FLANGE-III													
										SHEET NO.	NO. OF SHEETS		

ALL SHARP EDGES SHALL BE MACHINED TO 0.4x45°
MARKED SURFACE SHALL BE FINISHED TO RA0.8

CGSM-145

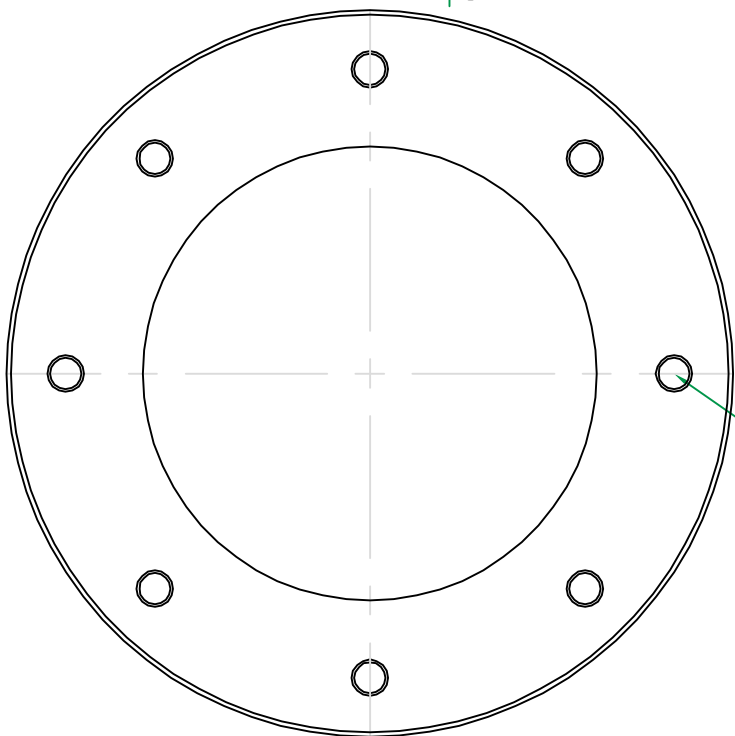
NAME	SIGN.	DATE	NO. OF
DAN KSRAD		26.12.05	VAR.
AL		02.01.06	
MMRAN		09.01.06	
APPN			

FLANGE-III

RD DG 4 35 1133 4160

SHEET NO.	NO. OF SHEET
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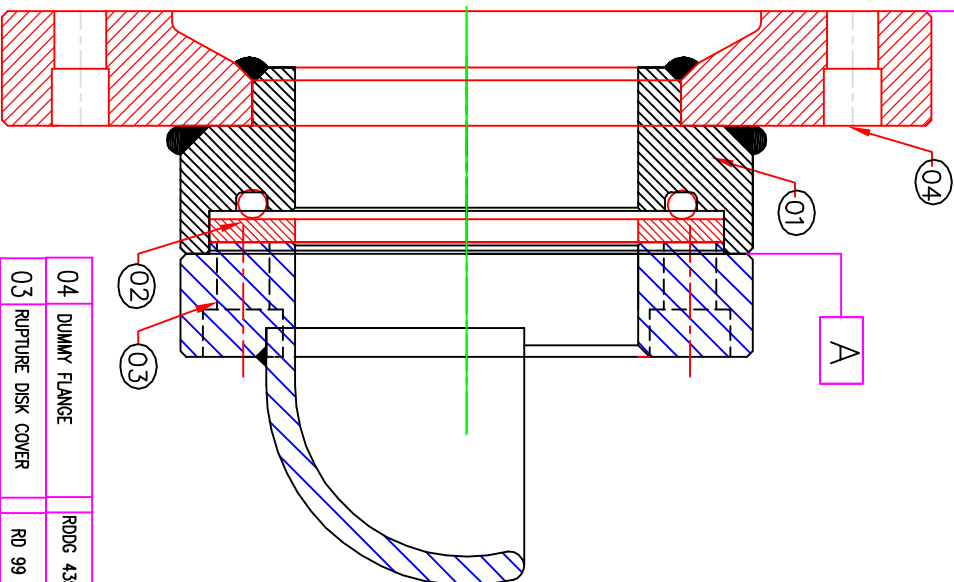
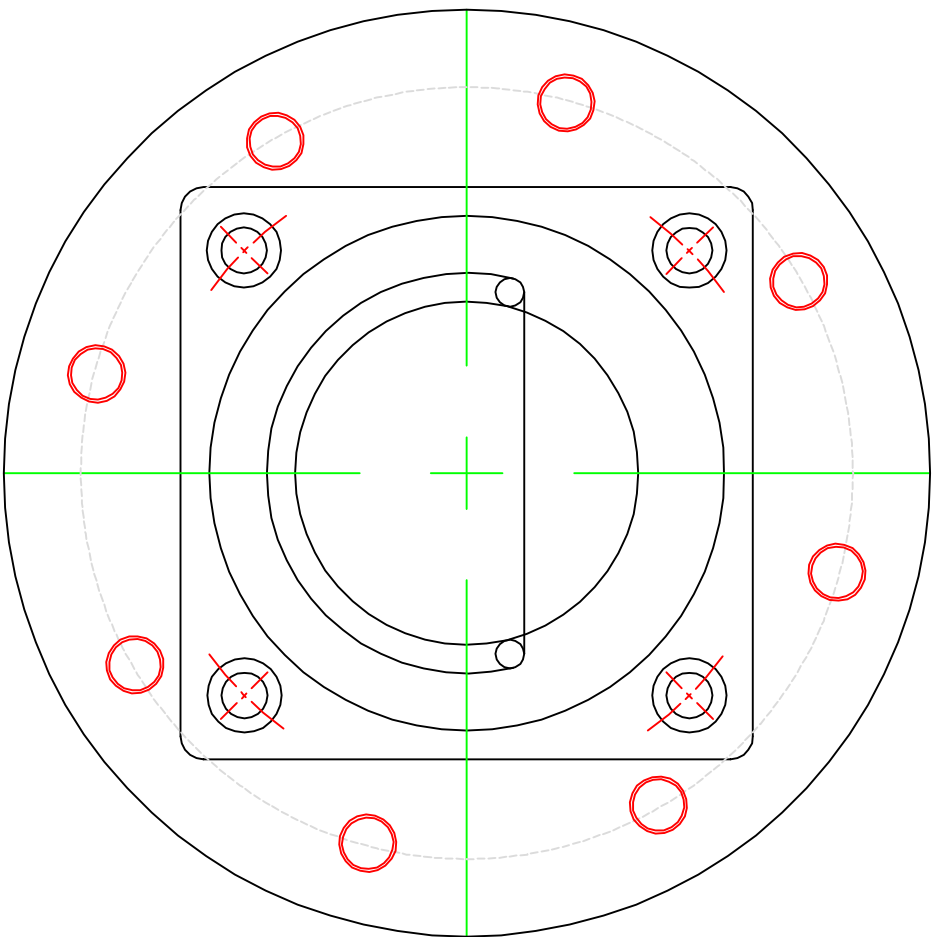
8 NO., 9.2 CLEAR HOLES
@135±0.07 PCD WITH 0.4X45° C/F

[illegible]

REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED
		CHECKED			CHECKED			CHECKED
ZONE			ZONE					
DEPT. CODE TITLE GRADE OF TOL. DIM. C/M/J  SCALE NTS WEIGHT(KG) 2.5 CAND CODE								
DUMMY PLATE								
REF. TO	GRADE OF	ITEM	NO.	ITEM	NO.	REV.		
RD DG 4 35	0617	0980	1					
DRAWING NO.								
RD DG 4 35	0617 0983A							
SHEET NO.	NO. OF SHEETS							

TYPE OF PRODUCT		NAME OF CUSTOMER		GSM-420	
		BHARAT HEAVY ELECTRICALS LTD.		HYDRABAD	
DEPT.	GRADE OF TOL. DIM.	SCALE	WEIGHT(KG)	DRN	NAME
CODE	C/M/F		NTS	CNO	AL
			2.5	APPD	MRRAD
TITLE				REF. TO	SIGN.
DUMMY PLATE				RD DG 4 35 0617 0980	DATE
CARD CODE					25.08.17
DRAWING NO.				RD DG 4 35 0617 0983A	DATE
SHEET NO.					25.08.17
NO. OF SHEETS					25.08.17
REV.			ITEM NO.	ITEMS	NO. OF SHEETS
			01		

(ALL DIMENSIONS ARE IN mm)

 (21.6) 

1. FLANGE TO BE TIG / MIG WELDING WITH SUITABLE SS ELECTRODE

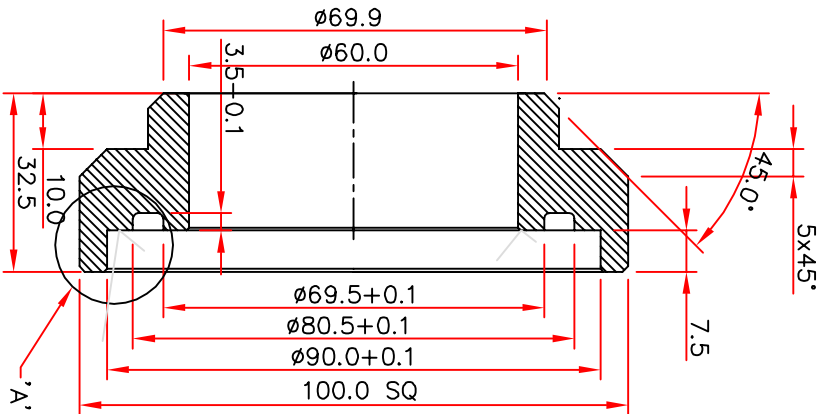
ITEM NO.	DESCRIPTION	STD	DRAWING NO.	ITNO.	MATL CODE	A UNIT	UNIT WGT.	ZONE
				VAR	MATL SPECN	C	QTY.	5
04	DUMMY FLANGE		RDDG 435 0617 0983		SS-304		1	
03	RUPTURE DISK COVER		RD 99 320 630		SS-304		1	
02	RING		RD 99 320 620		SS-304		1	
01	FLANGE		RD 99 320 610		SS-304		1	

GSM 145

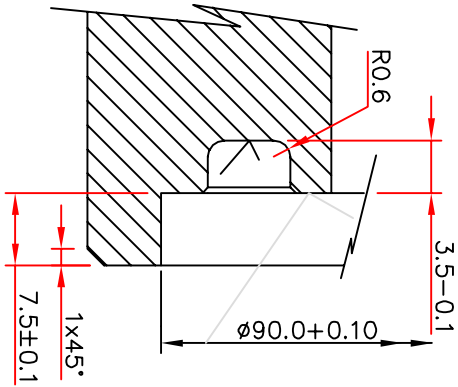
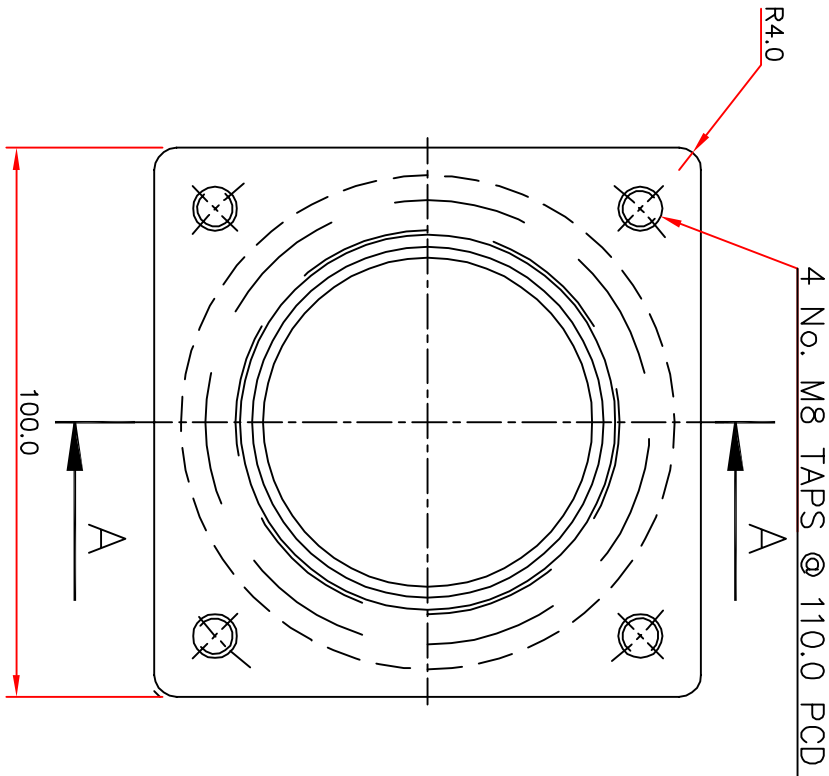
REV.		DATE	ALTERED	REV.	DATE	ALTERED	REV.		DATE	ALTERED	REV.		DATE	ALTERED	REV.		DATE	ALTERED
CHECKED				01	10/5/16	CHECKED	MNR				ZONE				ZONE			
REVISED FOR CIRCULAR FLANGE																		
TITLE																		
RUPTURE DISK ASSY																		
CARD CODE																		
DRAWING NO.																		
RD 99 320 600																		
SHEET NO.																		
NO. OF SHEETS																		

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IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

INVENTORY NO.	SIGN. AND DATE	REF. DRG. NO.
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SECTION AA



ENLARGED VIEW 'A'

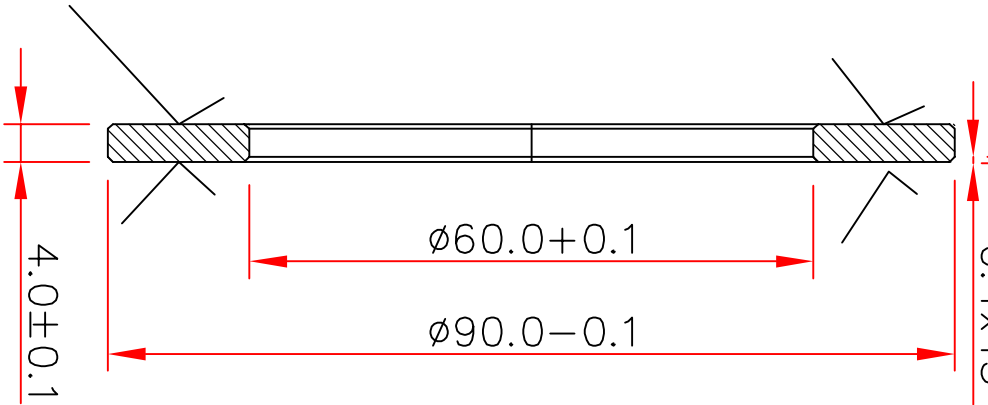
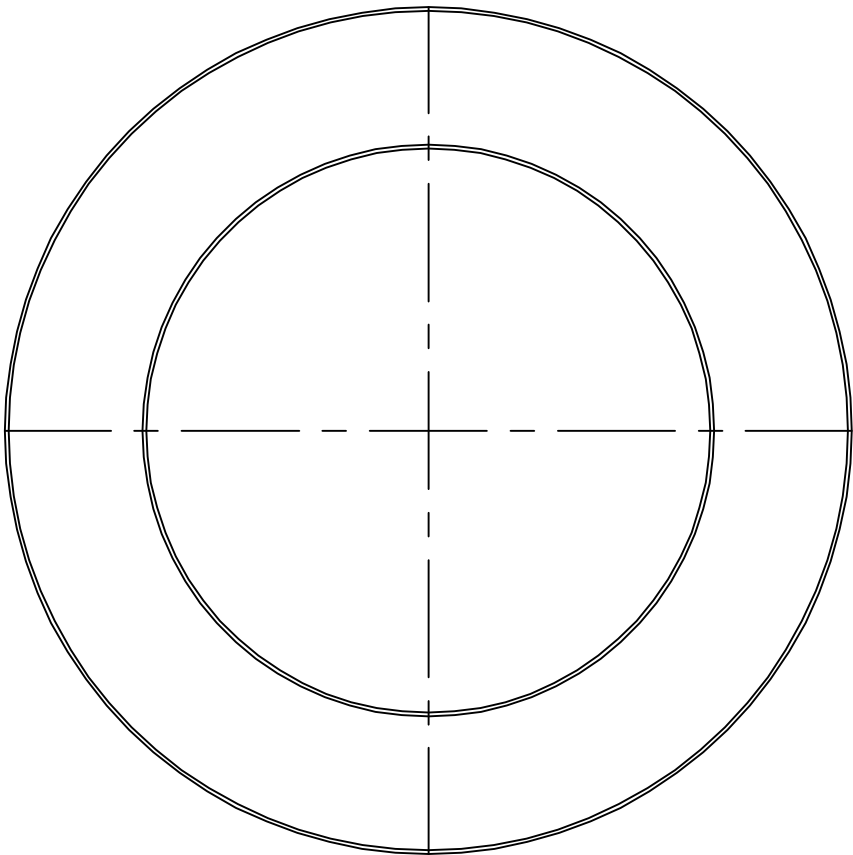
O-RING GROOVE SURFACE SHALL BE FINISHED TO RA 0.8
MARKED SURFACE SHALL BE FINISHED TO RA 1.6

REV.	DATE	ALTERED	REV.	DATE	ALTERED
CHECKED			CHECKED		
ZONE			ZONE		

DEPT	GRADE OF	SCALE	WEIGHTING	DIN	NAME	SIGN.	DATE	NO. OF
GS6	TOL. DIM.	NTS		ISO	RD		01.02.03	VAR.
CODE 35	C/M/F			APPD	HS JAN		01.02.03	
BHARAT HEAVY ELECTRICALS LTD.				RD 99 320 600 2				
HYDERABAD				RD 99 320 610 0				
FLANGE				SHEET NO. NO. OF SHEETS				

TYPE OF PRODUCT
NAME OF CUSTOMER
GSM 145

VAR. NO.	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	105.0 SQ x 30.0	SS 304	MATL. CODE	A	UNIT Wt.	QTY.	ZONE
01				SS PLATE							



MARKED SURFACE SHALL BE FINISHED TO RA 0.8
ALL SHARP EDGES SHALL BE MACHINED TO 0.4x45°

VAR/CD	REMARKS	VAR NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	VAR	ITEM NO.	MATL. CODE	A	L	UNIT	W.T.	QTY.	ZONE
		01		SS PLATE		095.0 x 6.0			SS 304-L						

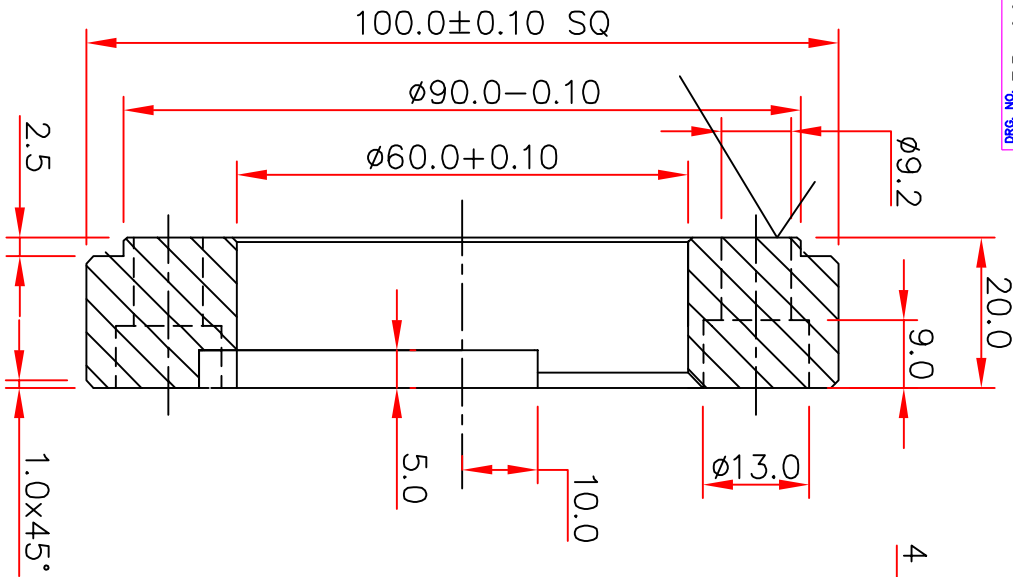
REV.	DATE	ALTERED	REV.	DATE	ALTERED	DEPT.	GRADE OF	SCALE	WEIGHT(KG)	REF. TO	NO. OF	NO. OF
ZONE		CHECKED	ZONE		CHECKED	CODE 35	GSM TOL DIM. C/M/F	NTS			ITEM NO.	ITEMS
TITLE												
RING												
CARD CODE												
RD 99 320 600 2 6												
REV.												
RD 99 320 620 0												
SHEET NO.												
NO. OF SHEETS												



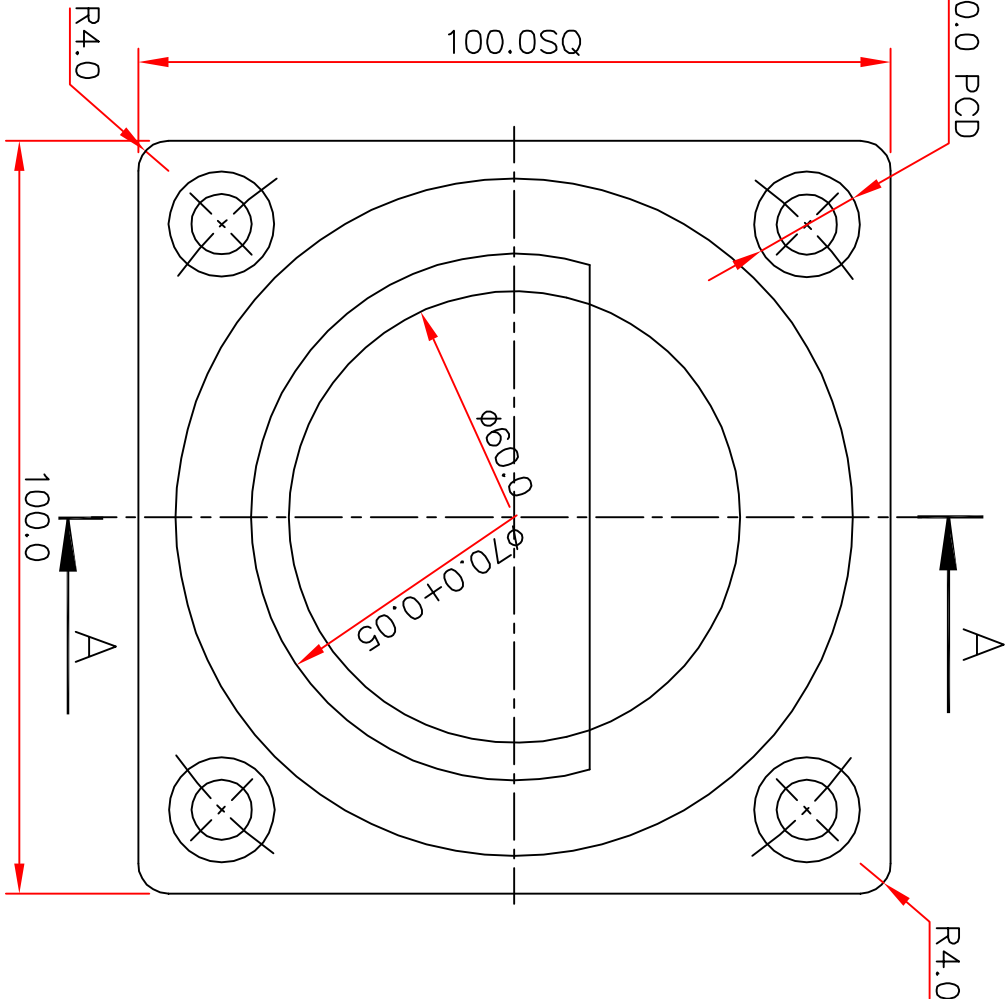
BHARAT HEAVY ELECTRICALS LTD.
HYDERABAD

TYPE OF PRODUCT
NAME OF CUSTOMER
GSM 145

DRN	KS RD	SIGN.	DATE	NO. OF
CHKD	MM RD		01.02.03	VAR.
APPRD	HS JMN		01.02.03	



4 Holes as shown 110.0 PCD



MARKED SURFACE SHALL BE FINISHED TO RA 1.6
ALL SHARP EDGES SHALL BE MACHINED TO 0.4x45°.

SECTION AA

VAR/CD	REMARKS	VAR NO.	ITEM NO.	DESCRIPTION	105.0 SQ x 25.0	SS 304	MAT'L. CODE	A	UNIT Wt.	QTY.	ZONE
01				SS PLATE							

TYPE OF PRODUCT
NAME OF CUSTOMER
GSM 145



BHARAT HEAVY ELECTRICALS LTD.
HYDERABAD

DIN	NAME	SHW.	DATE	NO. OF
IS 160	MM RAO		01.02.03	VAR.
CD	MM RAO		01.02.03	
APPO	MM RAO		01.02.03	
REF. TO				

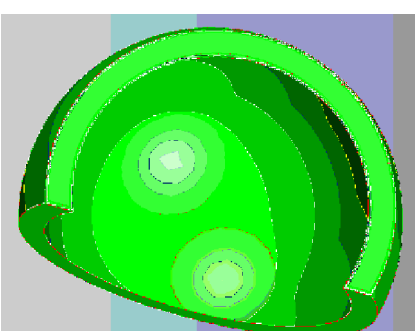
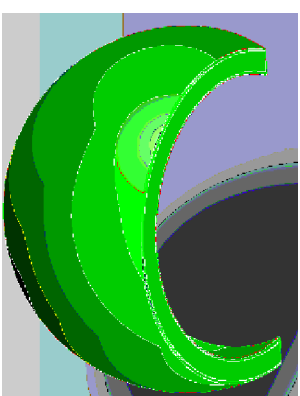
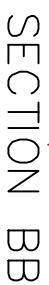
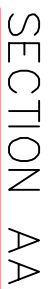
DEPT	GRADE OF	SCALE	WEIGHT(KG)	DIN	NAME	SHW.	DATE	NO. OF
GSM	TOL. DIM.	NTS		IS 160	MM RAO		01.02.03	VAR.
CODE 35	C/M/F			CD	MM RAO		01.02.03	
TITLE				APPO	MM RAO		01.02.03	

FLANGE

REV	DATE	ALTERED	REV	DATE	ALTERED	DEPT	GRADE OF	SCALE	WEIGHT(KG)	DIN	NAME	SHW.	DATE	NO. OF
ZONE		CHECKED	ZONE		CHECKED	GSM	TOL. DIM.	NTS		IS 160	MM RAO		01.02.03	VAR.
						CODE 35	C/M/F			CD	MM RAO		01.02.03	
										APPO	MM RAO		01.02.03	
										REF. TO				

CARD CODE	DRAWING NO.	REV	SHEET NO.	NO. OF SHEETS
	RD 99 320 630	2	RD 99 320 631	0

INVENTORY NO.	SIGN. AND DATE	REF. DRG. NO.
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[illegible]

BHARAT HEAVY ELECTRICALS LTD.
HYDERABAD

 BHARAT HEAVY ELECTRICALS LTD. HYDERABAD	DRN	NAME	SIGN.	DATE
	KIS RAO			01.02.03
	MM RAO			01.02.03
	APPO			01.02.03

REV.	DATE	ALTERED	REV.	DATE	ALTERED	DEPT.	GRADE OF	SCALE	WEIGHT(KG)	REF. TO	ITEM NO.	ITEM			
		CHECKED			CHECKED	636	TOI. DML.			RD 99	320	630			
ZONE			ZONE			CODE 35	C/M/F	MIS		2	6				
 TITLE PROTECTIVE COVER										CARD	NO.	RD 99	320	632	0
										DRAWING NO.					
										SHEET NO.					
										NO. OF SHEETS					

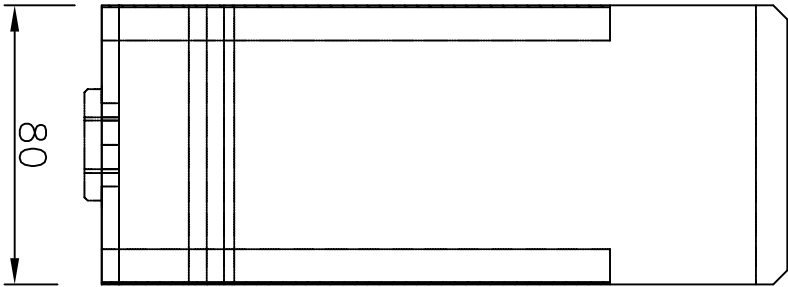
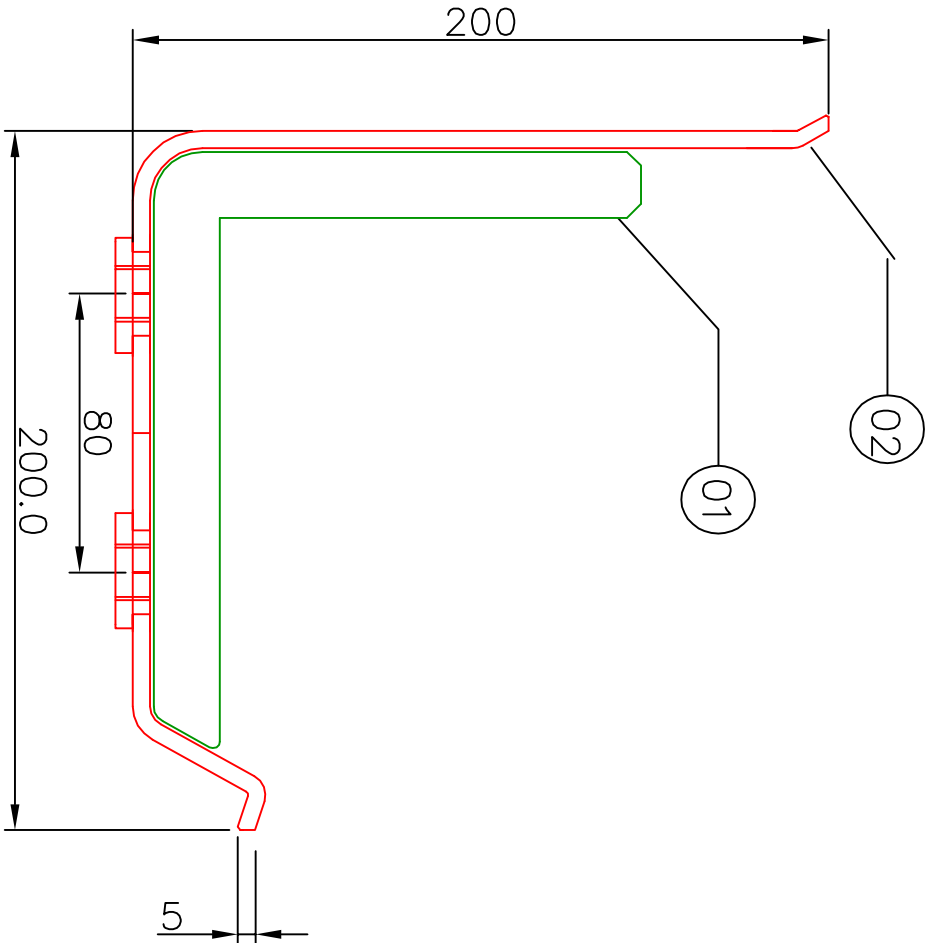
DETAILED A

INVENTORY NO.

[illegible]

DRN	NAME	SIGN.	DATE	NO. OF VAR.
	KSRAD		26.12.05	0
	MMRAO		02.01.06	
	HCTIAN		09.01.06	

DEPT.	GRADE OF TOL. DIM.	SCALE	WEIGHT(KG)	REF. TO	ITEM NO.	ITEM NO.
CODE	 C/M/F	NIS	2.5	RD DG 4 35 0619 6610	08	4
TITLE	FLANGE-V			DRAWING NO.	RD DG 4 35 0617 0983	REV
			CARD CODE	SHEET NO.	NO. OF SHEETS	



1. ALL SHARP EDGES SHALL BE MACHINED TO 0.4x45°
2. PIPE AND FLANGE TO BE TIG / MIG WELDING WITH SUITABLE SS ELECTRODE
3. THE ROOT SHOULD BE HOMOGENEOUS AND CONTINUOUS.

02	SUPPORT BRACKET	RD DG 4 35 1133 41308	SS-304L	01
01	SUPPORT PLATE	RD DG 4 35 1133 4130A	SS-304L	02
VAR. NO.	REMARKS	VAR. ITEM NO.	DESCRIPTION	STANDARD
			DRAWING NO.	VAR. IT. NO. MATL. CODE C. LIN. QTY. INOR

TYPE OF PRODUCT
NAME OF CUSTOMER
CGSM-145

DEPT. TOL. DIM. GRADE OF C/M/F NTS SCALE WEIGHT(KG) APPD. REF. TO

DRN. NAME SIGN. DATE NO. OF CHKD. AL. 04.01.12 01

REV.	DATE	ALTERED	REV.	DATE	ALTERED	TITLE	CAD CODE	SHEET NO.	NO. OF SHEETS
ZONE		CHECKED	ZONE		CHECKED	SUPPORT BRACKET ASSY.	RD DG 4 35 1133 4130		

Technical drawing of a mechanical part, likely a bracket or support, showing dimensions and a cross-section.

Dimensions:

- Overall width: 140
- Overall height: 171
- Inner width: 121
- Inner height: 162.5
- Top right corner radius: $R14$
- Inner corner radius: $R24$
- Bottom corner radius: $R2$
- Bottom left corner radius: $R5$
- Bottom right corner radius: $R2$
- Bottom right corner angle: 61°
- Top right corner chamfer: $4 \times 45^\circ$
- Bottom right corner chamfer: $4 \times 45^\circ$
- Bottom right corner thickness: 10

Cross-section:

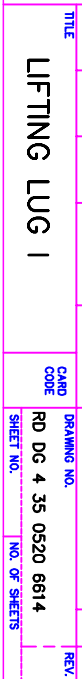
The cross-section shows a hatched area representing the material, with a total thickness of 10.

		01	SS PLATE			SS-304L		08	
VAR 00	REMARKS	VAR NO.	ITEM NO.	DESCRIPTION	DRAWING NO.	IT NO.	MAT'L CODE	UNIT WT.	
				STD		VAR	MAT'L SPECN	C QTY.	08 ZONE

TYPE OF PRODUCT									
NAME OF CUSTOMER									
CGIS-145									
									
BHARAT HEAVY ELECTRICALS LTD.									
HYDERABAD									
DEPT. (GRADE OF TOL. DIM. C/M/F)									
									
SCALE									
NTS									
WEIGHT(KG)									
APRD									
DRN									
NAME									
KSRPAA									
SIGN.									
DATE									
04.01.12									
VAR.									
04.01.12									
DRO									
AL									
04.01.12									
MNRRAO									
04.01.12									
REF. TO									
RD DG 4 35 1133 4130									
ITEM NO.									
1									
REV.									
DATE									
04.01.12									
ALTERNED									
CHECKED									
ZONE									
REV.									
DATE									
04.01.12									
ALTERNED									
CHECKED									
ZONE									
TITLE									
SUPPORT PLATE									
CARD CODE									
RD DG 4 35 1133 4130A									
DRAWING NO.									
SHEET NO.									
NO. OF SHEETS									

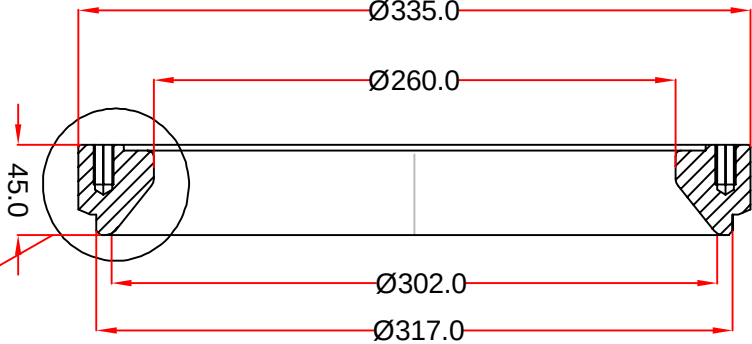
REV.	DATE	ALTERED	REV.	DATE	ALTERED	DEPT.	GRADE OF TOL. DIM.	SCALE	WEIGHT(KG)	REF. TO	ITEM NO.	ITEM
		CHECKED			CHECKED			NTS		RD DG 4 35	1133	4130
ZONE			ZONE			CODE	C/M/F					
						TITLE			CARD CODE	DRAWING NO.		REV.
						SUPPORT BRACKET			RD DG 4 35	1133	4130B	
						SHEET NO.			NO. OF SHEETS			

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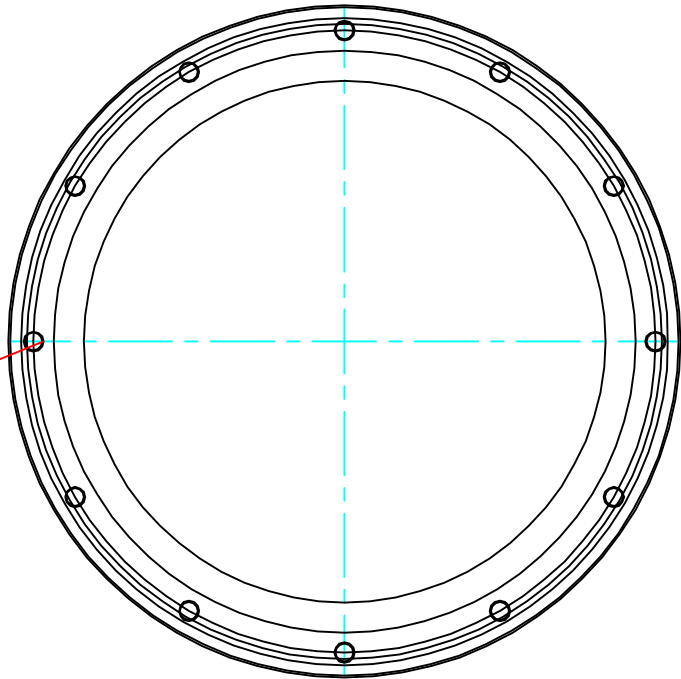


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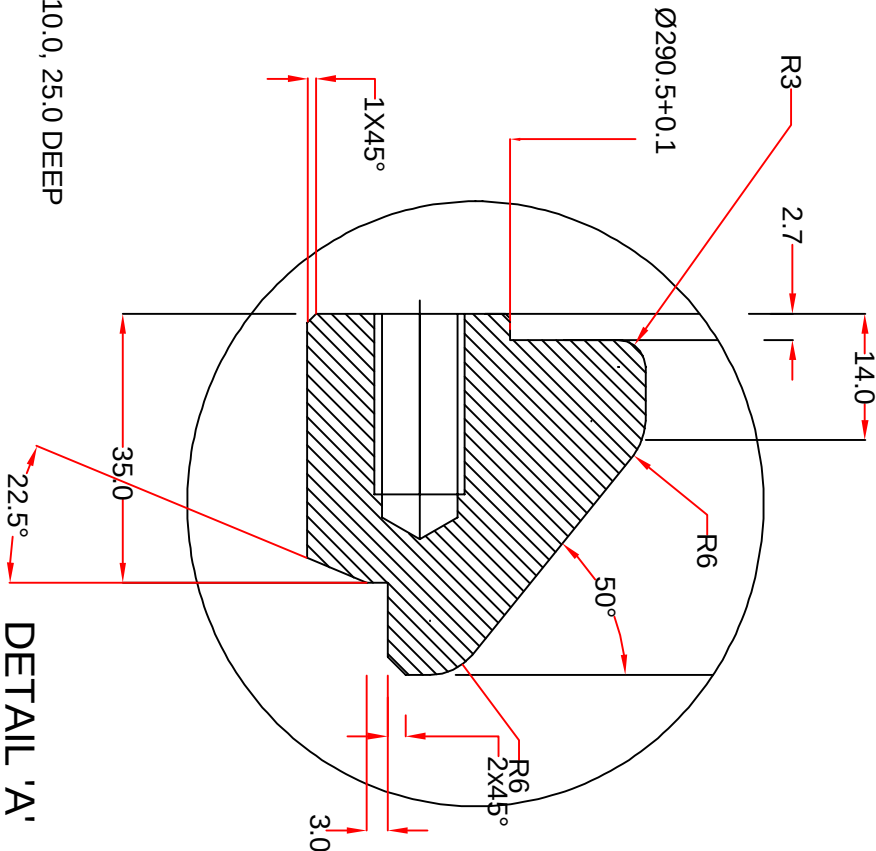
INVENTORY NO.	SIGN. AND DATE	REF. DRG. NO.
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REFER DETAIL 'A'



12 No., M10 TAPS @ 310.0, 25.0 DEEP



DETAIL 'A'

VAR. NO.	REMARKS	VAR. NO.	ITEM NO.	01	FLANGE	Ø340.0x50.0	SS-304	35.0	01

TYPE OF PRODUCT
NAME OF CUSTOMER
GSM-400



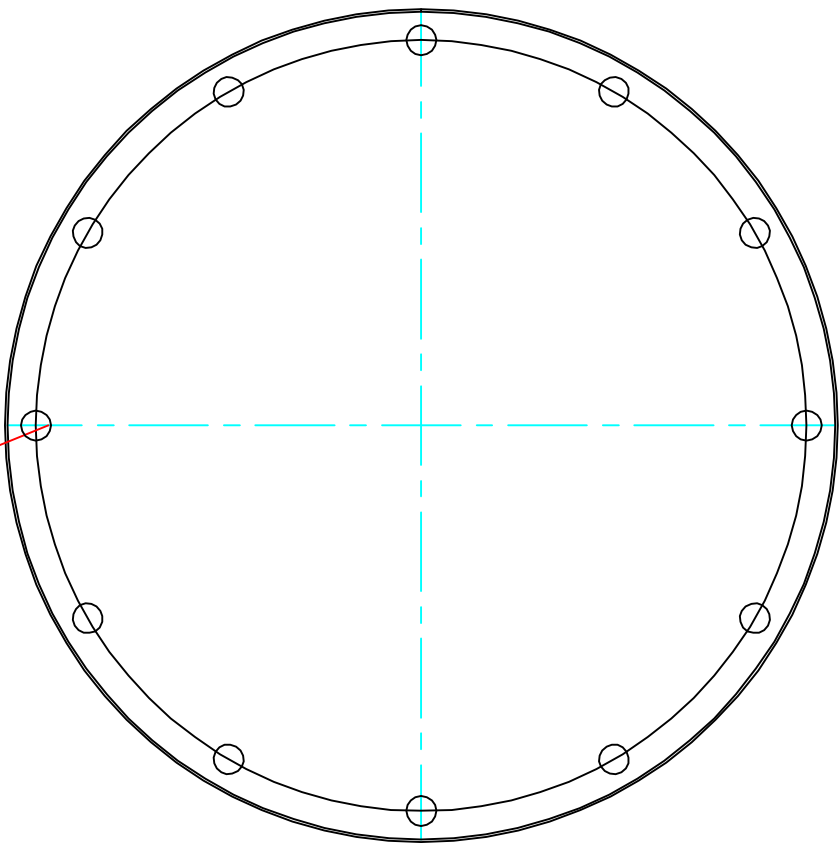
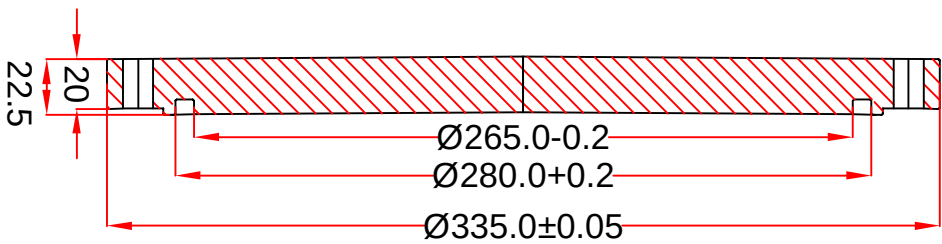
REV.	DATE	ALTERED	REV.	DATE	ALTERED	DEPT.	GRADE OF	SCALE	WEIGHT(KG)	DRAWING NO.	NO. OF SHEETS
ZONE		CHECKED	ZONE		CHECKED		TOL. DIM. C/M/F	NTS	11.0	RD DG 4 35 0617 0212B	NO. OF SHEETS

ALL SHARP EDGES SHALL BE MACHINED TO 0.4x45°

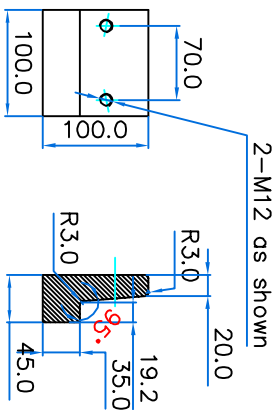
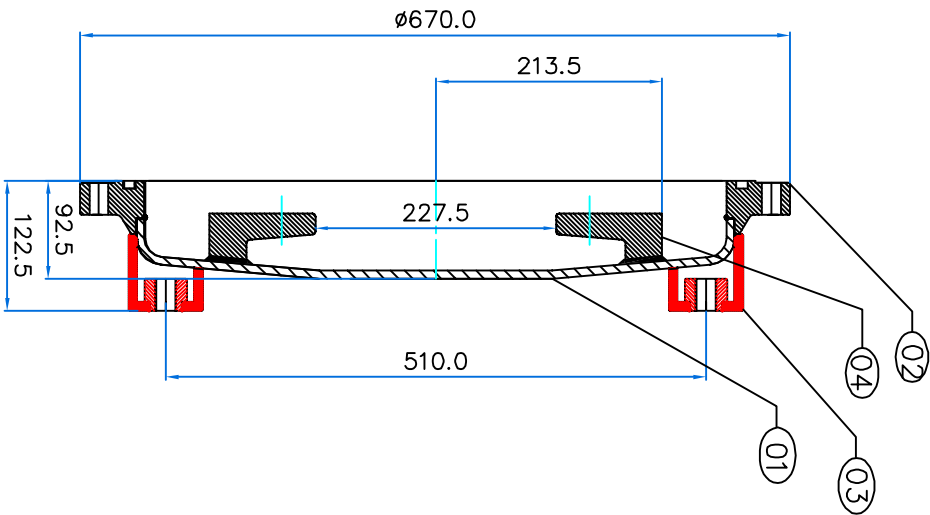
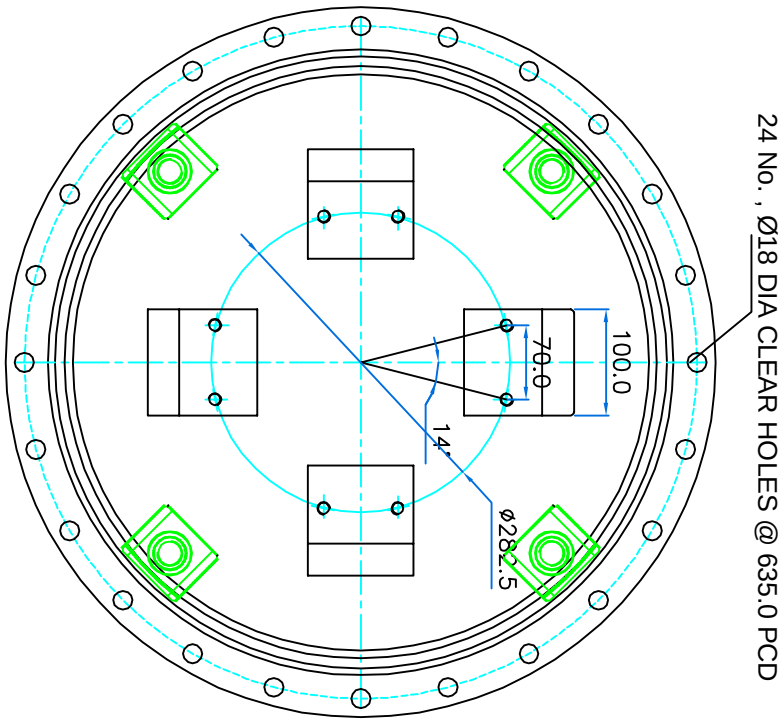
REV.	DATE	ALTERED	REV.	DATE	ALTERED
		CHECKED			CHECKED
ZONE			ZONE		

TYPE OF PRODUCT		NAME OF CUSTOMER		GSM-400	
		BHARAT HEAVY ELECTRICALS LTD.		HYDERABAD	
DEPT.	GRADE OF TOOL DIM.	SCALE	WEIGHT(KG)	DIN	NAME
CODE	C/M/F		NTS	11.0	AL
				CARD	AL
				APPD	MMRAO
TITLE			REF. TO	NO. OF SHEETS	DATE
FLANGE-VI			RD DG 4 35 0520 6610	1	21.05.16
DRAWING NO.			RD DG 4 35 0617 0212C	NO. OF SHEETS	WVR.
SHEET NO.			NO. OF SHEETS	REV.	

ALL SHARP EDGES SHALL BE MACHINED TO 0.4X45°



12 NO., Ø10 CLEAR HOLES @ 310.0, THROUGH TYPE



Note:

1. FLANGE TO BE TIG / MIG WELDING WITH SUITABLE SS ELECTRODE
2. THE ROOT SHOULD BE HOMOGENEOUS AND CONTINUOUS.
3. TESTED ASSEMBLIES TO BE DEGREASED, SAND BLASTED AND POWDER COATED ON OUTSIDE.
4. ELECTRO POLISH INSIDE SURFACE.
5. ALL WELDINGS SHALL BE GROUNDED TO DIMENSIONS.
6. FLANGES SHALL BE MACHINED TO DRAWING AFTER WELDING TO DISH.

VAR. NO.	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	DRAWING NO.	IT. NO.	MATL. CODE	MATL. SPECN.	A. C.	UNIT	QTY.
			04	SUPPORT			SS-304L				04
			03	BRACKET	RD 99 320 700		SS-304L				04
			02	FLANGE	RD DG 4 35 0520 6622		SS-304L				01
			01	DISH	RD DG 4 35 0520 6621		SS-304L				01

TYPE OF PRODUCT
NAME OF CUSTOMER
GSM-245



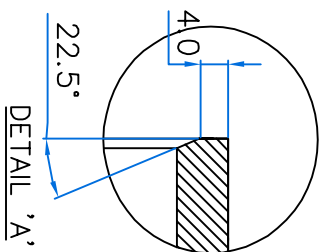
BHARAT HEAVY ELECTRICALS LTD.
HYDERABAD

DRN	NAME	SIGN.	DATE	NO. OF
AL			07/02/19	VAR.
CHKD	AL		07/02/19	
APPR	MURAO		07/02/19	NO. OF
REF. TO				ITEMS

REV.	DATE	ALTERED	REV.	DATE	ALTERED	TITLE	CARD CODE	DRAWING NO.	REV.
		CHECKED			CHECKED	DISH ASSY	RD DG 4 35 0520 6600		
ZONE			ZONE						

INVENTORY NO.	SIGN. AND DATE	REF. DRG. NO.
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GSM-245

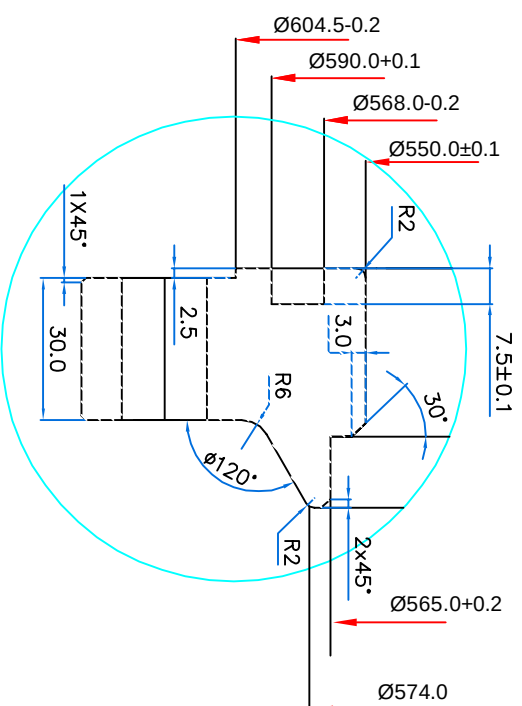
REV.	DATE	ALTERED CHECKED	REV.	DATE	ALTERED CHECKED	DEPT.	GRADE OF TOL. DIM. C/M/F	SCALE	WEIGHT(G)	REF. TO	ITEM NO. (ITEMS)
ZONE			ZONE			CODE				DRAINING NO.	
						TITLE				CARD CODE	
								DISH		RD DG 4 35 0520 6621	
										SHEET NO.	NO. OF SHEETS
										RD DG 4 35 0520 6621	



BHARAT HEAVY ELECT
HYDERABAD

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INVENTORY NO.



REFER DETAIL 'A'

DETAIL 'A'

1. Sealing area shall be plosished to RA 0.8 or better.
2. M 16.0 Taps shall be chamfered uniformly (0.8x45°).
3. PCD and flange centre shall be concentric within ± 0.05
4. Finished flange shall be degreased and packed in 125 micron poly bag and sealed.
5. Component shall be Machined to dimensions after welding to dish

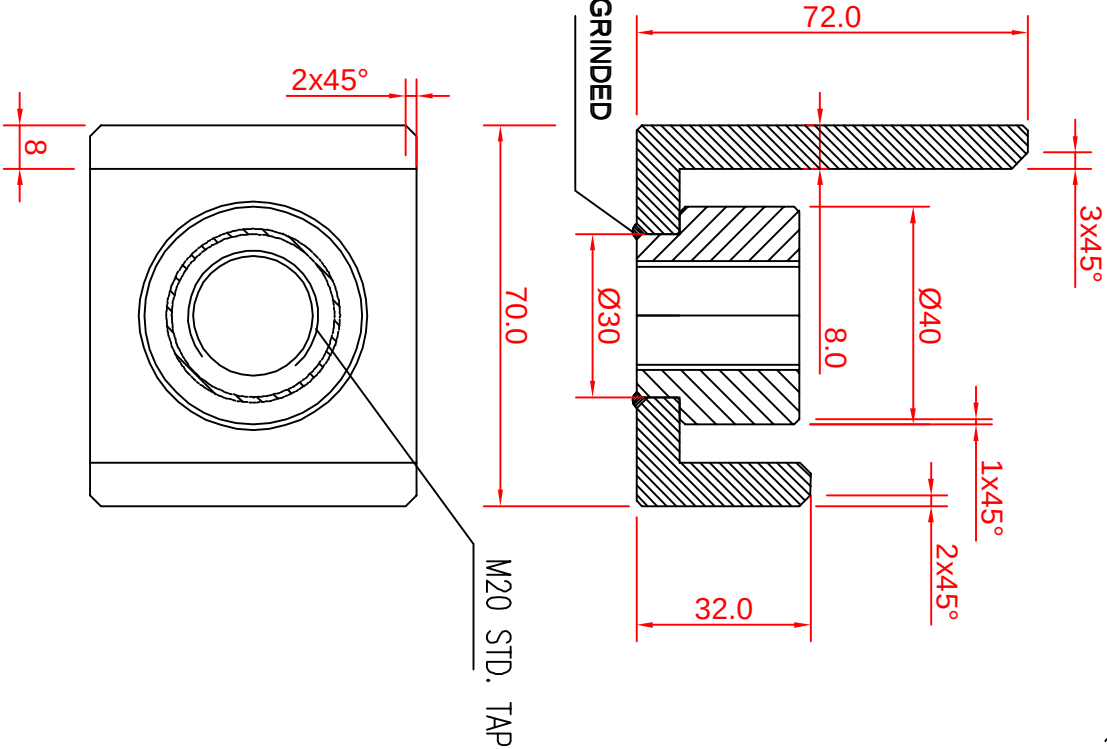
REV.	DATE	ALTERED	CHECKED	REV.	DATE	ALTERED	CHECKED	DEPT.	GRADE OF TOL. DIM.	SCALE	WEIGHT(NG)	DRAWING NO. REF. TO	ITEM NO.	ITEM	
			CHECKED					CODE	C/M/F						
ZONE				ZONE				TITLE			CARD CODE	DRAWING NO.		REV.	
								FLANGE						RD DG 4 35 0520 6622	
												SHEET NO.	NO. OF SHEETS		

[illegible]

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INVENTORY NO.	SIGN. AND DATE	REF. DRG. NO.
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TIG/MIG WELDED AND GRINDED



AFTER WELDING SURFACE SHALL BE GRINDED TO DIMENSIONS
ALL SHARP EDGES SHALL BE MACHINED TO 0.4x45°
COMPONENT SHALL MATCH ENCLOSURE SURFACE.

VAR. NO.	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	VAR.	SS-304L	MATL. CODE	A	UNIT	UNIT WT.	QTY.	GS	ZONE
			01	BLOCK											

TYPE OF PRODUCT
NAME OF CUSTOMER
GSM 145



BHARAT HEAVY ELECTRICALS LTD.
HYDERABAD

DRN	NAME	SIGN.	DATE	NO. OF
ORD	KS RMD		01.02.02	VAR.
APPD	MM RMD		01.02.02	

DEPT. CODE 35

GRADE OF TOL. PMA. C/M/F

SCALE NTS

WEIGHT(G)

REF. TO RD DG 4 35 0417 6620

ITEM NO. 1
REV. 2

BRACKET

CARD CODE RD 99 320 700

SHEET NO. NO. OF SHEETS 1 0