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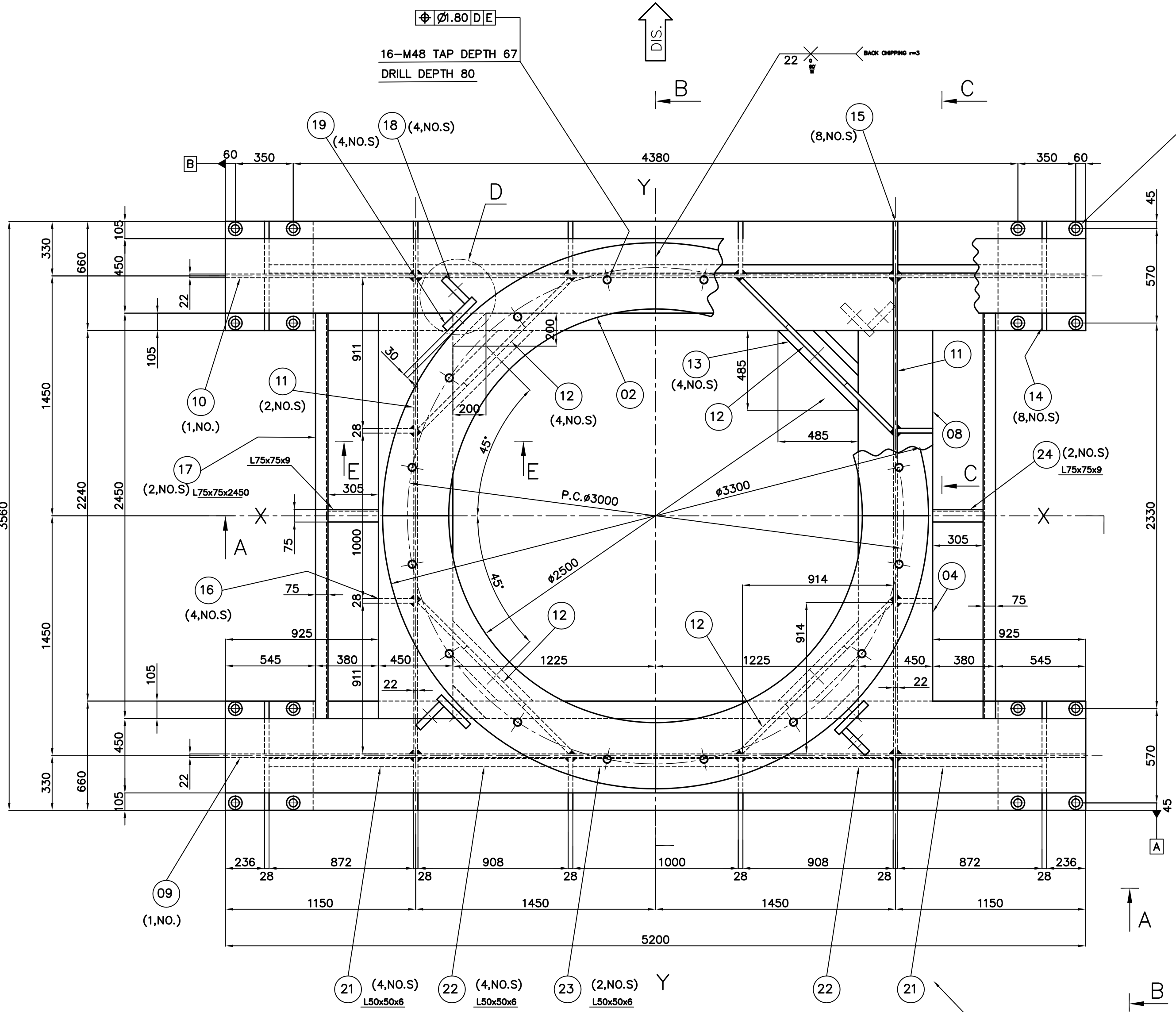
INVENTORY NO. SIGN. AND DATE REF. DRG. NO. COMPUTER FILE NAME :
FP11825016723-ROO
P1-44978-RO

FIRST ANGLE PROJECTION

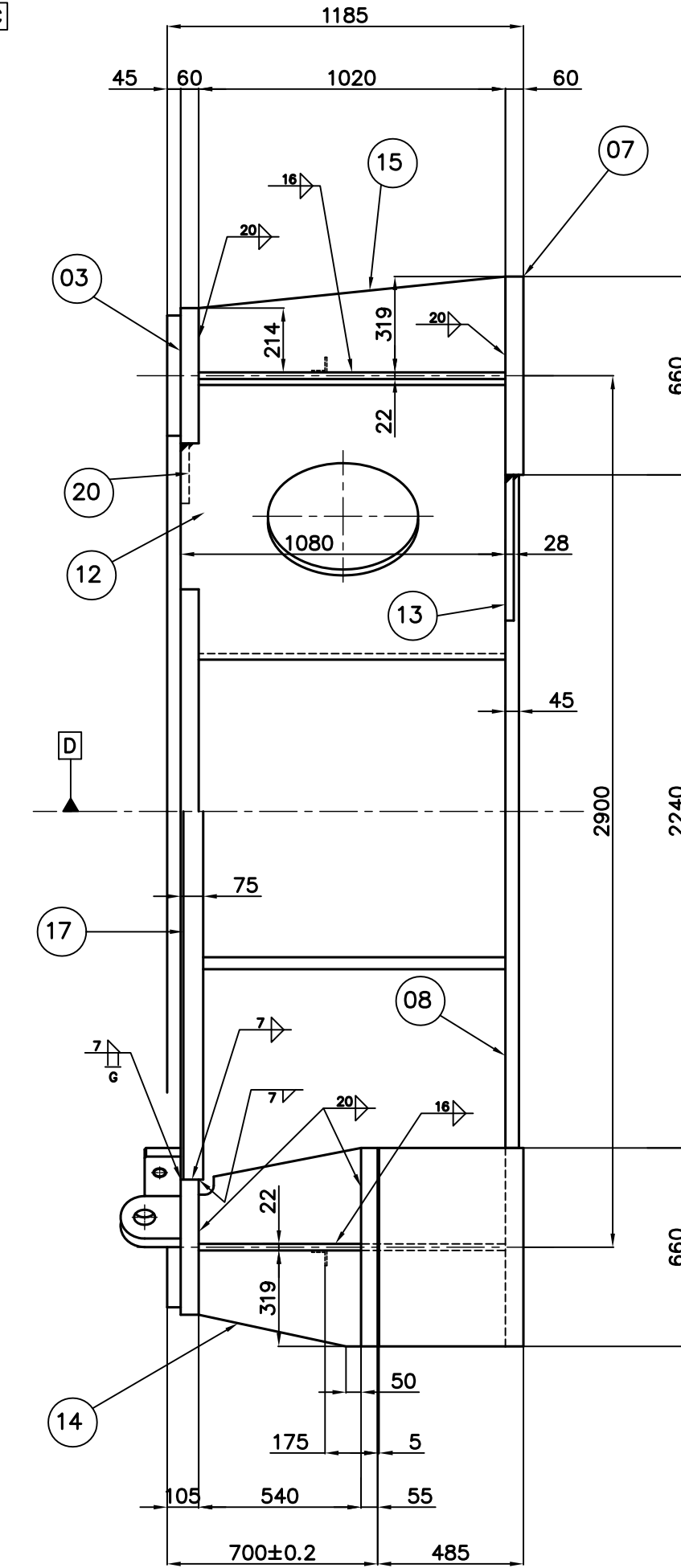
(ALL DIMENSIONS ARE IN mm)

1 182 50 1 6723

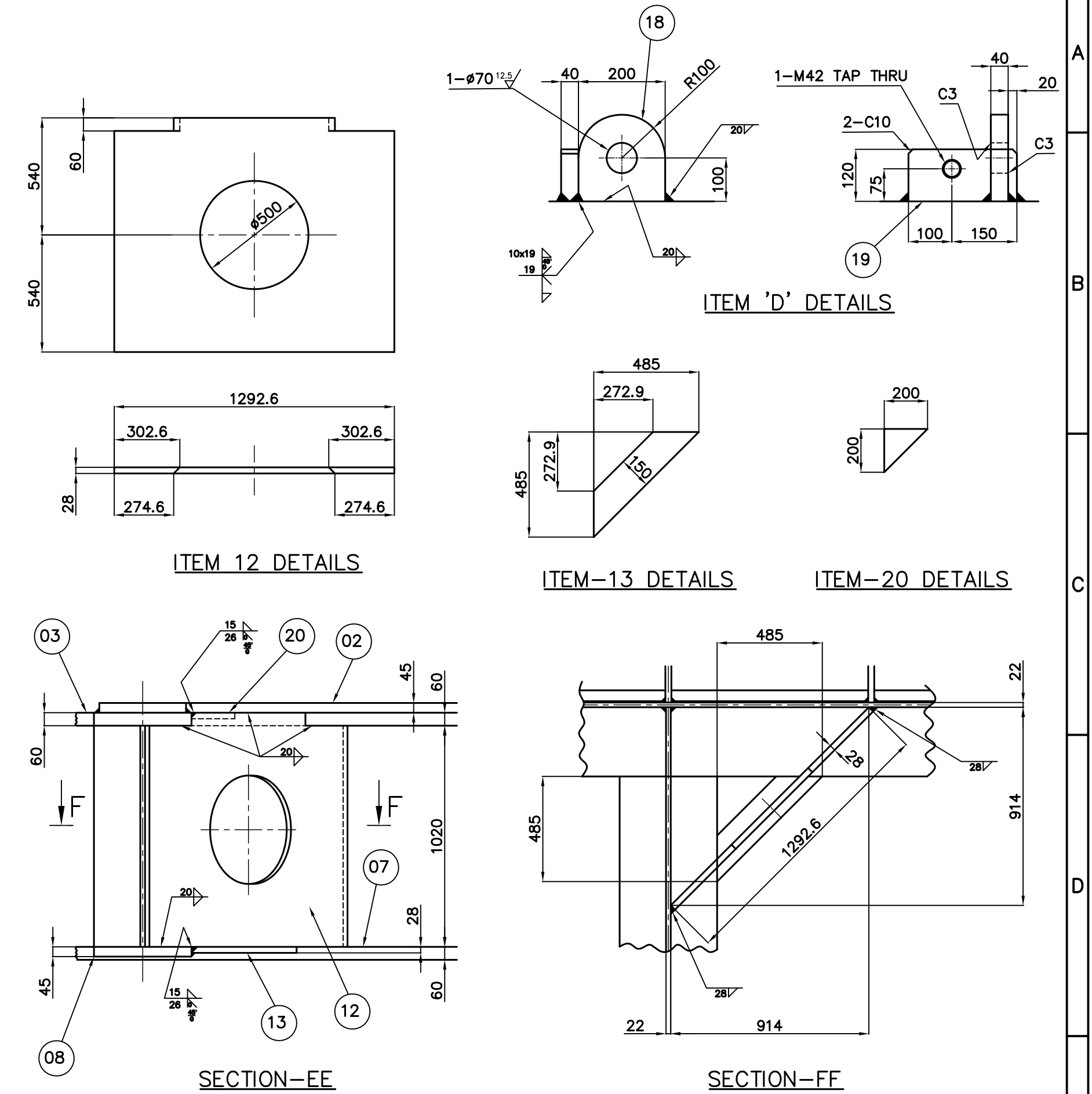
DRG. NO.



4x4-#48
COUNTER BORE #82



SECTION BB



NOTE:

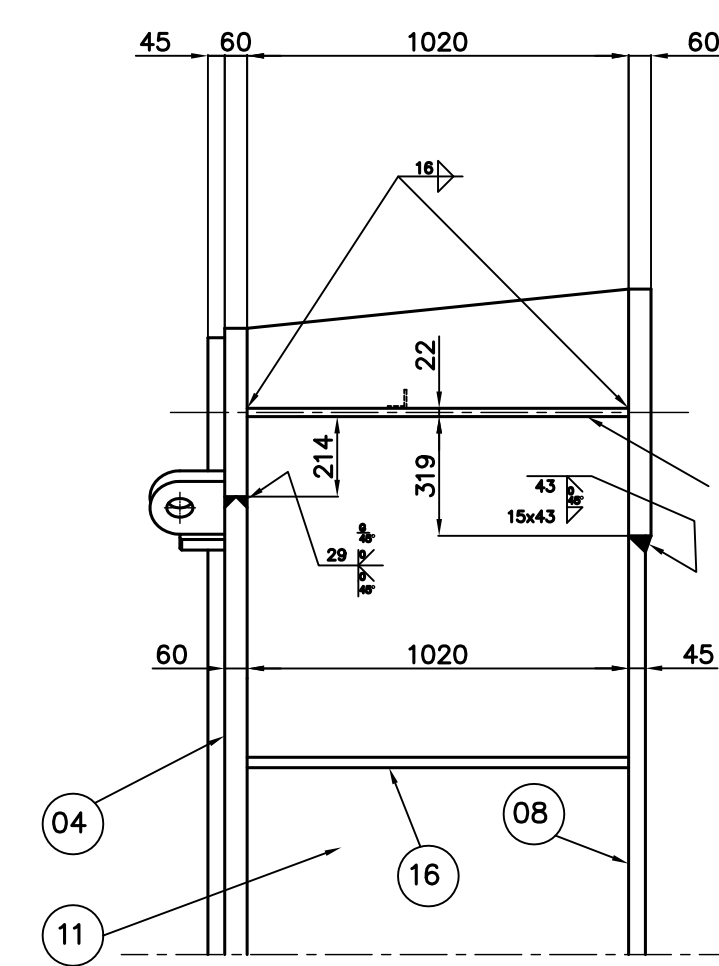
1. SHAPES SHALL BE SYMMETRY TO THE AXIS OF X-X AND Y-Y UNLESS INDICATED
2. THIS PEDESTAL SHALL BE FORCED OF 45 TONS STATIC LOAD (MOTOR DEAD WEIGHT)
3. REGARDING THE WELDING GROOVE AND LEG LENGTH ONLY REPRESENTATIVE DIMENSIONS ARE INDICATED. OTHER AREA SHALL BE ALSO FIRMLY WELDED
4. DIMENSIONS SHOWN ARE FINISH MACHINED DIMENSIONS.
5. WELDING AS PER BHEL WELD PROCEDURE SPECN NO. WE-001.
6. RAW MATERIAL PROCUREMENT SHALL BE AS PER A10119, UT TESTED PLATES SHALL BE PROCURED FOR PLATES HAVING MORE THAN OR EQUAL TO 25 MM THICK
7. D.P.T SHALL BE DONE ON 100 % OF WELDS AS PER A0850131 ACCEPTANCE AS PER A0850129, LEVEL-IV.
8. SPOT R.T TO BE CARRIED OUT ON 10 % OF BUTT WELDS FOR PLATES UP TO 25 MM AS PER THE QUALIFICATION PROCEDURE-ASME SECTION VIII DIV I. UW 52.
9. RT TO BE CARRIED OUT ON 100% BUTT WELD JOINT FOR MORE THAN 25 MM THICK PLATES PER THE QUALIFICATION PROCEDURE-ASME SECTION VIII DIV I. UW 51.
10. UT TO BE CARRIED OUT ON 100% BUTT WELD JOINT FOR MORE THAN 25 MM IF UT IS TO BE DONE IN PLACE OF RT PER THE MANUFACTURER STANDARD PRACTICE.
11. STRESS RELIEVING TO BE DONE AS PER HY0640763
12. SAND BLASTING TO BE DONE TO REMOVE SCALES, AFTER SHORT BLASTING ONE COAT OF PRIMER TO BE APPLIED WITHIN 2 HOURS
13. WHEREVER NOT SPECIFIED, ALL SHARP EDGES TO BE CHAMFERED TO 2x45°.
14. WHEREVER NOT SPECIFIED TOLERANCE ON MACHINED DIMENSIONS SHALL BE AS PER A0230208 MEDIUM CLAS

PAINTING:

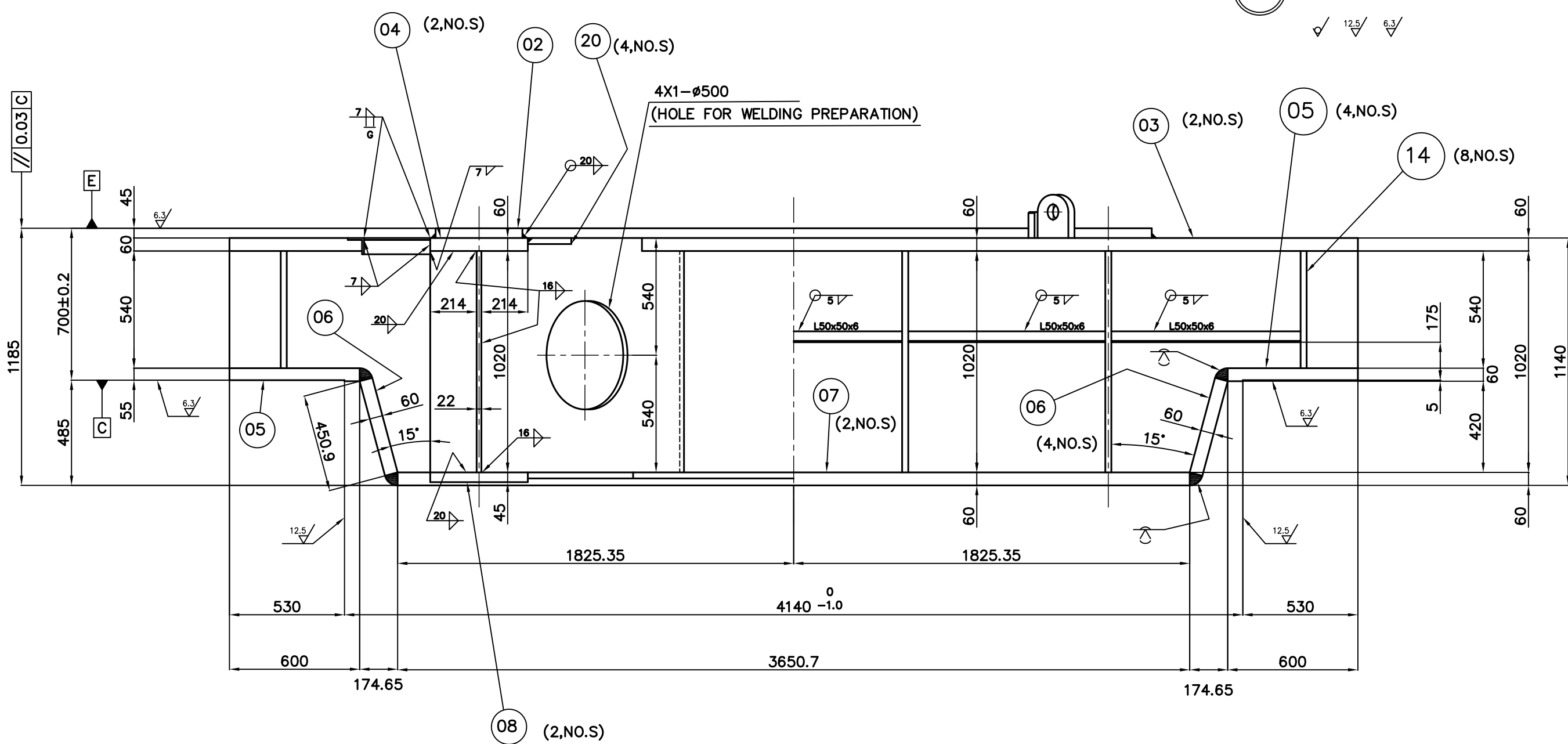
1. FINISH PAINTING FOR ALL SURFACE, FINISH PAINTING FOR ALL EXTERNAL SURFACE, A COAT OF A COAT OF RED LEAD PRIMER OF MINIMUM THICKNESS OF 50 MICRONS FOLLOWED UP WITH UNDERCOAT OF SYNTHETIC ENAMEL PAINT OF MINIMUM THICKNESS OF 50 MICRONS SHALL BE APPLIED. THE TOP COAT SHALL CONSIST OF TWO COATS EACH OF MINIMUM THICKNESS OF 50 MICRONS OF SYNTHETIC ENAMEL PAINT AND THUS TOTAL THICKNESS SHALL BE MINIMUM 200 MICRONS. PAINT GRADE 631 OF IS-5
2. MACHINED SURFACES SHALL BE COATED WITH SUITABLE RUST PREVENTIVE COAT AS PER HY0490563, CATEGORY 'B'
3. MACHINED SURFACES SHALL NOT BE PAINTED

PACKING AND DISPATCH:

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



SECTION CC



SECTION AA

01	MOTOR PEDESTAL	1 182 50 1 6723	00	FP9715451098	13580	13580
				AA10119		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				TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		
1. REF.TO HY0230261 FOR UN TOLERANCES.				90MN		
2. CHAMFER M/CD SHARP ED 1.2 TO 1.0 AT 45°.				BHARAT HEAVY ELECTRICALS LTD. HYDERABAD		
3. INTERNAL M/CD CORNER RADI 1 TO 0.7.				DEPT. PUMPS	SCALE N.T.S	WEIGHT (KG) 13580
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.				CODE 410	REF. TO ASSY DRG. -NA-	ITEM NO. -NA-
				TITLE MOTOR PEDESTAL		
				DRAWING NO. 1 182 50 1 6723		
				SHEET NO. 01 NO OF SHEETS 01		