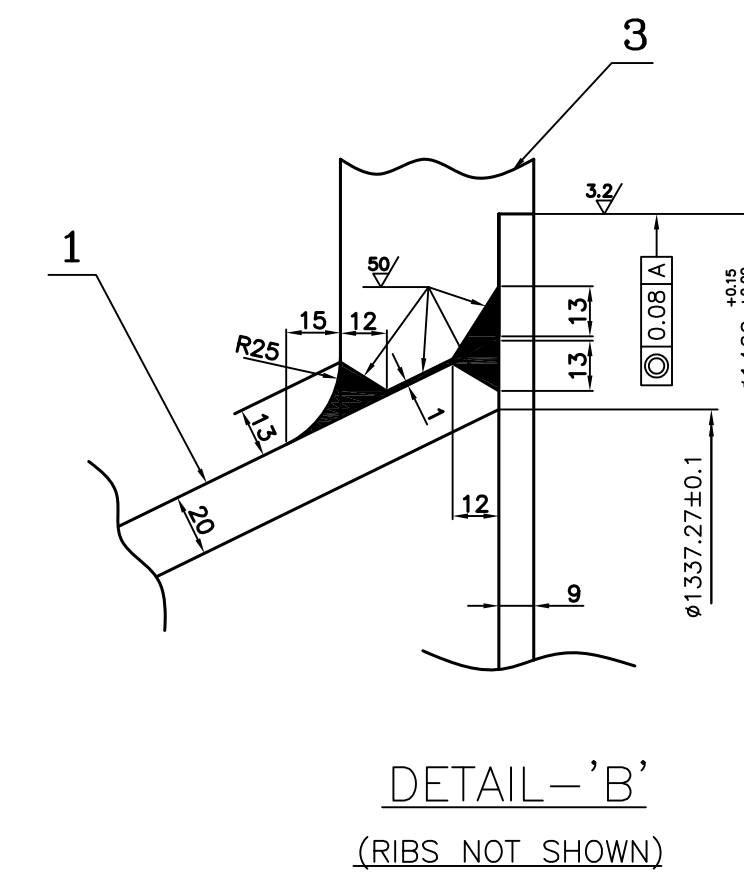
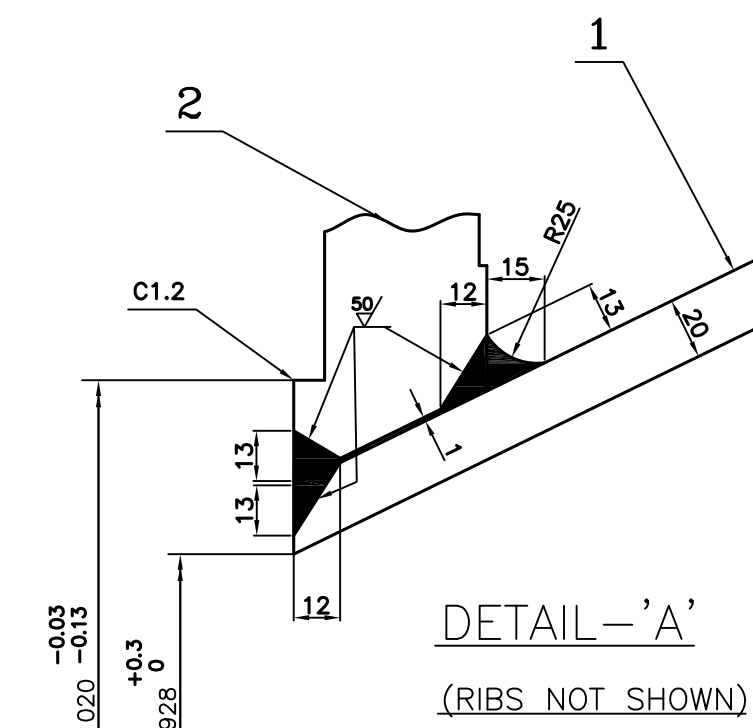
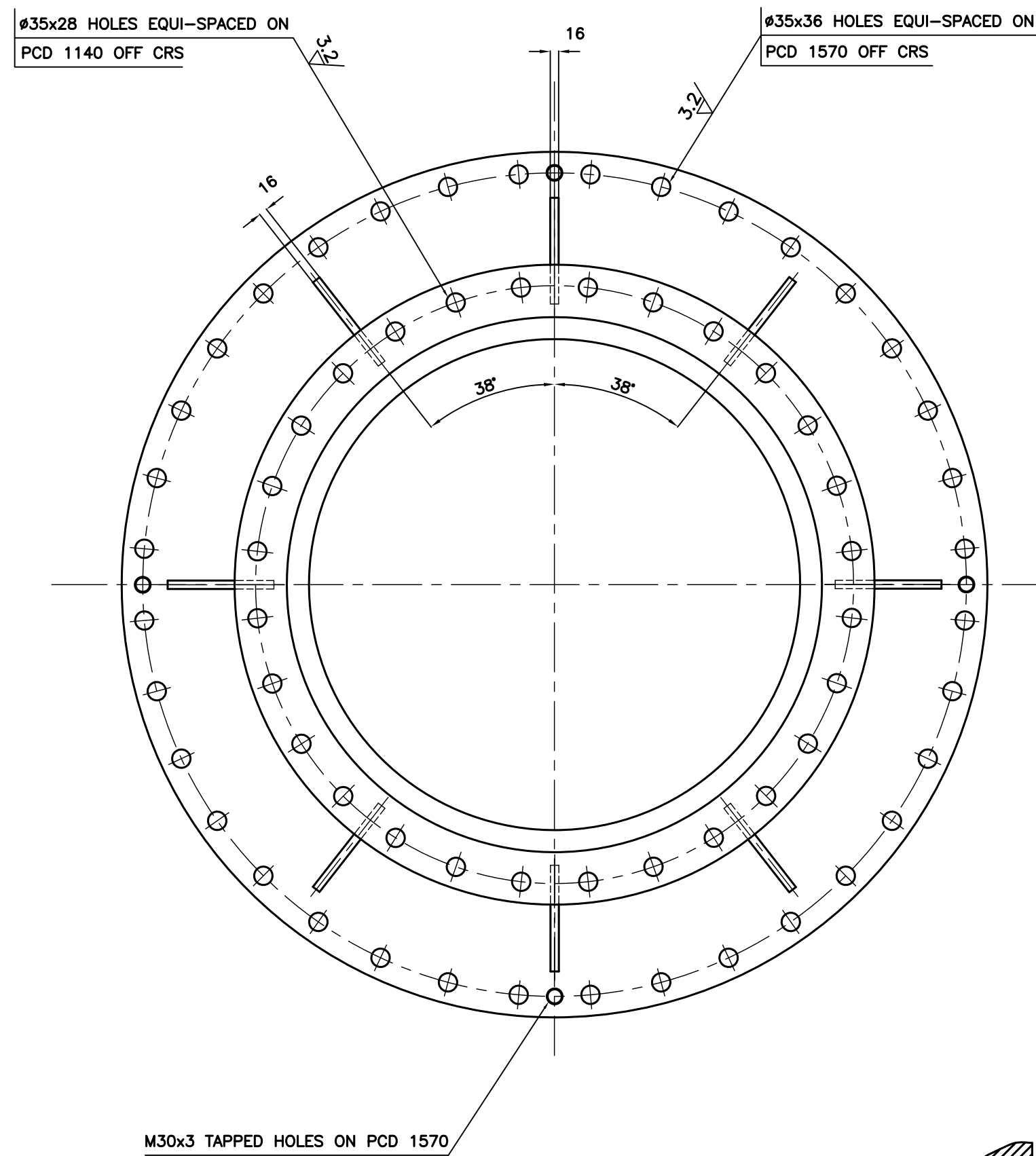
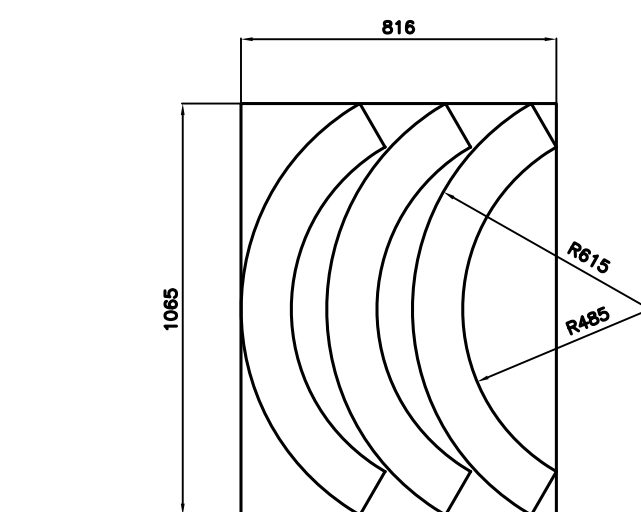
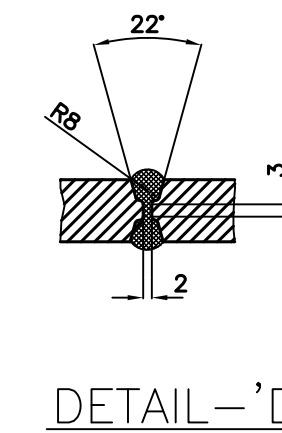
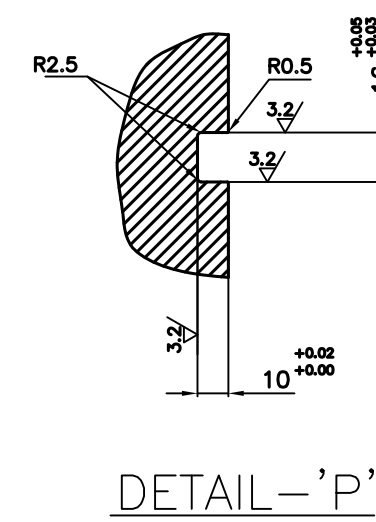


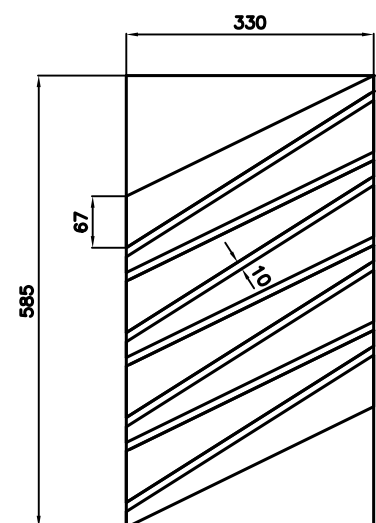
INVENTORY NO	SIGN. AND DATE	REF. DRG. NO.	COMPUTER FILE NAME :
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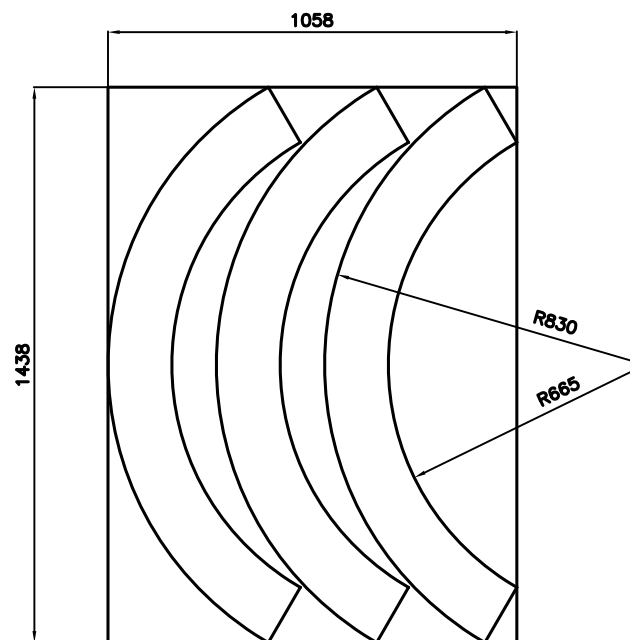
FINISH MACHINED DRAWING



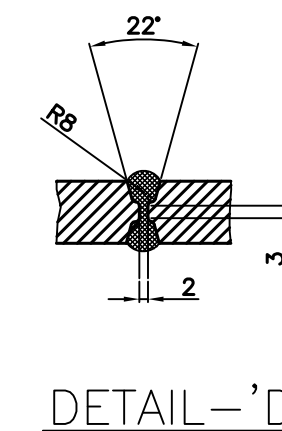
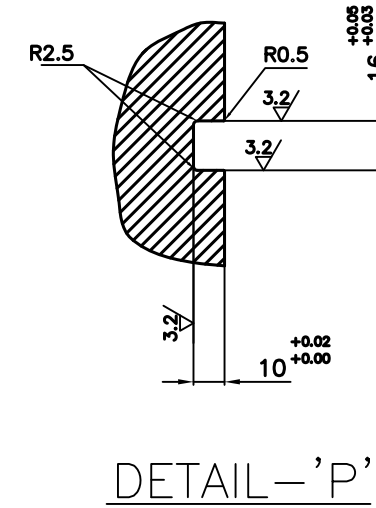
POS.NO.2 CUTTING PLAN FOR REFERENCE



POS.NO.4 CUTTING PLAN FOR REFERENCE



POS.NO.3 CUTTING PLAN FOR REFERENCE



NOTE-I:

1. FOR FLANGES POS.N 2&3; SEGMENTAL WELDING IS PERMITTED (MAXIMUM 3 SEGMENTS)
SEGMENTS SHALL BE WELDED WITH DOUBLE "U" TYPE WELDING AS SHOWN IN DETAIL "D".
2. FOR SHELL POS.No 1; MAXIMUM 2 NO VERTICAL WELD JOINT IS PERMITTED.
HORIZONTAL/RADIAL WELDING ON THE SHELL IS NOT PERMITTED
3. DIMENSIONS SHOWN IN THE FINISH MACHINED DRAWING ARE FINISH MACHINED DIMENSIONS.
SUPPLIER SHALL SELECT SUITABLE MARGIN FOR RAW MATERIAL WHEREVER MACHINING IS INDICATED.

4. MATERIAL:

POSITION NO.1 MATERIAL: SS304L GRADE
POSITION NO.2,3&4 MATERIAL: IS 2062 GR.B

4. ALL MATERIAL SHALL BE ARRANGED BY THE SUPPLIER

NOTE-II:

1. WELDING AS PER BHEL WELD PROCEDURE SPECN NO. WE-046
2. D.P.T SHALL BE DONE ON 100 % OF WELDS AS PER AA0850131 ACCEPTANCE AS PER AA0850129 LEVEL-IV
3. R.T TO BE CARRIED OUT ON ALL WELD JOINTS 100 % AS PER THE QUALIFICATION PROCEDURE-ASME SECTION IX.
4. STRESS RELIEVING TO BE DONE AS PER HY0640763, BEFORE MACHINING.
5. SHOT BLASTING TO BE DONE TO REMOVE SCALES, AFTER SHORT BLASTING ONE COAT OF PRIMER TO BE APPLIED WITHIN 2 HOURS.
6. WHEREVER NOT SPECIFIED, ALL SHARP EDGES TO BE CHAMFERED TO 2x45°
7. WHEREVER NOT SPECIFIED TOLERANCE ON MACHINED DIMENSIONS AS PER AA0230208 MEDIUM CLASS.
8. COMPONENT SHALL BE PRESSURE TESTED AT 7.5 Kg/Sq. Cm. FOR 30 MINUTES DURATION.

PAINTING:

1. MACHINED SURFACES SHALL NOT BE PAINTED.
2. MACHINED SURFACES SHALL BE COATED WITH SUITABLE RUST PREVENTIVE COAT AS PER HY0490563, CATEGORY 'B'

PACKING AND DESPATCH:

1. TO BE PROPERLY PACKED AND DESPATCHED SUCH THAT NO DAMAGE IS CAUSED DURING HANDLING AND TRANSIT.

4	RIBS			PL.16 X 320 X 585	IS2062 GR.B		1	
3	CS FLANGES			PL.56 X 1058 X 1438	IS2062 GR.B		1	
2	CS FLANGE			PL.56 X 816 X 1065	IS2062 GR.B		1	
1	SS SHELL			PL.32 X 1533 X 3066	STAINLESS STEEL SS340L ASTM A240 S30403		1	
I	SUCTION LINER	1 182 36 1 7134			FP9714071054	690	690	
							1	
ITEM NO	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	MATERIAL CODE	NET WT.	GROSS WT.	
					MATERIAL SPECN.	QUANTITY		

THE FOLLOWING CONDITIONS APPLY
EXCEPT OTHERWISE STATED

EXCEPT OTHERWISE SPECIFIED:

1. REF. TO HY0230261 FOR UNIFORM TOLERANCES.
2. CHAMFER M/CD SHARP ED 1.2 TO 1.0 AT 45°.
3. INTERNAL M/CD CORNER RADII 1 TO 0.7.
4. THE SURFACE ROUGHNESS WHEREVER NOT SHOWN SHALL BE TAKEN FROM THE SURFACE ROUGHNESS SHOWN OUT SIDE BACK SLASHES GIVEN AT THE TOP MOST RIGHT CORNER OF THE DRG.

TYPE OF PRODUCT

OR NAME OF CUSTOMER/PROJECT

NAME OF CUSTOMER/PROJECT
 भारत हेवी इलेक्ट्रिकल्स लिमिटेड
 HYDERABAD
 BHARAT HEAVY ELECTRICALS LTD
 HYDERABAD

DEPT.	PUMPS
CODE	410

TITLE	SUCTION LINER
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SECTION EIGHT

CW1Q

	NAME	SIGN.	DATE
DRN.	SATISH	SATISH	31.01.20
CHD.	MSRAM	MSRAM	31.01.20
APPD.	K.H.R.K	K.H.R.K	31.01.20

WEIGHT (KG)	REF. TO ASSY DRG.	ITEM NO.
690	-NA-	-NA-

	DRAWING NO.	
	1 182 36 1 7134	

	SHEET NO.	NO OF SHEETS
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	REV.	DATE	ALTERED		REV.	DATE	ALTERED		REV.	DATE	ALTERED		REV.	DATE	ALTERED		REV.	DATE	ALTERED	
			CHECKED	APPD.			CHECKED	APPD.			CHECKED	APPD.			CHECKED	APPD.			CHECKED	APPD.
J	ZONE				ZONE				ZONE				ZONE				ZONE			