

PSGSG 14-15 / 010	Process Specifications for Spacer (Distance Piece-I) Assembly	Drawing No.	RDDG43506170560 / 35027200630
		Date	12.01.2015
		Product	GSM 420
1.0	APPLICATION: Spacer (Distance Piece-I) Assembly (Drawing No. RDDG43506170560 / 35027200630) is a part of gas insulated switchgear equipment. The gas pressure in this metal enclosure is maintained at 0.75 M.Pa. This leak tight assembly shall meet following specification.		
2.0	SPECIFICATIONS:	Vendor's compliance	
2.1	Material: Low Carbon Austenitic stainless steel confirming to AISI-304.		
2.2	Standard seamless or ERW (straight/ spiral) tubular sections shall be used for construction, where ever applicable in design. Fabricated / drawn sections can be used for other areas not confirming to standard pipe schedules.		
2.3	Drawn profiles, to size, only shall be used for direct welding with the flanges. No smithy is allowed for formation/ matching of profiles in view of defect inception. Pipe and flanges shall be TIG / MIG welded with suitable SS electrode.		
2.4	The welded sections shall be sized as per drawing and verified /tested using Dye Penetration (D.P.) technique or x-ray at all stages of welding. Inside edges/weld shall be fused to obtain near smooth weld surface.		
2.5	The flanges shall be manufactured to drawings and welded as per instructions to the shells maintaining parallelism of faces and perpendicularity as prescribed.		
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2.6	The flange sealing surfaces shall be polished to RA 0.8 or better and the bolting holes shall be machined fine, using jig borer/ CNC milling, and shall have uniform chamfer. The tolerances, wherever not mentioned in the drawing, shall be within 0.1°. Any sharp corners shall be removed as per the drawing. Wherever not specified in the drawing, a chamfer of 0.5x45° shall be provided at the sharp corners and edges.		
2.7	Weld splatter, if any, shall be removed by chipping or grinding on completion of the weld.		
2.8	Dye penetration report shall be generated and submitted to BHEL.		
2.9	Component shall be electro chemical polished on the inside surface and powder coating (RAL5105 BLUE) shall be done outside.		
2.10	The assemblies further shall be sandblasted on the outer surface and powder coated (> 50 Micron) to shade as specified on drawing. During this operation all flanges shall be masked at the sealing surfaces and at the collar.		
2.11	The dimensional checks and the leak test shall be carried out in presence of BHEL inspector. It is preferable to have first stage inspection after assembling the first module at supplier's works.		
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2.12	The accepted component shall be packed in wooden boxes with suitable covers on the flanges to prevent transit damages. A thick polyethylene cover shall be used to seal to component from ingress of moisture and water. For transit time higher than a week, adequate quantity of moisture absorbent shall also be placed with the component.		
2.13	Following certificates shall be furnished for acceptance of the component: 1.Material certificate, 2.Material test certificate , 3.Stage wise DP / X-ray tests 4.Pressure withstand test report 5.Electro-polishing schedule A certified copy of above documents shall be sent along with the delivery note.		
2.14	Performance Guarantee/Warranty: Supplier shall provide Guarantee certificate for the equipment to ensure reliability of the equipment for a period of not less than 12 months from the date of receipt at BHEL.		
2.15	Any Other information: In case of doubts please contact BHEL for clarifications. Supplier can furnish any other/additional information, considering overall requirements.		
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