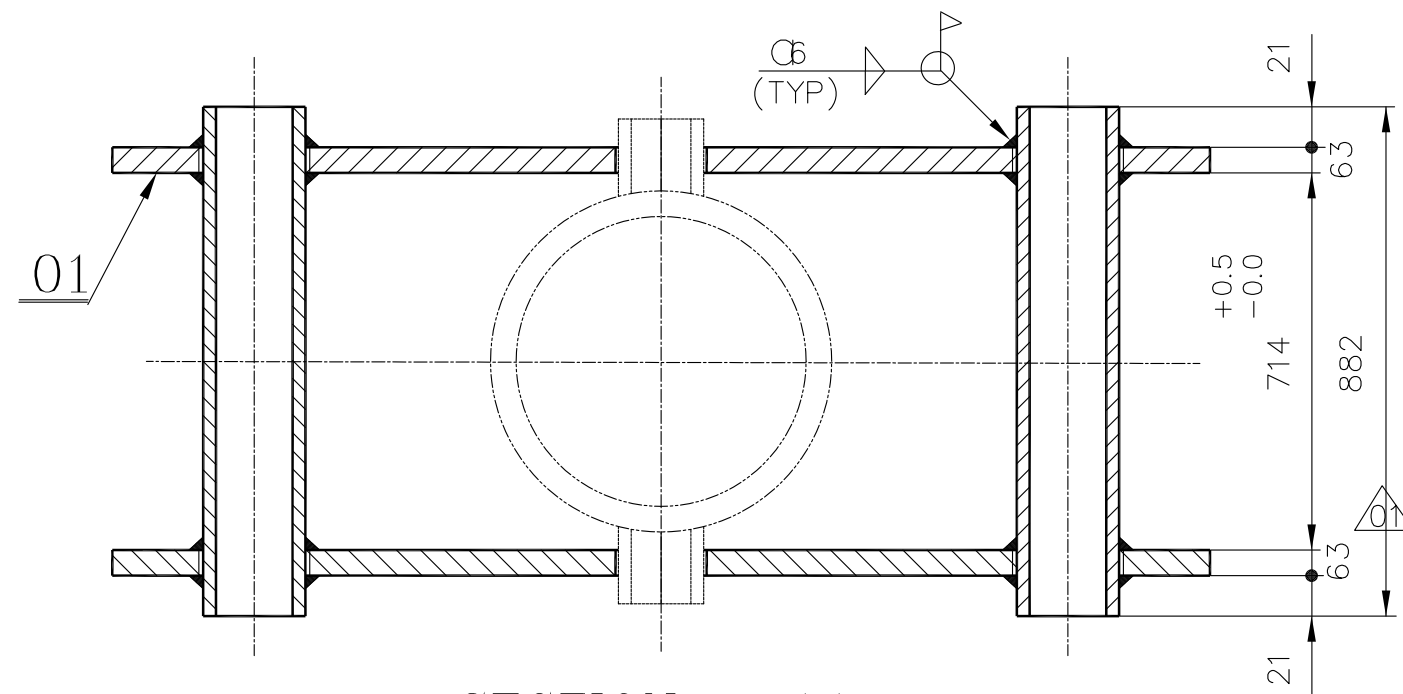
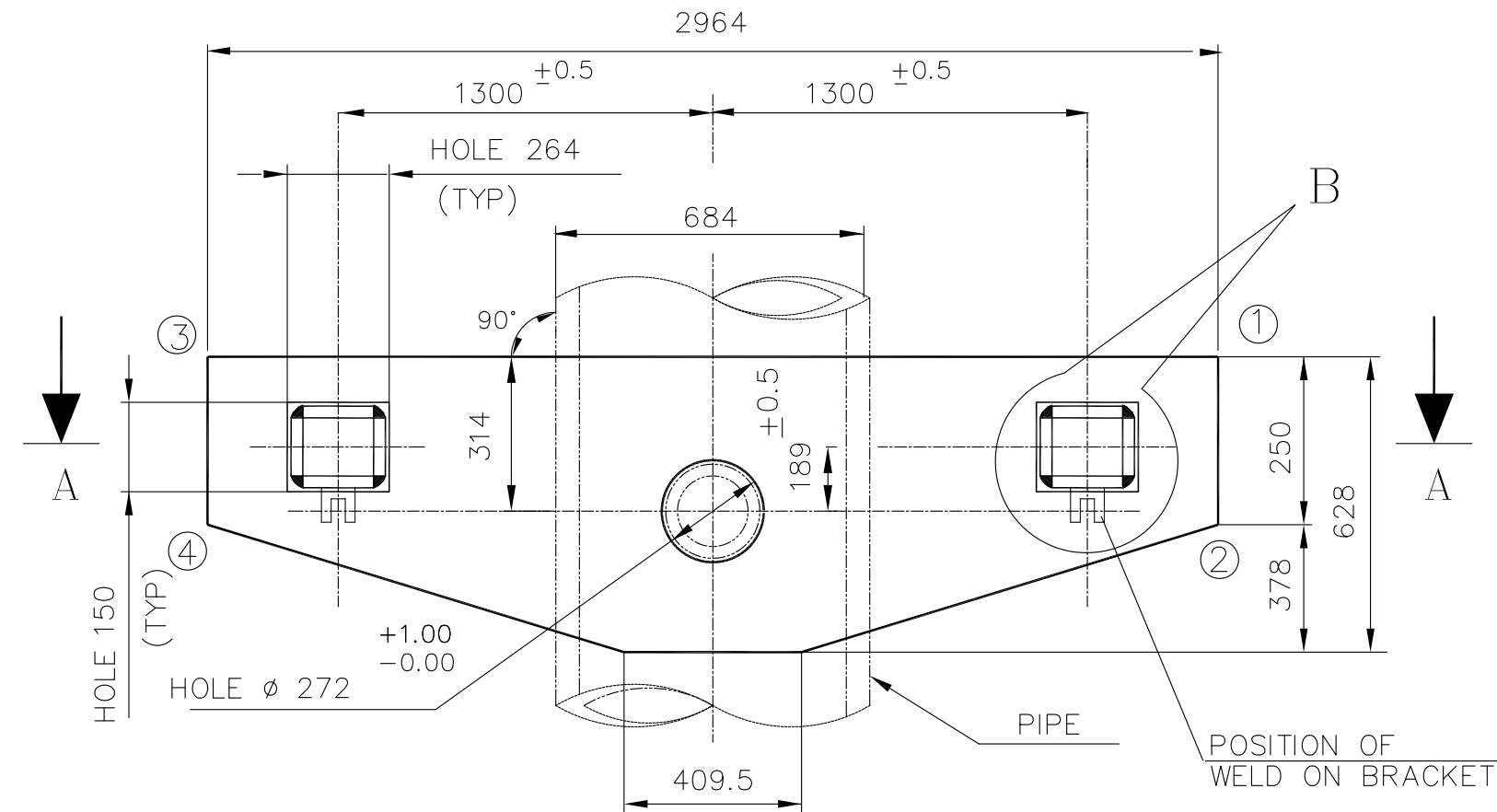
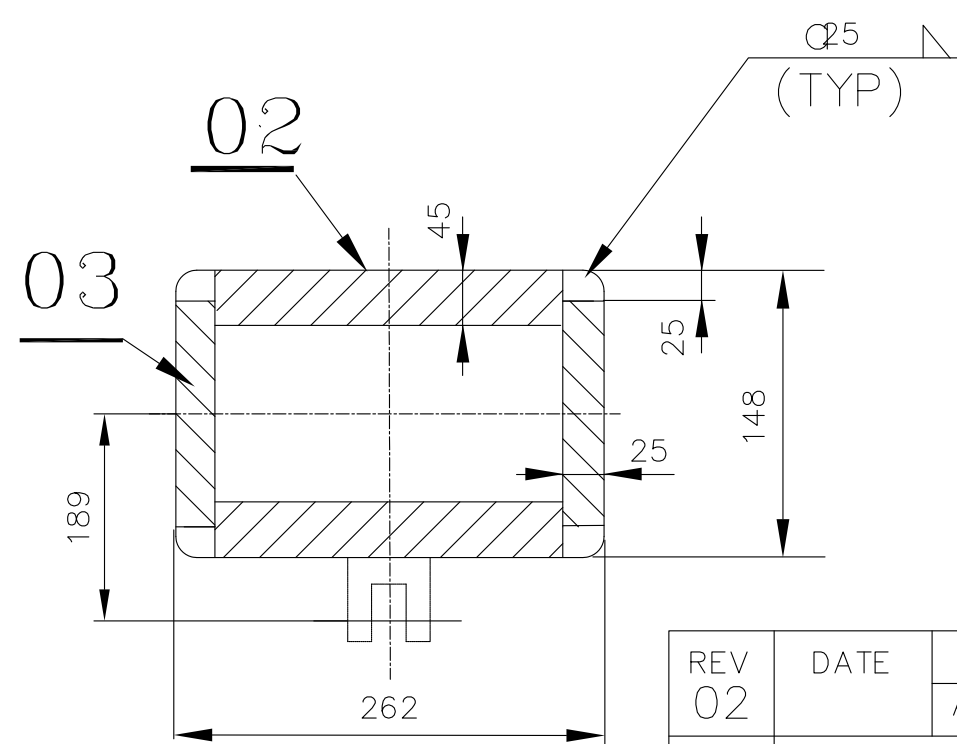


DRAWING NO. 3-80-830-31509



SECTION – AA



DETAIL – B

REV 02	DATE	ALTERED
		APPROVED
ZONE		

REV	DATE	ALTERED	P SURESH
01	09.09.14	APPROVED	M MANO
ZONE	ITEMNO. 02,03 DIMENSIONS CHANGED		
	REVISIONS MARKED AS 		

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

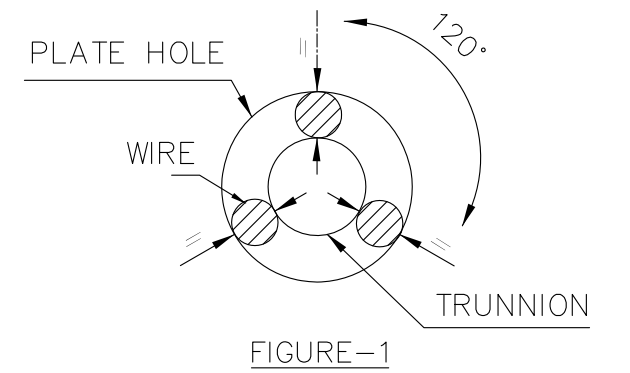
- ## B. NOTES FOR ERECTION

- 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.

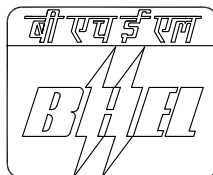
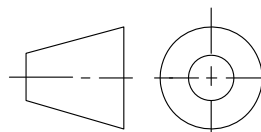
- b, PARALLELITY OF THE TWO PLATES BY MEASURING THE INNER SURFACE TO INNER SURFACE DIMENSION AT THE FOUR CORNER POINTS (①-④) OF THE PLATES MARKED IN THE DRG. ALL THE FOUR MEASUREMENT SHALL BE TO THE DIMENSIONS GIVEN IN THE DRAWING TAKING IN TO CONSIDERATION THE TOLERANCE.

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 MATL.SPECIFICATION.



01	03	BOX PLATE 2 25 x 98 x 882	3-80-830-31509		159422820000	C	16.963
					SA387GR12CL2		4
01	02	BOX PLATE 1 45 x 212 x 882	3-80-830-31509		159422850000	C	66.052
					SA387GR12CL2		4
	01	CLAMP PLATE 63 x 628 x 2964	3-80-830-31509		159422740000	C	613.912
					SA387GR22CL2		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		XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX YYYYYYYYYYYYYYYYYYYYYYYYYYYYYYYY TAG No.						
		BHARAT HEAVY ELECTRICALS LTD., PIPING CENTRE, CHENNAI 600 017		DRN	NAME P SURESH	SIGN	DATE 26.06.14	NO OF ITEMS
				CHD	SARAVANAN C		26.06.14	
				APPD	K V RAMANI		26.06.14	
DEPT.	GRADE OF UN TOL. DIM		SCALE	WEIGHT (Kg).	REF TO ASSY / OLD DRG			ITEM No.
CODE	C/M/F			1550.096				
TITLE TRUNNION CLAMP FOR PIPE OD684(AS) DBT 2600				CARD CODE U 01	DRAWING No. 3-80-830-31509			REV 01