

69200-101-19-0

FIRST ANGLE PROJECTION

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  
(ZONE: H1, H5)

SECTION C-C  
(ZONE: E6, J9)

SECTION B-B  
(ZONE: C1, C4)

SECTION K-K  
(ZONE: H4, H5)

SECTION G-G  
(ZONE: F7, I7)

SECTION H-H  
(ZONE: F2, I2)

VIEW - H1  
(ZONE: B14)

VIEW-Q  
(ZONE: B10)

DETAIL-W

DETAIL-U

DETAIL-V

DETAIL-X

DETAIL-Y

WELDING DETAIL

SECTION M-M  
(ZONE: B6, B9)

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

02. UNLESS OTHERWISE SPECIFIED IN THE QUALITY PLAN -

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

BOTH SIDES 0.35-S1

ONE SIDE 0.70-S1

PLATE THICKNESS S1

FILLET WELD THICKNESS A

NOTES:

01. ITEM NO. 27 WAS 620405042

02. SECTION C-C SHOWN.

03. VIEW FOR ITEM 27 UPDATED

04. ITEM NO. 32 QUANTITY IS NET WAS GIVEN.

05. NET WEIGHT WAS 8608

06. NET WEIGHT WAS 6208934

07. ITEM NO. 32 WAS PL. 25 X #25

08. 20% 30% DELETED FROM VIEW-H.

09. ANGLE 25° AND 27.5° WERE 2° AND 20°.

10. 20% WAS 270

11. ITEM-25 NET WT WAS 537, GROSS WT WAS 638

12. ITEM-26 NET WT WAS 169, GROSS WT WAS 195

13. ITEM-27 NET WT WAS 180, GROSS WT WAS 198

14. ITEM-28 NET WT WAS 316, GROSS WT WAS 315

15. ITEM-29 NET WT WAS 100, GROSS WT WAS 137

16. ITEM-30 NET WT WAS 3016, GROSS WT WAS 3687

17. ITEM-31 NET WT WAS 3365, GROSS WT WAS 3635

18. ITEM-24 GROSS WT WAS 181

19. ITEM-25 NET WT WAS 1205, GROSS WT WAS 1380

20. ITEM-26 NET WT WAS 87, GROSS WT WAS 100

21. ITEM-27 NET WT WAS 33, GROSS WT WAS 64

22. ITEM-28 NET WT WAS 81, GROSS WT WAS 95

23. ITEM-29 NET WT WAS 31, GROSS WT WAS 44

24. ITEM-30 NET WT WAS 20, GROSS WT WAS 35

25. ITEM-31 NET WT WAS 100, GROSS WT WAS 137

26. ITEM-24 GROSS WT WAS 181

27. ITEM-25 NET WT WAS 1205, GROSS WT WAS 1380

28. ITEM-26 NET WT WAS 87, GROSS WT WAS 100

29. ITEM-27 NET WT WAS 33, GROSS WT WAS 64

30. ITEM-28 NET WT WAS 81, GROSS WT WAS 95

31. ITEM-29 NET WT WAS 31, GROSS WT WAS 44

32. ITEM-30 NET WT WAS 20, GROSS WT WAS 35

33. ITEM-31 NET WT WAS 100, GROSS WT WAS 137

34. ITEM-24 GROSS WT WAS 181

35. ITEM-25 NET WT WAS 1205, GROSS WT WAS 1380

36. ITEM-26 NET WT WAS 87, GROSS WT WAS 100

37. ITEM-27 NET WT WAS 33, GROSS WT WAS 64

38. ITEM-28 NET WT WAS 81, GROSS WT WAS 95

39. ITEM-29 NET WT WAS 31, GROSS WT WAS 44

40. ITEM-30 NET WT WAS 20, GROSS WT WAS 35

41. ITEM-31 NET WT WAS 100, GROSS WT WAS 137

42. ITEM-24 GROSS WT WAS 181

43. ITEM-25 NET WT WAS 1205, GROSS WT WAS 1380

44. ITEM-26 NET WT WAS 87, GROSS WT WAS 100

45. ITEM-27 NET WT WAS 33, GROSS WT WAS 64

46. ITEM-28 NET WT WAS 81, GROSS WT WAS 95

47. ITEM-29 NET WT WAS 31, GROSS WT WAS 44

48. ITEM-30 NET WT WAS 20, GROSS WT WAS 35

49. ITEM-31 NET WT WAS 100, GROSS WT WAS 137

50. ITEM-24 GROSS WT WAS 181

51. ITEM-25 NET WT WAS 1205, GROSS WT WAS 1380

52. ITEM-26 NET WT WAS 87, GROSS WT WAS 100

53. ITEM-27 NET WT WAS 33, GROSS WT WAS 64

54. ITEM-28 NET WT WAS 81, GROSS WT WAS 95

55. ITEM-29 NET WT WAS 31, GROSS WT WAS 44

56. ITEM-30 NET WT WAS 20, GROSS WT WAS 35

57. ITEM-31 NET WT WAS 100, GROSS WT WAS 137

58. ITEM-24 GROSS WT WAS 181

59. ITEM-25 NET WT WAS 1205, GROSS WT WAS 1380

60. ITEM-26 NET WT WAS 87, GROSS WT WAS 100

61. ITEM-27 NET WT WAS 33, GROSS WT WAS 64

62. ITEM-28 NET WT WAS 81, GROSS WT WAS 95

63. ITEM-29 NET WT WAS 31, GROSS WT WAS 44

64. ITEM-30 NET WT WAS 20, GROSS WT WAS 35

65. ITEM-31 NET WT WAS 100, GROSS WT WAS 137

66. ITEM-24 GROSS WT WAS 181

67. ITEM-25 NET WT WAS 1205, GROSS WT WAS 1380

68. ITEM-26 NET WT WAS 87, GROSS WT WAS 100

69. ITEM-27 NET WT WAS 33, GROSS WT WAS 64

70. ITEM-28 NET WT WAS 81, GROSS WT WAS 95

71. ITEM-29 NET WT WAS 31, GROSS WT WAS 44

72. ITEM-30 NET WT WAS 20, GROSS WT WAS 35

73. ITEM-31 NET WT WAS 100, GROSS WT WAS 137

74. ITEM-24 GROSS WT WAS 181

75. ITEM-25 NET WT WAS 1205, GROSS WT WAS 1380

76. ITEM-26 NET WT WAS 87, GROSS WT WAS 100

77. ITEM-27 NET WT WAS 33, GROSS WT WAS 64

78. ITEM-28 NET WT WAS 81, GROSS WT WAS 95

79. ITEM-29 NET WT WAS 31, GROSS WT WAS 44

80. ITEM-30 NET WT WAS 20, GROSS WT WAS 35

81. ITEM-31 NET WT WAS 100, GROSS WT WAS 137

82. ITEM-24 GROSS WT WAS 181

83. ITEM-25 NET WT WAS 1205, GROSS WT WAS 1380

84. ITEM-26 NET WT WAS 87, GROSS WT WAS 100

85. ITEM-27 NET WT WAS 33, GROSS WT WAS 64

86. ITEM-28 NET WT WAS 81, GROSS WT WAS 95

87. ITEM-29 NET WT WAS 31, GROSS WT WAS 44

88. ITEM-30 NET WT WAS 20, GROSS WT WAS 35

89. ITEM-31 NET WT WAS 100, GROSS WT WAS 137

90. ITEM-24 GROSS WT WAS 181

91. ITEM-25 NET WT WAS 1205, GROSS WT WAS 1380

92. ITEM-26 NET WT WAS 87, GROSS WT WAS 100

93. ITEM-27 NET WT WAS 33, GROSS WT WAS 64

94. ITEM-28 NET WT WAS 81, GROSS WT WAS 95

95. ITEM-29 NET WT WAS 31, GROSS WT WAS 44

96. ITEM-30 NET WT WAS 20, GROSS WT WAS 35

97. ITEM-31 NET WT WAS 100, GROSS WT WAS 137

98. ITEM-24 GROSS WT WAS 181

99. ITEM-25 NET WT WAS 1205, GROSS WT WAS 1380

100. ITEM-26 NET WT WAS 87, GROSS WT WAS 100

101. ITEM-27 NET WT WAS 33, GROSS WT WAS 64

102. ITEM-28 NET WT WAS 81, GROSS WT WAS 95

103. ITEM-29 NET WT WAS 31, GROSS WT WAS 44

104. ITEM-30 NET WT WAS 20, GROSS WT WAS 35

105. ITEM-31 NET WT WAS 100, GROSS WT WAS 137

106. ITEM-24 GROSS WT WAS 181

107. ITEM-25 NET WT WAS 1205, GROSS WT WAS 1380

108. ITEM-26 NET WT WAS 87, GROSS WT WAS 100

109. ITEM-27 NET WT WAS 33, GROSS WT WAS 64

110. ITEM-28 NET WT WAS 81, GROSS WT WAS 95

111. ITEM-29 NET WT WAS 31, GROSS WT WAS 44

112. ITEM-30 NET WT WAS 20, GROSS WT WAS 35

113. ITEM-31 NET WT WAS 100, GROSS WT WAS 137

114. ITEM-24 GROSS WT WAS 181

115. ITEM-25 NET WT WAS 1205, GROSS WT WAS 1380

116. ITEM-26 NET WT WAS 87, GROSS WT WAS 100

117. ITEM-27 NET WT WAS 33, GROSS WT WAS 64

118. ITEM-28 NET WT WAS 81, GROSS WT WAS 95

119. ITEM-29 NET WT WAS 31, GROSS WT WAS 44

120. ITEM-30 NET WT WAS 20, GROSS WT WAS 35

121. ITEM-31 NET WT WAS 100, GROSS WT WAS 137

122. ITEM-24 GROSS WT WAS 181

123. ITEM-25 NET WT WAS 1205, GROSS WT WAS 1380

124. ITEM-26 NET WT WAS 87, GROSS WT WAS 100

125. ITEM-27 NET WT WAS 33, GROSS WT WAS 64

126. ITEM-28 NET WT WAS 81, GROSS WT WAS 95

127. ITEM-2