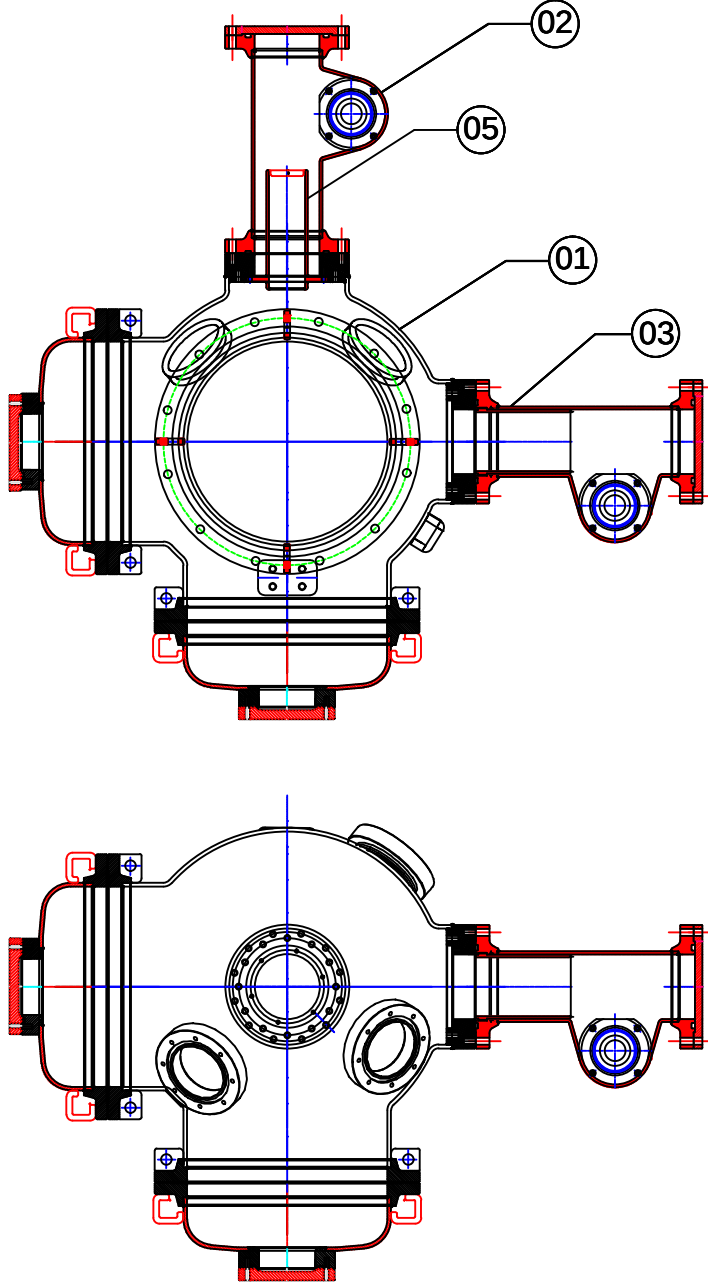




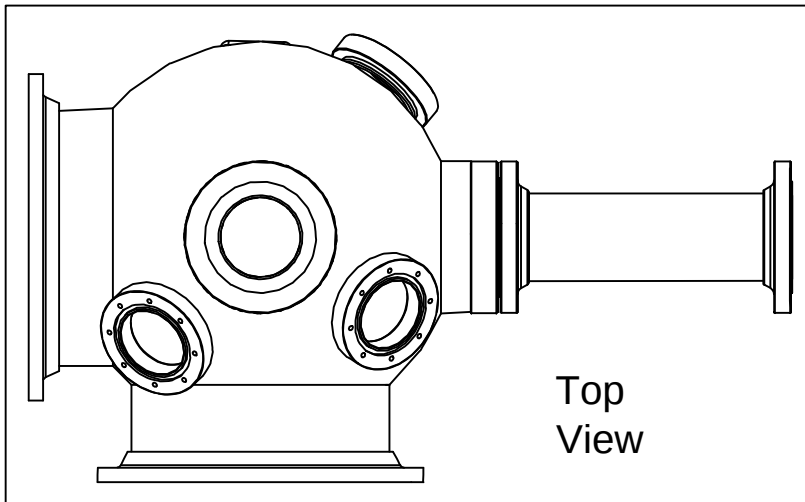
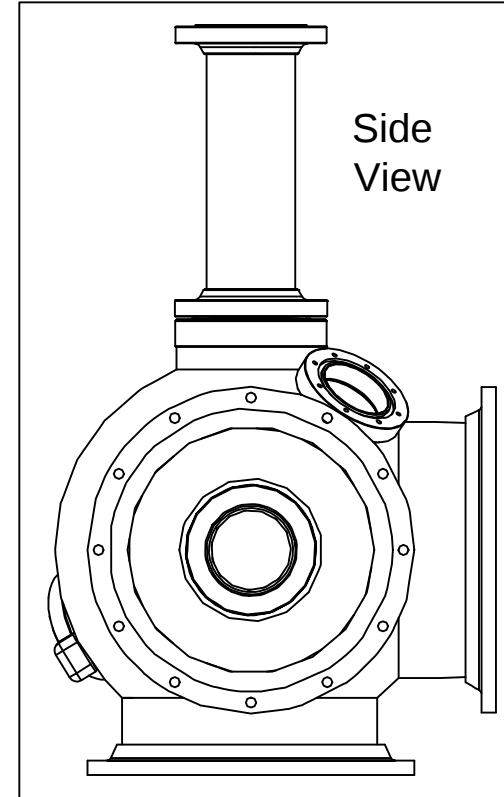
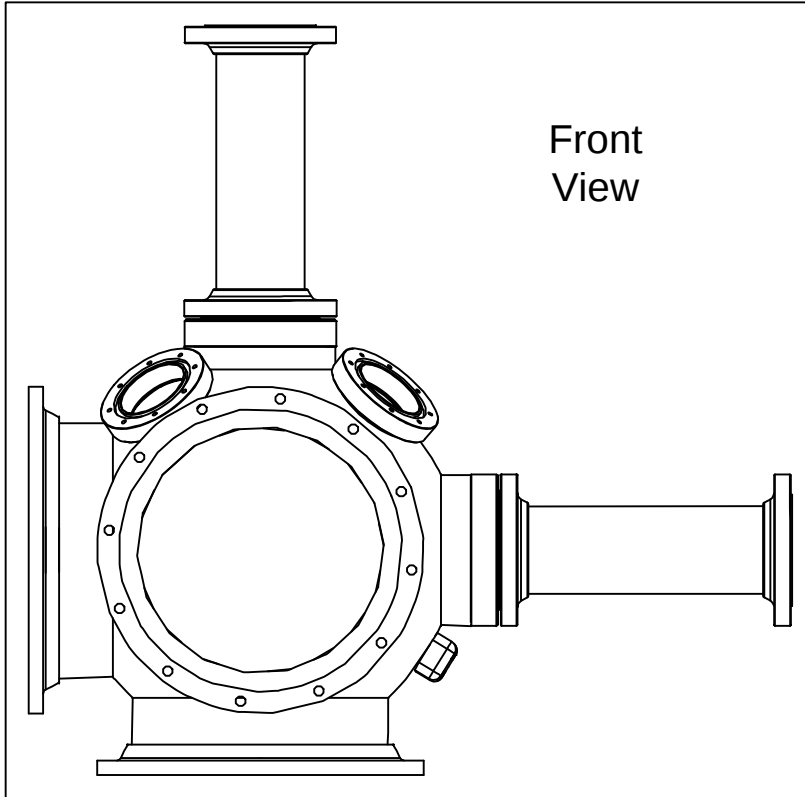
NOTE:

1. PIPE AND FLANGE TO BE TIG/MIG WELDING WITH SUITABLE SS ELECTRODE
2. THE ROOT SHOULD BE HOMOGENEOUS AND CONTINUOUS.
3. PRESSURE TEST AT 15.0 BAR FOR 15 MINUTES
4. TESTED ASSEMBLIES TO BE DEGREASED, SAND BLASTED AND POWDER COATED ON OUTSIDE.
5. MAINTAIN PERPENDICULARITY AND PARALLARITY BETWEEN FLANGES WITHIN 0.1°
6. INNER SURFACE OF DS ENCLOSURE AND DISH ENDS SHALL BE ELECTROPOLISHED.

05	DS SS SHIELD	RD DG 4 35 0517 2519	SS-304 L	01		
04	DISH END-II	RD DG 4 35 0517 2040	SS-304 L	03		
03	ES DRIVE ASSEMBLY	RD DG 4 35 0517 2370	SS-304 L	01		
02	DS DRIVE ASSEMBLY	RD DG 4 35 0517 2570	SS-304 L	01		
01	DS/ES ENCLOSURE	RD DG 4 35 0517 2031	SS-304 L	01		
ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.NO.	MATL. CODE	UNIT WT.
				VAR	MATL. SPECN.	QTY.

TYPE OF PRODUCT		NAME OF CUSTOMER				GSM-245	
BHARAT HEAVY ELECTRICALS LTD.		DRN	NAME	SIGN.	DATE	NO. OF VAR.	
HYDERABAD		CKD	BSM		14.10.13	01	
		APPD	MMRAO		14.10.13		
DEPT.	GRADE OF TOL. DIM. C/M/F	SCALE	WEIGHT(KG)	REF. TO		ITEM NO.	NO. OF ITEMS
CODE		NTS		RD DG 4 35 0517 2000		1	
TITLE			CARD CODE	DRAWING NO.		REV.	
DS/ES ENCLOSURE ASSEMBLY				RD DG 4 35 0517 2030			
				SHEET NO.		NO. OF SHEETS	

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



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REF. DRG. NO.

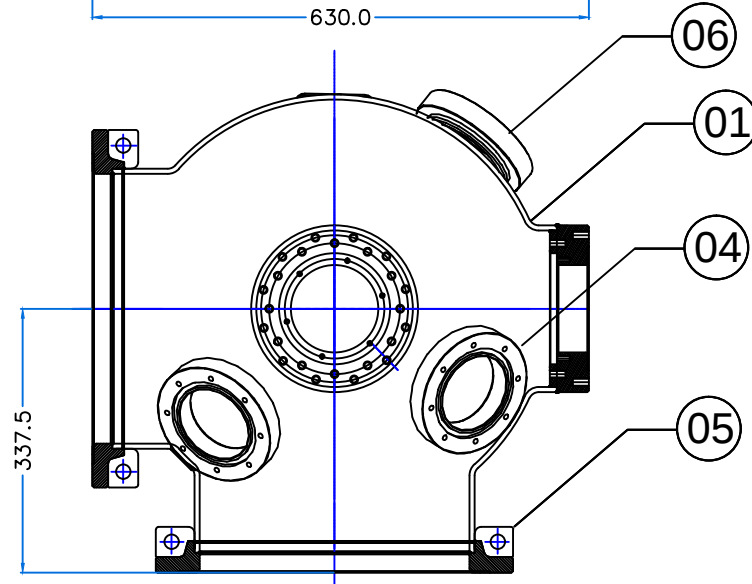
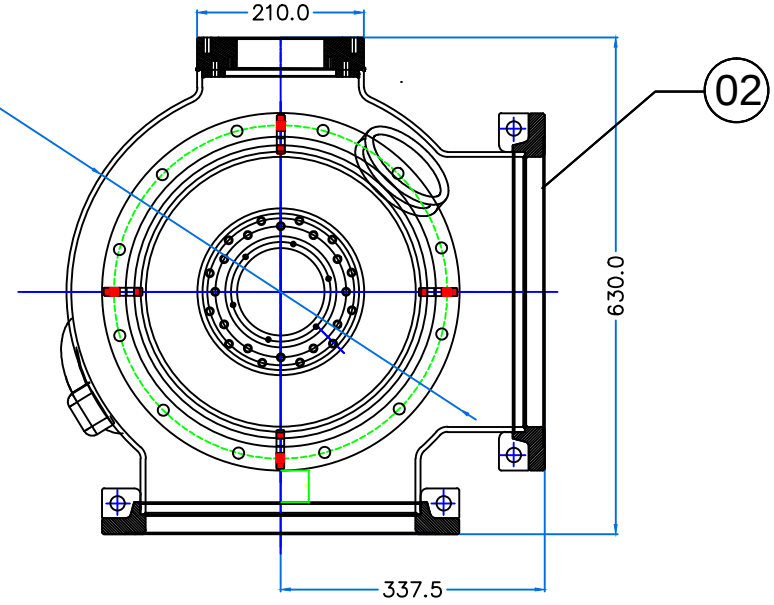
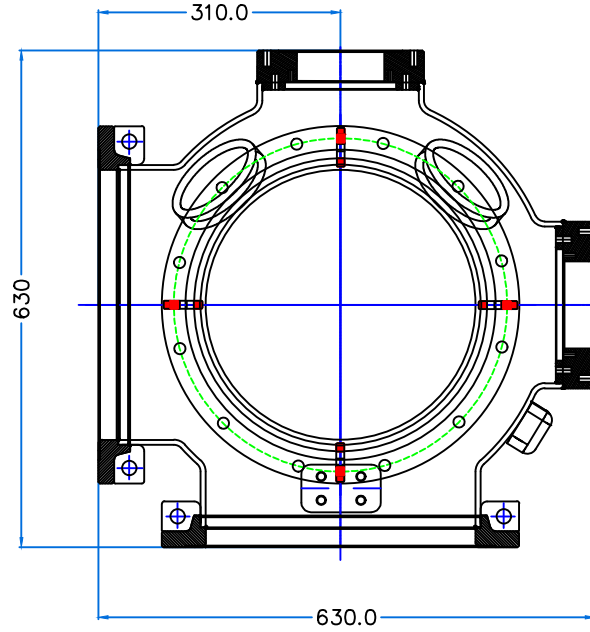
SIG. AND DATE

INVENTORY NO.

RD DG 4 35 0517 2031
DRG. NO.

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)



05	RUPTURE DISK ASSY	RD DG 99 320 600		SS-304 L		1		
05	LIFTING LUGS	RD DG 4 35 0517 2013		SS-304 L		12		
04	FLANGE-III	RD DG 4 35 1133 4160		SS-304 L		02		
03	FLANGE-IV	RD DG 4 35 0517 2033		SS-304 L		02		
02	FLANGE-II	RD DG 4 35 0569 1013		SS-304 L		03		
01	SPHERICAL PIPE	RD DG 4 35 0517 2032		SS-304 L		01		
ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.NO. VAR	MATL. CODE MATL. SPECN.	A C UNIT	UNIT WT. QTY.	GS ZONE

TYPE OF PRODUCT

NAME OF CUSTOMER

GSM-245



BHARAT HEAVY ELECTRICALS LTD.
HYDERABAD

DRN	NAME	SIGN.	DATE	NO. OF
CKD	NSK		14.10.13	VAR.
APPD	BSMURTHY		15.10.13	
	MMRAO		15.10.13	

01

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

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

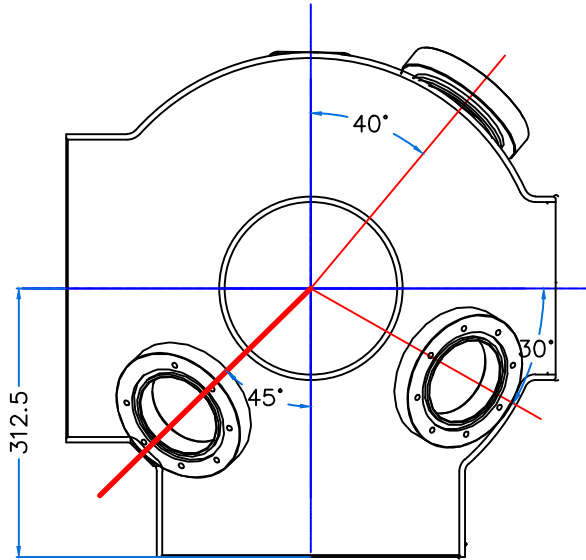
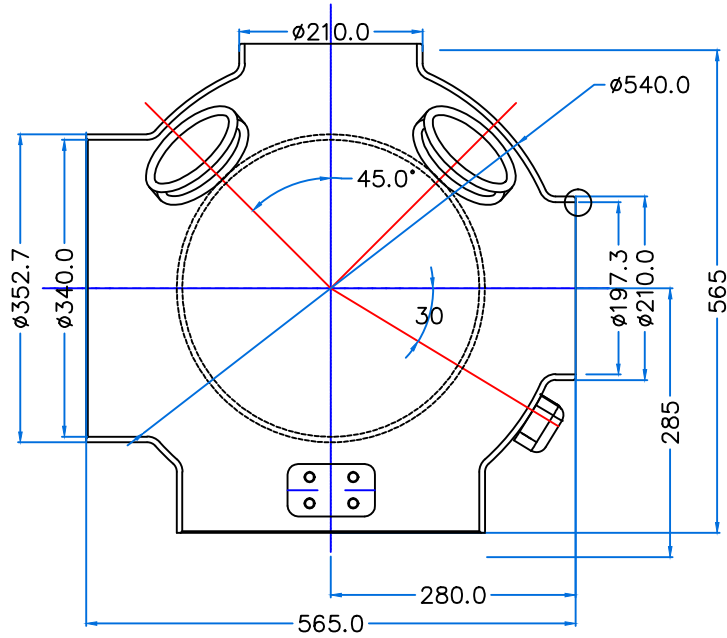
TITLE
DS/ES ENCLOSURE

CARD CODE

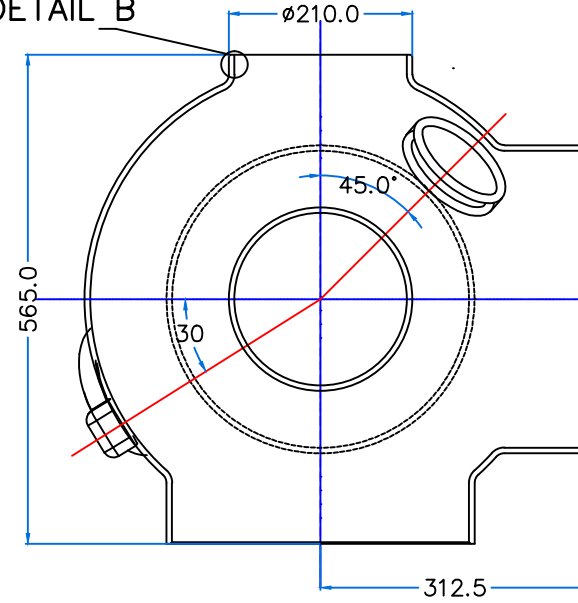
REF. TO	ITEM NO.	NO. OF
RD DG 4 35 0517 2030	1	ITEMS
DRAWING NO.		REV.
RD DG 4 35 1131 2031		
SHEET NO.		NO. OF SHEETS

RD DG 4 35 0517 2032
DRG. NO.

FIRST ANGLE PROJECTION



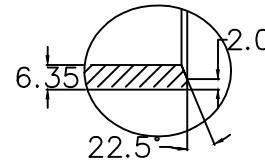
DETAIL B



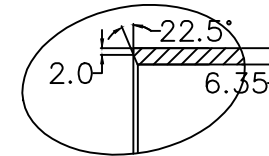
DETAIL A

(ALL DIMENSIONS ARE IN mm)

ISOMETRIC VIEW



DETAIL 'A'



DETAIL 'B'

VAR.00	REMARKS	VAR. NO.	ITEM NO.	01	SPHERICAL PIPE	RD DG 4 35 0517 2032	SS-304 L	01	UNIT WT.	QTY.	CS	ZONE
VAR												

TYPE OF PRODUCT		NAME OF CUSTOMER		GSM-245	
BHARAT HEAVY ELECTRICALS LTD.		HYDERABAD			
DRN	NAME	SIGN.	DATE	NO. OF	
CKD	BSM		16.09.17	VAR.	
APPD	MMRAO		16.09.17	01	
DEPT.	GRADE OF	SCALE	WEIGHT(KG)	REF. TO	ITEM
CODE	TOL. DIM.	NTS		RD DG 4 35 0517 2031	NO.
TITLE			CARD	DRAWING NO.	REV.
SPHERICAL PIPE			CODE	RD DG 4 35 0517 2032	
			SHEET NO.		NO. OF SHEETS

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

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

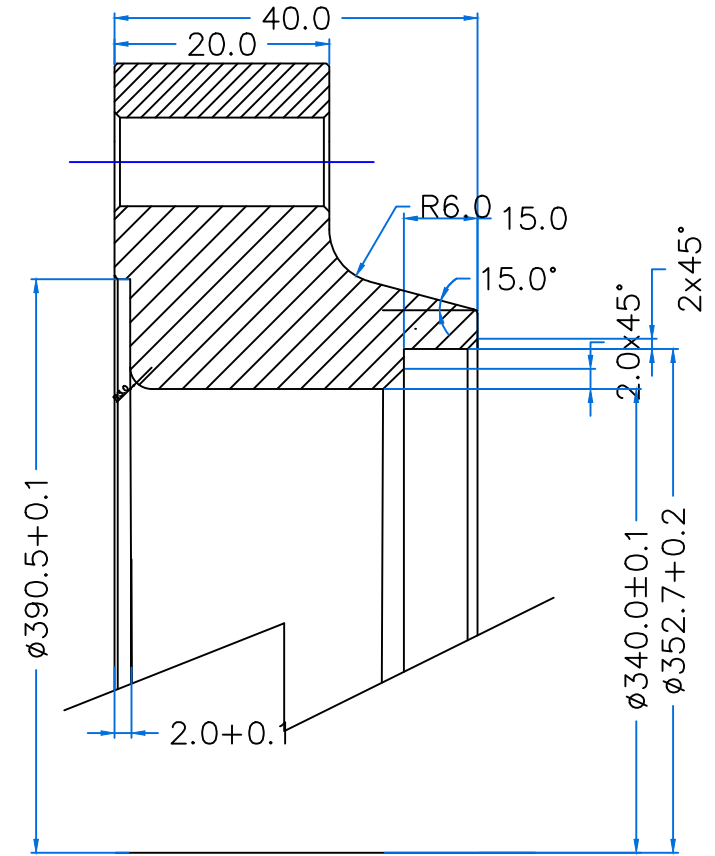
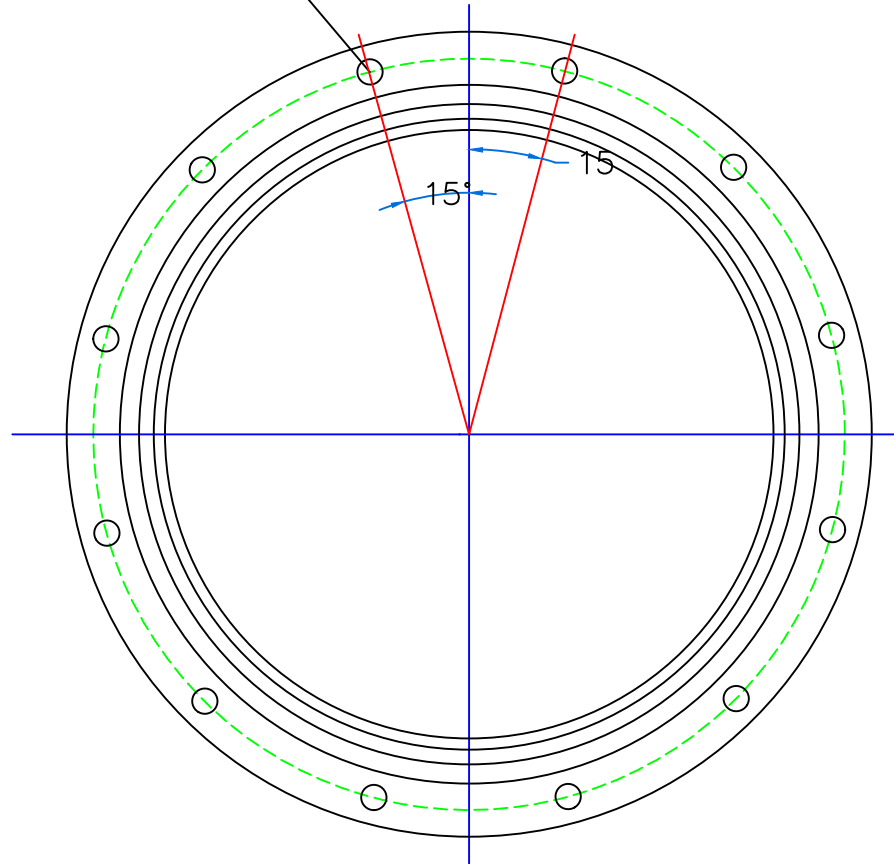
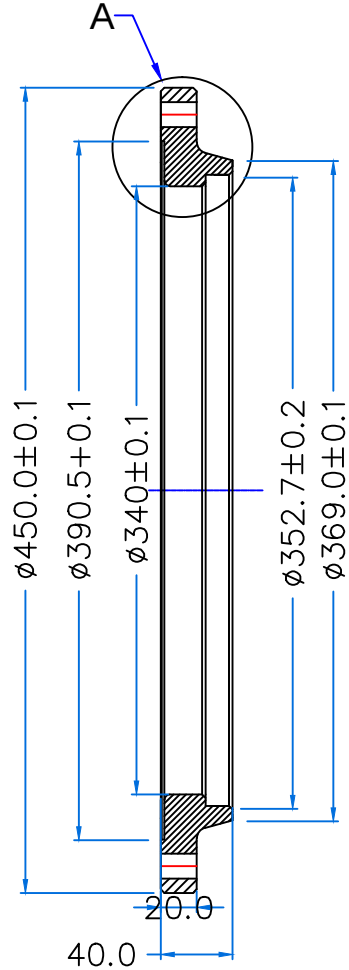
DRG. NO. RDDG435-0569-1013

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

(~1.6)

12 Nos $\phi 14$ Clear holes @PCD 420.0 ± 0.1

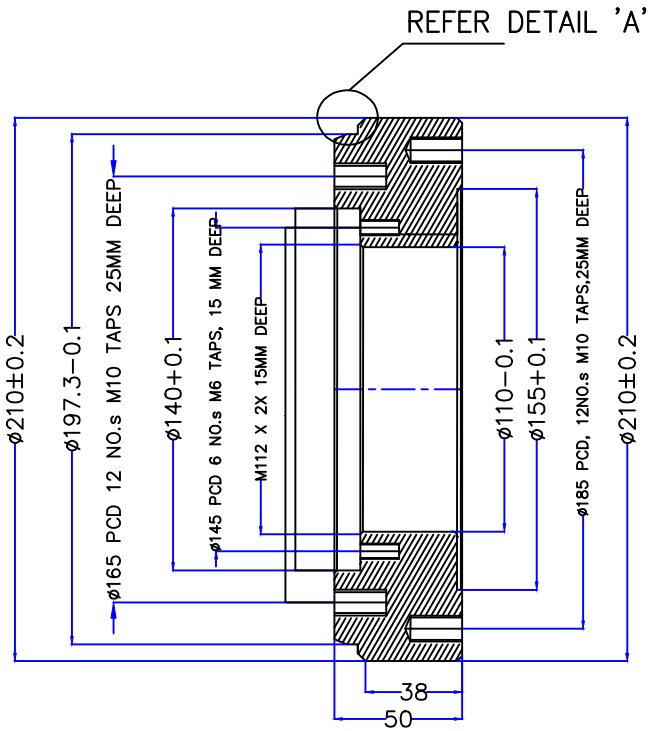


ENLARGED VIEW 'A'

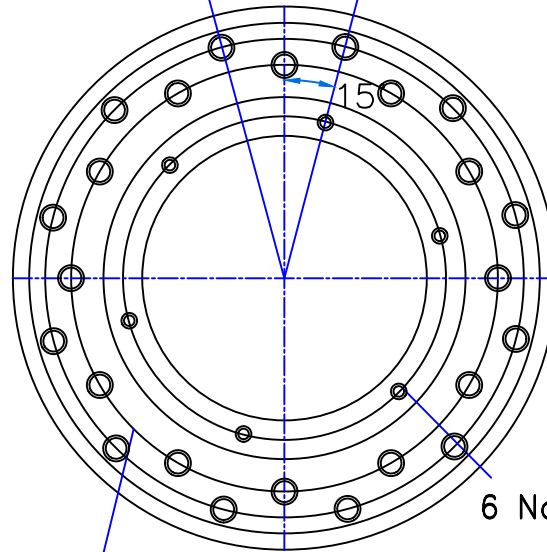
02		FLANGE		$\phi 460 \times 45 \text{ mm}$		SS-304L		01	
VAR.00	REMARKS	VAR NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.NO.	MATL. CODE	UNIT WT.
							VAR	MATL. SPECN.	QTY.

TYPE OF PRODUCT		NAME OF CUSTOMER				GSM-245			
		BHARAT HEAVY ELECTRICALS LTD.		DRN	NAME	SIGN.	DATE	VAR.	
		HYDERABAD		CKD	Mintoo		30.04.14		
				APPD	MMRAO		30.07.14		
					MMRAO		30.07.14	01	
DEPT.	GRADE OF TOL. DIM. C/M/F	SCALE	WEIGHT(KG)	REF. TO	ITEM NO.				
CODE		NTS		RDDG435-0569-1010	1				
TITLE				DRAWING NO.		REV.			
FLANGE II				RDDG435-0569-1013					
				SHEET NO.		NO. OF SHEETS			

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

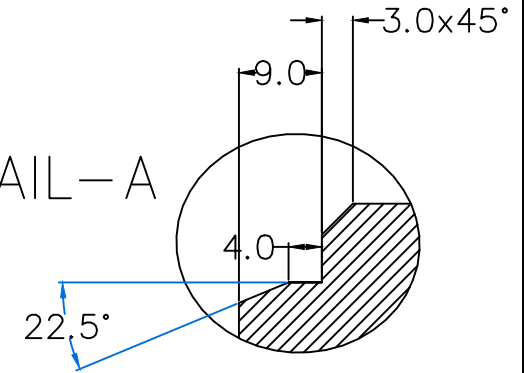


12 No., M10 TAPS @ 185.0 PCD, 25.0 DEEP



6 No., M6 TAPS @ 125.0 PCD, 25.0 DEEP

DETAIL-A



12 No., M10 TAPS @ 165.0 PCD, 25.0 DEEP

Note:

- Sealing area shall be polished to RA 0.8 or better.
- $\phi 14.0$ holes shall be chamfered uniformly (0.8x45°).
- PCD and flange centre shall be concentric within ± 0.05
- Finished flange shall be degreased and packed in 125 micron poly bag and sealed.
- Component shall be Machined to dimensions after welding to spherical pipe

VAR.00	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.NO.	MATL. CODE	A	C	UNIT	QTY.	GS	ZONE
				SS BLANK		$\phi 350.0 \times 45.0$		SS-304L			02			

TYPE OF PRODUCT		GSM-245									
NAME OF CUSTOMER		BHARAT HEAVY ELECTRICALS LTD. HYDERABAD									
DRN	NAME	SIGN.	DATE	NO. OF							
CKD	BSM		15.10.13	VAR.							
APPD	MMR		15.10.13	01							
DEPT.	GRADE OF	SCALE	WEIGHT(KG)	REF. TO							
CODE	TOL. DIM.	NTS		RD DG 4 35 0517 2031							
TITLE		CARD	NO. OF SHEETS	REV.							
FLANGE-IV				RD DG 4 35 0517 2033							
		SHEET NO.									

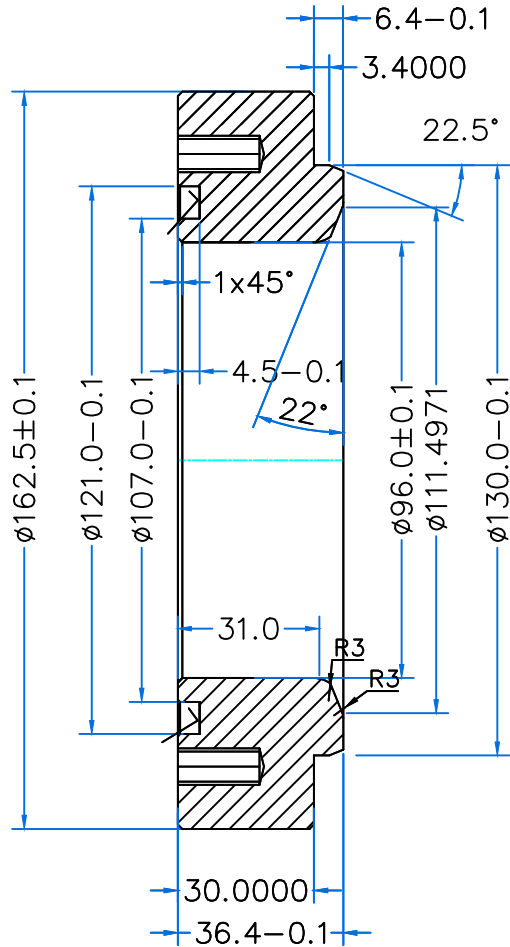
REV.	DATE	ALTERED	REV.	DATE	ALTERED
		CHECKED			CHECKED
ZONE			ZONE		

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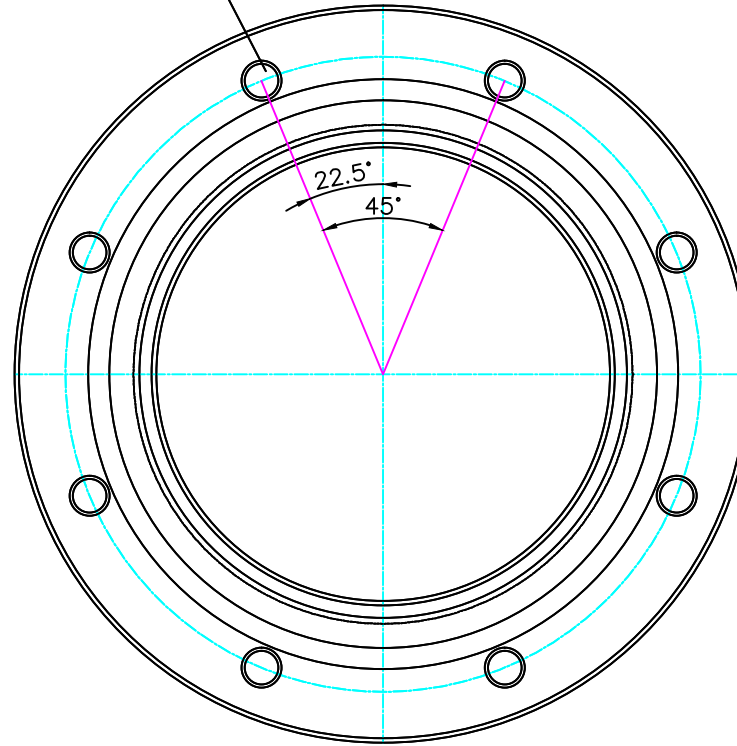
RD DG 4 35 1133 4160
DRG. NO.

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)



8 No. M8 TAPS @ 135.0 PCD, 20.0 deep



ALL SHARP EDGES SHALL BE MACHINED TO $0.4 \times 45^\circ$
MARKED SURFACE SHALL BE FINISHED TO RA0.8

VAR.00	REMARKS	VAR. NO.	ITEM NO.	01	SS BLANK	STD	DRAWING NO.	IT.NO.	MATL. CODE	SS-304L	A	UNIT	01	UNIT WT.	QTY.	GS	ZONE
--------	---------	----------	----------	----	----------	-----	-------------	--------	------------	---------	---	------	----	----------	------	----	------

TYPE OF PRODUCT		CGSM-145													
NAME OF CUSTOMER		BHARAT HEAVY ELECTRICALS LTD. HYDERABAD													
DRN		NAME		SIGN.		DATE		NO. OF							
CKD		KSRAO				26.12.05		VAR.							
APPD		AL				02.01.06									
		MMRAO				09.01.06		01							
REF. TO		RD DG 4 35 1133 4100 4													
DRAWING NO.		RD DG 4 35 1133 4160													
SHEET NO.		NO. OF SHEETS													

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

DEPT.	GRADE OF	SCALE	WEIGHT(KG)	REF. TO	ITEM	NO. OF
CODE	TOL. DIM.	NTS		RD DG 4 35 1133 4100	NO.	ITEMS
TITLE	C/M/F					
FLANGE-III			CARD			
			CODE			

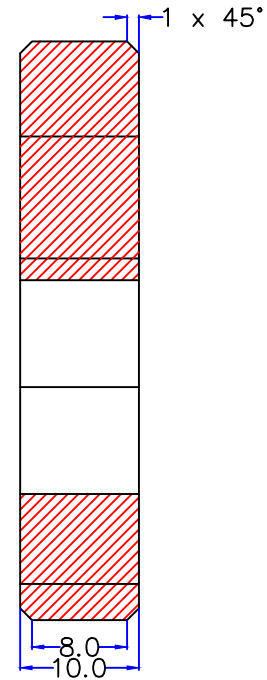
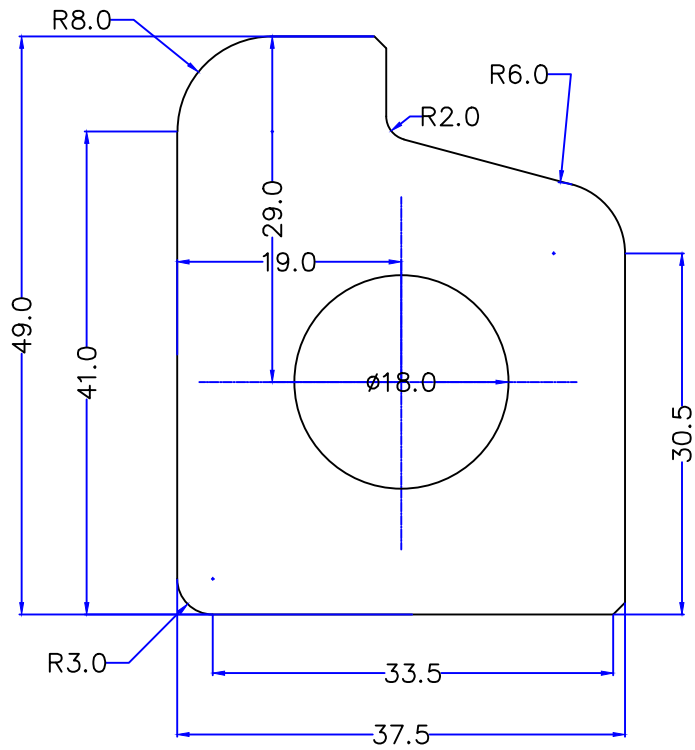
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DRG. NO. RD DG 4 35 0517 2013

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

(~3.2)



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

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-245											
		BHARAT HEAVY ELECTRICALS LTD.		DRN	NAME	SIGN.	DATE	NO.OF			
		HYDERABAD		CKD		NSK	23.05.13	VAR.			
				APPD		MMRAO	23.05.13	01			
DEPT.	GRADE OF	SCALE	WEIGHT(KG)	REF. TO	ITEM	NO.OF					
CODE	TOL. DIM.	NTS		RD DG 4 35 0517 2000	NO.	ITEMS					
TITLE		CARD		DRAWING NO.	REV.						
LIFTING LUGS				RD DG 4 35 0517 2013							
SHEET NO.		NO. OF SHEETS									

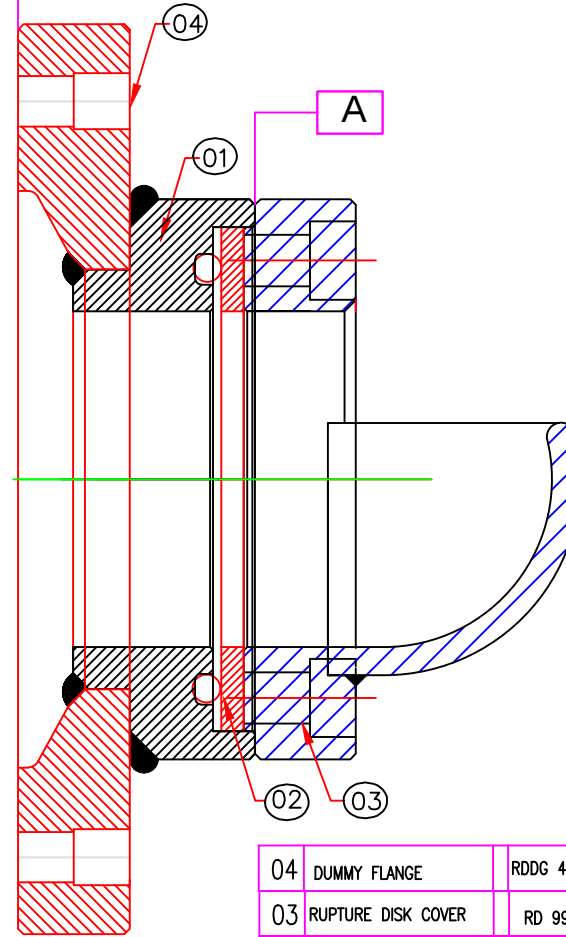
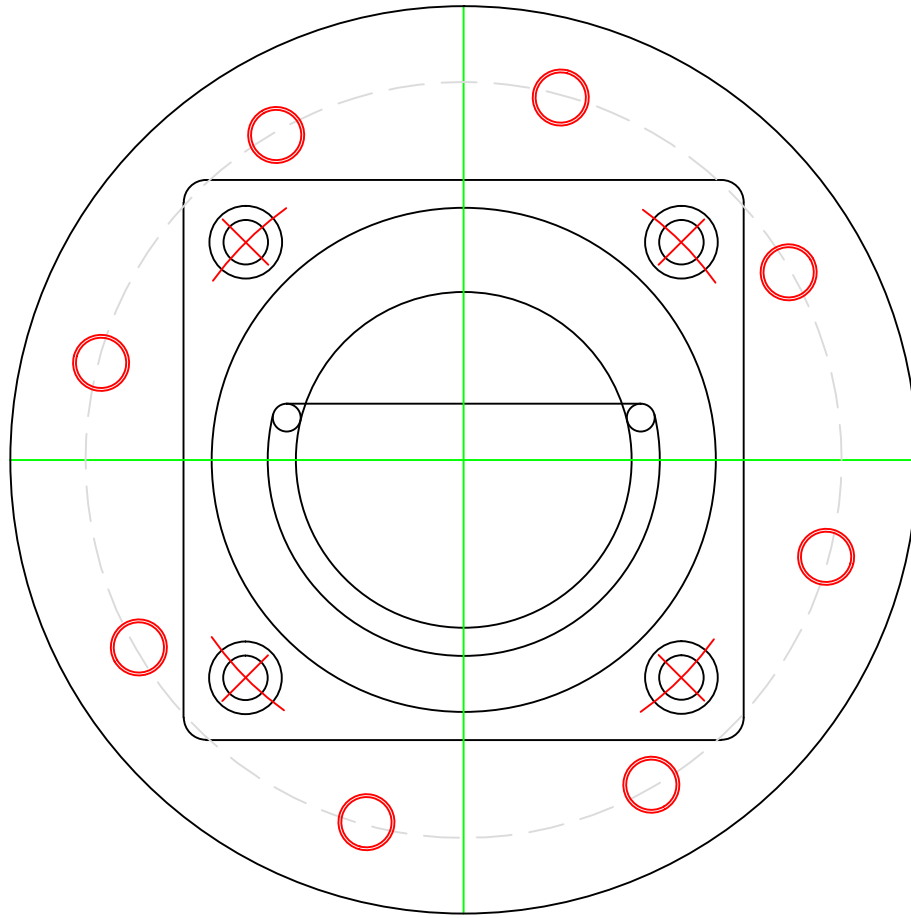
009 073 66 DR NO. 009 320 600

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

(~1.6)

0.1 A



Note:

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

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	
ITEM NO.	DESCRIPTION	DRAWING NO.	IT. NO. VAR	MATL. CODE MATL. SPECN.	UNIT QTY.

10/05/16

REV.	DATE	ALTERED	AL
01	10/5/16	CHECKED	MMR
ZONE			
REVISED FOR CIRCULAR FLANGE			

TYPE OF PRODUCT		NAME OF CUSTOMER		GSM 145	
BHARAT HEAVY ELECTRICALS LTD. HYDERABAD		DRN	KS RAO	SIGN.	DATE
		CKD	MM RAO		01.02.03
		APPD	HS JAIN		01.02.03
DEPT.	GRADE OF	SCALE	WEIGHT(KG)	REF. TO	ITEM NO.
GSG	TOL. DIM.	NTS		RD 99 320 200	2
CODE 35	C/M/F			DRAWING NO.	REV.
TITLE		CARD CODE		RD 99 320 600	01
RUPTURE DISK ASSY		SHEET NO.		NO. OF SHEETS	

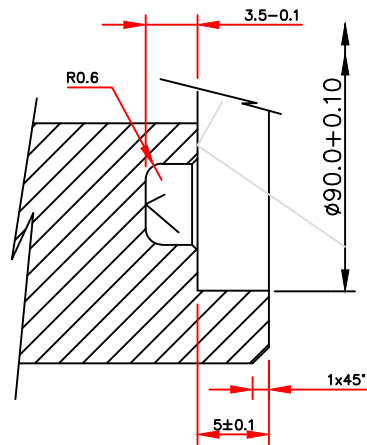
019 075 66-DR

DRG. NO.

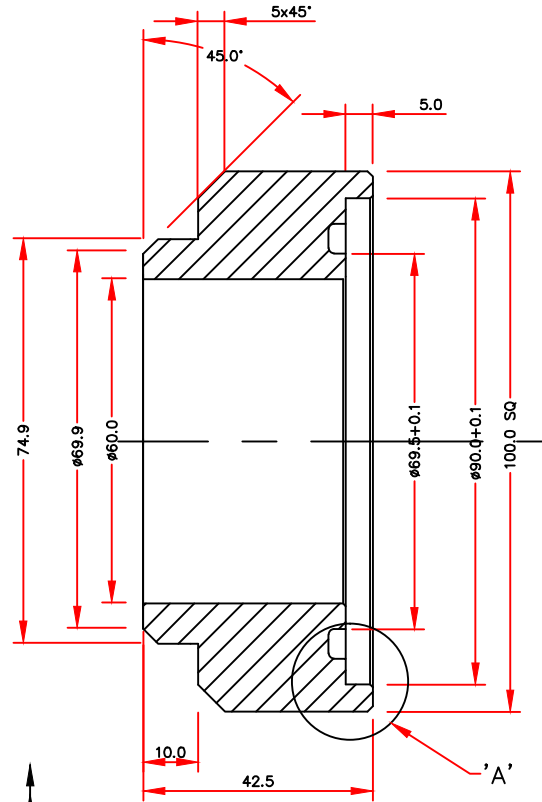
FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

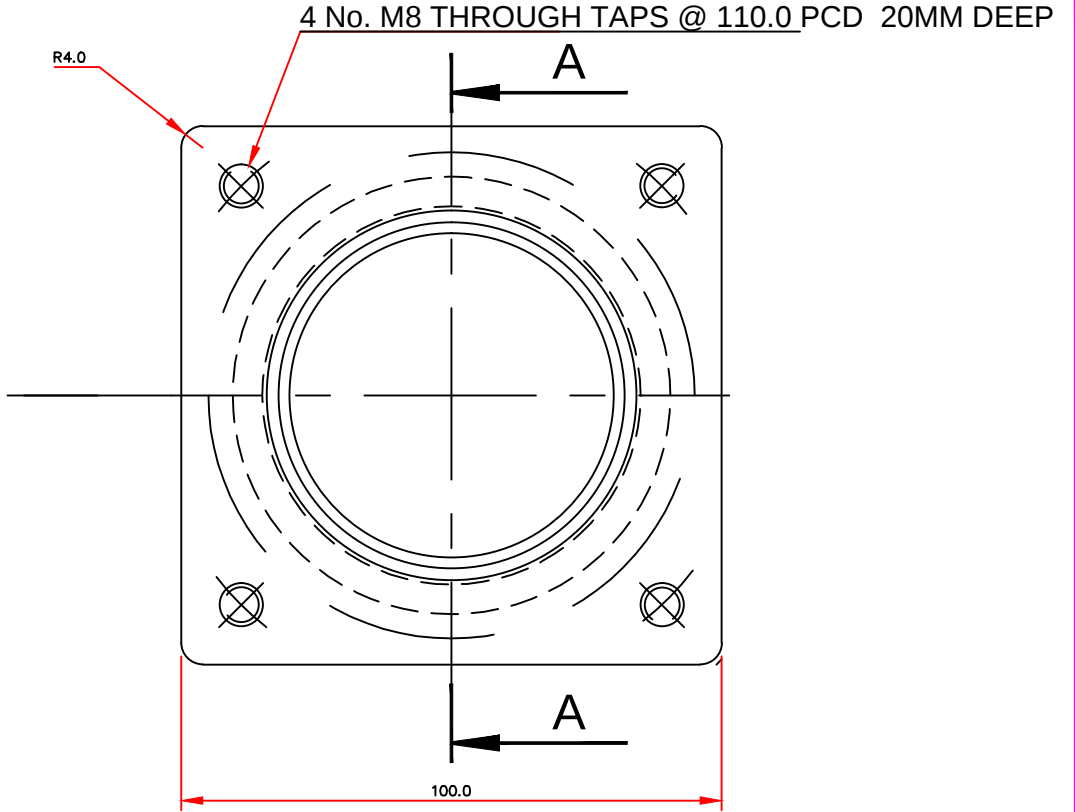
(~1.6)



ENLARGED VIEW 'A'



SECTION AA



VAR.00	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.NO.	MATL. CODE	A	UNIT	UNIT WT.	CS	ZONE
			01	SS PLATE		105.0 SQ x 30.0		SS 304					
							VAR	MATL. SPECN.			QTY.		

TYPE OF PRODUCT		GSM 145					
NAME OF CUSTOMER		BHARAT HEAVY ELECTRICALS LTD. HYDERABAD					
DRN	KS RAO	SIGN.	DATE	NO. OF			
CKD	MM RAO		01.02.03	VAR.			
APPD	HS JAIN		01.02.03				
DEPT.	GSS	GRADE OF	TOL. DIM.	SCALE	WEIGHT(KG)	REF. TO	ITEM
CODE	35	C/M/F		NTS		RD 99 320 600	2
TITLE		FLANGE		CARD	DRAWING NO.	REV.	
				CODE	RD 99 320 610	0	
				SHEET NO.		NO. OF SHEETS	

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		

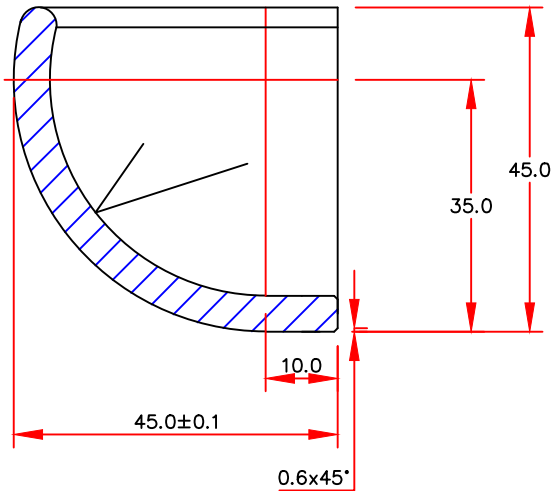


			01	TEFLON		Ø88X Ø65MM x 2.5MM			TEFLON					
VAR.00	REMARKS	VAR NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.NO.	MATL. CODE	A C	UNIT	UNIT WT.	CS		
							VAR	MATL. SPECN.			QTY.			

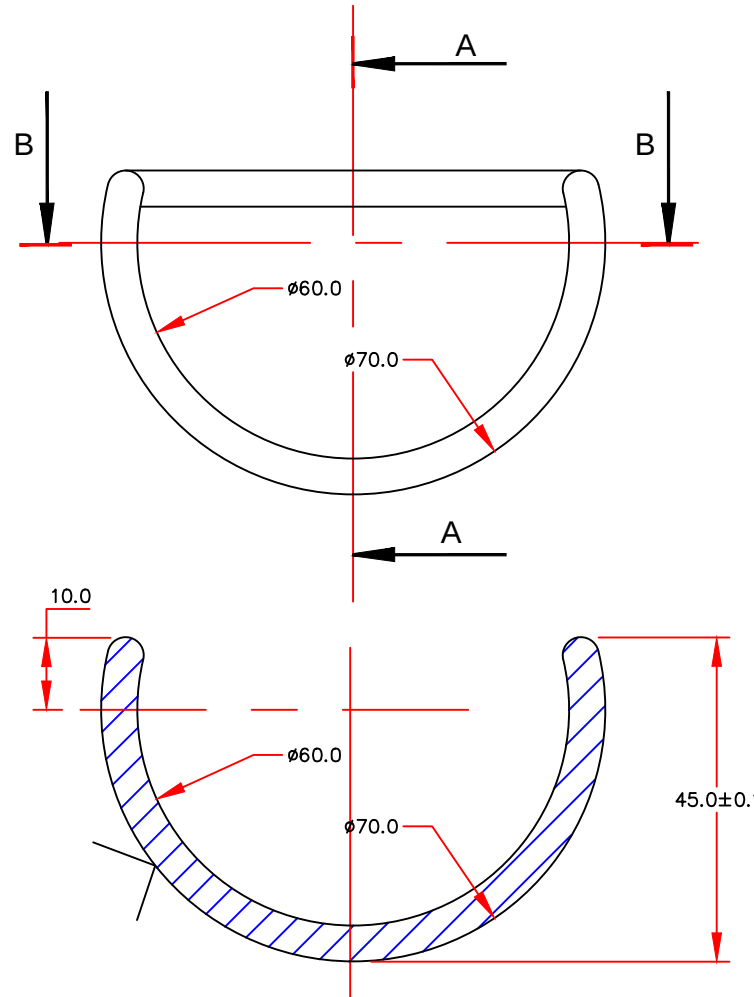
MARKED SURFACE SHALL BE FINISHED TO RA 0.8
ALL SHARP EDGES SHALL BE MACHINED TO 0.4x45°

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

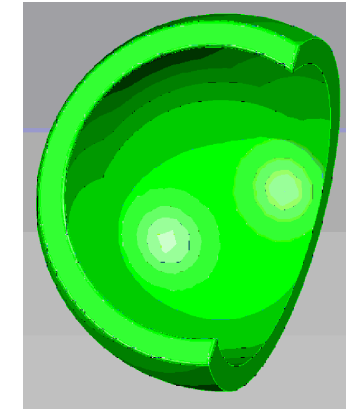
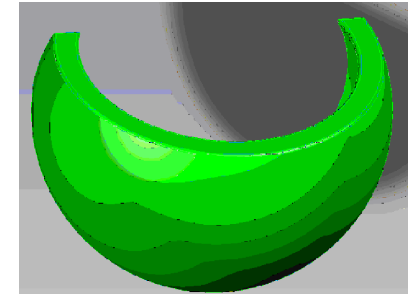
[illegible]



SECTION AA



SECTION BB



SURFACE SHALL BE FINISHED TO RA1.6
COMPONENT SHALL BE MADE USING SUITABLE PATTERN.
ALL SHARP EDGES SHALL BE MACHINED TO 0.4x45°

VAR.00	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.NO.	MATL. CODE	A	UNIT	UNIT WT.	QTY.	GS	ZONE
		01		SS PLATE				SS_304-L						

TYPE OF PRODUCT		GSM 145	
NAME OF CUSTOMER		BHARAT HEAVY ELECTRICALS LTD. HYDERABAD	
DRN	KS RAO	SIGN.	DATE
CKD	MM RAO		01.02.03
APPD	MM RAO		01.02.03
DEPT.	GSG	GRADE OF TOL. DIM.	C/M/F
CODE	35		
TITLE	PROTECTIVE COVER		
SCALE	NTS	WEIGHT(KG)	
REF. TO	RD 99 320 630	ITEM NO.	2
DRAWING NO.	RD 99 320 632	REV.	0
SHEET NO.	NO. OF SHEETS		

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

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REF. DRG. NO.

SIGN. AND DATE

INVENTORY NO.

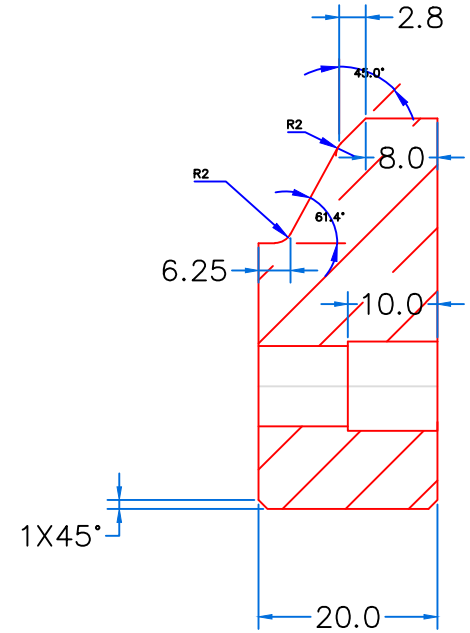
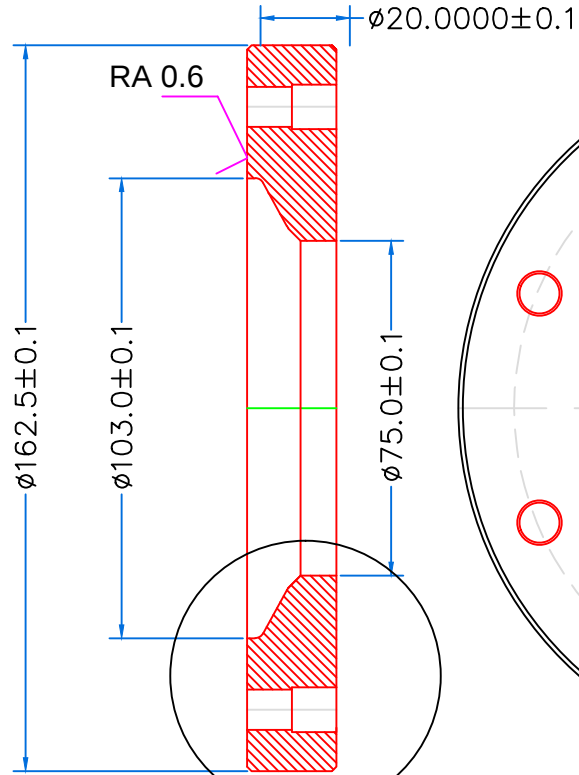
RD DG 4 35 0617 0983

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

(~1.6)

8 NO., HOLES WITH COUNTER FOR M8
@135±0.07 PCD WITH 0.4X45° C/F



DETAILED A

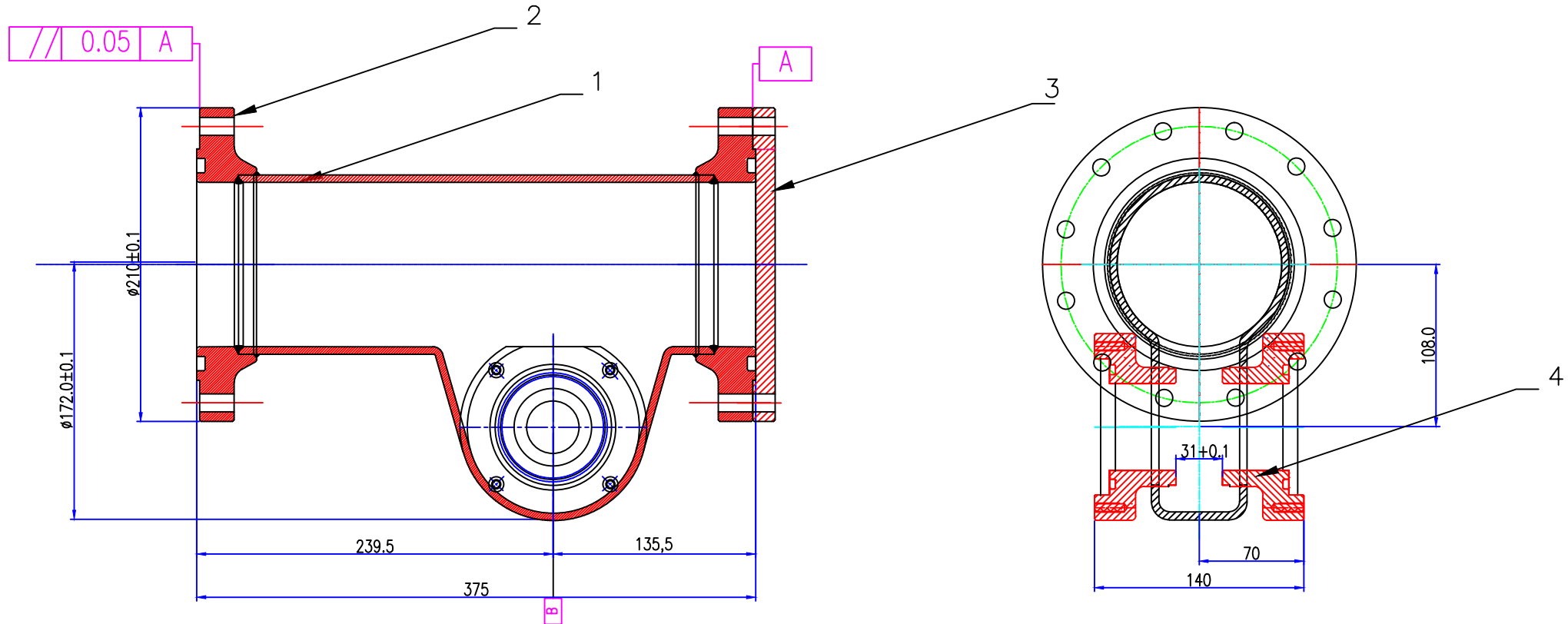
			01	FLANGE-V						2.3 KG		
										SS-304L		01
VAR.00	REMARKS	VAR NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.NO.	MATL. CODE	A	UNIT	UNIT WT.	ZONE
							VAR	MATL. SPECN.	C		QTY.	

TYPE OF PRODUCT		GSM 420									
NAME OF CUSTOMER											
		BHARAT HEAVY ELECTRICALS LTD.				DRN	NAME	SIGN.	DATE	NO.OF	
		HYDERABAD				CKD	KSRAO		26.12.05	VAR.	
						APPD	MMRAO		02.01.06	01	
							HSJAIN		09.01.06		
DEPT.	GRADE OF TOL. DIM. C/M/F		SCALE	WEIGHT(KG)		REF. TO			ITEM NO.	NO.OF ITEMS	
CODE			NTS	2.5		RD DG 4 35 0619 6610			08	4	
TITLE					CARD CODE	DRAWING NO.				REV.	
FLANGE-V						RD DG 4 35 0617 0983				01	
						SHEET NO.			NO. OF SHEETS		

RD DG 4 35 10517 2570
DRG. NO.

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)



NOTE:

1. PIPE AND FLANGE TO BE MIG WELDING WITH SUITABLE SS ELECTRODE
2. THE ROOT SHOULD BE HOMOGENEOUS AND CONTINUOUS.
3. PRESSURE TEST AT 15.0 BAR FOR 15 MINUTS
4. TESTED ASSEMBLIES TO BE DEGREASED, SAND BLASTED AND POWDER COATED ON OUTSIDE.
5. MAINTAIN PERPENDICULARITY AND PARALLARITY BETWEEN FLANGES WITHIN 0.1°
6. INNER SURFACE OF DS ENCLOSURE AND DISH ENDS SHALL BE ELECTROPOLISHED.

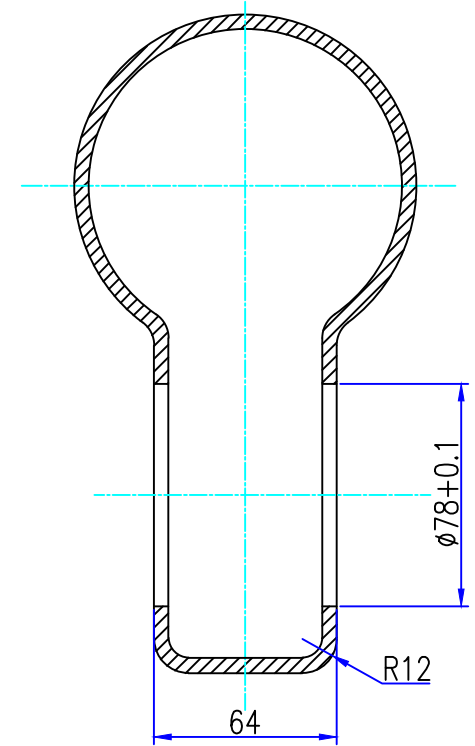
04	SHAFT HOUSING	RD DG 4 35 0517 2074		SS-304L		01	
03	GAS VALVE COVER	RD DG 4 35 0517 2073		SS-304L		01	
02	FLANGE-I	RD DG 4 35 0517 2072		SS-304L		02	
01	DRIVE PIPE	RD DG 4 35 0517 2071		SS-304L		01	
ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.NO.	MATL CODE	UNIT	QTY.
				VAR	MATL SPECN.	A	

TYPE OF PRODUCT		GSM-245					
NAME OF CUSTOMER							
	BHARAT HEAVY ELECTRICALS LTD.		DRN	NAME	SIGN.	DATE	NO. OF
	HYDERABAD		CKD	BSM		01.09.12	01
			APPD	MMRAO		01.09.12	
DEPT.	GRADE OF TOL. DIM. C/M/F	SCALE	WEIGHT(KG)	REF. TO		ITEM NO.	NO. OF ITEMS
CODE		NTS	59.5	RD DG 4 35 0517 2030		2	
TITLE			CARD CODE	REF. TO			
D/S DRIVE HOUSING ASSY				RD DG 4 35 0517 2570			
				SHEET NO. NO. OF SHEETS			

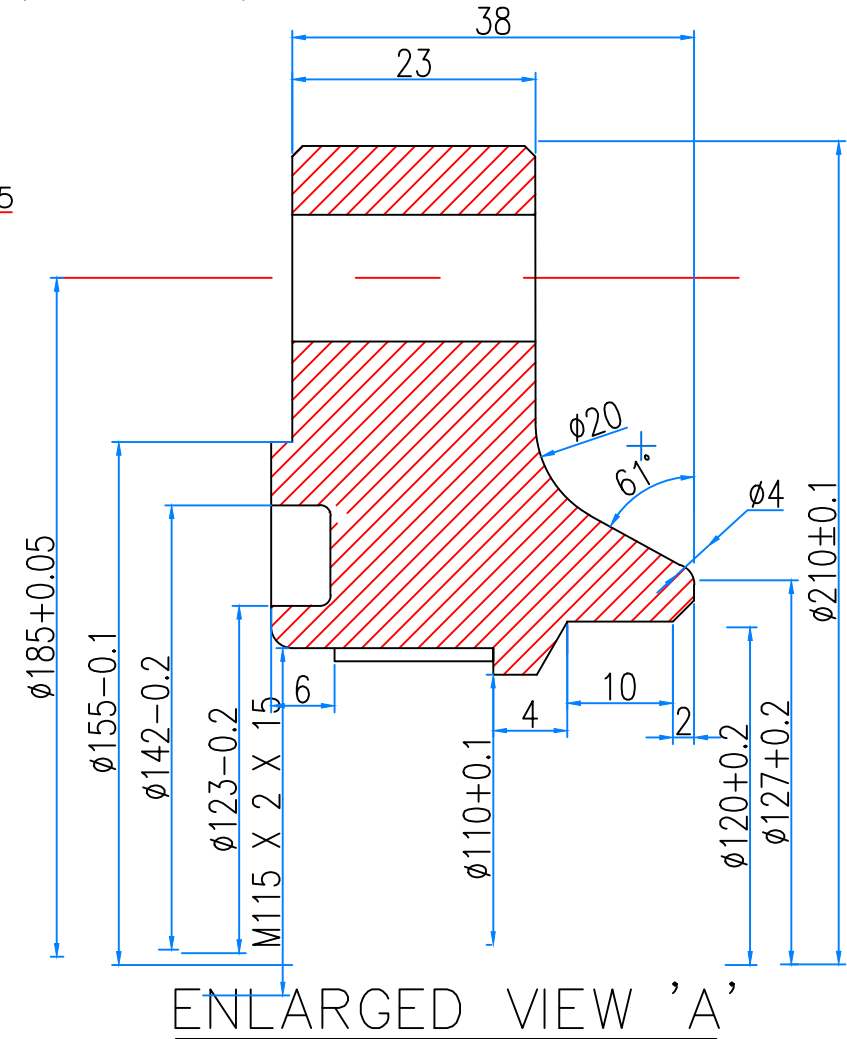
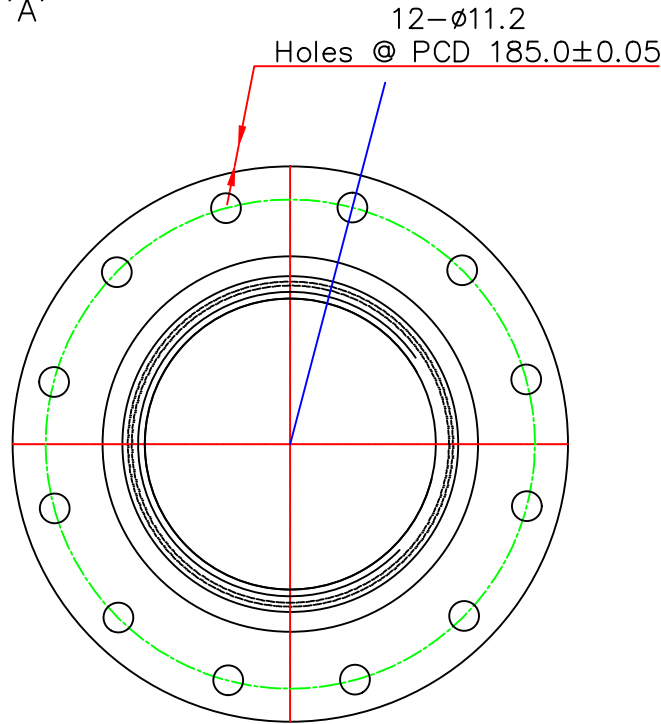
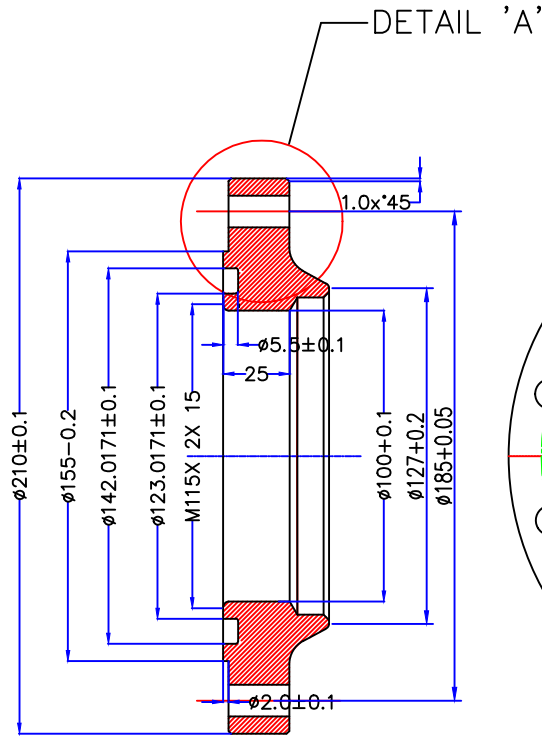
REV.	DATE	ALTERED	ZONE	REV.	DATE	ALTERED	ZONE
		CHECKED				CHECKED	
MODIFIED ON 16/08/2014							

INVENTORY NO.

(ALL DIMENSIONS ARE IN mm)



TYPE OF PRODUCT		GSM-245									
NAME OF CUSTOMER											
		BHARAT HEAVY ELECTRICALS LTD. HYDERABAD		DRN	NAME	SIGN.	DATE	NO.OF			
				CKD	BSM		10.12.13	VAR.			
				APPD	MMRAO		10.12.13	01			
DEPT.	GRADE OF TOL. DIM.		SCALE	WEIGHT(KG)	REF. TO			ITEM NO.	NO.OF		
CODE	C/M/F		NTS	59.5	RD DG 4 35 0517 2070		1		ITEMS		
TITLE				CARD CODE	DRAWING NO.		REV.				
DRIVE PIPE					RD DG 4 35 0517 2071						
				SHEET NO.		NO. OF SHEETS					



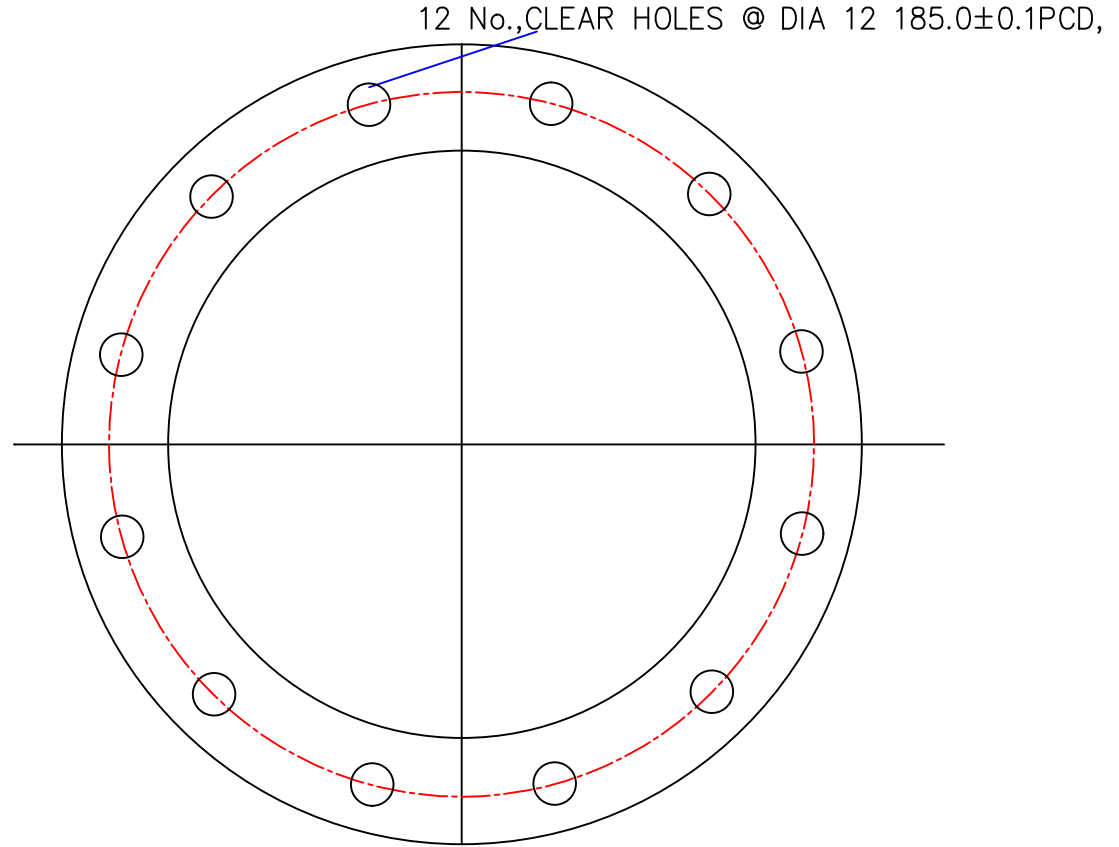
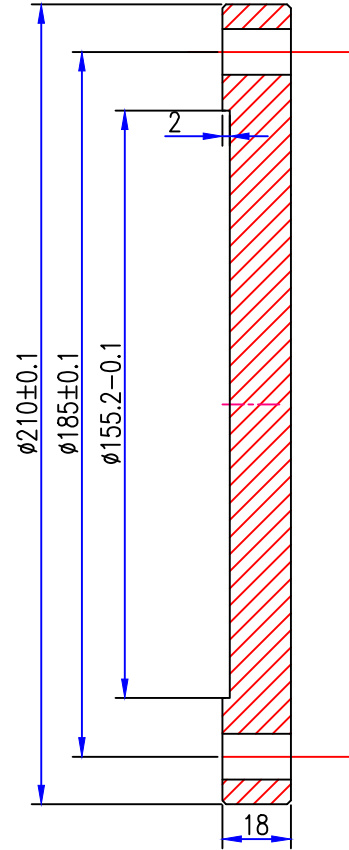
Note:

1. Sealing area shall be polished to RA 0.8 or better.
2. ϕ 11.0 holes 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 spherical pipe

VAR.00	REMARKS	VAR. NO.	ITEM NO.	01	BLOCK	$\phi 210.0 \times 38.0$	SS-304L	UNIT WT.	QTY.	GS	ZONE
--------	---------	----------	----------	----	-------	--------------------------	---------	----------	------	----	------

TYPE OF PRODUCT		NAME OF CUSTOMER		GSM-245	
BHARAT HEAVY ELECTRICALS LTD.		HYDERABAD			
DRN	NAME	SIGN.	DATE	NO. OF	
CKD	BSM		13.12.13	VAR.	
APPD	MMRAO		13.12.13		
DEPT.		GRADE OF TOL. DIM. C/M/F	SCALE	WEIGHT(KG)	REF. TO
TITLE		NTS			RD DG 4 35 0517 2070
FLANGE-I					2
DRAWING NO.		CARD CODE		REV.	
RD DG 4 35 0517 2072				00	
SHEET NO.		NO. OF SHEETS			

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



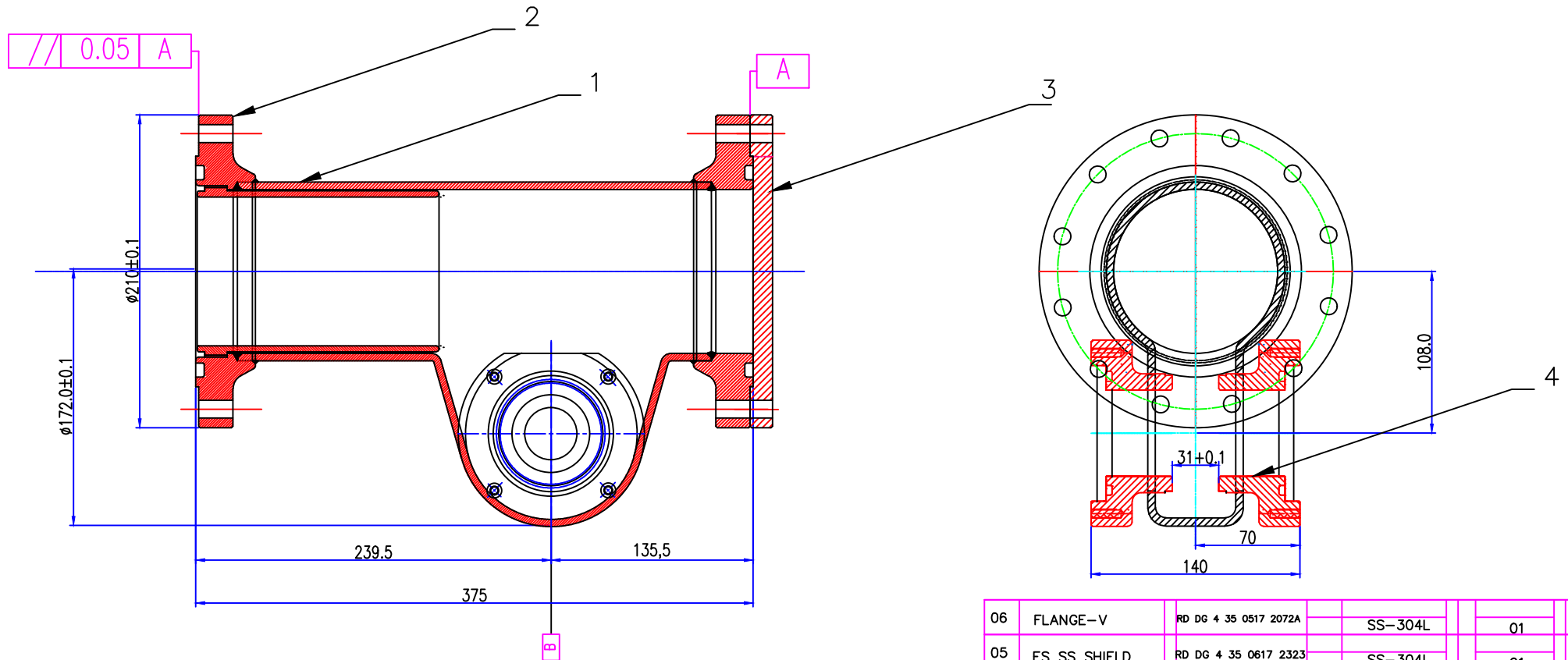
ALL SHARP EDGES SHALL BE MACHINED TO 0.4x45°
DISH SHALL BE PREPARED WITH SUITABLE DIE.

01	SHEET	SS-304L	01
VAR.00	REMARKS	IT.NO.	MATL. CODE
VAR. NO.	ITEM NO.	DESCRIPTION	DRAWING NO.
VAR	MATL. SPECN.	A	UNIT
UNIT	QTY.	GS	ZONE

TYPE OF PRODUCT		NAME OF CUSTOMER			
		GSM-245			
	BHARAT HEAVY ELECTRICALS LTD.		DRN	NAME	SIGN.
	HYDERABAD		CKD	BSM	DATE
			APPD	MMRAO	NO. OF
DEPT.	GRADE OF	SCALE	WEIGHT(KG)	REF. TO	ITEM
CODE	TOL. DIM.			RD DG 4 35 0517 2070	NO.
TITLE			CARD CODE	DRAWING NO.	REV.
GAS VALVE COVER				RD DG 4 35 0517 2073	
				SHEET NO.	NO. OF SHEETS

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

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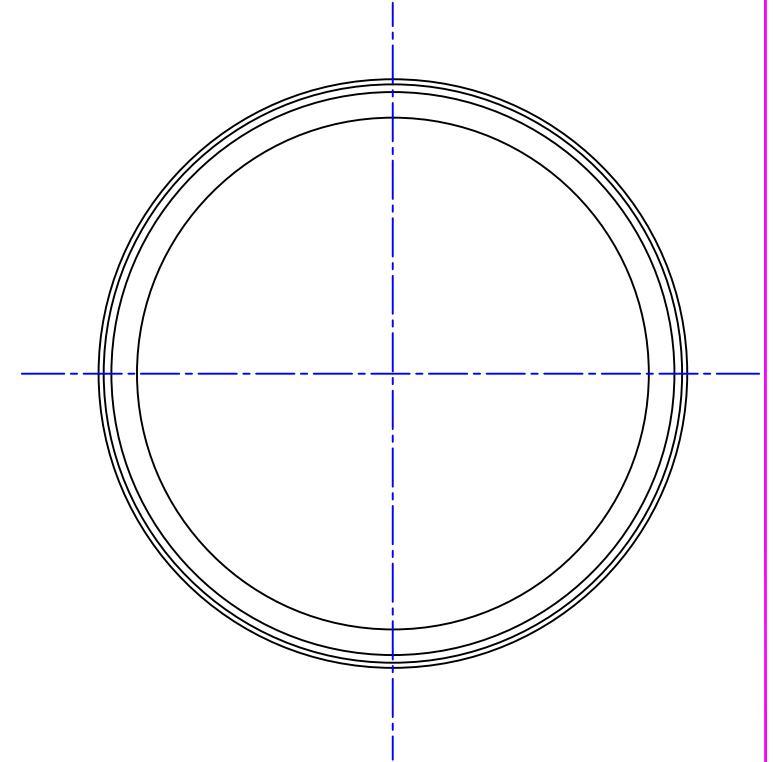
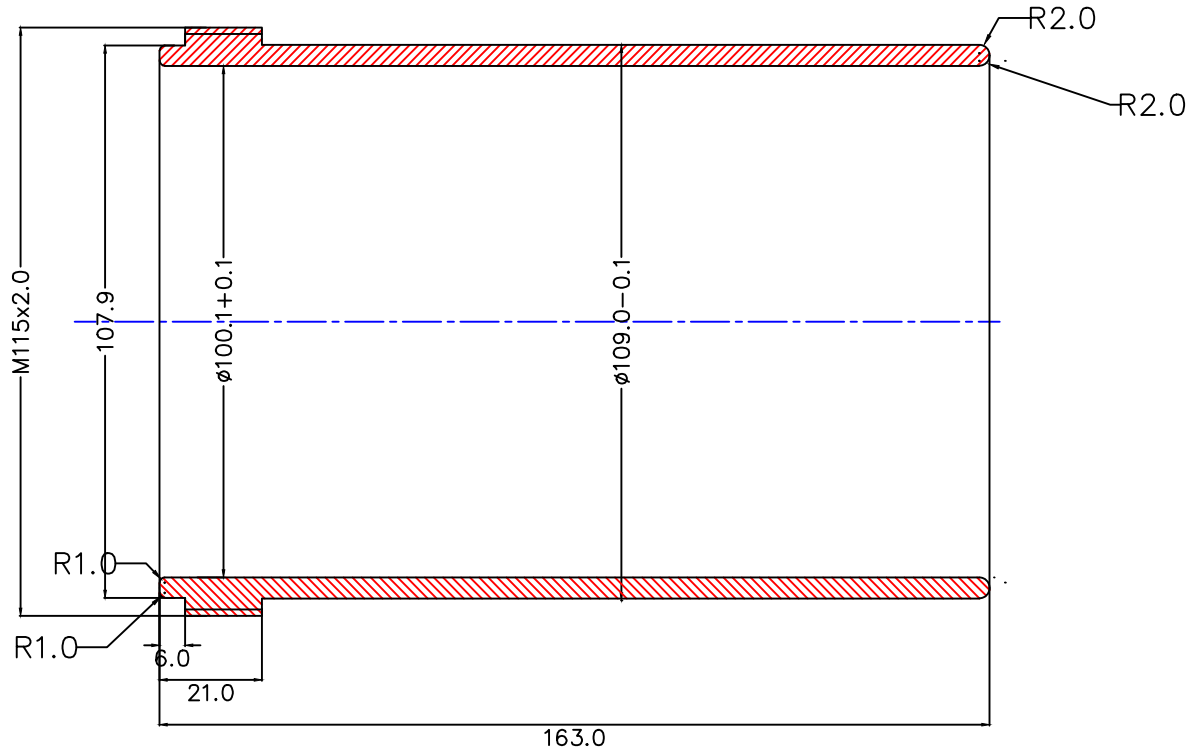
NOTE:

1. PIPE AND FLANGE TO BE MIG WELDING WITH SUITABLE SS ELECTRODE
2. THE ROOT SHOULD BE HOMOGENEOUS AND CONTINUOUS.
3. PRESSURE TEST AT 15.0 BAR FOR 15 MINUTS
4. TESTED ASSEMBLIES TO BE DEGREASED, SAND BLASTED AND POWDER COATED ON OUTSIDE.
5. MAINTAIN PERPENDICULARITY AND PARALLARITY BETWEEN FLANGES WITHIN 0.1°
6. INNER SURFACE OF DS ENCLOSURE AND DISH ENDS SHALL BE ELECTROPOLISHED.

06	FLANGE-V	RD DG 4 35 0517 2072A		SS-304L		01				
05	ES SS SHIELD	RD DG 4 35 0617 2323		SS-304L		01				
04	SHAFT HOUSING	RD DG 4 35 0517 2074		SS-304L		01				
03	GAS VALVE COVER	RD DG 4 35 0517 2073		SS-304L		01				
02	FLANGE-I	RD DG 4 35 0517 2072		SS-304L		02				
01	DRIVE PIPE	RD DG 4 35 0517 2071		SS-304L		01				
ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.NO.	MATL. CODE	A	UNIT	UNIT WT.	GS	ZONE
				VAR	MATL. SPECN.			QTY.		

TYPE OF PRODUCT		GSM-245							
NAME OF CUSTOMER									
		BHARAT HEAVY ELECTRICALS LTD.			DRN	NAME KSSRAO	SIGN.	DATE 01.09.12	NO. OF VAR.
HYDERABAD					CKD	BSM		01.09.12	01
					APPD	MMRAO		01.09.12	
DEPT.	GRADE OF TOL. DIM.		SCALE	WEIGHT(KG)	REF. TO			ITEM NO.	NO. OF ITEMS
CODE	C/M/F		NTS	59.5	RD DG 4 35 0517 2030			3	
TITLE				CARD CODE	DRAWING NO.			REV.	
E/S DRIVE HOUSING ASSY					RD DG 4 35 0517 2370				
				SHEET NO.			NO. OF SHEETS		

REV.	DATE	ALTERED	REV.	DATE	ALTERED
		CHECKED			CHECKED
ZONE			ZONE		
	MODIFIED ON 16/08/2014				



SURFACE SHALL BE FINISHED TO RA0.8

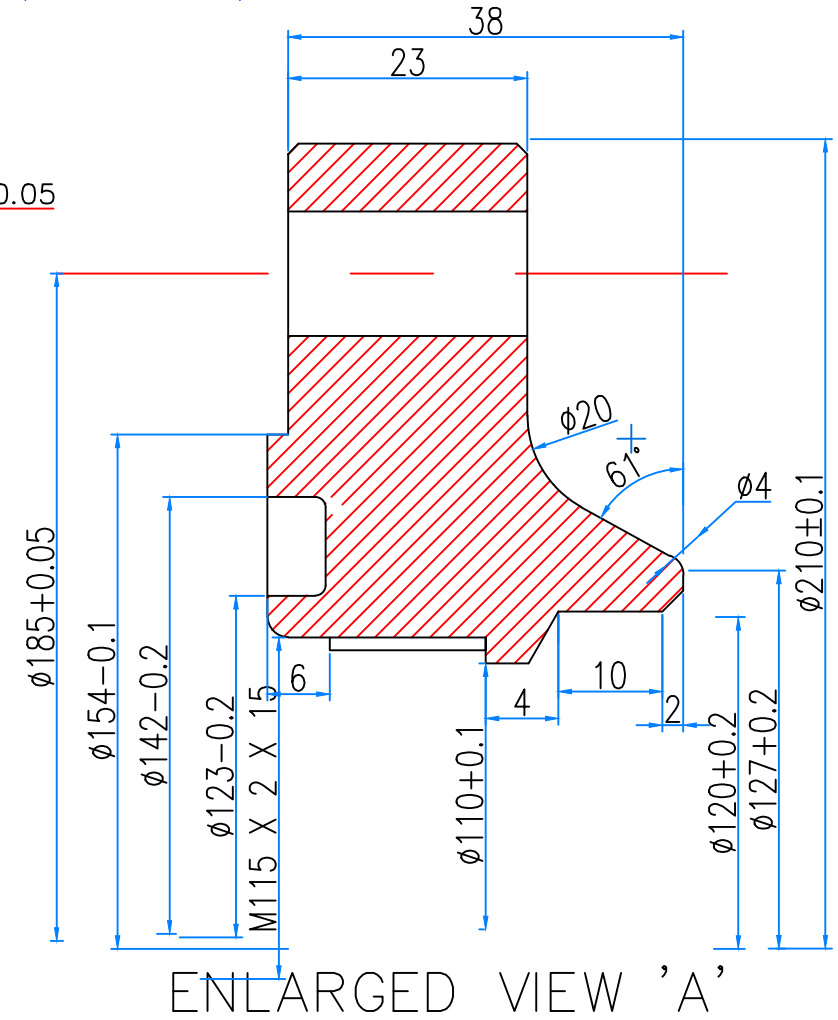
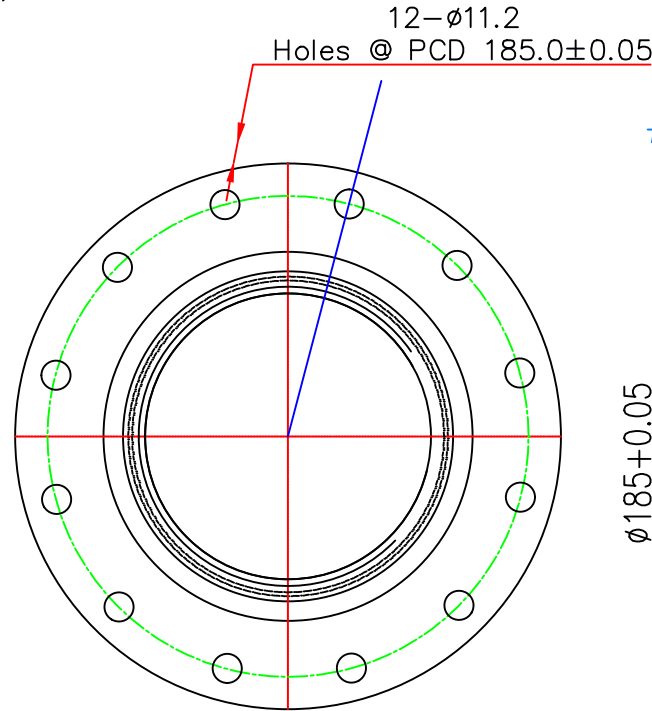
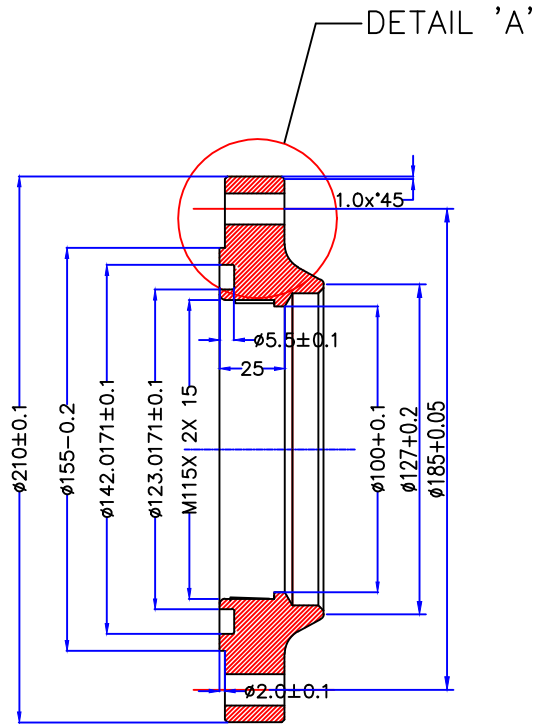
ID AND OD OF PIPE TO BE TAKEN EXTRA AND SHOULD BE GROUNDED TO ACTUAL DIMENSION
AFTER WELDING

ALL SHARP EDGES SHALL BE FINISHED TO 0.4x45°

				SS GUIDE		RD DG 4 35 0517 2519A		SS-304L						
VAR.00	REMARKS	VAR NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.NO.	MATL. CODE	A	UNIT	UNIT WT.	QTY.	GS	ZONE
							VAR	MATL. SPECN.						

TYPE OF PRODUCT		GSM-245									
NAME OF CUSTOMER											
		BHARAT HEAVY ELECTRICALS LTD.		DRN	NAME	SIGN.	DATE	NO. OF			
		HYDERABAD		CKD	BSM		30/08/14	VAR.			
				APPD	MMRAO		30/08/14				
DEPT.	GRADE OF	SCALE	WEIGHT(KG)	REF. TO	ITEM	NO. OF					
CODE	TOL. DIM.				NO.	ITEMS					
C/M/F											
TITLE		CARD		DRAWING NO.		REV.					
ES SS SHIELD		CODE		RD DG 4 35 0517 2300 2							
				RD DG 4 35 0517 2323							
				SHEET NO.		NO. OF SHEETS					

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



Note:

1. Sealing area shall be polished to RA 0.8 or better.
2. ϕ 11.0 holes 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 spherical pipe

VAR.00	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.NO.	MATL. CODE	A	C	UNIT	QTY.	CS	ZONE
			01	BLOCK		$\phi 210.0 \times 38.0$		SS-304L						

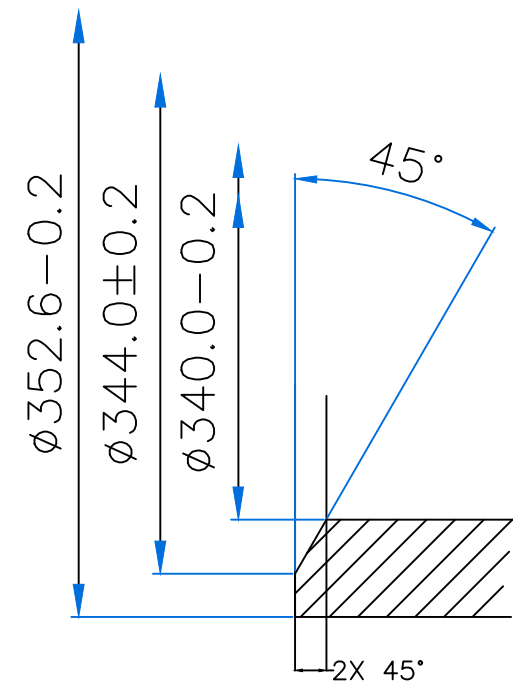
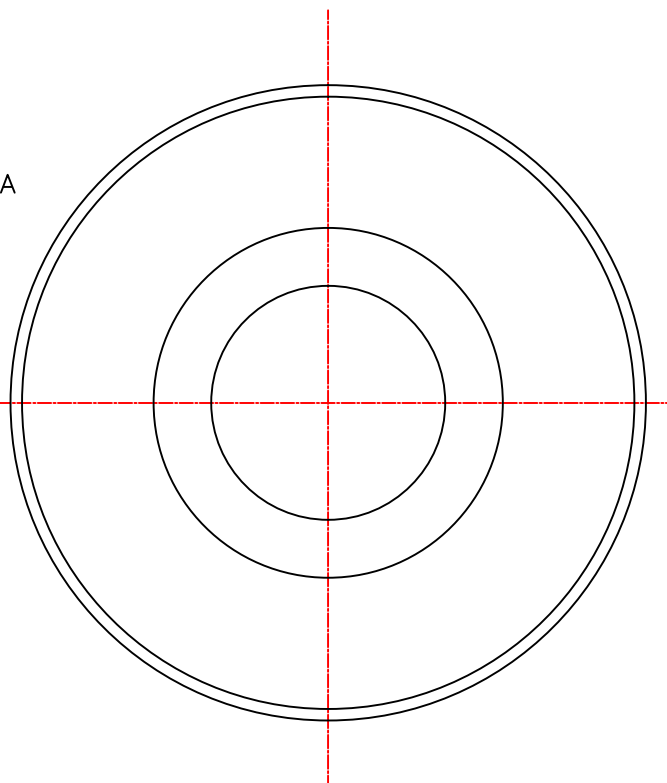
TYPE OF PRODUCT		NAME OF CUSTOMER				GSM-245					
Bharat Heavy Electricals Ltd.		HYDERABAD		NAME		SIGN.		DATE		NO. OF VAR.	
DRN		NSK		13.12.13						01	
CKD		BSM		13.12.13							
APPD		MMRAO		13.12.13							
DEPT.		GRADE OF TOL. DIM. C/M/F		SCALE		WEIGHT(KG)		REF. TO		ITEM NO.	
CODE				NTS				RD DG 4 35 0517 2070		2	
TITLE				FLANGE-V				CARD CODE		REV.	
								RD DG 4 35 0517 2072A		00	
								SHEET NO.		NO. OF SHEETS	

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

REV.	DATE	ALTERED	REV.	DATE	ALTERED
		CHECKED			CHECKED
ZONE			ZONE		
	MODIFIED ON 28/10/17				

INVENTORY NO.

(ALL DIMENSIONS ARE IN mm)



ENLARGED VIEW 'A'

[illegible]

NAME OF CUSTOMER

GSM-245



BHARAT HEAVY ELECTRICALS LTD.
HYDERABAD

DRN	NAME	SIGN.	DATE	NO. OF VAR.
CKD	BSM		14.10.13	01
APPD	MMRAO		14.10.13	

301

REV.	DATE	ALTERED	REV.	DATE	ALTERED
		CHECKED			CHECKED
ZONE				ZONE	
	MODIFIED ON 28/10/17				

DEPT.	GRADE OF TOL. DIM. C/M/F		SCALE	WEIGHT(KG)	REF. TO	ITEM NO.	NO. OF ITEMS
CODE					RD DG 4 35 0517 2040	1	
TITLE				CARD CODE	DRAWING NO.		REV.
DISH-I					RD DG 4 35 0517 2041		
					SHEET NO.		NO. OF SHEETS

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REF. DRG. NO.

SIGN. AND DATE

INVENTORY NO.

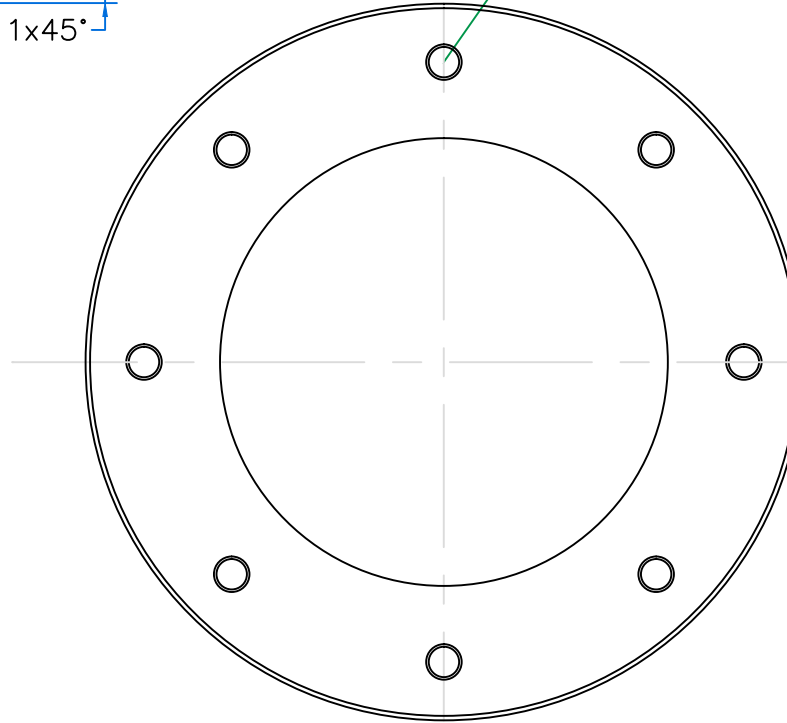
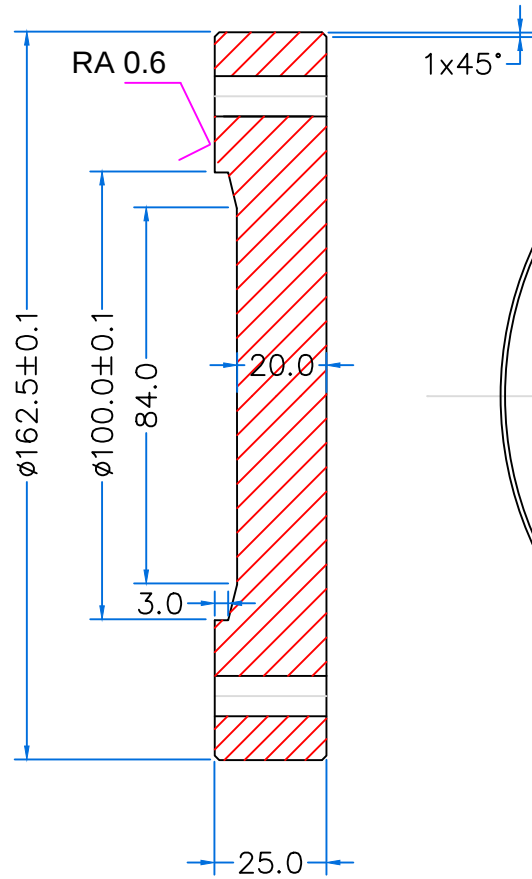
RD DG 4 35 0617 0983A

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

(~1.6)

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



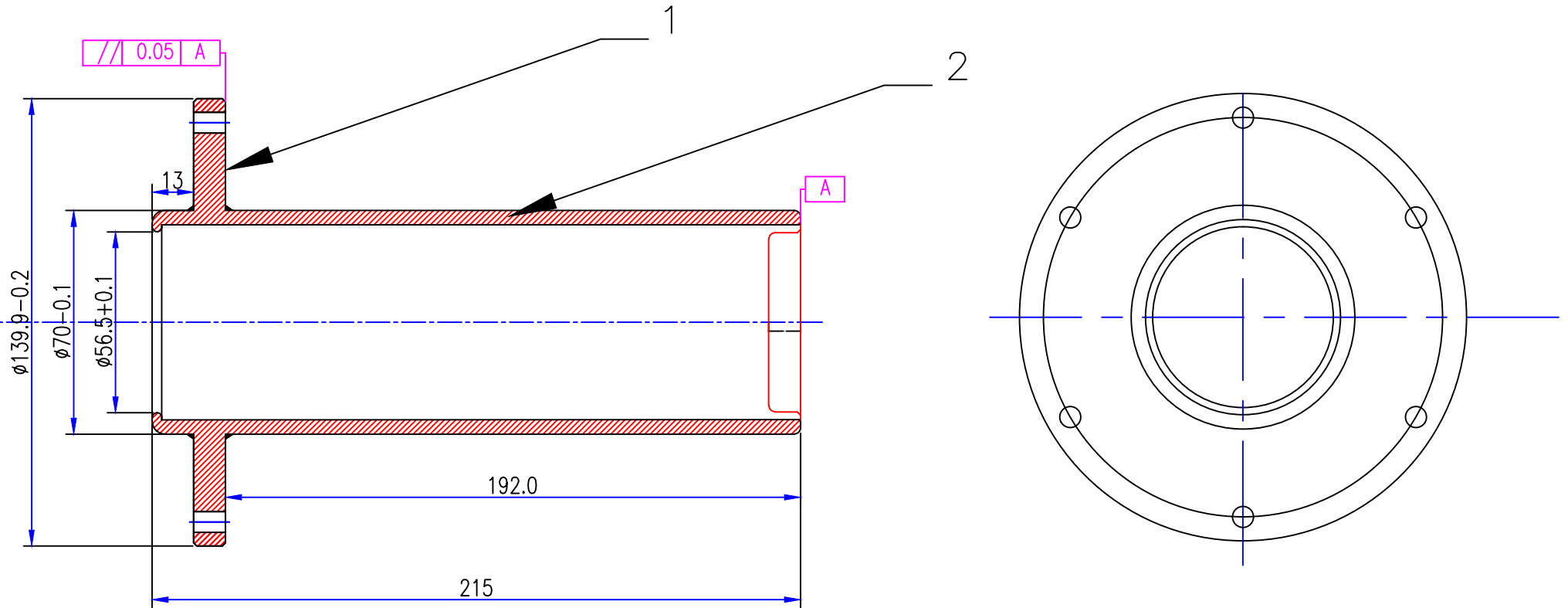
ALL SHARP EDGES SHALL BE MACHINED TO 0.4x45°
MARKED SURFACE SHALL BE FINISHED TO RA0.8

		01	DUMMY PLATE				SS-304L		01	
VAR.00	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.NO.	MATL. CODE	A C UNIT	UNIT WT.
							VAR	MATL. SPECN.		QTY.

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

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

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[illegible]

SURFACE SHALL BE FINISHED TO RA0.8

ID AND OD OF PIPE TO BE TAKEN EXTRA AND SHOULD BE GROUNDED TO ACTUAL DIMENSION AFTER WELDING

ALL SHARP EDGES SHALL BE FINISHED TO 0.4x45°

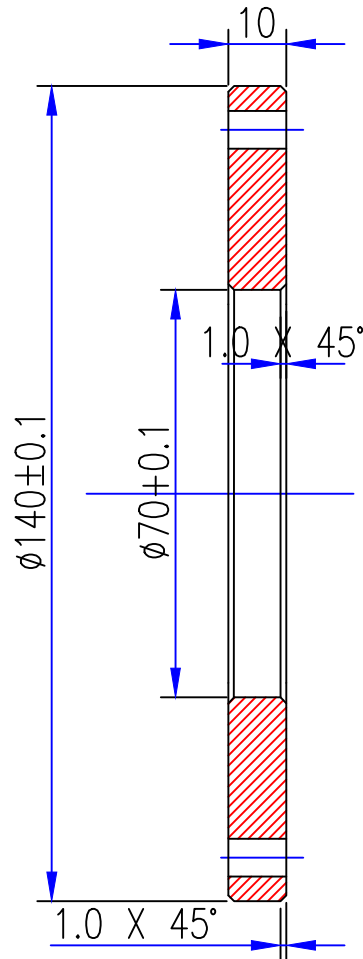
REV.	DATE	ALTERED	REV.	DATE	ALTERED	DEPT.	GRADE OF TOL. DIM.		SCALE	WEIGHT(KG)	REF. TO	ITEM NO.	NO. OF ITEMS	
		CHECKED			CHECKED	CODE	C/M/F					RD DG 4 35 0517 2500	5	
ZONE			ZONE			TITLE				CARD CODE	DRAWING NO.			REV.
						DS SS SHIELD					RD DG 4 35 0517 2519			
											SHEET NO.		NO. OF SHEETS	

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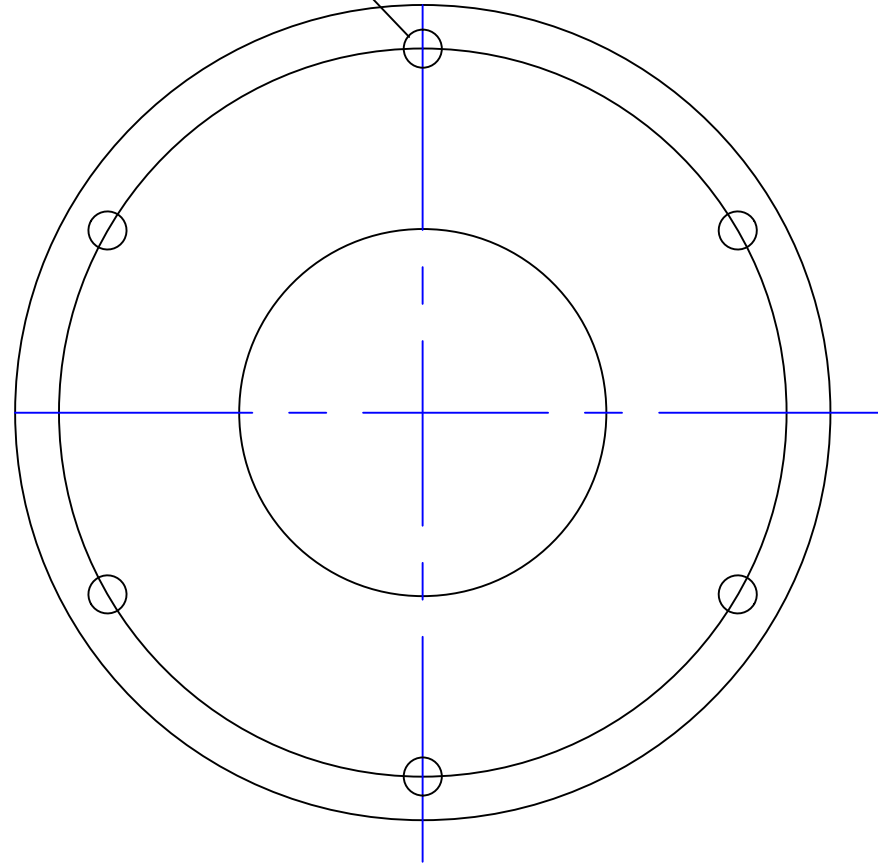
RD DG 4 35 0517 2519A
DRG. NO.

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)



6 No., $\phi 6.5$ CLEAR HOLES @ 125.0 PCD



SURFACE SHALL BE FINISHED TO RA0.8

ALL SHARP EDGES SHALL BE FINISHED TO 0.4x45°

ID AND OD OF PIPE TO BE TAKEN EXTRA AND SHOULD BE GROUNDED TO ACTUAL DIMENSION
AFTER WELDING

				SS PLATE	$\phi 140 \times 10$		S-304				
VAR.00	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.NO.	MATL. CODE	A	UNIT	UNIT WT.
							VAR	MATL. SPECN.	C		QTY.

TYPE OF PRODUCT		GSM-245									
NAME OF CUSTOMER											
		BHARAT HEAVY ELECTRICALS LTD. HYDERABAD			DRN	NAME	SIGN.	DATE	NO. OF		
					CKD	BSM		2/08/14	VAR.		
					APPD	MMRAO		2/08/14			
DEPT.	GRADE OF TOL. DIM. C/M/F		SCALE	WEIGHT(KG)	REF. TO				ITEM NO.	NO. OF ITEMS	
CODE					RD DG 4 35 0517 2519				2		
TITLE				CARD CODE	DRAWING NO.				REV.		
SS PLATE					RD DG 4 35 0517 2519A						
					SHEET NO.		NO. OF SHEETS				

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

REF. DRG. NO.

SIGN. AND DATE

INVENTORY NO.

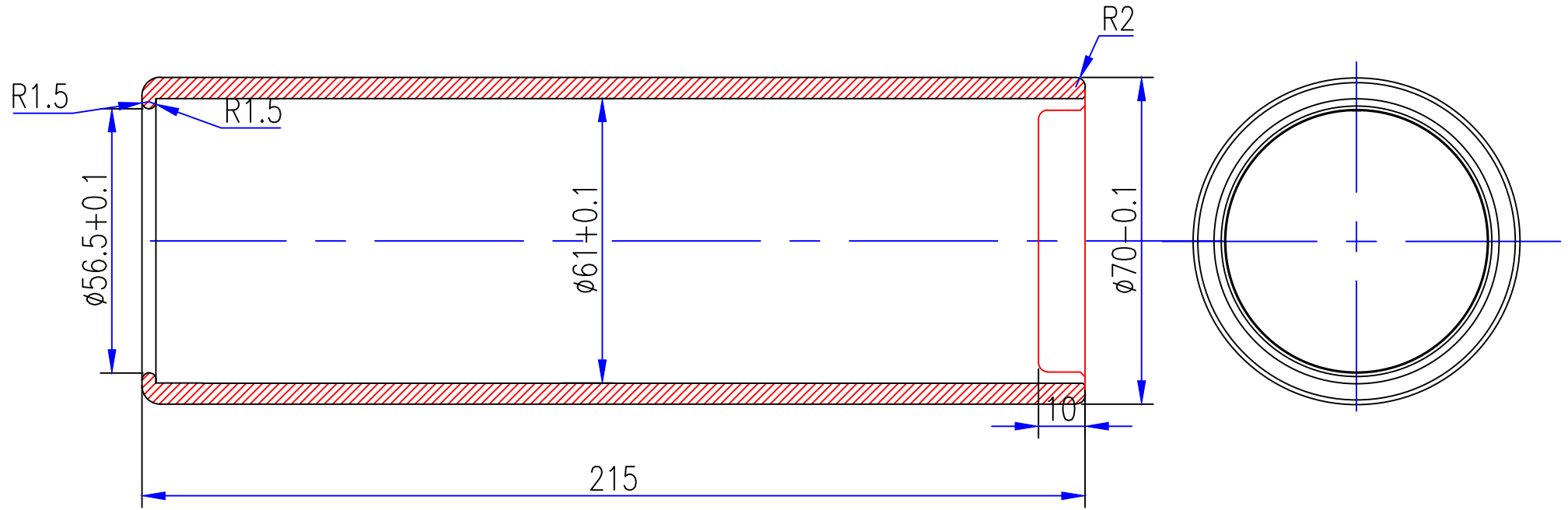
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INVENTORY NO. SIGN. AND DATE REF. DRG. NO.

RD DG 4 35 0517 2519B
DRG. NO.

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)



SURFACE SHALL BE FINISHED TO RA0.8
ALL SHARP EDGES SHALL BE FINISHED TO 0.4x45°
ID AND OD OF PIPE TO BE TAKEN EXTRA AND SHOULD BE GROUNDED TO ACTUAL DIMENSION
AFTER WELDING

				SS BUSH		$\phi 70 \times \phi 55 \times 215$		S-304				
VAR.00	REMARKS	VAR NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.NO.	MATL. CODE	A	UNIT	UNIT WT.	ZONE
							VAR	MATL. SPECN.	C		QTY.	GS

REV.	DATE	ALTERED	REV.	DATE	ALTERED	DEPT.	GRADE OF TOL. DIM. C/M/F	SCALE	WEIGHT(KG)	REF. TO	ITEM NO.	NO.OF ITEMS
		CHECKED			CHECKED	CODE				RD DG 4 35 0517 2519	2	
ZONE			ZONE			TITLE				DRAWING NO.	REV.	
						SS PIPE				RD DG 4 35 0517 2519B		
										SHEET NO.	NO. OF SHEETS	

TYPE OF PRODUCT		GSM-245						
NAME OF CUSTOMER								
		BHARAT HEAVY ELECTRICALS LTD. HYDERABAD		DRN	NAME	SIGN.	DATE	NO.OF VAR.
				CKD	BSM		2/08/14	
				APPD	MMRAO		2/08/14	
DEPT.	GRADE OF TOL. DIM. C/M/F		SCALE	WEIGHT(KG)	REF. TO		ITEM NO.	NO.OF ITEMS
CODE					RD DG 4 35 0517 2519		2	
TITLE				CARD CODE	DRAWING NO.		REV.	
SS PIPE					RD DG 4 35 0517 2519B			
				SHEET NO.		NO. OF SHEETS		