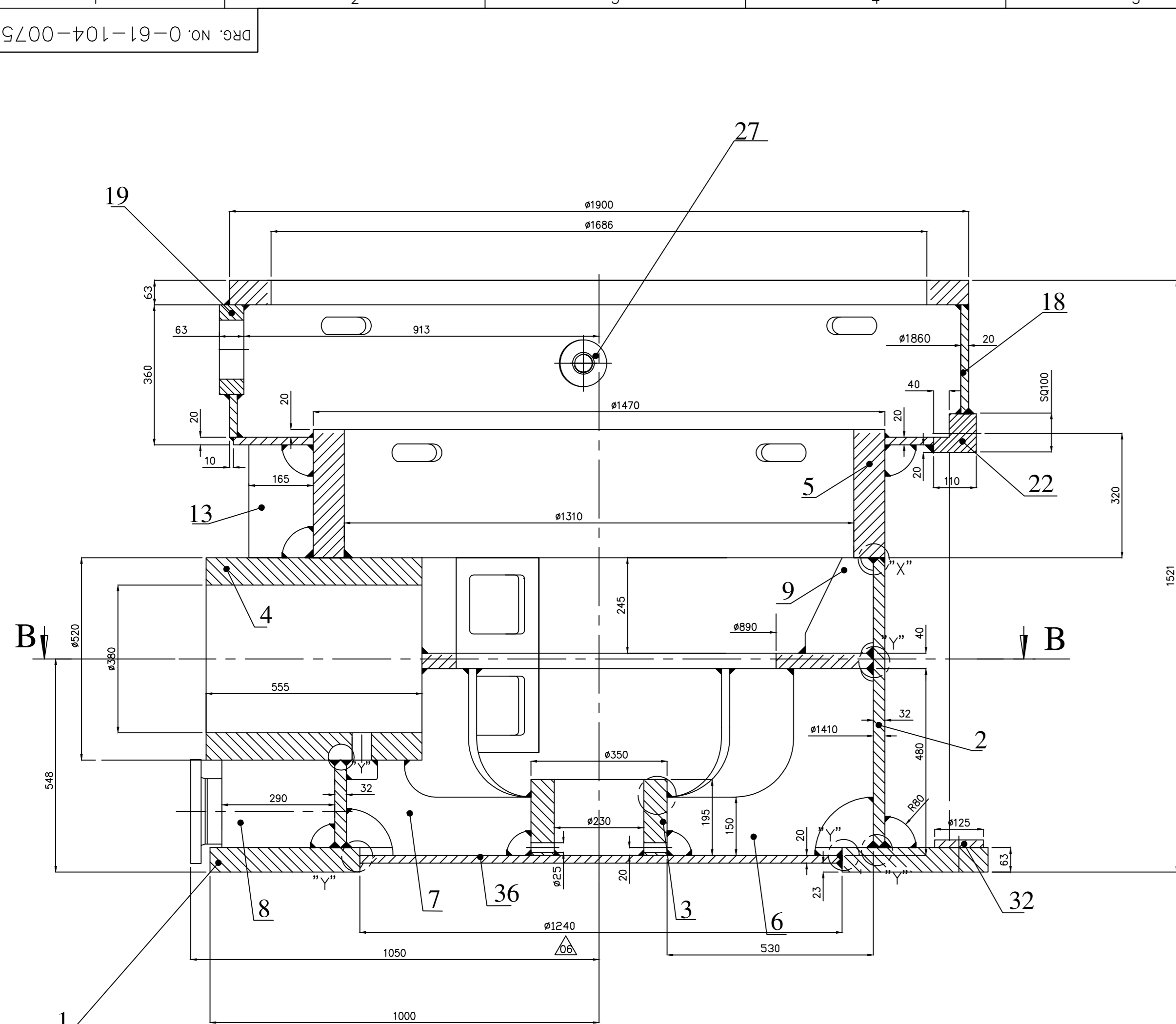
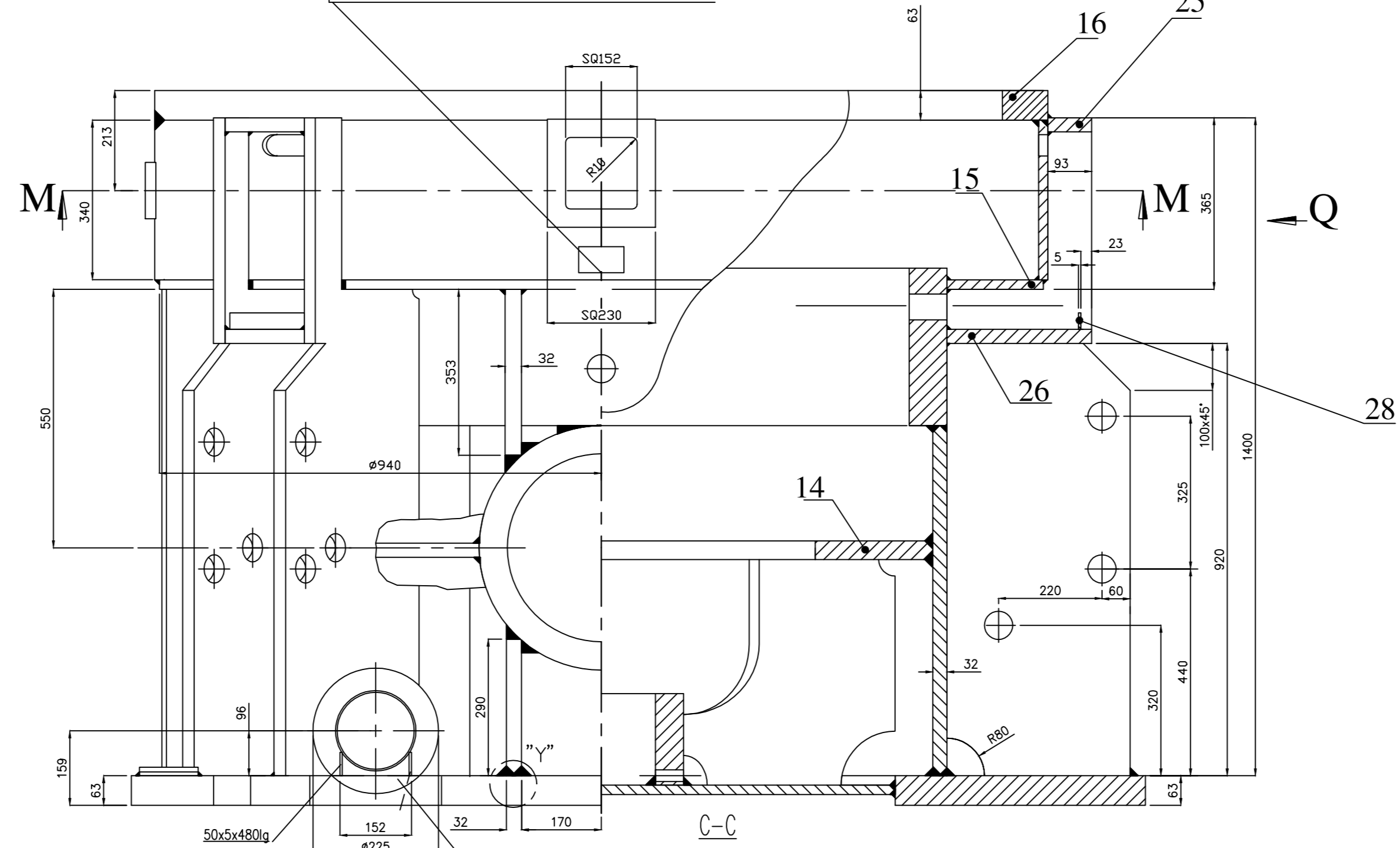


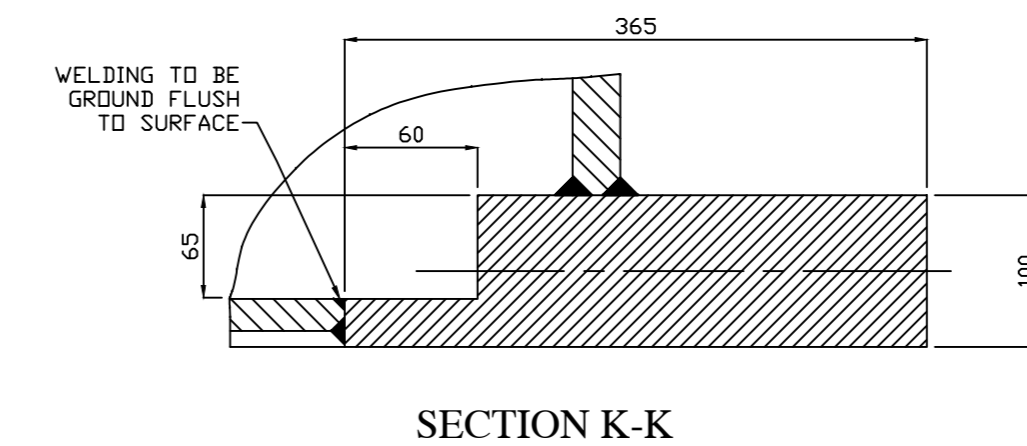
ON OUTSIDE SURFACE OF SHELL
PUNCH ID NO & DRG NO. WITH
15 MM LETTERS. ID NO IS IN FORMAT
WWW/YY/NNN
WWW= VENDOR CODE
YY=YEAR (EG.02 FOR 2002-03)
NNN=VENDOR SERIAL NO. FOR THE YEAR



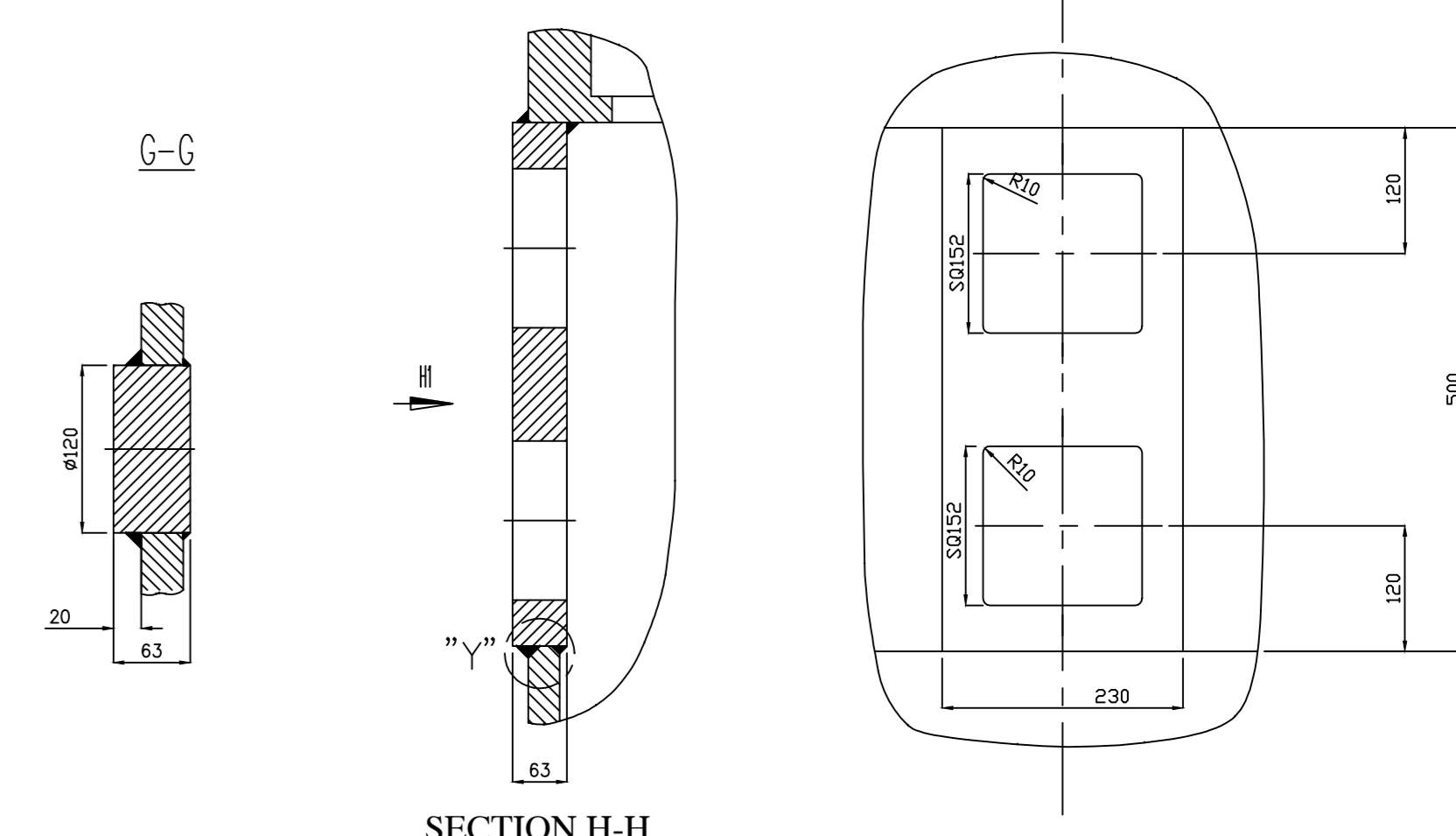
SECTION A-A



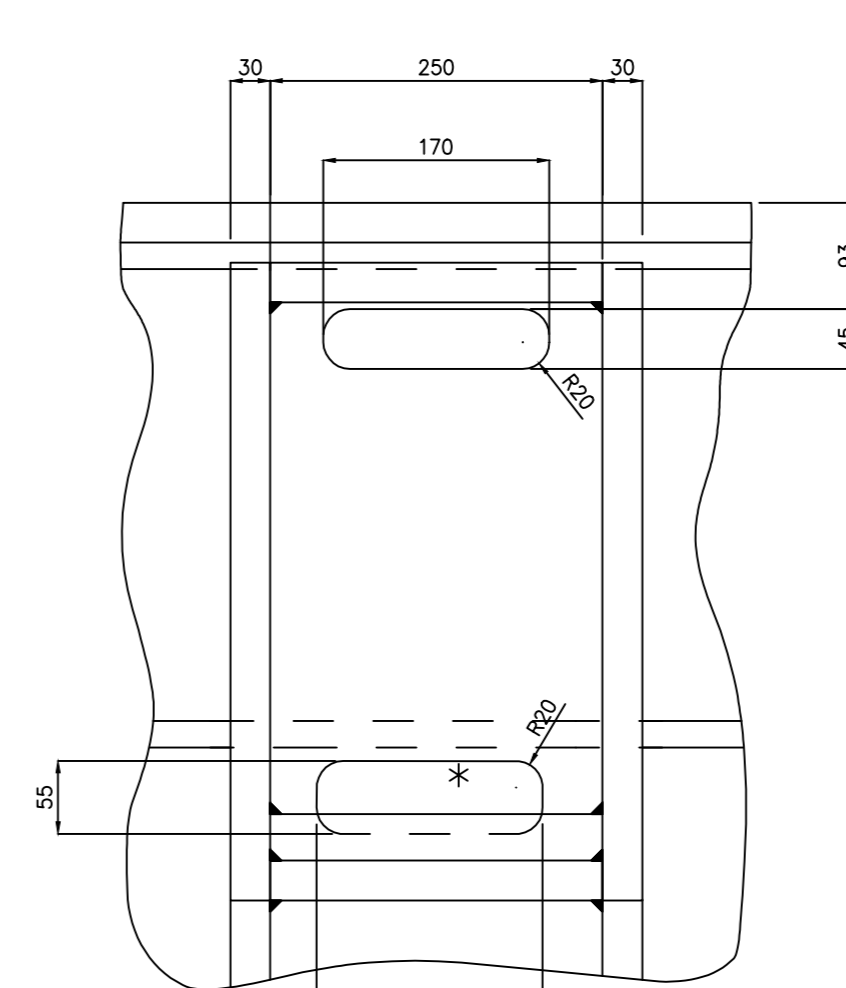
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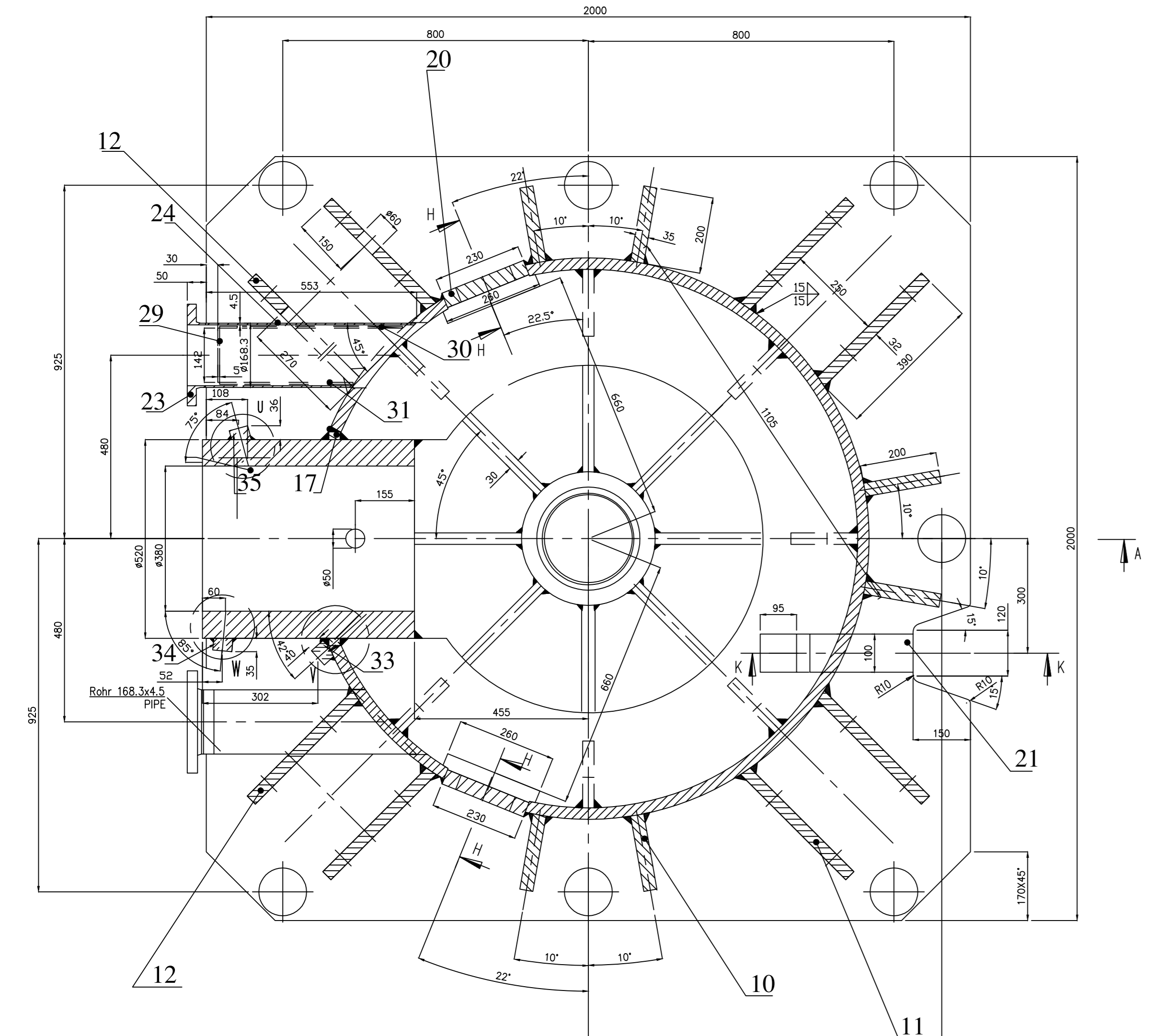
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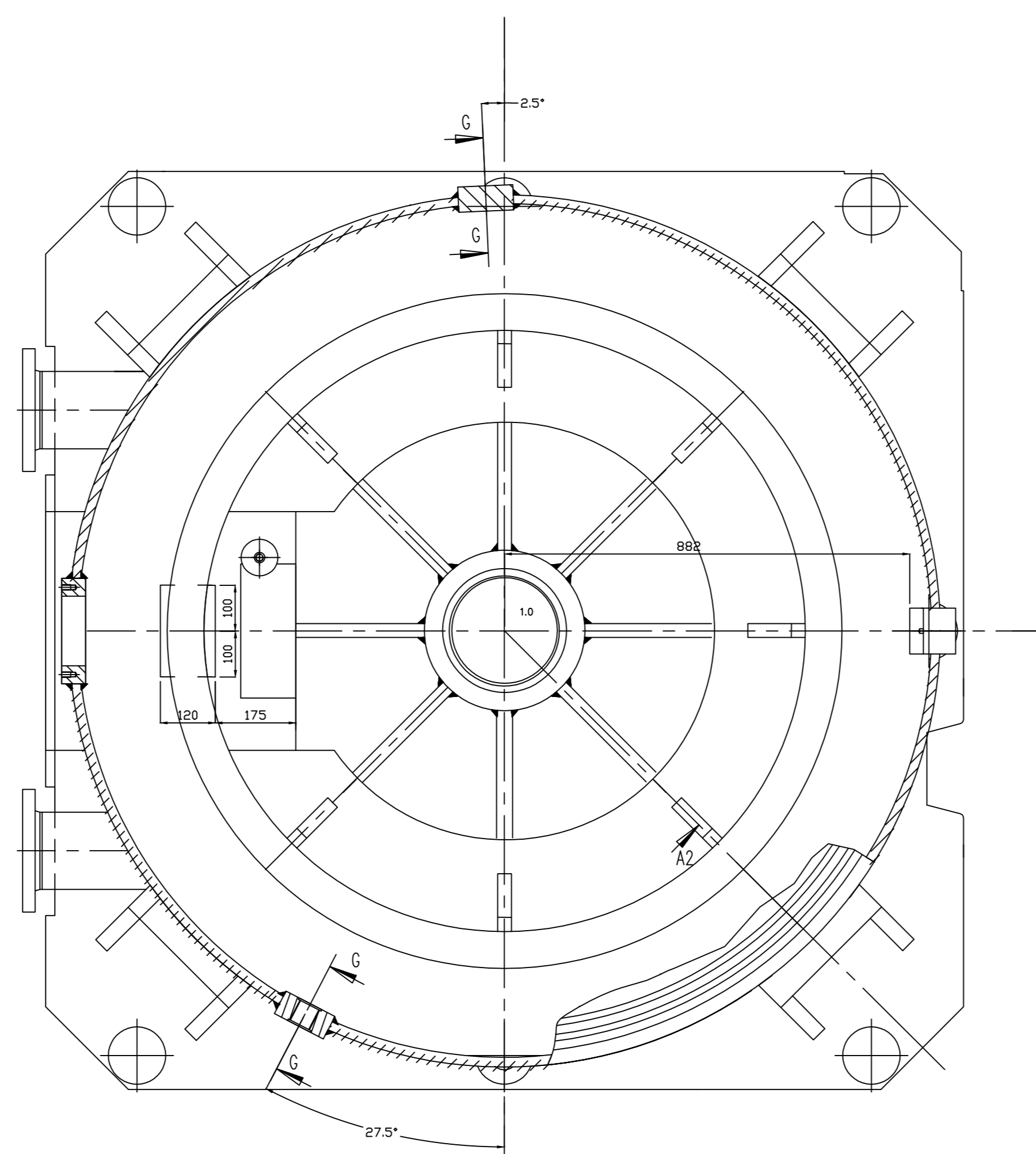
VIEW-HI GROSS WT : 8608 KG



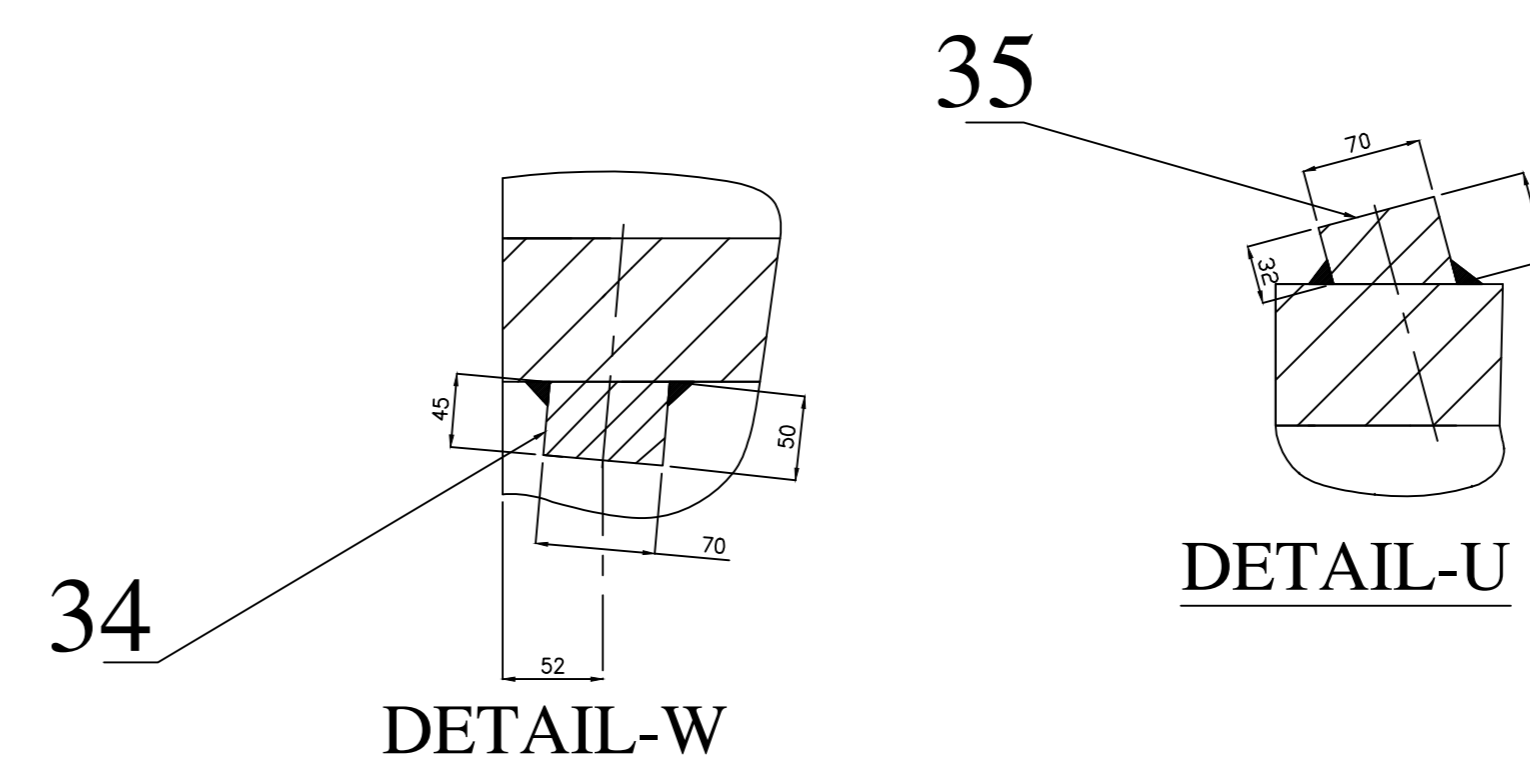
VIEW-Q



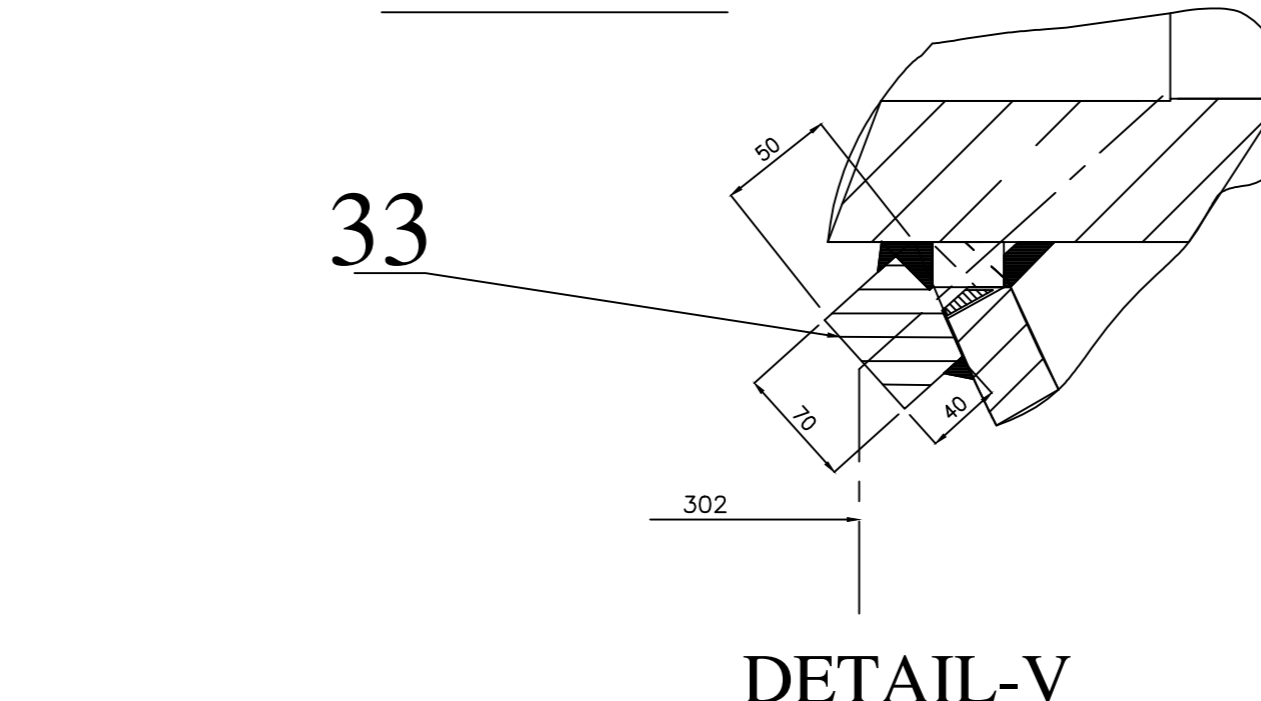
SECTION B-B



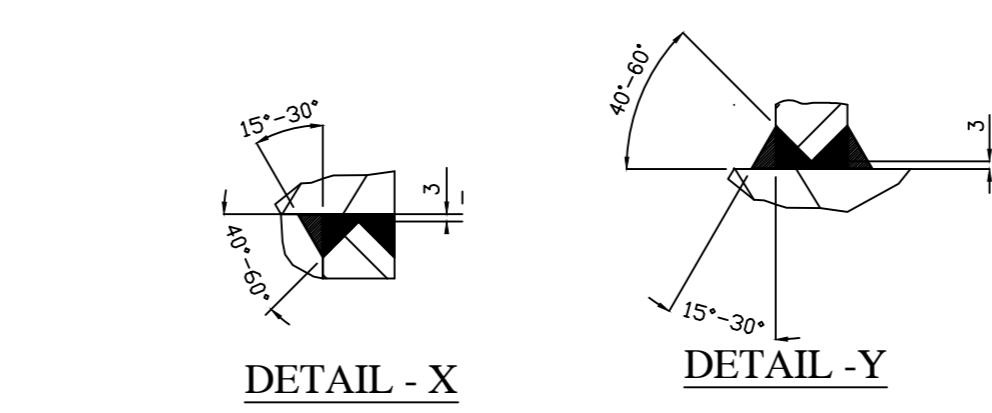
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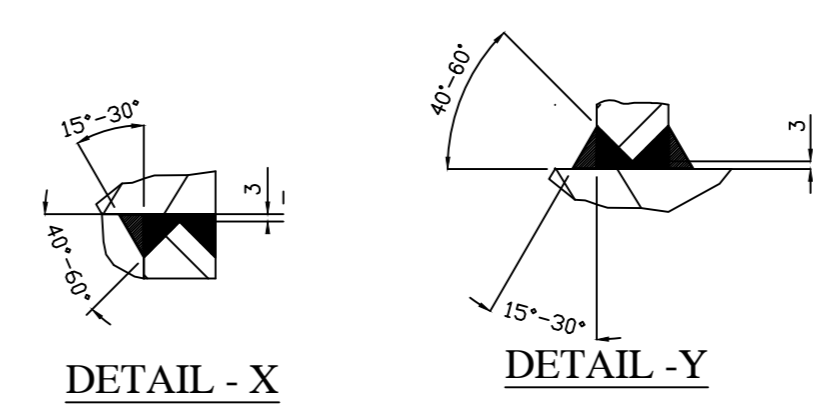
DETAIL-U



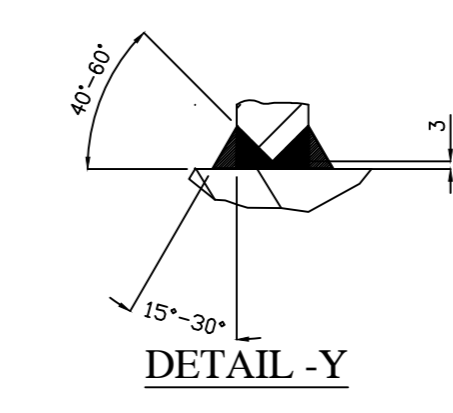
DETAIL-W



DETAIL-V



DETAIL-X



DETAIL-Y

WELDING DETAIL

GROSS WT: 8608 kg

NOTES:

- 01. ALL BUTT WELDS TO BE FULL PENETRATION 'X' WELDS. FOR FILLET WELD SIZE REFER TABLE.1. ALL RIBS TO BE WELDED ALLROUND WITH 12 ϕ
- 02. UNLESS OTHERWISE SPECIFIED IN THE QUALITY PLAN -
 - A. ALL BUTT WELDS TO BE 10% SPOT RADIOGRAPHED(100% FOR KNOT) ACCEPTANCE AS PER HY0850170.
 - B. ALL BUTT WELDS TO BE LPI TESTED AFTER BACK CHIPPING AS PER AA0850131, ACCEPTANCE AA0850129
 - C. ALL WELDS TO BE 100% LPI TESTED. ACCEPTANCE AS PER A0850129.
- 03. TRP AS PER CAT 'd' OF HY 0490563 & PAINTING AS PER APPROVED PAINTING SCHEDULE.
- 04 CARRYOUT KEROSENE LEAK TEST AFTER FABRICATION OF THE CHAMBERS FORMED BY 1) ITEMS 5, 15, 22 & 18 , 2) ITEMS 5, 26 & 28 3) 1,2,21&36 . FILL THESE CHAMBERS WITH KEROSENE ALLOW IT TO STAND FOR 8 HOURS. NO SEEPAGE OR SWEATING IS PERMITTED IN THE AREA UNDER EXAMINATION.
- 05 ALL DIAMETERS TO BE CONCENTRIC WITHIN ± 2 . AXIS OF ITEM NO.4 TO BE WITHIN ± 1 OF GEARBOX VERTICAL AXIS
- 06 REFER DRG. NO.0-61-104-00783 FOR FINISH MACHINING.
- 07 NOTE 01 AND 02 ARE APPLICABLE TO PART DRGS. ALSO.
- 08 DIMENSIONS IN BRACKET IS FOR INFORMATION ONLY.

TABLE. 1

ALL WELD SEAMS CONTINUOUSLY WELDED.
SEE TABLE FOR UNDIMENSIONED FILLET WELDS:

WELDING	PLATE THICKNESS S1														
	2	3	4	5	6	8	10	12	16	20	25	30	35	40	
BOTH SIDES 0.35-S1	2	2.5	2.5	2.5	2.5	3	4	5	6	7	8	10	12	15	18
ONE SIDE 0.70-S1	2	2.5	3	4	5	6	7	8	12	12	14	14	16	20	

ITEM NO.	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG. NO. OR FORGING DRG. NO.	MATERIAL SPECN.	MATERIAL CODE	NET WT.	GROSS WT.	QUANTITY
36	PL20X01245X1245					AA1011819139	192.6	243.3	1
35	RTD STUB-5	4-61-104-02819				AA1011819210	1.13	1.88	1
34	RTD STUB-4	4-61-104-02818				AA1011819210	1.31	1.88	1
33	RTD STUB-3	4-61-104-02830				AA1011819210	1.32	1.88	1
32	PL20X0125					AA1011819139	2.4	2.4	8
31	PL5X50X350					AA1011808013	0.69	0.69	2
30	PL5X50X480					AA1011808013	0.95	0.95	2
29	PIPE SUPPORT	4-61-104-02939				AA1011808013	0.12	0.32	2
28	PL5X35X250					AA1011808013	0.35	0.35	4
27	PL63X140X140					AA1011819236	9.7	9.7	2
26	DOOR FRAME-II	4-61-104-02937				AA1011819171	19	20.9	4
25	DOOR FRAME-I	4-61-104-02936				AA1011819171	5.62	6.86	4
24	PIPE QD168.3X4.5 LG-563	4-61-104-02934				HY1048655806	8.5	10.23	2
23	WELD NECK FLANGE NOM D 150 NP16					HY7244298218	7.75	7.75	2
22	STUB-II	4-61-104-02933				AA1011819287	6.75	11.28	1
21	STUB-I	4-61-104-02932				AA1011819287	23.8	34.3	1
20	WINDOW FRAME BOTTOM	4-61-104-02931				AA1011819236	34.11	60.53	2
19	WINDOW FRAMETOP	4-61-104-02930				AA1011819236	14.78	28.49	1
18	SHELL TOP PLATE	4-61-104-02929				AA1011819139	310.68	336.15	1
17	PLATE-FOOT	4-61-104-02928				AA1011819171	51.45	108.1	1
16	TOP RIM	4-61-104-02927				AA1011819236	298.1	552.44	1
15	SUPPORT FOR THRUST PAD	4-61-104-02926				AA1011819139	168.28	261.86	1
14	SUPPORT FOR BOTTOM BEARING	4-61-104-02925				AA1011819198	238.77	317.64	1
13	RIB-VIII	4-61-104-02924				AA1011819171	12.10	15.96	2
12	RIB-VII	4-61-104-02923				AA1011819171	93.47	141.68	2
11	RIB-VI	4-61-104-02922				AA1011819171	102.97	141.68	6
10	RIB-V	4-61-104-02921				AA1011819171	49.5	55.13	6
09	RIB-IV	4-61-104-02920				AA1011819171	7.56	11.85	7
08	RIB-III	4-61-104-02919				AA1011819171	19.56	22.6	2
07	RIB-II	4-61-104-02918				AA1011819171	17.19	31.06	1
06	RIB-I	4-61-104-02917				AA1011819171	32.8	66.47	7
05	RING-III	4-61-104-03471				AA10119	882.35	1011.2	1
04	RING-II	3-61-104-03239				BA9413150010	4.30	4.31	1
03	RING-I	4-61-104-02914				AA19331	1	1	1
02	SHELL-BOTTOM	4-61-104-02913				AA1011819171	665	752.93	1
01	FOOT OF HOUSING	4-61-104-02912				AA1011819236	1325	1998.03	1

THE FOLLOWING CONDITIONS APPLY REF. TO HY0230261 FOR UNSPECIFIED TOLERANCES.

1. CHAMFER M/C/D. SHARP EDGES 1.2 TO 1.0 AT 45°.

2. INTERNAL M/C/D. CORNER RADI 1 TO 0.7

3. THE SURFACE ROUGHNESS WHERE-EVER NOT SHOWN SHALL BE TAKEN FROM THE SURFACE ROUGHNESS SHOWN OUT SIDE THE BACK SLASH GIVEN OR THE TOP MOST RIGHT CORNER OF THE DRG.

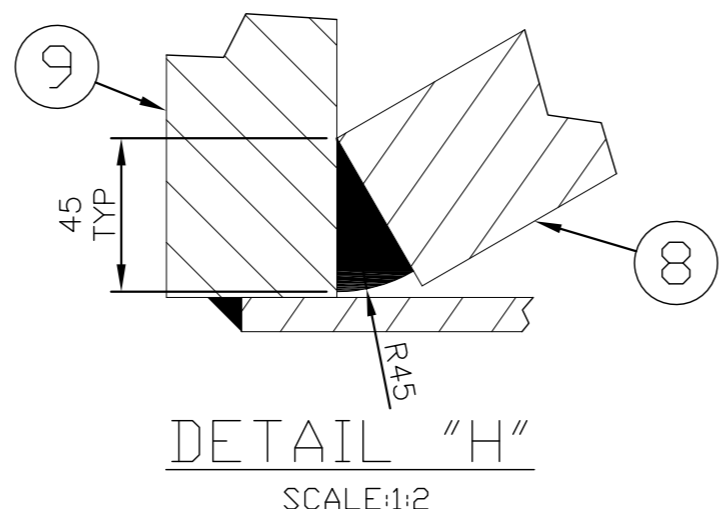
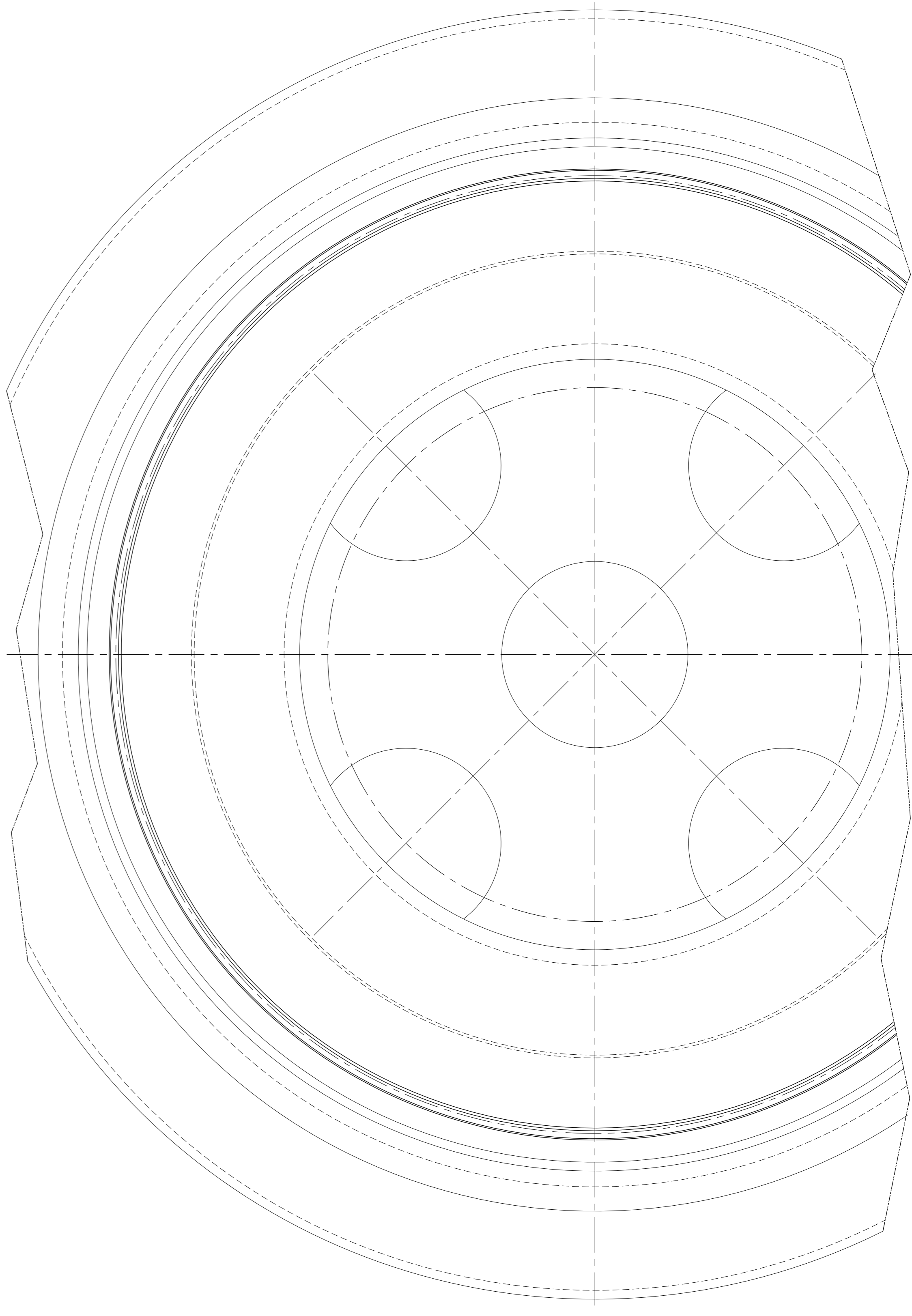
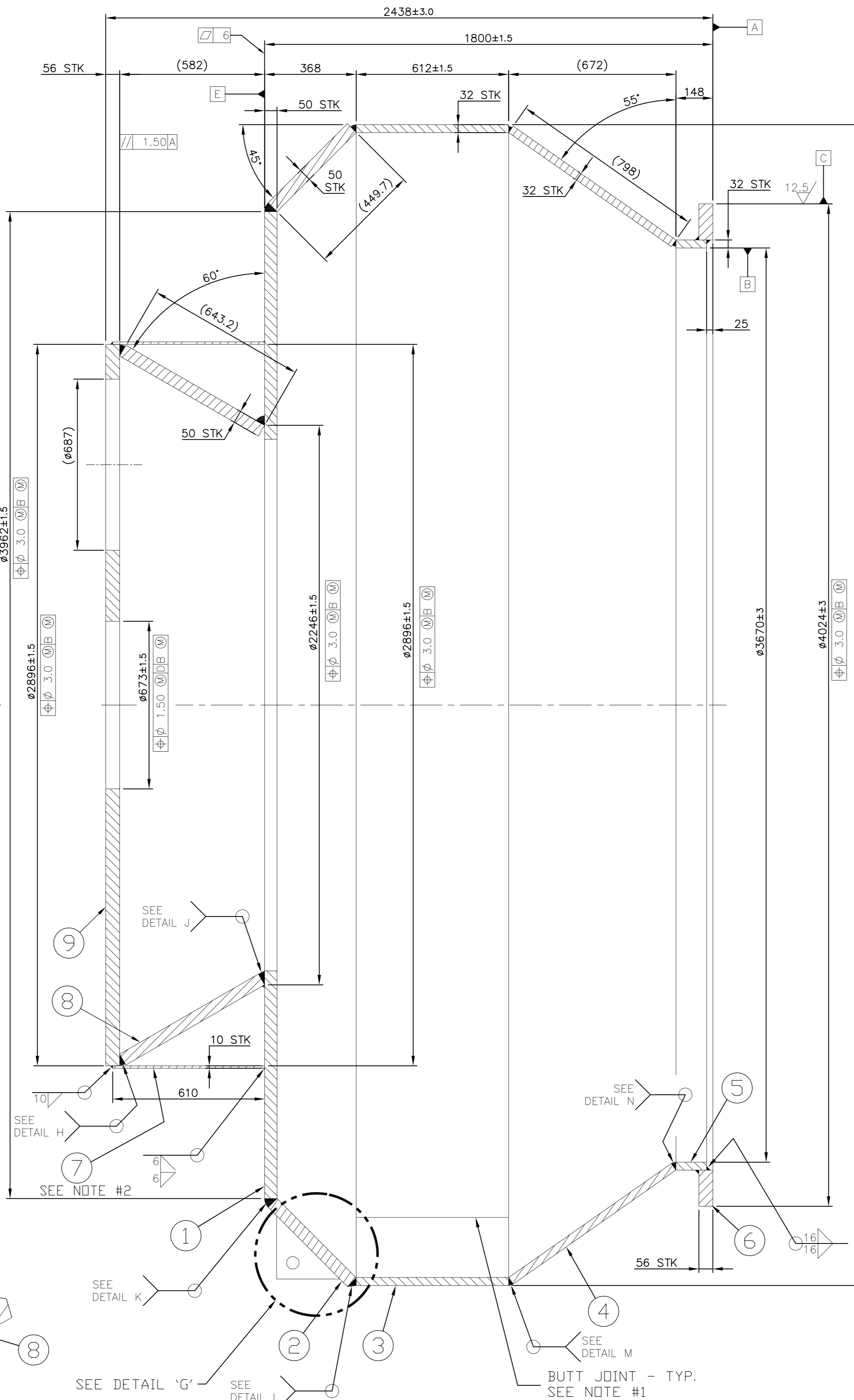
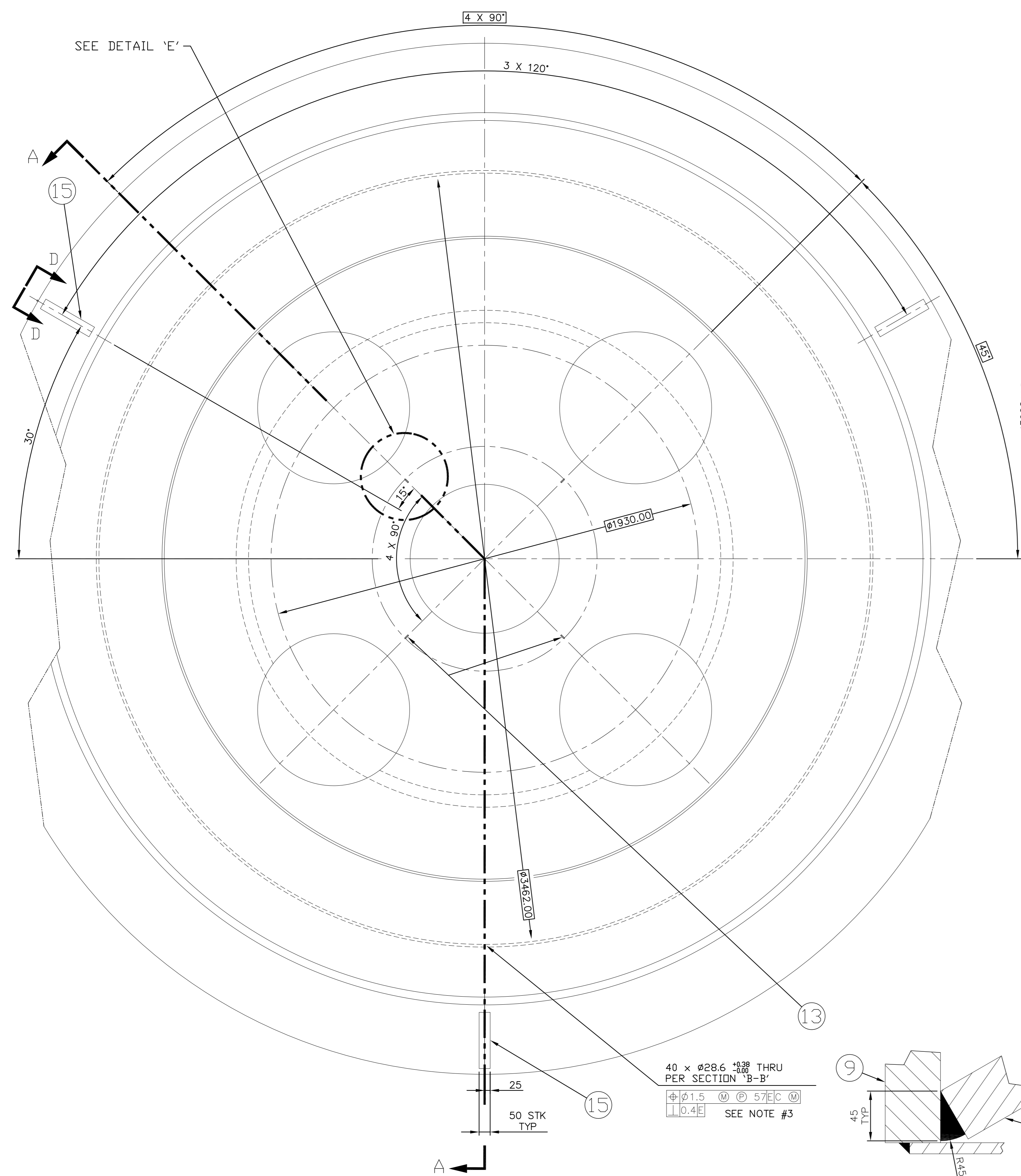
TYPE OF PRODUCT: XRP-1043 BOWL MILL
NAME OF CUSTOMER/PROJECT: BHARAT HEAVY ELECTRICALS LIMITED
HYDERABAD

SCALE: 1:10
WEIGHT (KG): 6389.34

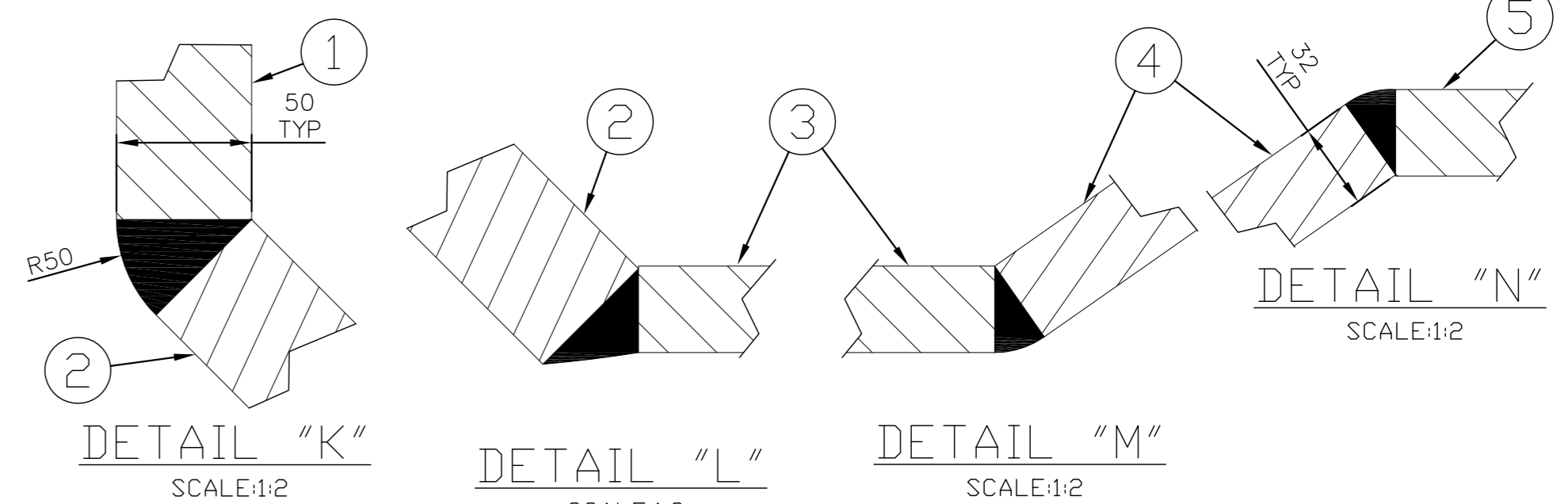
DRAWING NO: 0-61-104-00759
REV: 06

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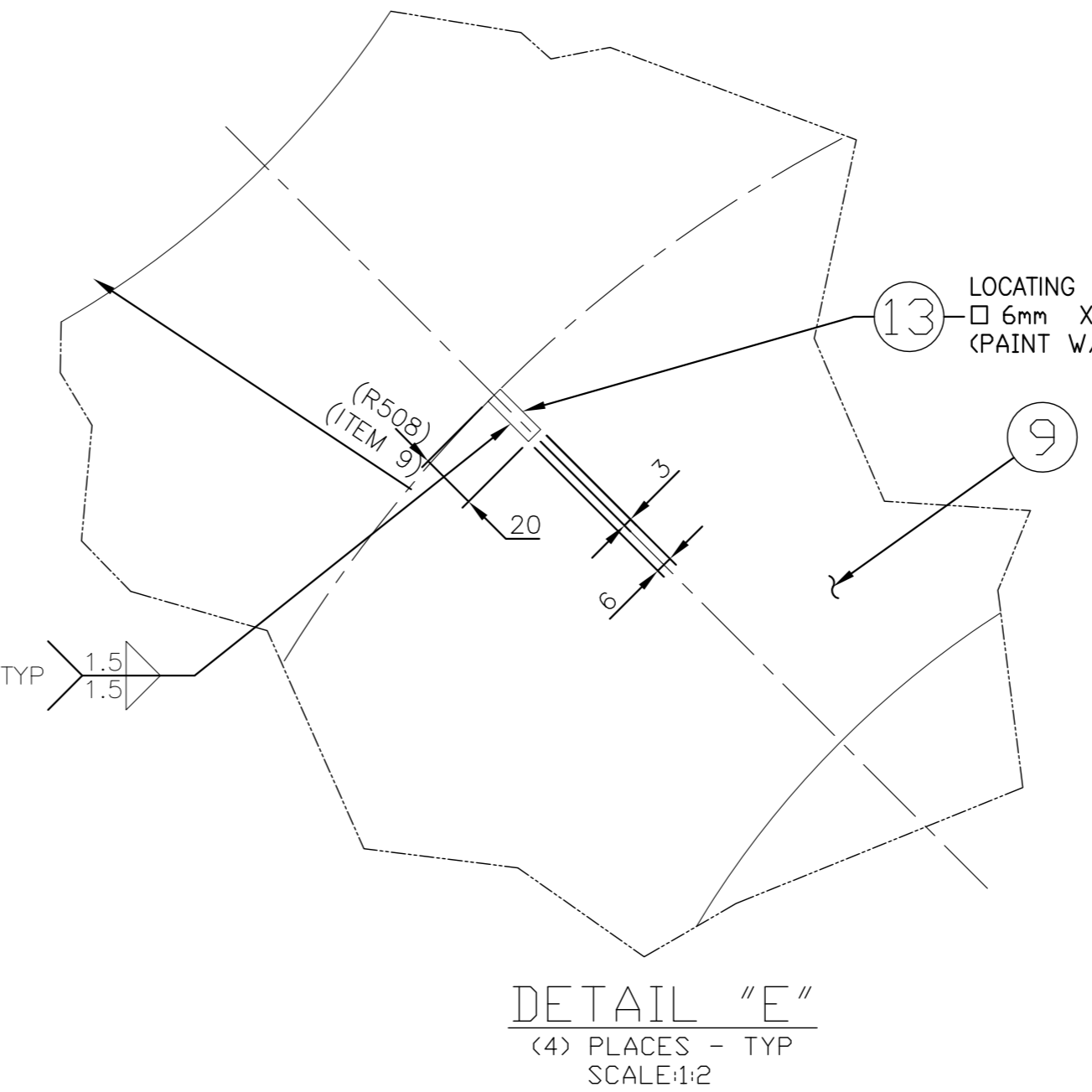
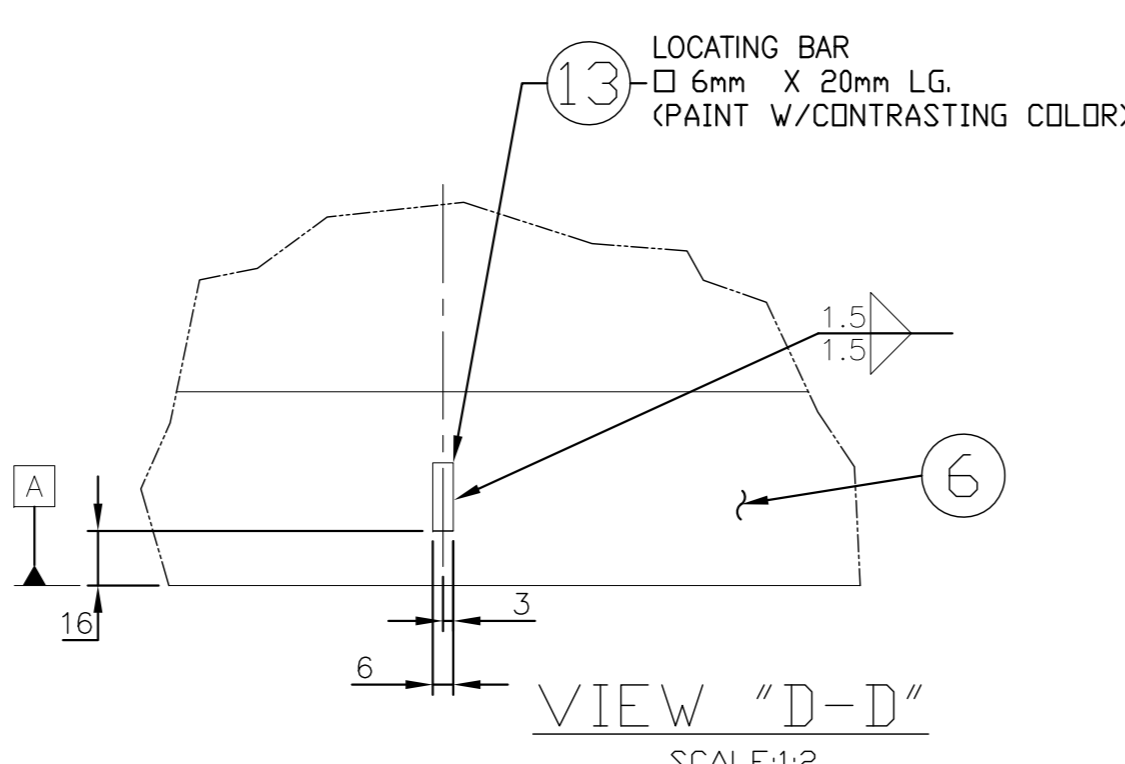
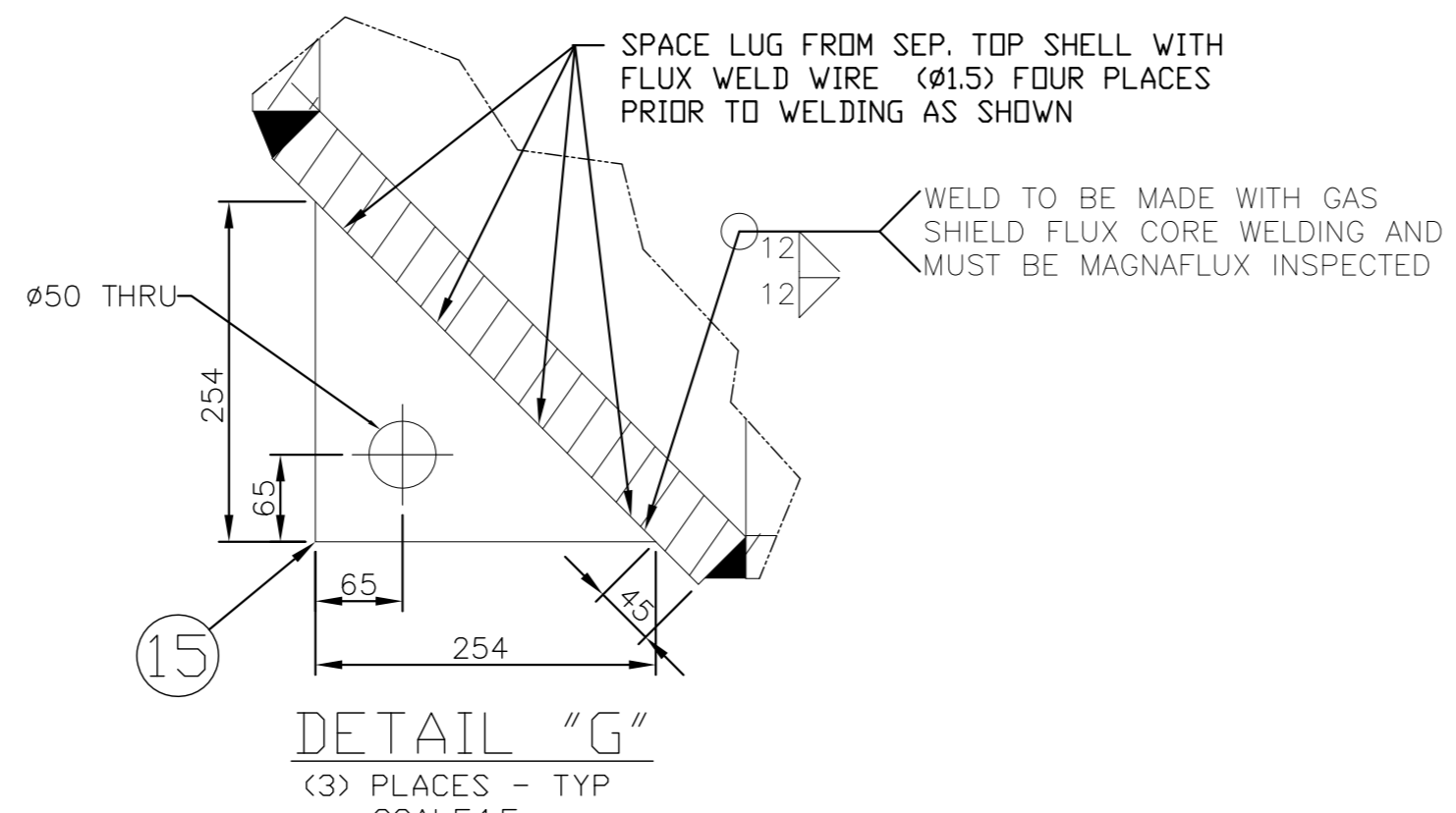
07600-01C-19-0 DN 098



SECTION "A-A"

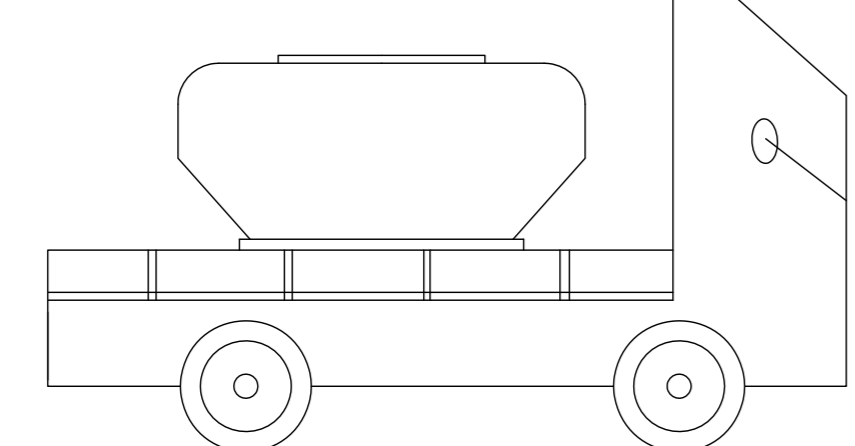


- NOTES:**
- BUTT JOINTS TO BE MADE WITH FULL STRENGTH WELDS. ALL WELDS SHALL BE IN ACCORDANCE WITH WPS NO. WE001.
 - THIS WELD SHALL BE MAGNA FLUX INSPECTED.
 - UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN MM.
 - ALL BUTT WELDS TO BE 10% SPOT RADIOGRAPHED(100% FOR KNOT) ACCEPTANCE AS PER HY0850170.
 - ALL BUTT WELDS TO BE LPI TESTED AFTER BACK CHIPPING AS PER AA0850131, ACCEPTANCE AS PER AA0850129.
 - ALL WELDS TO BE 100% LPI TESTED AS PER AA0850131. ACCEPTANCE AS PER A0850129.
 - TRANSPORT (FABRICATED SEP. TOP) WITH LARGER FLANGE (06) RESTING ON THE TRUCK. (SEE FIG BELOW)
 - HEAT TREATMENT OF THE SEP TOP WITH LARGER FLANGE (06) ON THE FURNACE TROLLEY.



THIRD ANGLE PROJECTION

TOTAL GROSS WT: 23306 KG



THIS DWG. DOES NOT CONTAIN ALL INFORMATION NECESSARY FOR MFG. THIS PART. REFER TO RELEVANT PURCUREMENT SPECIFICATIONS & BILL OF MATERIALS FOR COMPLETE MATERIAL IDENTIFICATION & PROCESSING.

ITEM NO	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG. NO. OR FORGING DRG. NO.	MATERIAL CODE	NET WT.	GROSS WT.

REV	DATE	ALTERED	CHECKED	APPROVED	REV	DATE	ALTERED	CHECKED	APPROVED	REV	DATE	ALTERED	CHECKED	APPROVED	REV	DATE	ALTERED	CHECKED	APPROVED	REV	DATE	ALTERED	CHECKED	APPROVED	
05	07.10.14		SHARIFF	AMAN	S.GHATGE	03	07.09.14	SHARIFF	AMAN	S.GHATGE	02	10.06.14	SHARIFF	AMAN	S.GHATGE	01	09.01.14	SHARIFF	AMAN	S.GHATGE					

NAME	DATE	NO OF
SHARIFF	11.07.13	VAR.
AMAN	11.07.13	
S.GHATGE	11.07.13	

REF.	SCALE	WEIGHT (KG)	REF. TO ASSY DRG.	ITEM NO	NO OF
4460	NTS	16457	0-61-310-00904		

TITLE	DRAWING NO.	REV.
SEPARATOR TOP FABRICATION	0-61-310-00940	05

SHEET NO	NO OF SHEETS
	16