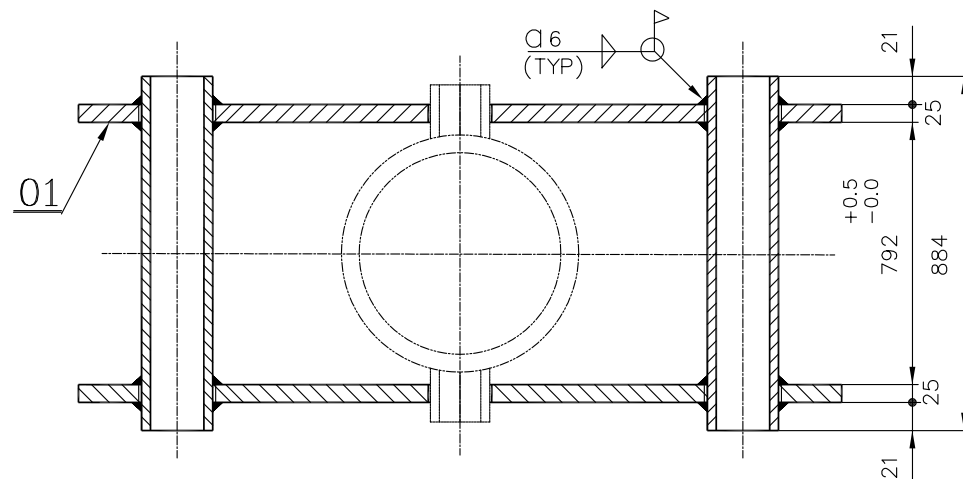
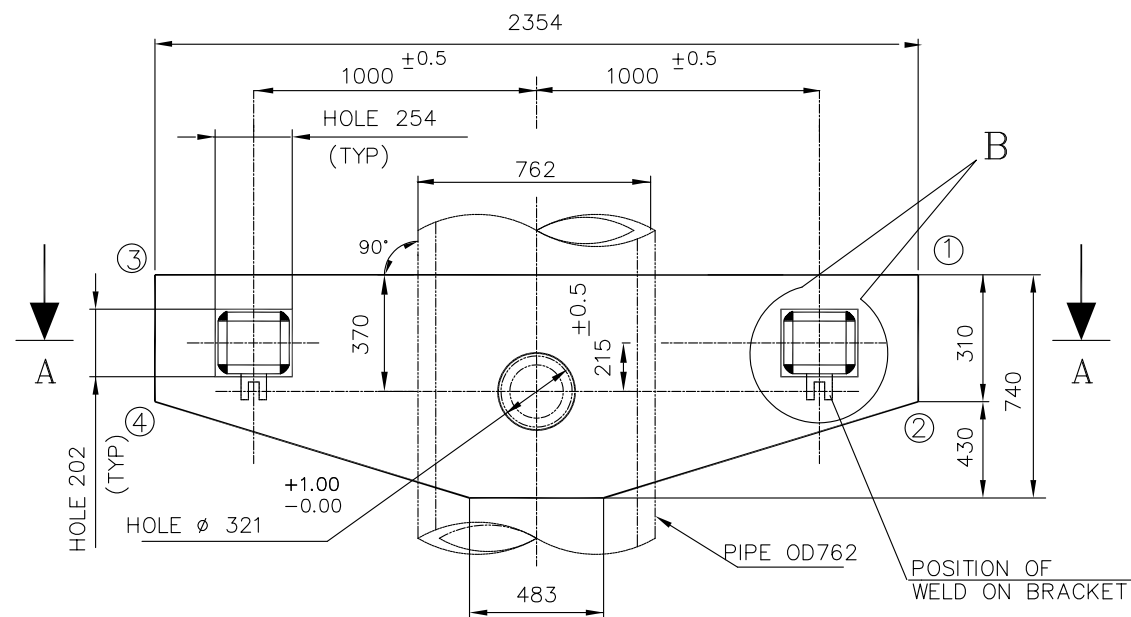
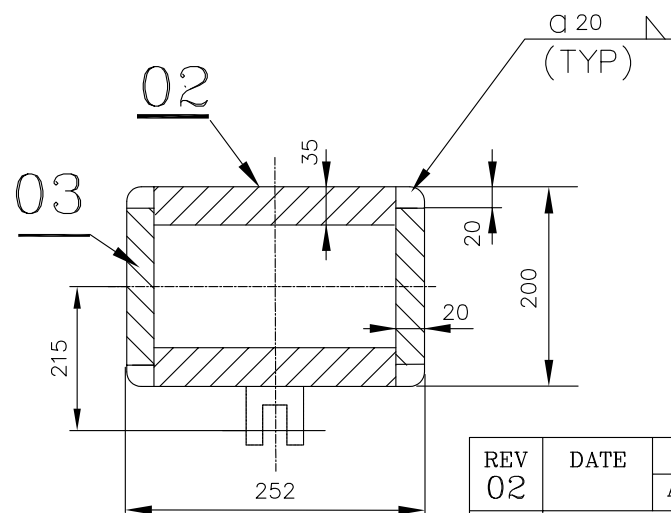


DRAFTING No



SECTION - AA



DETAIL – B

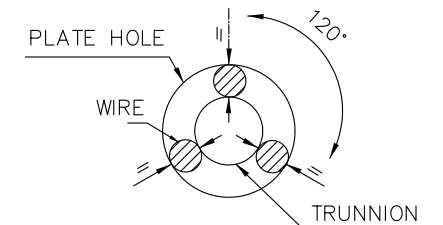
- | | | |
|-------------------|---|------------------------|
| 1.DESIGN LOAD | : | 230 KN |
| 2.MEDIUM TEMP | : | 540 °C |
| 3.WELD ON BRACKET | : | 250 KN |
| 4.TRUNNION SIZE | : | 320 $^{+0.30}_{-0.00}$ |
| 5.HYDRO LOAD | : | 230 KN |

REV 02	DATE	ALTERED	REV 01	DATE	ALTERED
		APPROVED			APPROVED
ZONE			ZONE		

1,THE CLAMP PLATE & BOX PLATE ARE TO BE TACK WELDED AT SHOP AND SENT AS A SINGLE DESPATCHABLE UNIT,
2,W.O NO & DU NO ARE TO BE MARKED IN BOTH THE CLAMP PLATE AS WELL AS IN BOTH THE BOXES BEFORE DESPATCH.
3,REQUIRED SURFACE FINISH IS
a , FOR HOLE: 6.3 μm
b, OTHER MACHINED SURFACE :12.5 μm

1,BEFORE TACK WELDING OF PLATE WITH BOX,THE FOLLOWING ARE TO BE ENSURED

a,UNIFORM GAP BETWEEN PLATE HOLE AND TRUNNION ALONG THE CIRCUMFERENCE AS SHOWN IN FIGURE -1, THIS COULD BE ENSURED BY INSERTING THIN SHEETS OF SUITABLE THICKNESS OR WIRES OF SUITABLE DIAMETER AT 3 PLACES 120° APART.



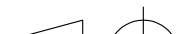
FIGURE—1

- 6, PARALLELITY OF THE TWO PLATES BY MEASURING THE INNER SURFACE TO INNER SURFACE DIMENSION AT THE FOUR CORNER POINTS ((1) – (4)) OF THE PLATES MARKED IN THE DRG. ALL THE FOUR MEASUREMENTS SHALL BE TO THE DIMENSIONS GIVEN IN THE DRAWING TAKING INTO CONSIDERATION THE TOLERANCE.
- 2, BEFORE FINAL WELDING OF BOXES TO PLATE, ROTATION OF CLAMP ABOUT TRUNNIONS IS TO BE ENSURED.
- 3, LOCATION OF WELD ON BRACKET SHALL BE AS INDICATED IN THIS DRAWING. ORIENTATION OF WELD ON BRACKET SHALL BE AS PER THE GUIDELINES GIVEN IN THE ERECTION NOTES FOR PIPING HANGERS AND SUPPORTS (DRG.NO. 4-80-999-99321)
- 4, CORRECT ELECTRODE TO BE USED FOR WELDING PLATE WITH BOX CONSIDERING PLATE & BOX MATERIAL SPECIFICATION.

	03	BOX PLATE 2 20 x 160 x 884	3-80-830-29505		15 942 113 0000 SA 515 Gr70	C	22.206 4
	02	BOX PLATE 1 35 x 212 x 884	3-80-830-29505		15 942 116 0000 SA 515 Gr70	C	51.49 4
	01	CLAMP PLATE 25 x 740.6 x 2354	3-80-830-29505		15 942 270 0000 SA 387 GR22 CL2	C	227.165 2
VAR NO.	ITEM NO.	DESCRIPTION	DRAWING NO.	ITEM NO.	MATERIAL CODE	A	UNIT WT.
				VAR NO.	MATERIAL SPEC.	C	QTY.

TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT

	BHARAT HEAVY ELECTRICALS LTD.,		DRN	NAME DINESH	SIGN	DATE 11.05.12	NO OF ITEMS
	PIPING CENTRE,		CHD	MRK		11.05.12	
	CHENNAI 600 017		APPD	M.MANO		11.05.12	

DEPT.	GRADE OF UN TOL. DIM		SCALE	WEIGHT (Kg).	REF TO ASSY / OLD DRG	ITEM No.
CODE	C/M/F'			749.114		
TITLE				CARD CODE	DRAWING No.	REV
TRUNNION CLAMP (PIPE OD762) DBT=2000				U 01	3-80-830-29505	00