



TECHNICAL REQUIREMENTS

1. ALL WELDS ARE OF GR. III TO A0622101 & 15MM FILLET UNLESS OTHERWISE SPECIFIED
2. APPLY TRP ON MACHINED SURFACES TO BOP 06090084.
3. ASSY- TO BE STRESS RELIEVED TO 0640299 BEFORE MACHINING.
4. ALL WELDS TO BE CRACK TESTED BY DTP TO BOP 0801909 FOR THE FULL LENGTH OF WELD SEAM BEFORE & AFTER STRESS RELIEVING.
5. ALL OIL TIGHT WELDS TO BE D.P. TESTED AFTER FIRST RING RUN AND ALSO AFTER SECOND RING WELDING.
6. COOLER FLANGING FLANGE ITEM-5, 20, 21 & 22 TO BE WELDED TO HOUSING AFTER BRACKET HAS BEEN STRESS RELIEVED.
7. DIMENSIONS MARKED THUS * ARE FOR D.O. REFERENCE ONLY.
8. REFER DRAWING 1 263 53 05705 FOR GRAVITY TESTING.
9. SURFACES OF ASSY. ARE TO BE PREPARED PRIOR TO PAINTING TO A06474101.
10. AFTER PREPARATION APPLY 2 COAT OF ANTI CORROSIVE PRIMUM PAINT TO A056101 AND 2 COAT OF HIGH QUALITY FULL GLOSSY OUD DRY FINISHING PAINT TO A056126 COLOUR LIGHT GREY TO SHADE NO. ISC- 631 OF IS: 5.
11. WELDS TO BE COURED BY TRP BHPART 4 FOR 54 HRS. AFTER PAINTED AND THESE WELDS SHOULD BE PROTECTED WITH TRP BHAPART 4 FOR 54 HRS TO 55188. THESE WELDS TO BE PAINTED AFTER GRAVITY TEST TO BOP 0805095 IS OVER.
12. ALL TAPPED HOLES AND M/C SURFACES TO BE PROTECTED DURING STRESS RELIEVING.
13. PRE-MACHINED FACES OF GUIDE BEARING SUPPORT RING ITEM-13 TO BE LEVELLED WITH MAX LEVEL AND MAX WELD REFINISH BEFORE FINAL FINISHING WITH RESPECT TO DOWNSTREAM.
14. WATER REQUIRED FOR GRAVITY TEST = 8000 LITRES (APPROX.)
15. TEST THE MATERIAL/ASSEMBLY AS PER CUSTOMER APPROVED QA PLAN.
16. THE GRAVITY TEST IS TO BE KEPT PARALLEL TO THE BRACKET AXIS DURING WELDING (VERTICALLY WITHIN 2 MM).

001			025	SUPPORT ASSY. FOR BRUSH GEAR CASING	2 256 10 05704	00		AA1011808110	NA	NA	257.72												
016			024	RIB 16TK-X40X110L.G. S.S.Q. PLATE				AA10108	NA	NA	0.55												
001			023	SIDE PLATE (WITH COOLER FLANGE AND OIL LEVEL DETECTOR)	1 256 01 05702	009			NA	NA	304.68	G											
001			022	FLANGE 25NB	3 299 88 01008	001			NA	NA	2.02												
001			021	FLANGE 40NB	3 299 88 01008	003			NA	NA	4.33												
002			020	FLANGE 50NB	3 299 88 01008	004			NA	NA	4.97												
016			019	STIFFENER	1 256 01 05702	008			NA	NA	10.70												
008			018	STIFFENER	1 256 01 05702	005			NA	NA	104.73												
004			017	SIDE PLATE (WITHOUT COOLER FLANGE)	1 256 01 05702	010			NA	NA	425.46	H											
008			016	STIFFENER	1 256 01 05702	007			NA	NA	31.09												
001			015	SUPPORT RING FLANGE	1 256 01 05701	003			NA	NA	263.77												
001			014	CYLINDER	1 256 01 05701	004			NA	NA	348.93												
001			013	GUIDE BEARING SUPPORT RING	2 256 01 05701	001			NA	NA	592												
008			012	RIB	3 256 01 05707	00			NA	NA	318.05												
016			011	STIFFENER	1 256 01 05702	003			NA	NA	10.51	J											
001			010	CYLINDER	1 256 01 05701	007			NA	NA	346.10												
001			009	SPRING PLATE	1 256 01 05702	001			NA	NA	655.22												
008			008	STIFFENER	1 256 01 05702	004			NA	NA	73.83												
001			007	CYLINDER	1 256 01 05701	006			NA	NA	393.97												
001			006	BOTTOM PLATE	1 256 01 05701	005			NA	NA	2499.50	K											
004			005	COOLER SUPPORT PLATE	1 256 01 05702	006			NA	NA	44.42												
003			004	SIDE PLATE (WITH COOLER FLANGE)	1 256 01 05702	011			NA	NA	305.07												
008			003	JOINT PLATE 80TK-X600X1580L.G. S.S.Q. PLATE				AA1011808289	NA	NA	595.34												
001			002	TOP PLATE	1 256 01 05701	002		AA10108	NA	NA	2364.86												
001			001	INTERMEDIATE PLATE	1 256 01 05701	001			NA	NA	4906												
58	VARDO	64	REMARKS	75	76 79	25	27	29	DESCRIPTION	35	59	60	DRAWING NO.	77	79	31	34	MATL. CODE	43	UNIT	58	QTY.	ZONE
58	VARDO	64	REMARKS	75	76 79	25	27	29	DESCRIPTION	35	59	60	DRAWING NO.	77	79	31	34	MATL. CODE	43	UNIT	58	QTY.	ZONE

[illegible]

GES