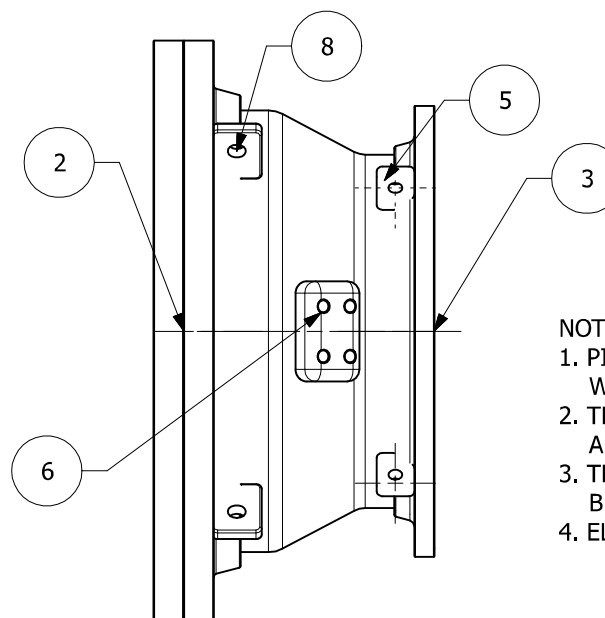
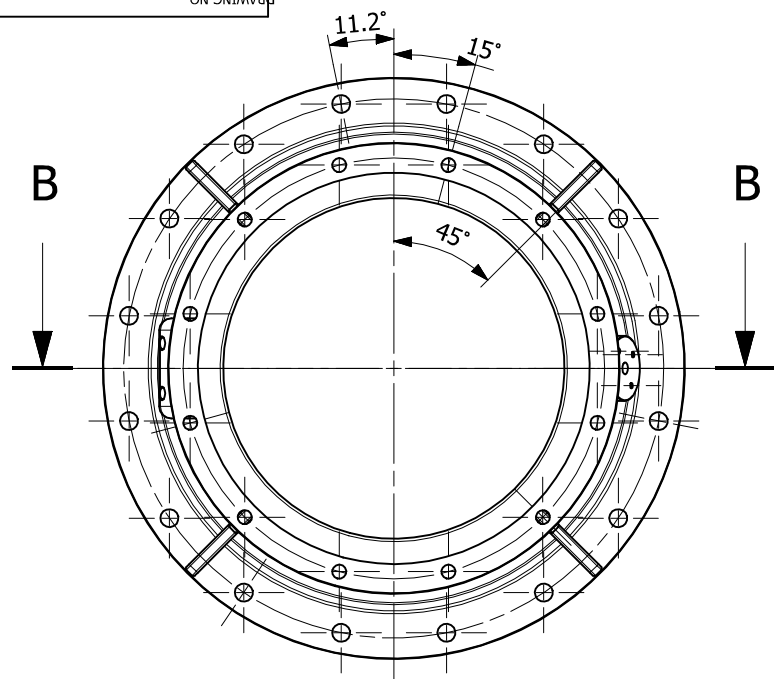
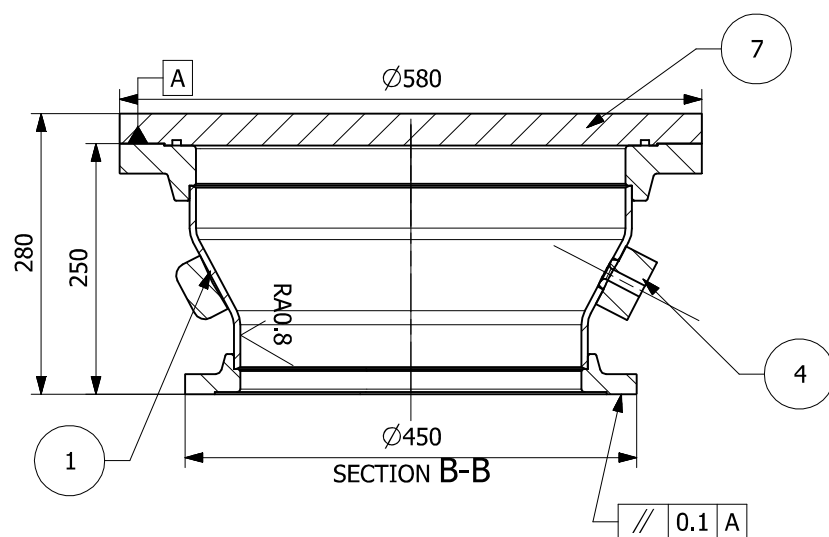
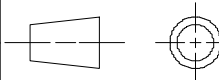




1. PIPE AND FLANGE TO BE MIG/TIG WELDED WITH SUITABLE SS ELECTRODE
2. THE ROOT SHOULD BE HOMOGENEOUS AND CONTINUOUS.
3. TESTED ASSEMBLIES TO BE DEGREASED, SAND BLASTED AND POWDER COATED ON OUTSIDE.
4. ELECTRO POLISH INSIDE SURFACE.

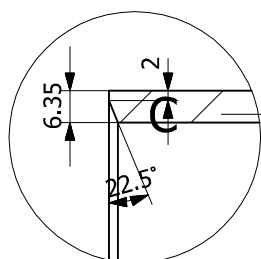
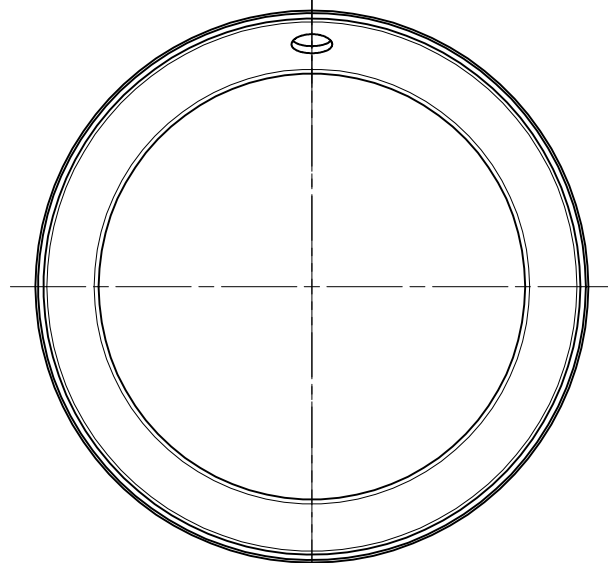


		8	LIFTING LUG II		RDDG43505170818										4		
		7	DUMMY PLATE WITH O-RING		RDDG43505170817										1		
		6	EARTHING PLATE		RDDG43505170080										1		
		5	LIFTING LUG		RDDG43505170812										4		
		4	GAS PORT FLANGE		RDDG43505170059										1		
		3	FLANGE II		RDDG43505170013										1		
		2	PT FLANGE		RDDG43505170815										1		
		1	PT REDUCER PIPE		RDDG43505170814										1		
VA R. NO.	REMARKS	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT. NO.	VA R.	MATL. CODE	MATL. SPCN.	A C	UNIT	UNIT WT.	QTY	GS	ZONE		

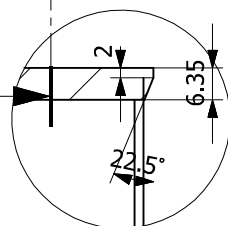
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT				GSM - 245				
बी एच ई एल  BHARAT HEAVY ELECTRICALS LIMITED, CORPORATE R & D, HYDERABAD				DRN. CKD. APPD.	NAME	SIGN.	DATE	NO. OF VAR
					NT		29.07.2020	
					NT		29.07.2020	
					MMR		29.07.2020	
DPT.GSG	UNTO. DMS. GR.		SCALE	WEIGHT(K.G.)	REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEMS	
CODE 35	NTS		RDDG43505170800					
TITLE					DRAWING NO.		REV NO.	
REDUCER ASSEMBLY-PT					RD DG 4 3505170813		-	
					SHT NO. 1		NO. OF SHT. 1	

DRAWING NO.

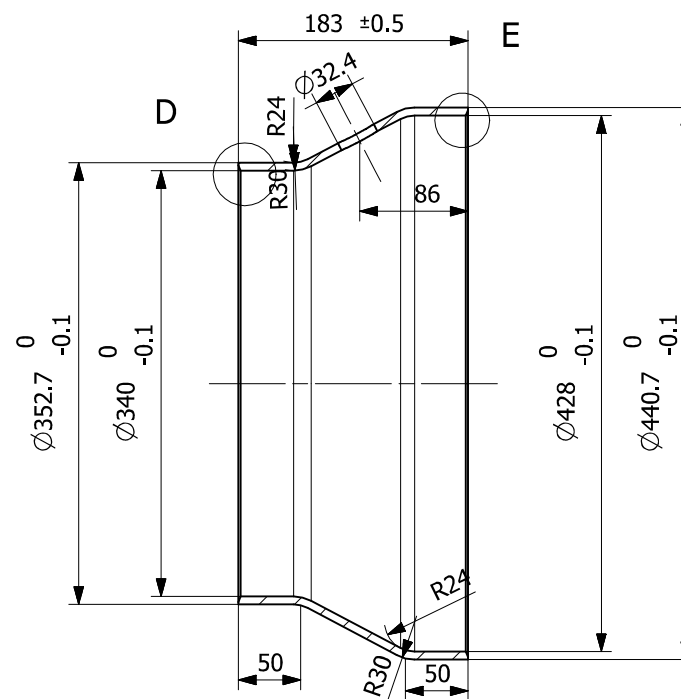
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DETAIL D
SCALE 1:1



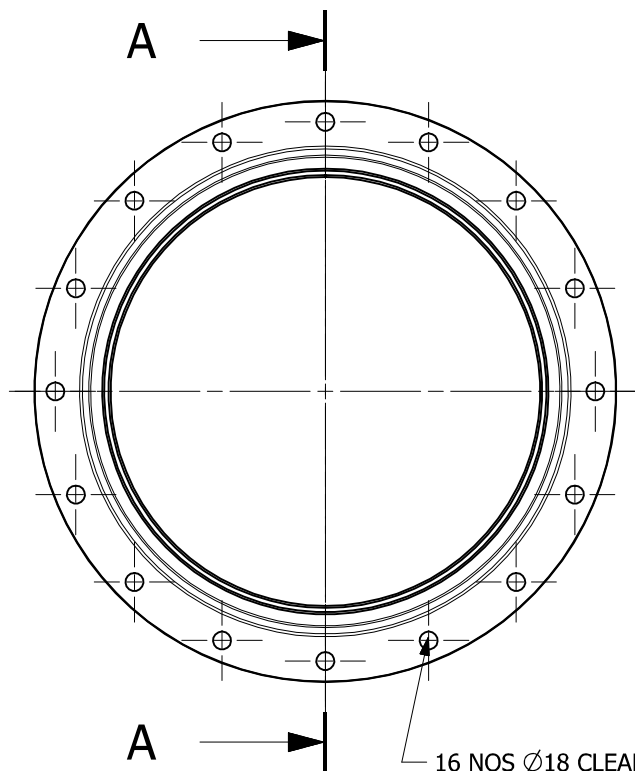
DETAIL E
SCALE 1:1



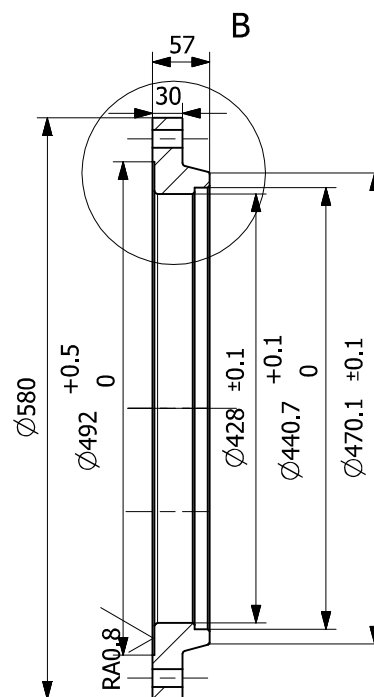
SECTION C-C

[illegible]

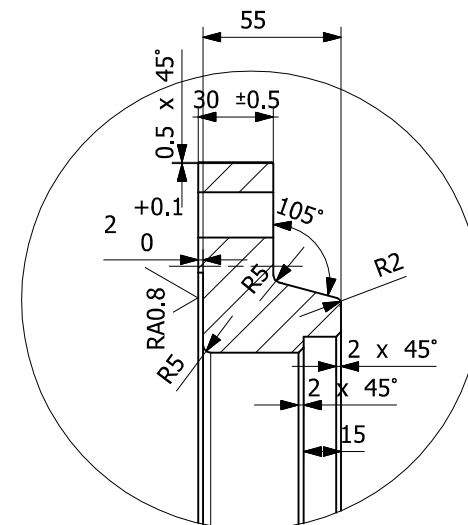
DRAWING NO.



- 16 NOS $\varnothing 18$ CLEAR HOLES AT PCD 538



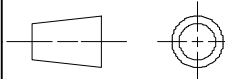
SECTION A-A



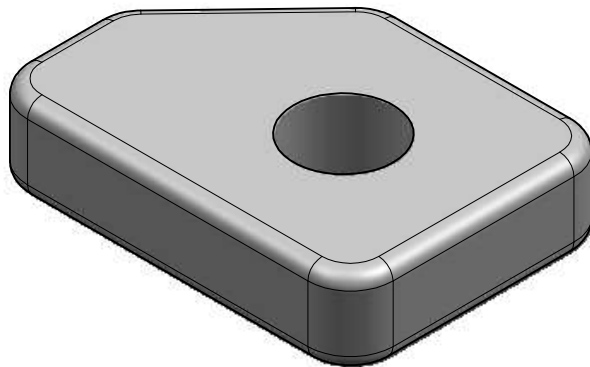
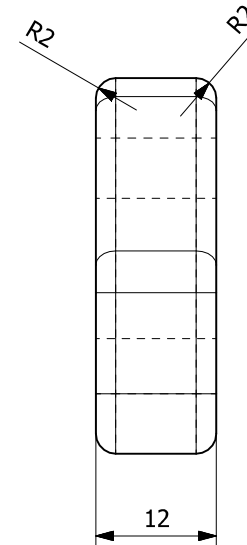
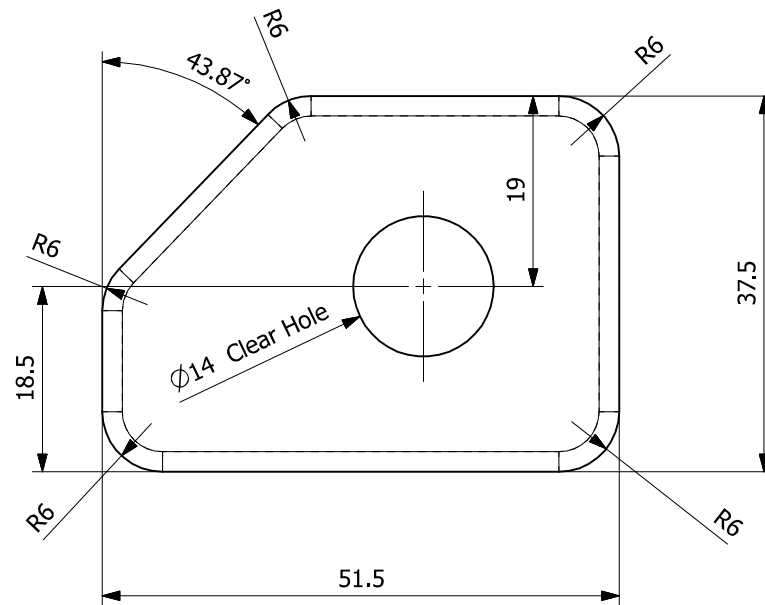
DETAIL B
SCALE 1:2

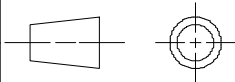
NOTE:

1. Ø18 HOLES SHALL BE CHAMFERED UNIFORMLY (0.8x45°)
2. PCD AND FLANGE CENTRE SHALL BE CONCENTRIC WITHIN ±0.1.
3. COMPONENT SHALL BE MACHINED TO DIMENSIONS AFTER WELDING TO PT REDUCER PIPE.

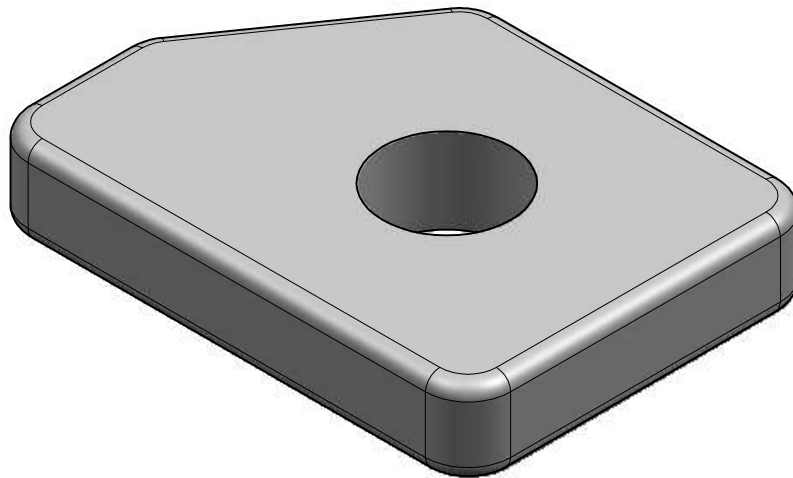
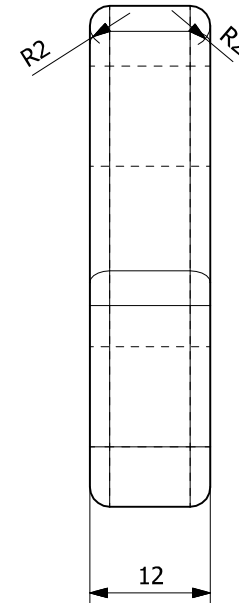
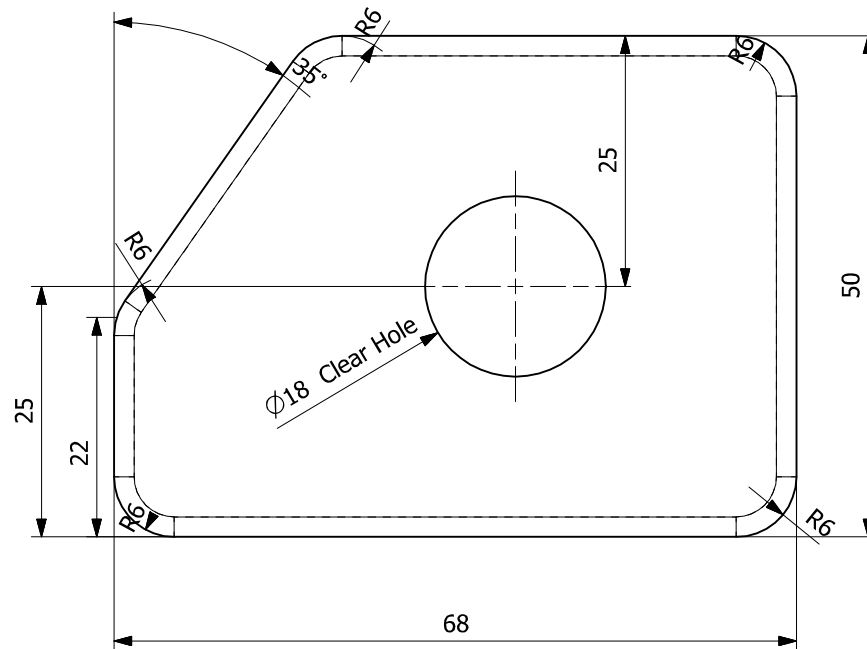
										SS304L									
VAR. NO.	REMARKS	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT. NO.	VAR.	MATL. CODE	MATL. SPCN.	A	C	UNIT	UNIT WT.	QTY	GS	POLE			
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT						GSM - 245													
बी एच ई एल  BHARAT HEAVY ELECTRICALS LIMITED, CORPORATE R & D, HYDERABAD							NAME	SIGN.	DATE	NO. OF VAR									
						DRN.	NT	27.07.2020											
						CKD.	NT	27.07.2020											
						APPD.	MMR	27.07.2020											
DPT.GSG	UNTOL. DMS. GR.			SCALE	WEIGHT(K.G.)	REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEMS											
CODE 35			NTS	33.7	RDDG43505170513														
TITLE						DRAWING NO.				REV NO.									
PT FLANGE						RD DG 4 35 0517 0815				-									
						SHT NO. 1		NO. OF SHT. 1											

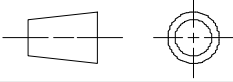
DRAWING NO.

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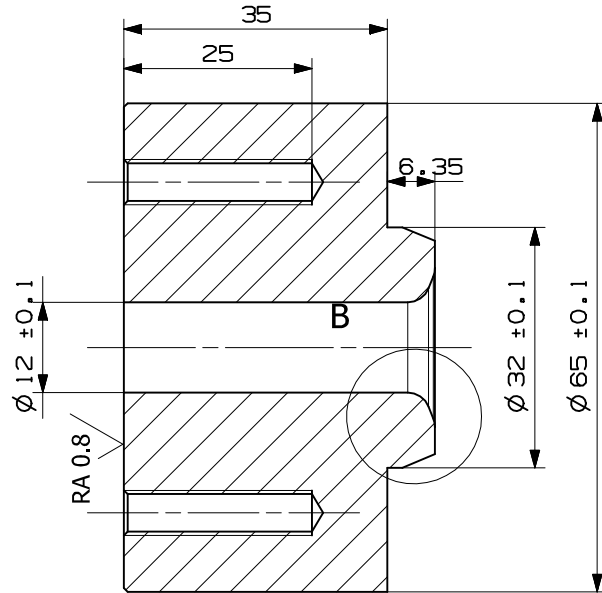
			SS PLATE						SS304L						
VAR. NO.	REMARKS	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT. NO.	VAR.	MATL. CODE	MATL. SPCN.	A/C	UNIT	UNIT WT.	QTY	GS	ZONE
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT															
BHARAT HEAVY ELECTRICALS LIMITED, CORPORATE R & D, HYDERABAD										NAME	SIGN.	DATE	NO. OF VAR		
									DRN.	NT		16.07.2020			
									CKD.	MMR		16.07.2020			
									APPD.	MMR		16.07.2020			
DPT.GSG		UNTOL. DMS. GR.				SCALE		WEIGHT(K.G.)		REF. TO ASSY. DRG. RDDG43505170810		ITEM NO.		NO. OF ITEMS	
CODE 35						NTS									
TITLE									DRAWING NO.				REV NO.		
LIFTING LUG									RD DG 435 0517 0812				-		
									SHT NO. 1				NO. OF SHT. 1		

DRAWING NO.

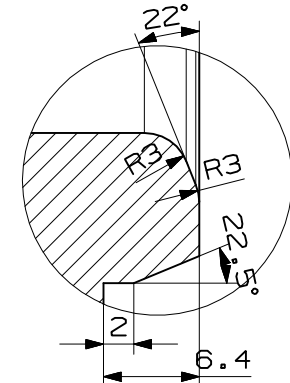
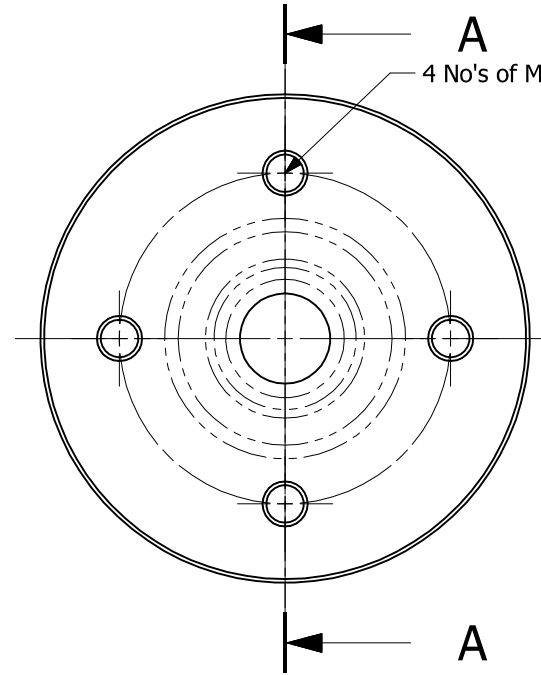


			SS PLATE						SS304L						
VAR. NO.	REMARKS	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT. NO.	VAR.	MATL. CODE	MATL. SPCN.	A/C	UNIT	UNIT WT.	QTY	GS	ZONE
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT						GSM - 245									
 BHARAT HEAVY ELECTRICALS LIMITED, CORPORATE R & D, HYDERABAD							NAME	SIGN.	DATE	NO. OF VAR					
						DRN.	NT		16.07.2020						
						CKD.	NT		16.07.2020						
						APPD.	MMR		16.07.2020						
DPT.GSG		UNTOL. DMS. GR.				SCALE	WEIGHT(K.G.)		REF. TO ASSY. DRG.		ITEM NO.		NO. OF ITEMS		
CODE 35						NTS									
TITLE									DRAWING NO.				REV NO.		
LIFTING LUG II									RD DG 435 0517 0818						
					SHT NO. 1			NO. OF SHT. 1							

DRAWING NO.

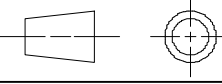


SECTION A-A

DETAIL B
SCALE 3:1

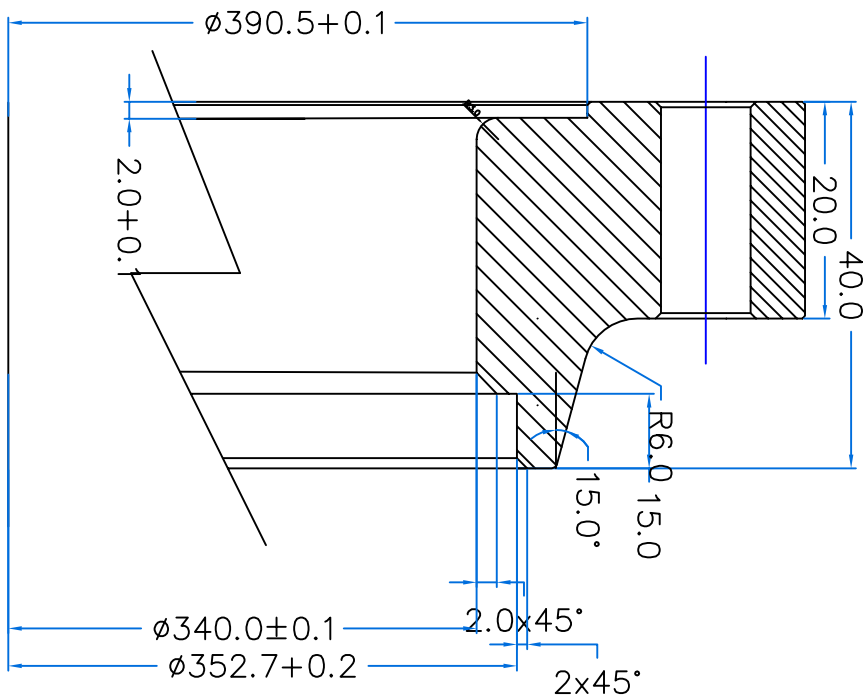
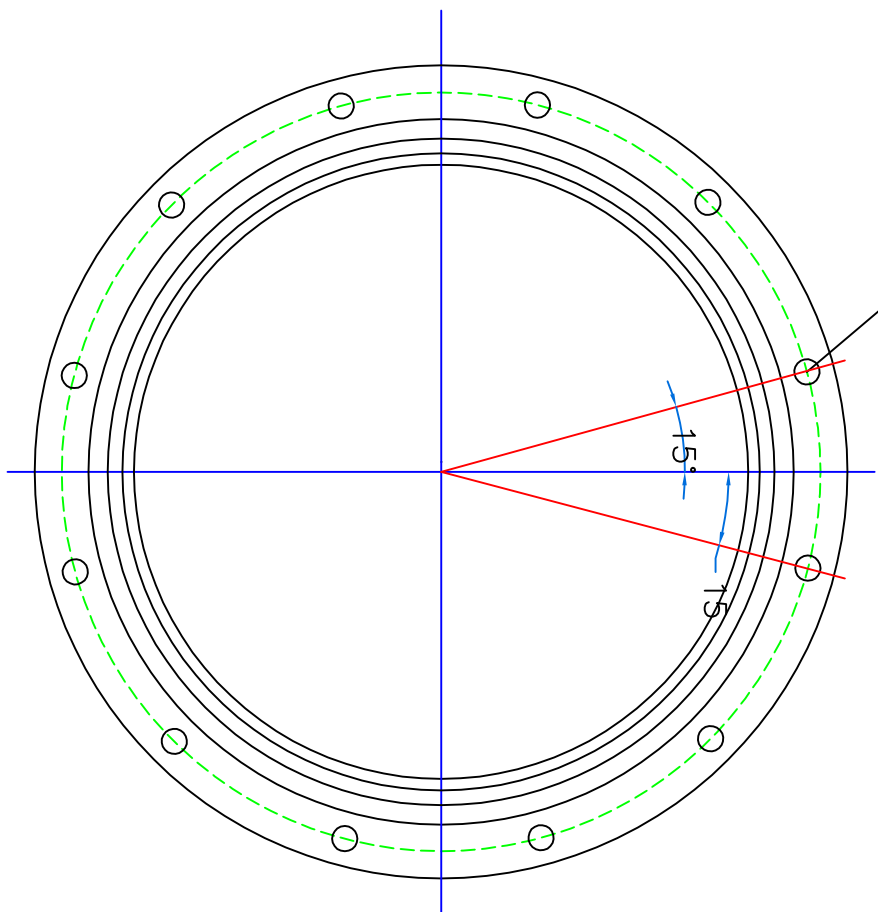
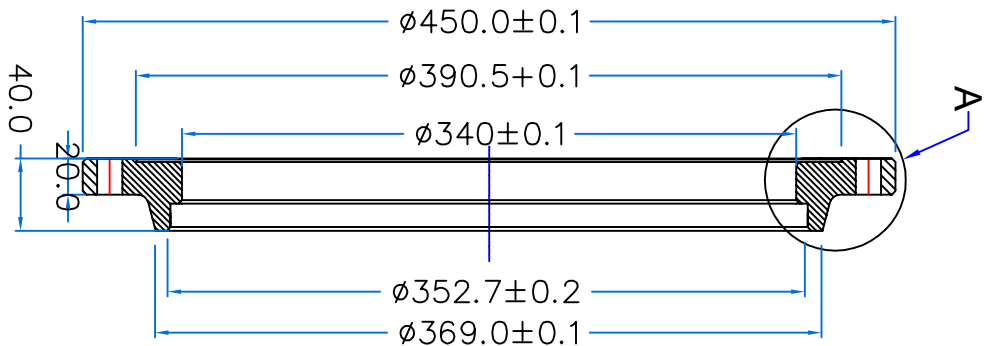
NOTE:

1. $\phi 6$ HOLES TO BE CHAMFERED UNIFORMLY TO $0.8 \times 45^\circ$.
2. PCD AND FLANGE CENTRE SHALL BE CONCENTRIC WITHIN ± 0.05 AFTER WELDING TO PIPE.
3. COMPONENT SHALL BE MACHINED TO DIMENSIONS AFTER WELDING TO PIPE.

VAR. NO.	REMARKS	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT. NO.	VAR.	MATL. CODE	MATL. SPCN.	A	C	UNIT	WT.	QTY	GS	ZONE
			BLOCK		DIA 70 X 45				SS304L							
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT										GSM - 245						
 BHARAT HEAVY ELECTRICALS LIMITED, CORPORATE R & D, HYDERABAD										DRN.	NT		28.07.2020	NO. OF VAR		
										CKD.	NT		28.07.2020			
										APPD.	MMR		28.07.2020			
DPT. GSG	UNTOL. DMS. GR.			SCALE	WEIGHT (K.G.)	REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEMS								
CODE 35				NTS		RDDG43505170813										
TITLE										DRAWING NO.		REV NO.				
GAS PORT FLANGE										RD DG 4 35 0517 0059		-				
										SHT NO. 1		NO. OF SHT. 1				

$$(21.6)$$

12 Nos $\phi 14$ Clear holes @P $\dot{C}D$ 420.0 $\pm$ 0.1



ENLARGED VIEW 'A'

02		FLANGE		ø460x45mm			01	
VAR NO.		DESCRIPTION			DRAWING NO.		UNIT WT.	
VAR.00	REMARKS				IT. NO.	SS-304L		
					VAR	MATL. CODE	MATL. SPECN.	
					UNIT		QTY.	
					A		GS	

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

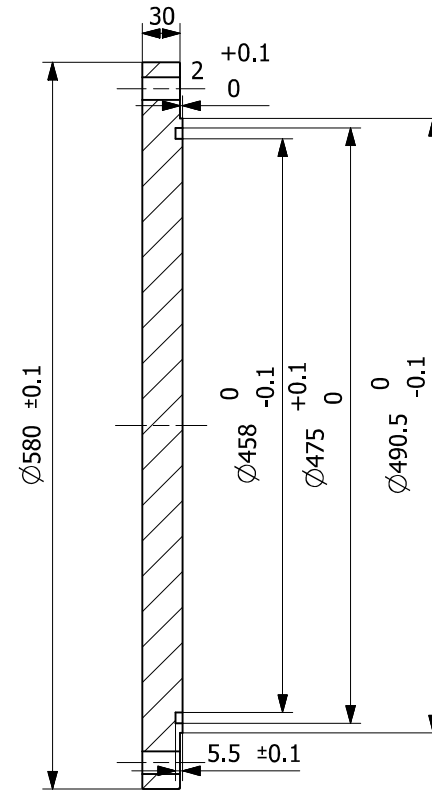
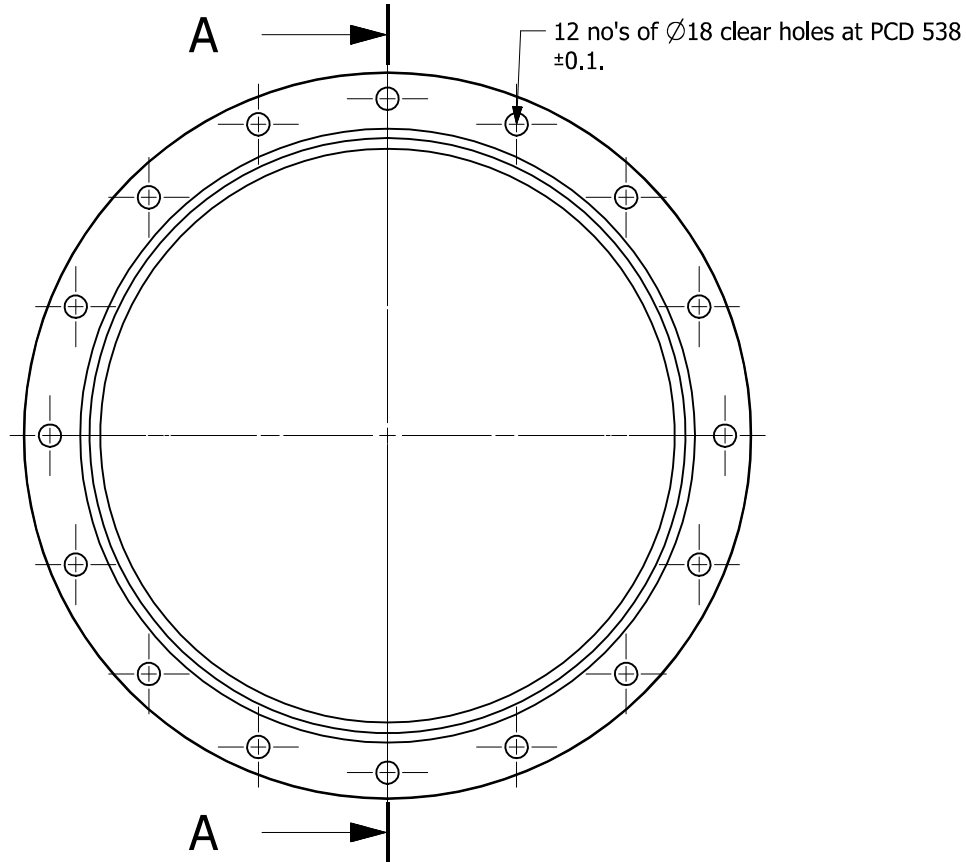
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REV.	DATE	ALTERED	REV.	DATE	ALTERED
		CHECKED			CHECKED
ZONE			ZONE		

[illegible]

DRAWING NO.

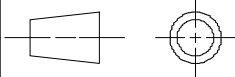
A



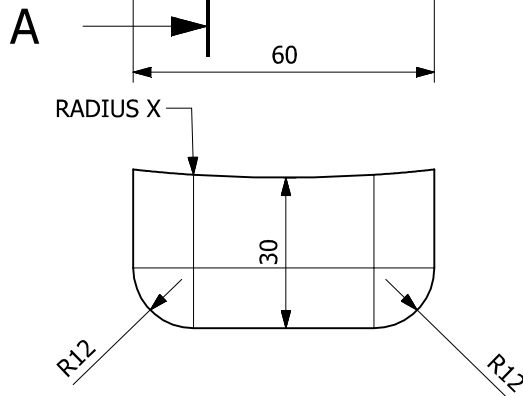
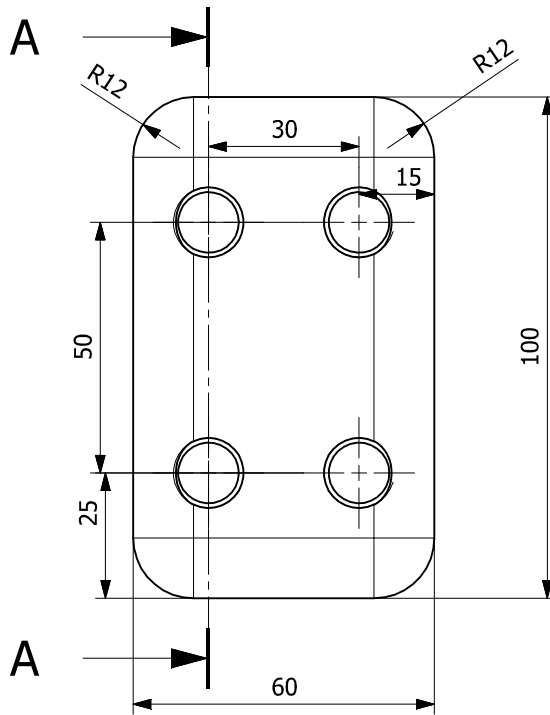
SECTION A-A

NOTE:

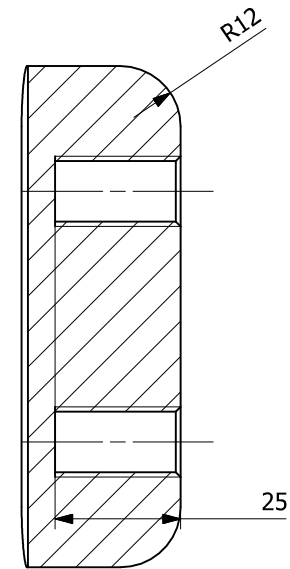
1. ALL SHARP EDGES TO BE MACHINED TO $0.4 \times 45^\circ$.
2. SURFACE SHALL BE MACHINED TO RA0.6
3. ITEM SHALL BE ZINC PACIFIED.
4. O-RING GROOVE TO BE FINISHED TO RA0.8.

VAR. NO.	REMARKS	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT. NO.	VAR.	MATL. CODE	MS- EN8	MATL. SPCN.	A C	UNIT	UNIT WT.	QTY	GS	ZONE
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT						GSM - 245										
बी एच ई एल  BHARAT HEAVY ELECTRICALS LIMITED, CORPORATE R & D, HYDERABAD							NAME	SIGN.	DATE	NO. OF VAR						
						DRN.	NT	27.07.2020								
						CKD.	NT	27.07.2020								
						APPD.	MMR	27.07.2020								
DPT.GSG		UNTOL. DMS. GR.		SCALE	WEIGHT(K.G.)	REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEMS								
CODE 35				NTS		RDDG43505170800										
TITLE										DRAWING NO.			REV NO.			
DUMMY PLATE WITH O-RING										RD DG 4 35 0517 0817			-			
										SHT NO. 1		NO. OF SHT. 1				

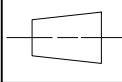
DRAWING NO.



NOTE:
1. 'RADIUS X' SHALL BE MADE ACCORDING
TO THE RADIUS OF ENCLOSURE



SECTION A-A

			SS BLOCK						SS304L						
VAR. NO.	REMARKS	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT. NO.	VAR.	MATL. CODE	MATL. SPCN.	A C	UNIT	UNIT WT.	QTY	GS	ZONE
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT															
BHARAT HEAVY ELECTRICALS LIMITED, CORPORATE R & D, HYDERABAD										NAME	SIGN.	DATE	NO. OF VAR		
									DRN.	NT		15.01.2020			
									CKD.	MMR		15.01.2020			
									APPD.	MMR		15.01.2020			
DPT.GSG		UNTOL. DMS. GR.				SCALE NTS		WEIGHT(K.G.)		REF. TO ASSY. DRG.		ITEM NO.		NO. OF ITEMS	
CODE 35															
TITLE										DRAWING NO.			REV NO.		
EARTHING PLATE										RD DG 435 0517 0080			-		
										SHT NO. 1		NO. OF SHT. 1			