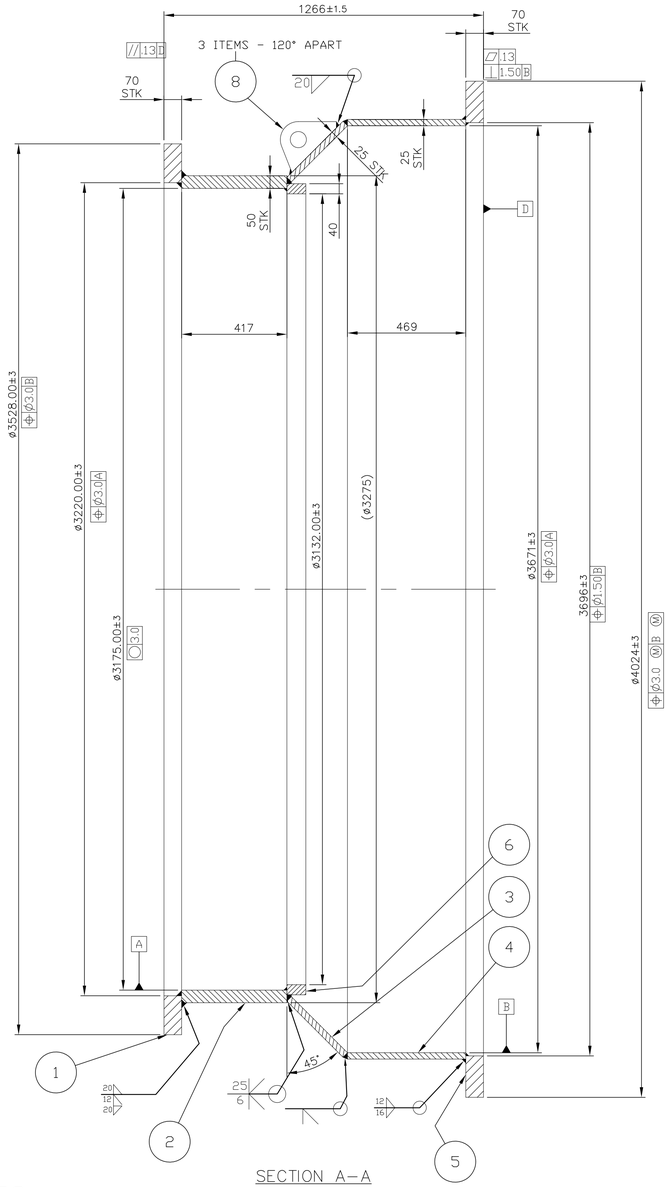
FIRST ANGLE PROJECTION

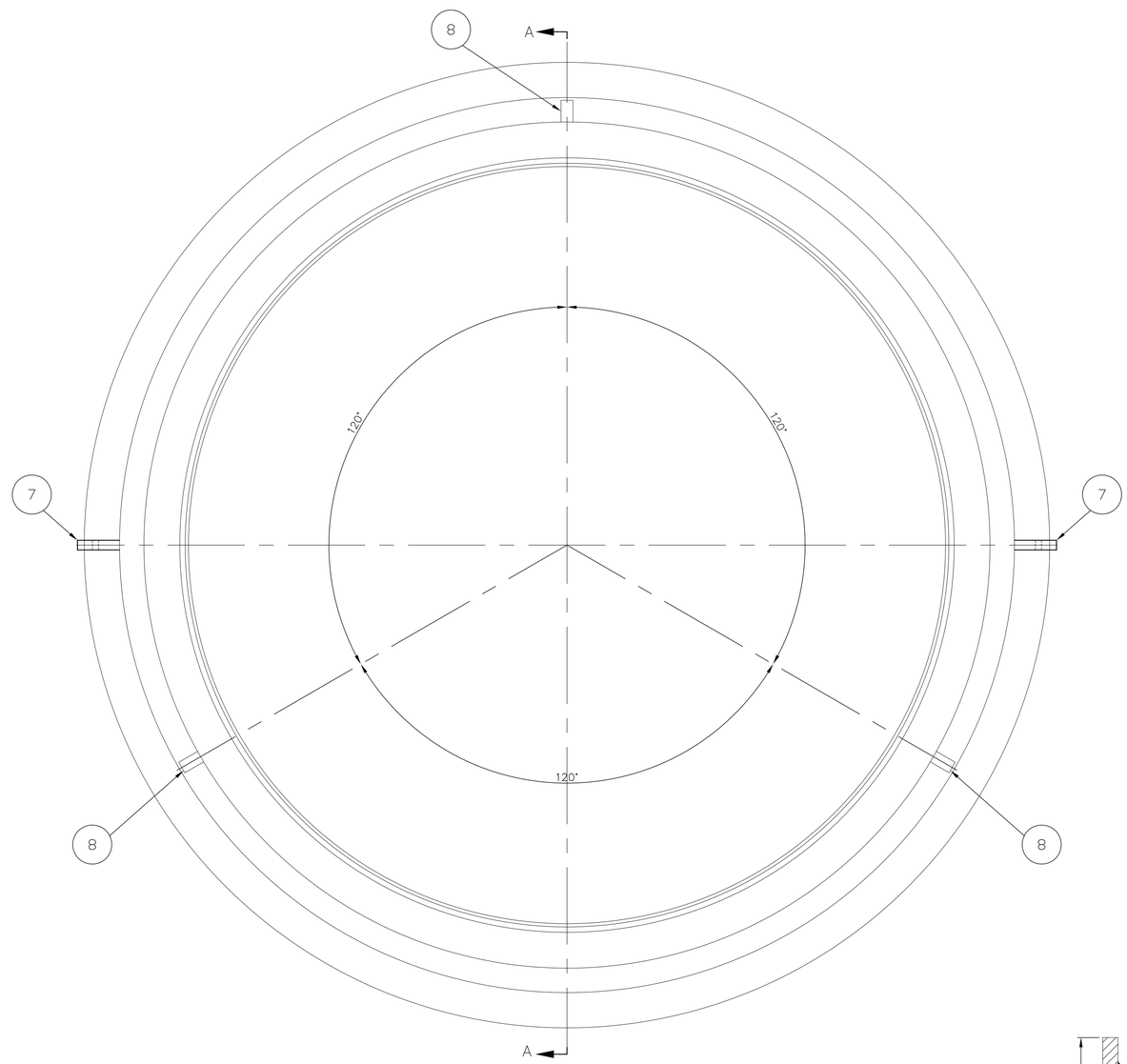
(ALL DIMENSIONS ARE IN mm)

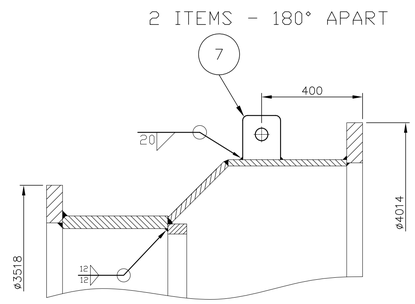
DRG. NO. 1-61-310-01846

W.P.S NO. WE 001



SECTION A-A





SECTION:C-C

NOTES:

1. ALL BUTT WELDS TO BE OF FULL PENETRATION.
2. ALL WELDS SHALL BE IN ACCORDANCE WITH WPS NO. WE001.
3. THIS WELD SHALL BE MAGNA FLUX INSPECTED.
4. UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN MM.
5. ALL BUTT WELDS TO BE 10% SPOT RADIOGRAPHED (100% FOR KNOT) ACCEPTANCE AS PER HY0850170.
6. ALL BUTT WELDS TO BE LPI TESTED AFTER BACK CHIPPING AS PER AA0850131, ACCEPTANCE AS PER AA0850129.
7. ALL WELDS TO BE 100% LPI TESTED AS PER AA0850131. ACCEPTANCE AS PER AA0850129.
8. TRANSPORT (FABRICATED SEP. TOP) WITH LARGER FLANGE (05) RESTING ON THE TRUCK. (SEE FIG BELOW)
9. HEAT TREATMENT OF THE SEP TOP WITH LARGER FLANGE (05) ON THE FURNACE TROLLEY.

ITEM NO.	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG. NO. OR FORGING DRG. NO.	MATERIAL CODE	NET WT.	GROSS WT.
1	SEPARATOR TOP-FAB ITEMS (DYNAMIC CLASSIFIER)	0-61-310-00891			MATERIAL SPECN.	QUANTITY	
						1	
						5686.84	7036.24

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED.

1. REF. TO HY0230261 FOR UNSPECIFIED TOLERANCES.
2. CHAMFER M/CD. SHARP EDGES AT 45°.
3. INTERNAL M/CD. CORNER RADII 1 TO 0.7
4. 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

NAME OF CUSTOMER/PROJECT HP-1103 BOWL MILL

BHARAT HEAVY ELECTRICALS LIMITED HYDERABAD

	NAME	SIGN	DATE	NO.OF VAR.
DRN.	ASHOK REDDY		10.10.12	
CHD.	AMAN		10.10.12	
APPD.	S.GHATGE		10.10.12	

RELEASED

DEPT.	UNTOL. DIMS. GR.	SCALE	WEIGHT (KG)	REF. TO ASSY DRG.	ITEM NO.	NO.OF ITEMS
446	¢/M/F	NTS	5686.84			
CODE PULV.						

TITLE

SEPERATOR TOP (FAB) FOR DYNAMIC CLASSIFIER

CARD CODE

DRAWING NO. 1-61-310-01846 REV. 04

SHEET NO. 01 NO OF SHEETS 01

REV.	DATE	ALTERED SHARIFF	ZONE
04	11.11.17	CHD./APPD. AMAN / S.GHATGE	1. ITEM-01 OD WAS ø3518. 2. ITEM-05 OD WAS ø4014. 3. TOLERANCE ±3.0 ADDED ON ITEM-06 ID ø3132. 4. WELDING ON ITEM-06 CHANGED FROM FILLET SIZE 6 TO 12. 5. NET & GROSS WTS MODIFIED ACCORDINGLY.
03	31.07.16	CHD./APPD. AMAN / S.GHATGE	1. ITEM 06 THICKNESS WAS 32. 2. DIM ø3132 WAS ø3148
02	06.04.15	CHD./APPD. AMAN / S.GHATGE	1. PLATE THICKNESS OF ITEMS-01, 05, 07 & 08 WAS 63 2. RAW MATL. SIZES OF ALL ITEMS RECALCULATED AS PER DWG 3. WTS MODIFIED ACCORDINGLY
01	09.04.12	CHD./APPD. AMAN / S.GHATGE	1. TIMING BAR (ITEM-07-4-61-320-02421) REMOVED. 2. LUGS (ITEM-07 & 08) ADDED. 3. SECTIONC-C ADDED. 4. SECTIONA-A & TOP VIEW MODIFIED. 5. NOTES ADDED. 6. NET & GROSS WTS MODIFIED ACCORDINGLY.

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IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETERMENTAL TO THE INTEREST OF THE COMPANY

INVENTORY NO | SIGN. AND DATE | REF. DRG. NO. | COMPUTER FILE NAME