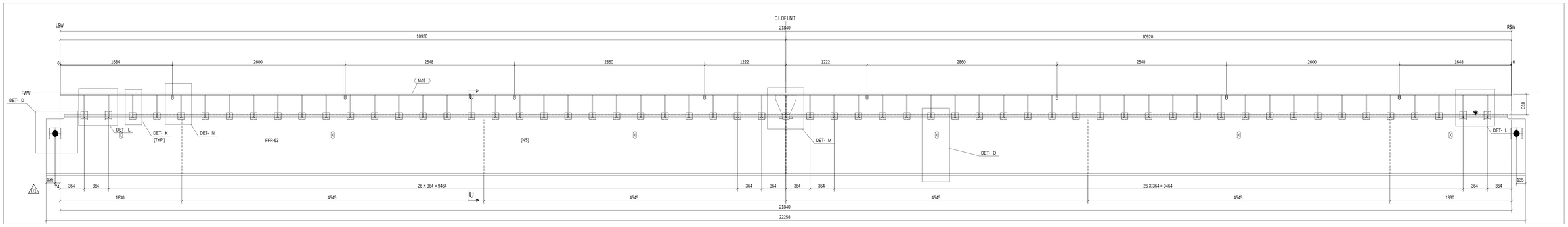
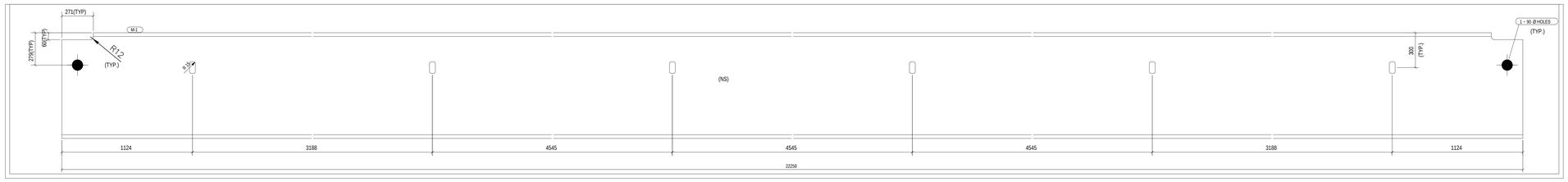
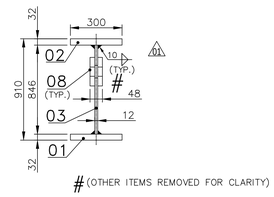
CORPORATE DRG ID:TP-DG-0-08-001-06130/04

DRAWING NO: 0-08-001-06130

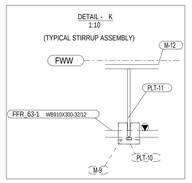
FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER PLANT STD. NO TP-322-0299

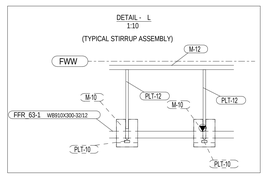


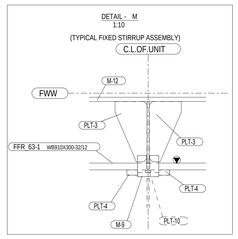


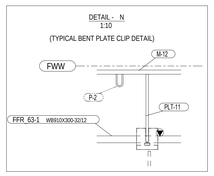


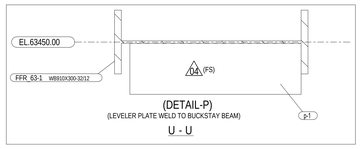
(OTHER ITEMS REMOVED FOR CLARITY)



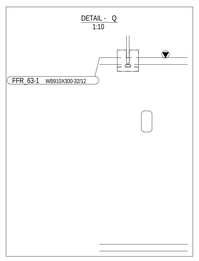








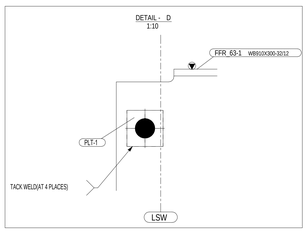
(DETAIL-P)
(LEVELER PLATE WELD TO BUCKSTAY BEAM)
U - U

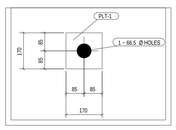


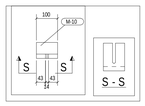
THIS IS DRAWING IS TO BE READ ALONG WITH BUCKSTAY STANDARD DRAWING NOS 0-08-000-06096 & 0-08-000-06097

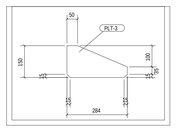
NOTES:-

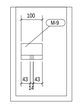
01. ALL RADII FOR CUTTING 12 M.M UNLESS NOTED
02. THE LOCATION OF DRAIN HOLES MAY BE SHIFTED BY 100 M.M TO AVOID INTERFERENCE WITH LEVELER GUIDE PLATES , IF NECESSARY
03. BOTTOM RETAINER ANGLE TO CONTACT EDGE OF BUCKSTAY FLANGE
04. C.L OF W.W, C.L OF BOILER / FURNACE TO BE CLEARLY MARKED ON BEAM & TIE PLATE, BY SUITABLE COLOUR PAINT, FOR EASY IDENTIFICATION AT SITE.
05. No. OFF TO BE MANUFACTURED FFR-63 -1 No.
06. FOR PRODUCTION NOTE REF. DRAWING NO. 4-08-000-02900 & 4-08-000-04056
07. MATERIAL SUBSTITUTION OF SA 387 GR.22 CL2 ACCEPTED IN PLACE OF SA387 GR.12 CL2
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, AS PER APPLICABLE Q.C.P
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 TIE 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:-

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

ITEM NUMBER	DESCRIPTION	STD	DRAWING NUMBER		ITEM NO / MATERIAL CODE	ADDT	UNIT WEIGHT	QTY	ZONE
					VAR NO / MATERIAL SPECN	DI	QUANTITY		
14	PLATE-12 240.0x906.0		p-1		150111320000 IS2062E250A	No	18.222 5		
13	PLATE-12 278.0x380.0		PLT-12		15942800000 SA387GR12CL2	No	9.951 4		
12	PLATE-12 290.0x380.0		PLT-11		15942800000 SA387GR12CL2	No	10.381 55		
11	PLATE-10 24.0x25.0		PLT-10		15111980000 IS2062E250A	No	0.047 518		
10	PLATE-25 50.0x75.0		PLT-4		15011081000 IS2062E250B	No	0.736 4		
9	PLATE-6 150.0x284.0		PLT-3		15942270000 SA387GR12CL2	No	1.445 2		
8	PLATE-18 170.0x170.0		PLT-1		15011033000 IS2062E250A	No	4.084 4		
7	PLATE-6 50.0x120.0		P-2		15942270000 SA387GR12CL2	No	0.300 8		
6	PLATE-20 300.0x21828.0		M-12		15942520000 SA387GR12CL2	No	1028.099 1		
5	~~SA300X200X20~~ ISA130X130X12 100		M-10		15013171000 IS2062E250A	No	1.700~~4.000~~ 8		
4	~~SA300X200X20~~ ISA130X130X12 100		M-9		15013171000 IS2062E250A	No	1.500~~4.000~~ 110		
3	PLATE-12 846x22258		M-1xWEB		15011320000 IS2062E250A	No	1773.811 1		
2	PLATE-32 300X21716		M-1xTFL		15011300000 IS2062E250B	No	1636.518 1		
1	PLATE-32 300X22258		M-1xBFL		15011300000 IS2062E250B	No	1677.383 1		

02 02

REV	DATE	ALTERED: KARTHIKA	REV	DATE	ALTERED: KARTH KS	REV	DATE	ALTERED: KEERTHIGA	REV	DATE	ALTERED: MURALI S
04	03.09.18	CHD & APPD : DHANAJI	03	20.06.2018	CHD & APPD : DHANAJI	02	16.07.2018	CHD & APPD : DHANAJI	01	12.06.2018	CHD & APPD : DHANAJI
ZONE	FITTINGS ADDED		ZONE	NOTES ADDED		ZONE	ITEM NO. 46 5 MATERIAL CHANGED TOTAL WEIGHT CHANGED		ZONE	CHANGES DONE AS PER INDICATED	

CAUTION: The information on this document is the property of BHARAT HEAVY ELECTRICALS LTD. It must not be used directly or indirectly in any way detrimental to the interest of the company.

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT

Bharat Heavy Electricals Ltd
UNIT: HIGH PRESSURE BOILER PLANT
TIRUCHIRAPALLI - 620014

	NAME	SIGNATURE	DATE
DRN	MURALI		27/02/2018
CHD	DHANAJI		28/02/2018
APPD	JOHNPETER		28/02/2018

DEPT	ST	ALL DIMENSIONS ARE IN MM	PROJECTION	SCALE	WEIGHT (Kg)	REF TO ASSY / OLD DWG
CODE	122			NTS	~~7005.276~~ 7026.376 02	

TITLE: FFR-63

DRAWING NO.: 0-08-001-06130 REV: 04

CORPORATE DRG ID:TP-DG-0-08-001-06130/04