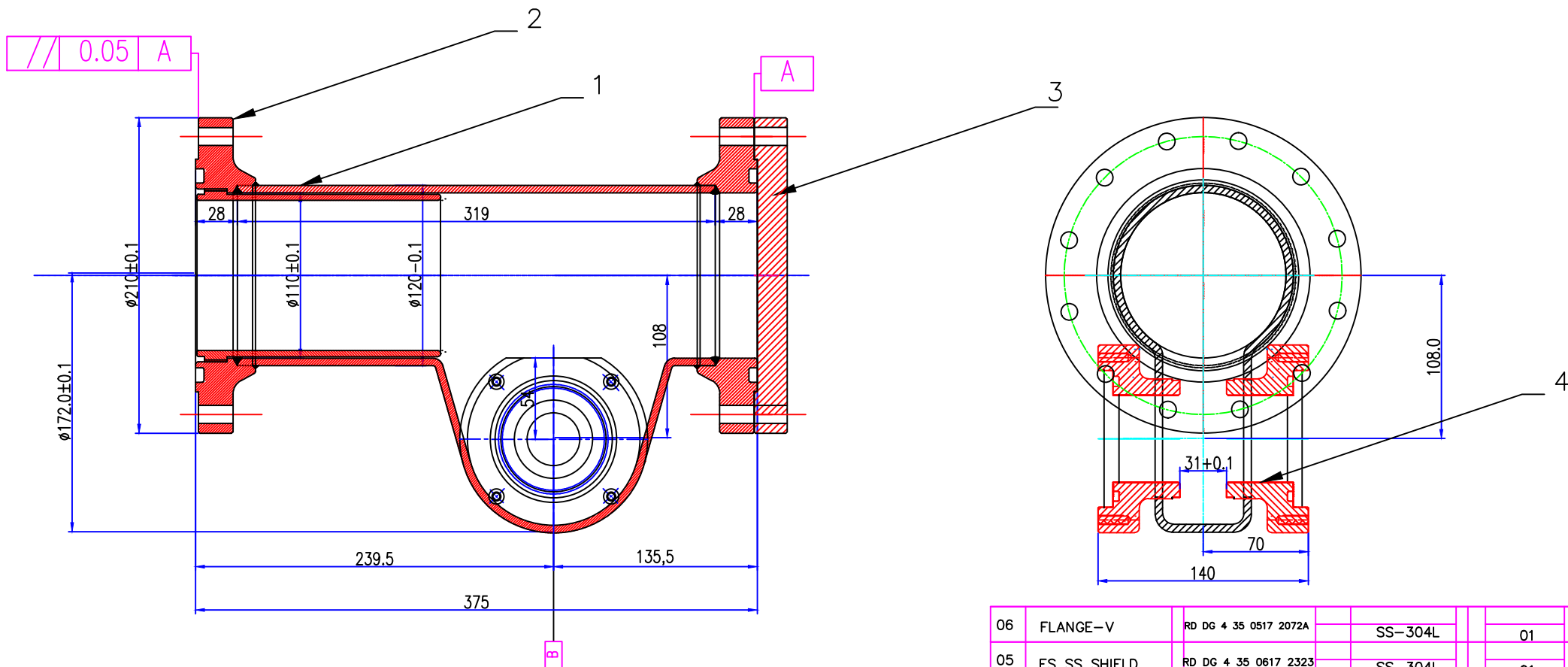


**NOTE:**

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.	C		QTY.		

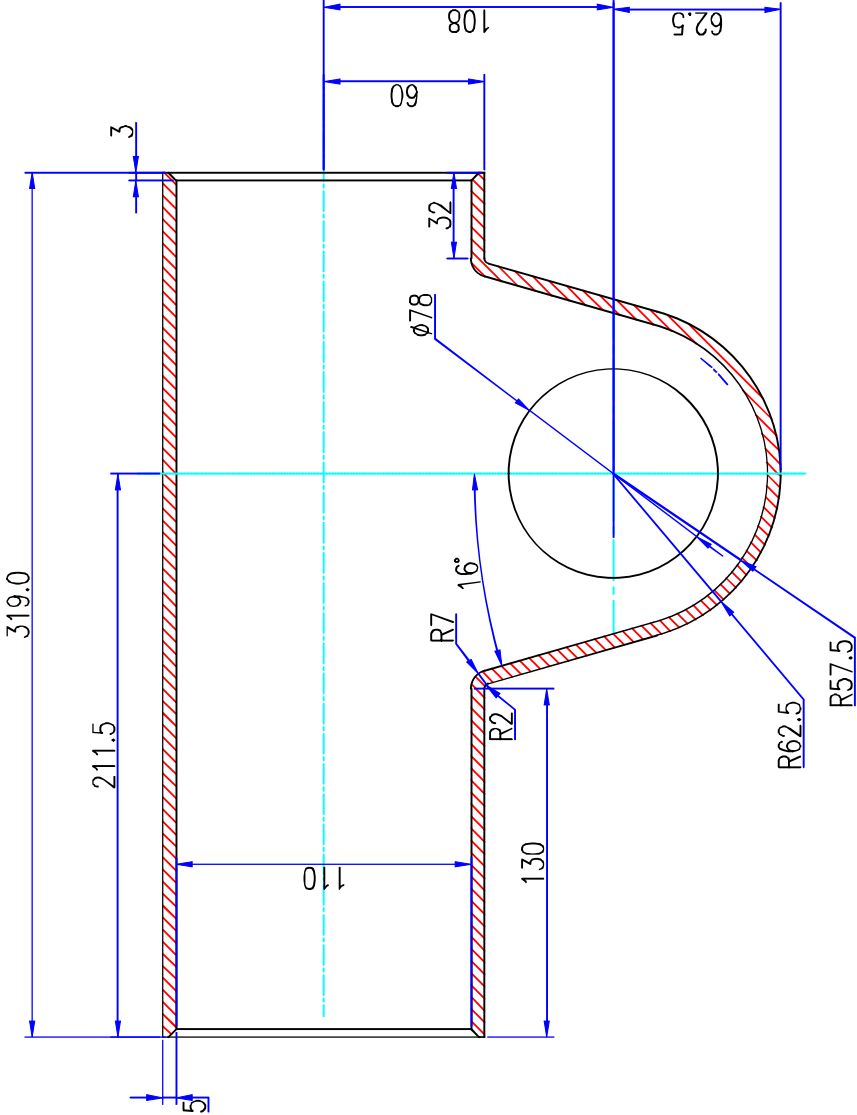
TYPE OF PRODUCT		GSM-245							
NAME OF CUSTOMER									
		NAME		SIGN.		DATE		NO. OF	
		KSSRAO				01.09.12		VAR.	
		CKD		BSM		01.09.12			
		APPD		MMRAO		01.09.12		01	
DEPT.	GRADE OF TOL. DIM. C/M/F	SCALE	WEIGHT(KG)	REF. TO		ITEM NO.		NO. OF	
CODE		NTS	59.5	RD DG 4 35 0517 2030		3			
TITLE			CARD CODE	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	MODIFIED ON 16/08/2014		ZONE		

1702 7150 35 4 35 0517 2071
RD ON 2017

FIRST ANGLE PROJECTION

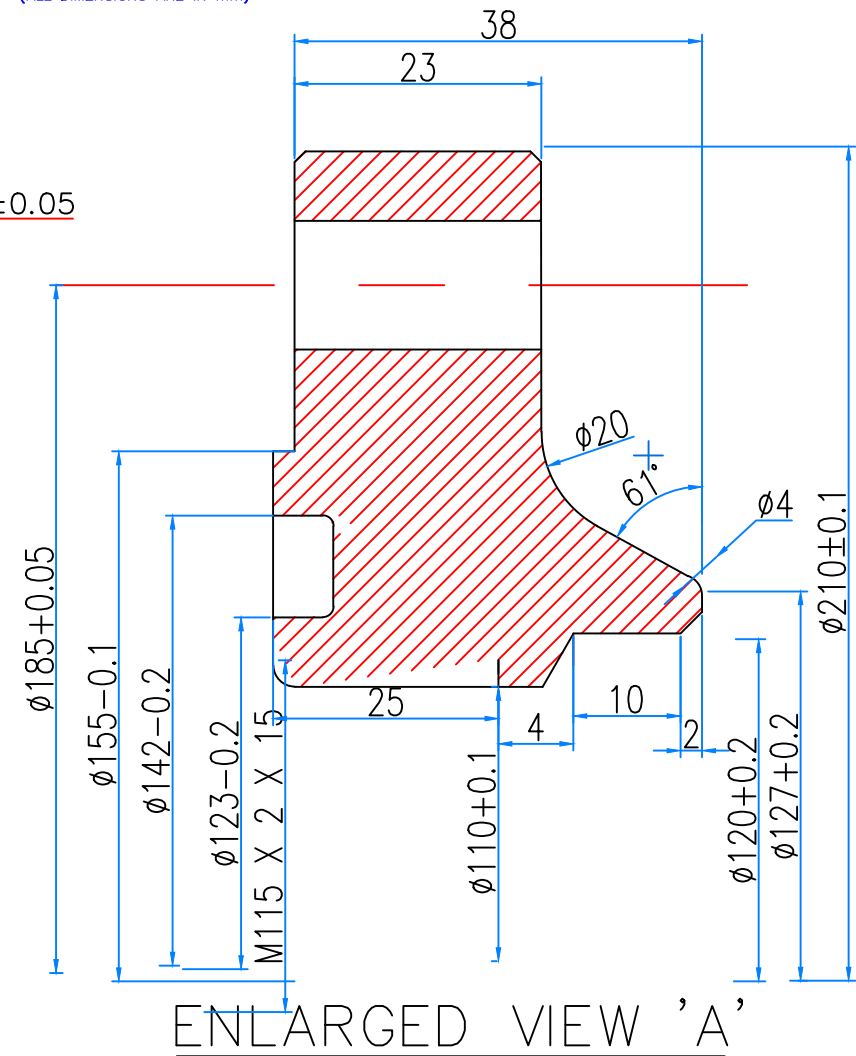
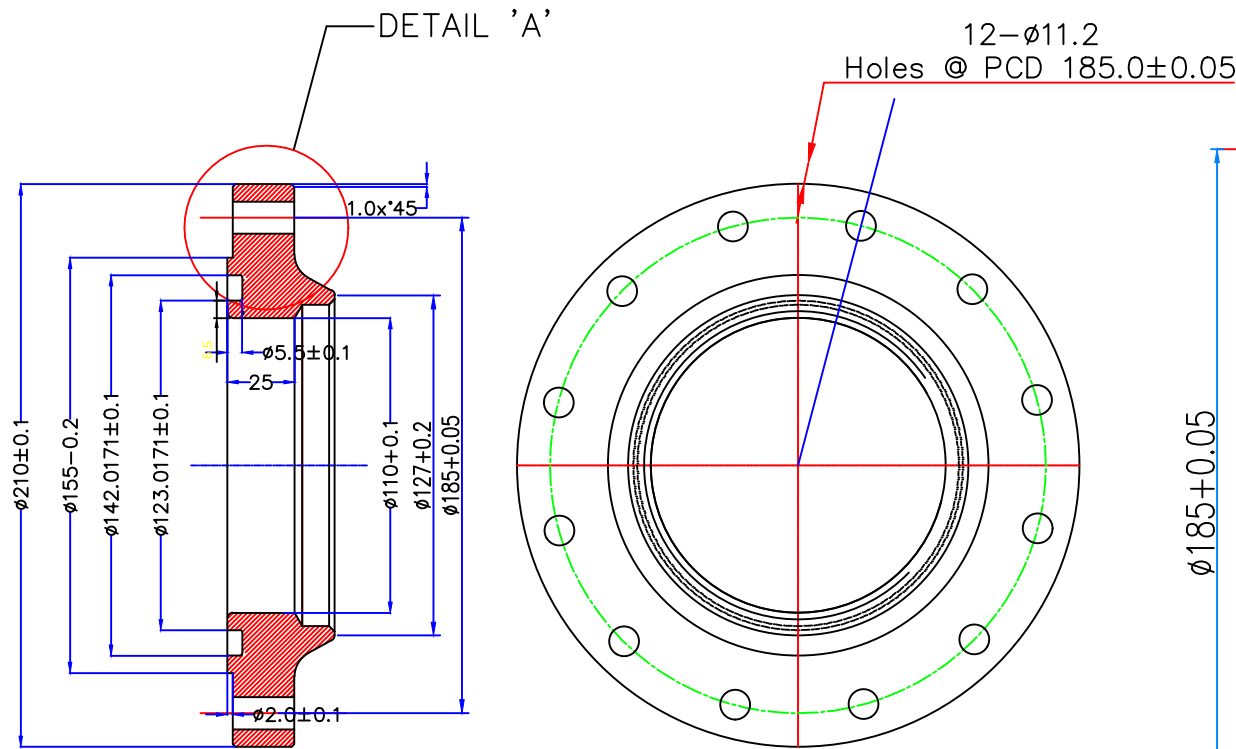
(ALL DIMENSIONS ARE IN mm)



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

REV.	DATE	ALTERED	CHECKED	ZONE	REV.	DATE	ALTERED	CHECKED	ZONE
01					01				
DRIVE PIPE					SS-304L				
VAR. NO.					ITEM NO.				
REMARKS					DRAWING NO.				
STG.					ITNO.				
VAR.					MATERIAL SPEC.				
UNIT WT.					QTY.				
NO.					NO.				
DATE					DATE				
10.12.13					10.12.13				
VAR.					VAR.				
10.12.13					10.12.13				
NO.					NO.				
01					01				
ITEM NO.					ITEM NO.				
1					1				
REV.					REV.				
RD DG 4 35 0517 2071					RD DG 4 35 0517 2071				
DRAWING NO.					DRAWING NO.				
RD DG 4 35 0517 2071					RD DG 4 35 0517 2071				
SHEET NO.					SHEET NO.				
NO. OF SHEETS					NO. OF SHEETS				

TYPE OF PRODUCT		NAME OF CUSTOMER		NAME		SIGN.		DATE		NO. OF	
GSM-245		BHARAT HEAVY ELECTRICALS LTD.		NSK		BSM		10.12.13		VAR.	
HYDERABAD		MMRAO		MMRAO		MMRAO		10.12.13		VAR.	
SCALE		WEIGHT(KG)		REF. TO		REF. TO		10.12.13		VAR.	
NTS		59.5		RD DG 4 35 0517 2071		RD DG 4 35 0517 2071		1		VAR.	
CARD CODE		CARD CODE		DRAWING NO.		DRAWING NO.		RD DG 4 35 0517 2071		VAR.	
TITLE		TITLE		DRAWING NO.		DRAWING NO.		RD DG 4 35 0517 2071		VAR.	
DRIVE PIPE		DRIVE PIPE		DRAWING NO.		DRAWING NO.		RD DG 4 35 0517 2071		VAR.	



- Note:
1. Sealing area shall be plosihed 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	IT. NO.	MATL. CODE	A	UNIT	UNIT WT.	GS	ZONE
					DESCRIPTION	DRAWING NO.		VAR	MATL. SPECN.	C		QTY.		

TYPE OF PRODUCT		NAME OF CUSTOMER		GSM-245	
Bharat Heavy Electricals Ltd.		HYDERABAD			
DRN	NAME	SIGN.	DATE	NO. OF	
CKD	NSK		13.12.13	VAR.	
APPD	BSM		13.12.13	01	
	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		CARD CODE	DRAWING NO.	REV.	
FLANGE-I			RD DG 4 35 0517 2072	00	
		SHEET NO.		NO. OF SHEETS	

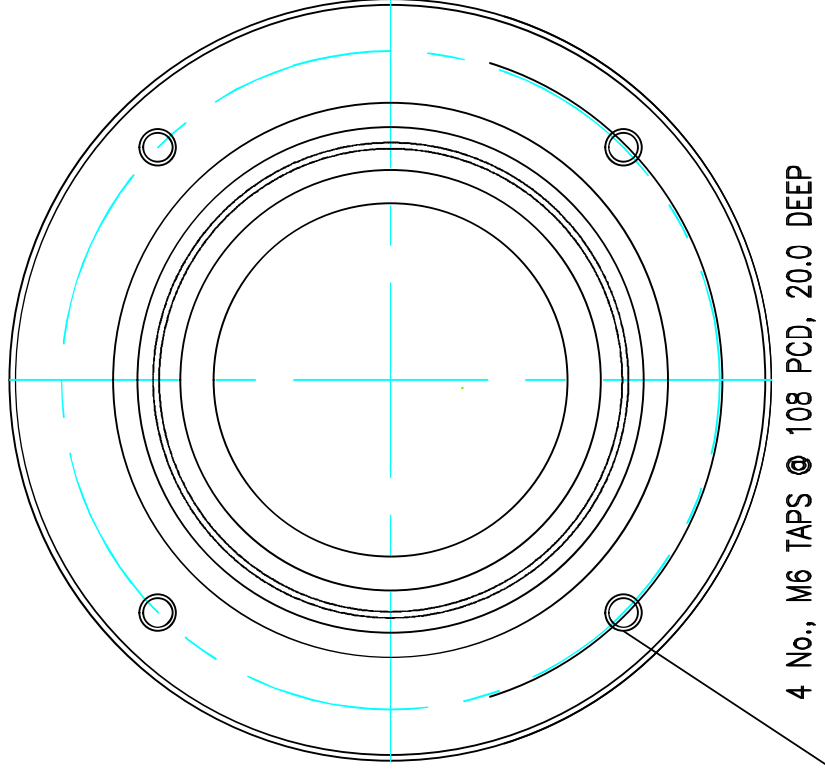
REV.	DATE	ALTERED	REV.	DATE	ALTERED
ZONE		CHECKED	ZONE		CHECKED

(ALL DIMENSIONS ARE IN mm)

REF. DRG. NO.

GN. AND DATE

INVENTORY NO.

[illegible]

TYPE OF PRODUCT	NAME OF CUSTOMER
1	2
3	4
5	6
7	8
9	10
11	12
13	14
15	16
17	18
19	20
21	22
23	24
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61	62
63	64
65	66
67	68
69	70
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79	80
81	82
83	84
85	86
87	88
89	90
91	92
93	94
95	96
97	98
99	100

1. All sharp edges shall be machined to 0.4x45°.
2. O-ring groove surface shall be finished to Ra0.6

 BHARAT HEAVY ELECTRICALS LTD. HYDERABAD										01 NO. OF TEARS																	
DEPT.		GRADE OF MATERIAL C/M/F		 SCALE		 NTS		WEIGHT(KG)		DRN		NAME NSK		SIGN.		DATE		NO. OF TEARS		REV.							
CODE										APPD		BSM				12.08.14		12.08.14		NO. OF SHEETS							
TITLE										DRAWING NO.										RD DG 4 35 0517 2070		RD DG 4 35 0517 2074					
SHAFT HOUSING																											

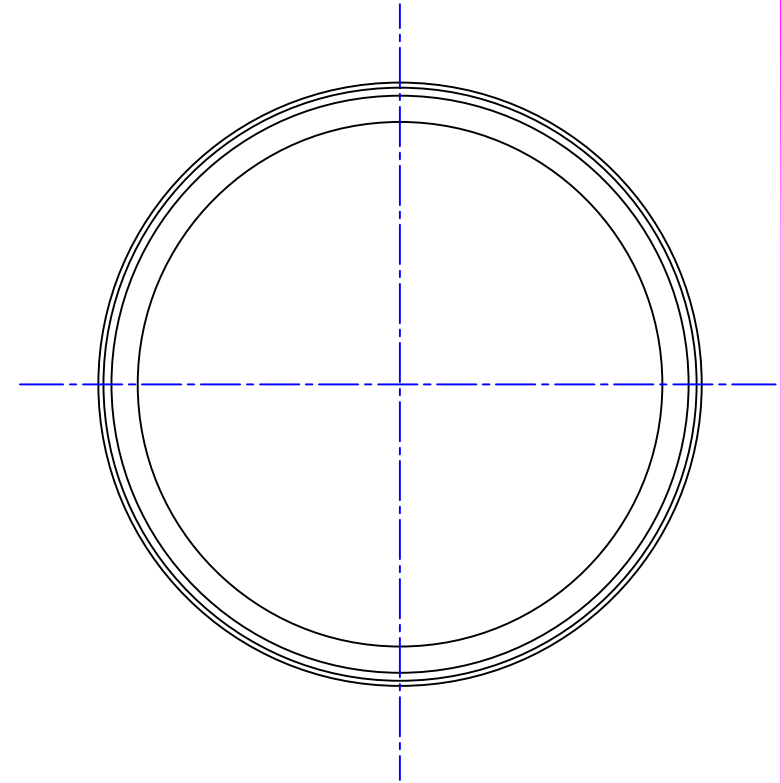
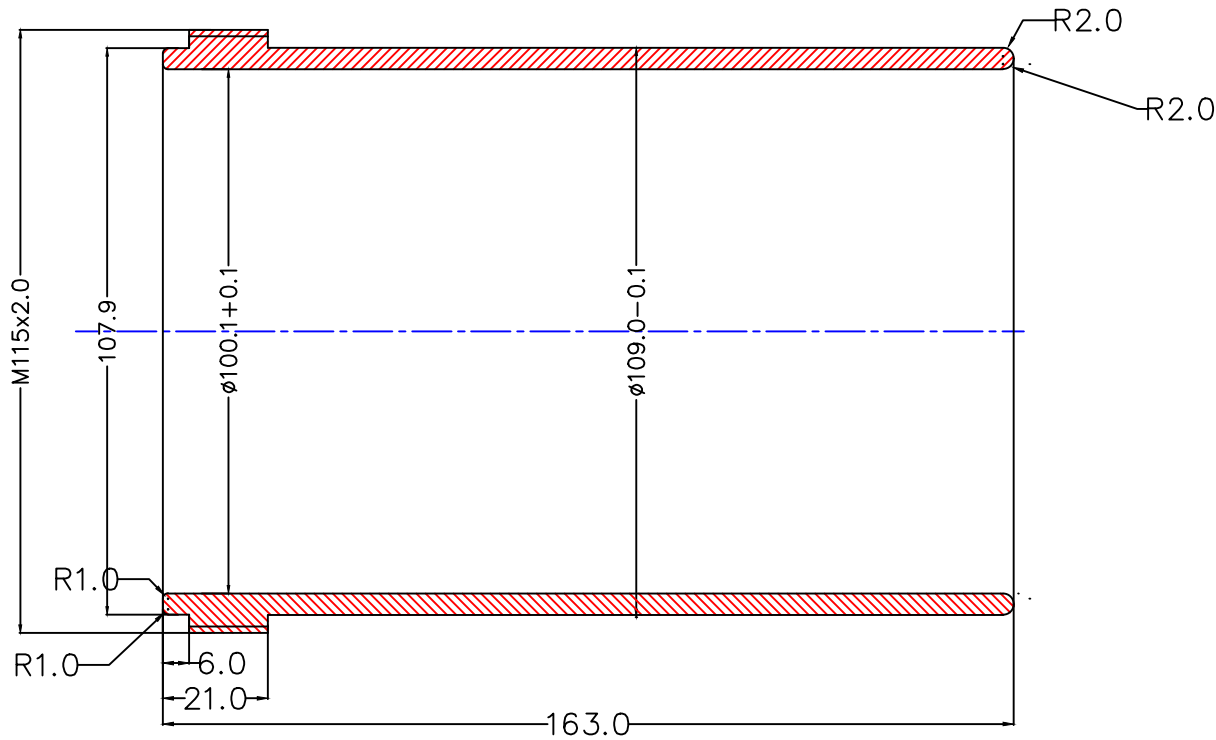
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IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

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

RD DG 4 35 0517 2323
DRG. NO.

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)



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

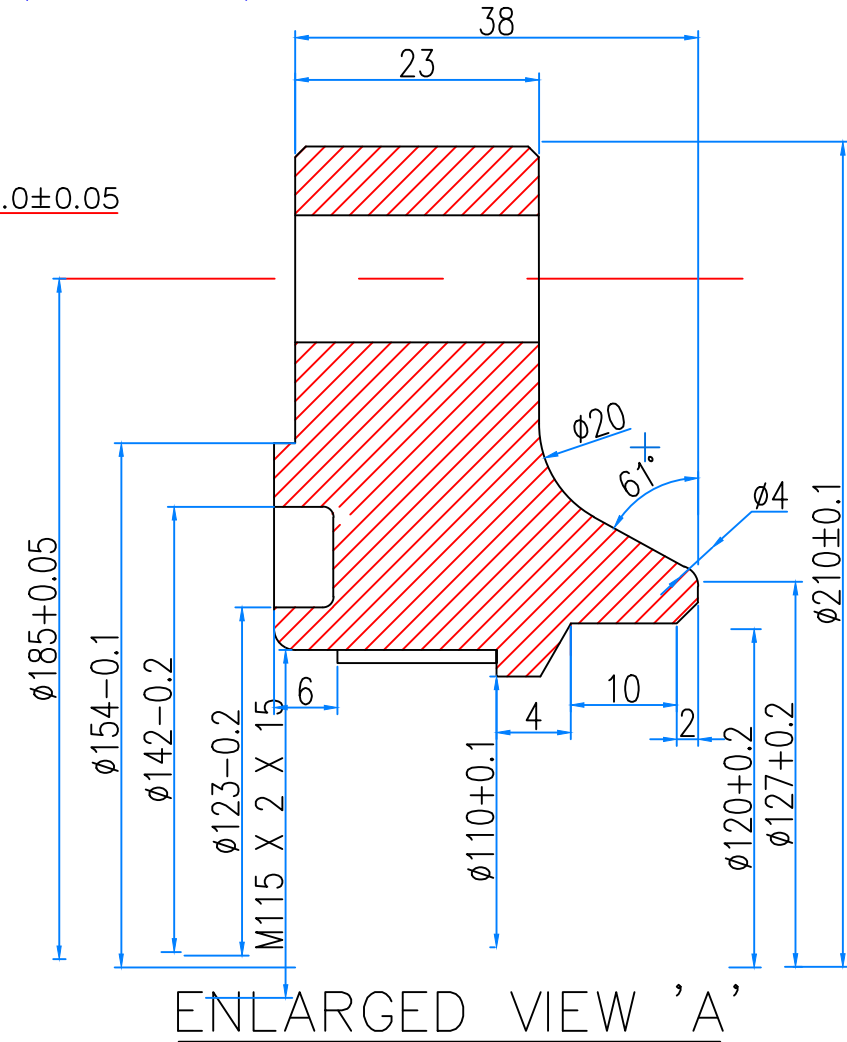
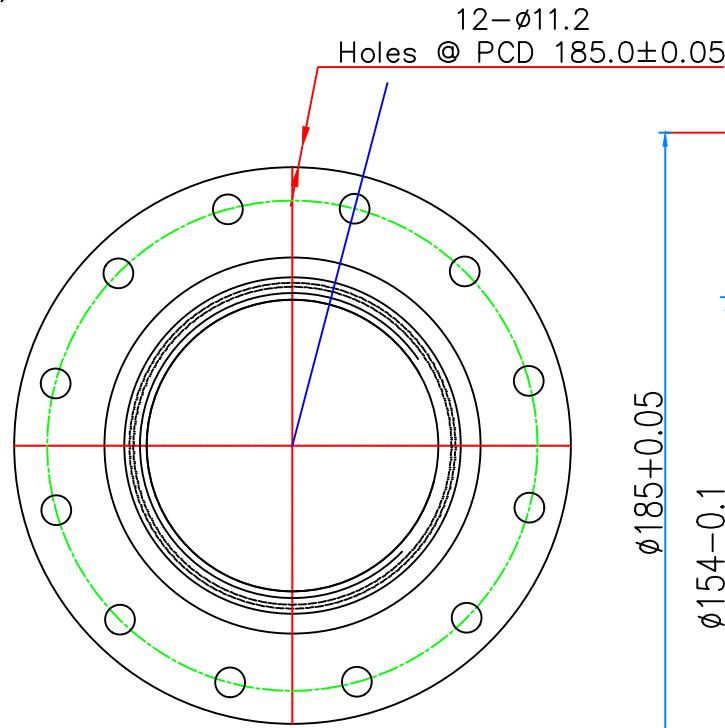
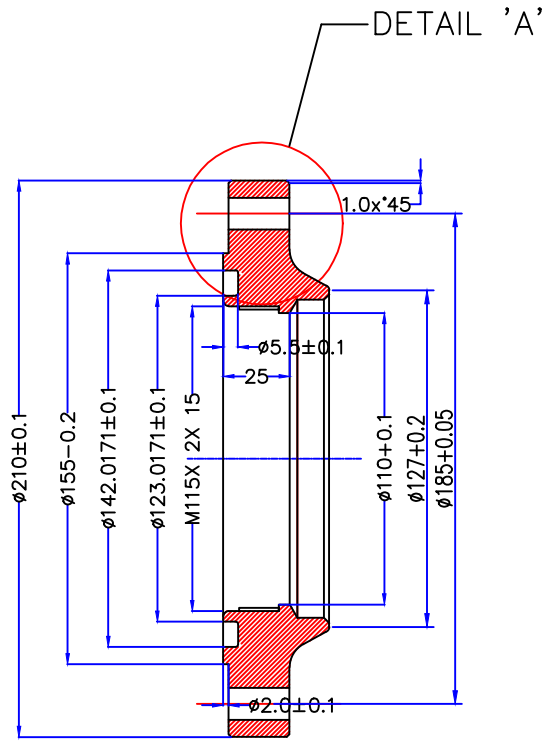
ALL SHARP EDGES SHALL BE FINISHED TO 0.4x45°

				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 WT.	ZONE
							VAR	MATL. SPECN.	C	QTY.	GS

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	
REF. TO		ITEM NO.		NO.OF				
RD DG 4 35 0517 2300		2						
DRAWING NO.		REV.						
RD DG 4 35 0517 2323								
SHEET NO.		NO. OF SHEETS						

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

DEPT.	GRADE OF TOL. DIM. C/M/F	SCALE	WEIGHT(KG)	CARD CODE
TITLE				
ES SS SHIELD				



- Note:
- Sealing area shall be plosihed to RA 0.8 or better.
 - ϕ 11.0 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.	01	BLOCK	$\phi 210.0 \times 38.0$	SS-304L	UNIT WT.	QTY.	G.S.	ZONE

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

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

FLANGE-V