



THIS IS DRAWING IS TO BE READ ALONG WITH BUCKSTAY STANDARD
DRAWING NOS 0-08-000-06096 & 0-08-000-06097

- NOTES:-**
- 01. ALL RADII FOR CUTTING 12 M.M UNLESS NOTED
 - 02. THE LOCATION OF DRAIN HOLES MAY BE SHIFTED BY 100 M.M TO AVOID INTERFERENCE WITH LEVELER GUIDE PLATES , IF NECESSARY
 - 03. BOTTOM RETAINER ANGLE TO CONTACT EDGE OF BUCKSTAY FLANGE
 - 04. C.L OF W.W, C.L OF BOILER / FURNACE TO BE CLEARLY MARKED ON BEAM & TIE PLATE, BY SUITABLE COLOUR PAINT, FOR EASY IDENTIFICATION AT SITE.
 - 05. No. OFF TO BE MANUFACTURED
 - FFR-71 -1 No.
 - 06. FOR PRODUCTION NOTE REF. DRAWING NO. 4-08-000-02909 & 4-08-000-04056
 - 07. MATERIAL SUBSTITUTION OF SA 387 GR.12 CL.2 ACCEPTED IN PLACE OF SA387 GR.12 CL.2
 - 08. FABRICATOR TO AVOID OPTIONAL JOINT AT THE STIFFENER PLATE LOCATION
 - 09. SUITABLE ELECTRODE LIKE E8018B2 TO BE USED AS PER APPLICABLE PREHEAT AND PWHT.
 - 10. REFER ELECTRODE SELECTION TABLE FOR VARIOUS COMBINATION OF MATERIALS
 - 11. STIRRUP TO MOVE FREELY ALONG FLANGE OF BUCKSTAY BEAM FOR 150 MM ON EITHER SIDE OF DETAILED STIRRUP LOCATION PRIOR TO WELDING STIRRUP TO THE PLATE
 - 12. STRAIGHTEN BUCKSTAY TO 10 MM MAX. SWEEP AND TO 12 MM MAX. CAMBER
 - 13. FOR BUCKSTAY TRANSPORTATION AND STORAGE AT SITE REFER DRAWING NO. 1-08-000-00318

NOTES:-
FOR ASSEMBLY DRAWING REFER PRINCIPAL DRAWING NO. 0-08-001-06141

14	PLATE-12 240.0x780.0	P-2	15011120000	No	17.860	
13	PLATE-12 278.0x380.0	PLT-12	150062250A	No	9.951	
12	PLATE-12 280.0x380.0	PLT-11	15042200000	No	10.381	
11	PLATE-10 24.0x25.0	PLT-10	15011080000	No	0.047	
10	PLATE-25 50.0x75.0	PLT-4	15011081000	No	0.736	
9	PLATE-4 150.0x284.0	PLT-3	15011082000	No	1.445	
8	PLATE-18 140.0x140.0	PLT-2	15011083000	No	2.769	
7	PLATE-4 50.0x120.0	P-1	15042270000	No	0.390	
6	PLATE-20 250.0x1508.0	M-10	15013171000	No	1.700	
5	PLATE-20 250.0x1508.0	M-9	15013171000	No	1.500	
4	PLATE-20 250.0x1508.0	M-6	15042200000	No	856.748	
3	PLATE-10 250.0x2228	M-3aWEB	15011080000	No	1448.265	
2	PLATE-25 300.0x1750	M-3aTFL	15011081000	No	1280.649	
1	PLATE-25 300.0x2228	M-3aBFL	15011081000	No	1308.674	

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		Bharat Heavy Electricals Ltd UNIT: HIGH PRESSURE BOILER PLANT TIRUCHIRAPALLI - 620014		DATE 20/02/2018
REPT ST	PROJECTION 1ST ANGLE	SCALE NTS	WEIGHT (KG) 5177.002	DATE 20/02/2018
CODE 122	TITLE FFR-71	DRAWING NO. 0-08-001-06133	REV 04	

REV 04	DATE 16.07.2018	ALTERED CHD & APPD : DHANUJI	REV 03	DATE 20.08.2016	ALTERED CHD & APPD : DHANUJI	REV 02	DATE 16.07.2018	ALTERED CHD & APPD : DHANUJI	REV 01	DATE 12.06.2018	ALTERED CHD & APPD : DHANUJI
ZONE	FITTINGS ADDED		ZONE	NOTES ADDED		ZONE	ITEM NO. 5 & 6 MATERIAL CHANGED TOTAL WEIGHT CHANGED		ZONE	CHANGES DONE AS PER INDICATED	