

3.5

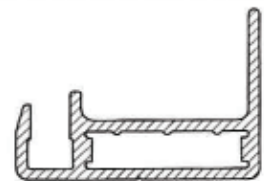
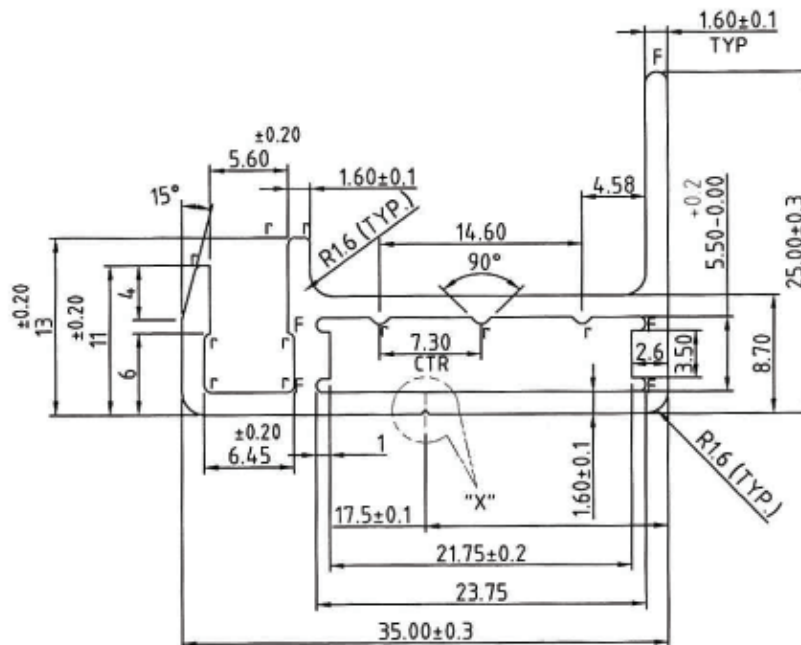
FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN MM)

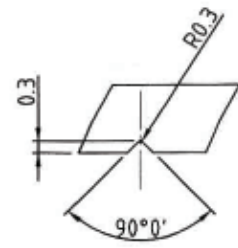
REV.	DATE	ALTERED	NAR	REV.	DATE	ALTERED	ADDITIONAL INFORMATION
01	130117	CHECKED	NAR	00		CHECKED	STATUS OF DRAWING
		APPROVED	CNP			APPROVED	DISTRIBUTION OF PRINTS

0.3x45° notch included for 4 mm Glass thick.
Weight Kg/m = 0.473 was 0.470

FIRST ISSUE



SCALE=1:1



DETAIL "X"

MATERIAL : ALUMINIUM ALLOY - 63400 WP AS PER IS:733 (OR) 6063-T6.

NOTE :

1. ALL UNSPECIFIED WALL THICKNESS - 1.6 ± 0.1 .
2. $r=0.50$, F - FULL RADIUS.
3. DIMENSIONAL TOLERANCES FOR EXTRUDED ALUMINIUM AS PER IS:3965.
4. HEAT TREATMENT CONDITION : WP (OR) T6.
5. ESTIMATED WEIGHT Kg/m = 0.473.
6. ROUND OF ALL SHARP CORNERS WITH 0.25 mm.
7. VENDOR EXTRUSION DRAWING TO BE APPROVED BY BHEL.

REMARKS	ITEM NO.	DESCRIPTION	STD.	MATERIAL CODE	A	UNIT	UNIT WL.(Kg)
				MATERIAL SPECN.	C		QUANTITY



BHARAT HEAVY ELECTRICALS LIMITED,
ELECTROPORCELAINS DIVISION, BANGALORE

NAME	SIGN.	DATE	No. OF VAR
NAR		181016	
NAR		181016	
CNP	Sd/-	191016	

DEPT. SPV	FOR UNSPECIFIED TOLERANCES	SCALE	WEIGHT (Kg)	REF. TO ASSY. DRG.	ITEM NO.	No. OF ITEM
CODE 100	REFER ED 0230499	2 : 1				

TITLE	DRAWING NO.	REV.
MAIN EXTRUSION - 4 mm Glass 300W SPV MODULE	4 988 04 003 10	01

SHEET NO.	NO. OF SHEETS
01	01

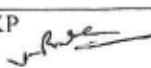
A4 SIZE

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REF. DRG.NO.

SIGN & DATE

INVENTORY NO.

	 BHEL-EPD	ELECTROPORCELAINS DIVISION BENGALURU – 560012, INDIA Purchase Specification Group : Photovoltaic Module		DOC. NO: EP-901-01-0009		
				REV. 00	JOB NO.-AF	
				PAGE 01 OF 02		
ALUMINIUM FRAMES & CORNER BLOCK, 4 mm Thick						
1.0 SCOPE: Supply of Aluminum frame, Corner block with electrolytically formed anodic coatings on Aluminum & Al alloy parts which are exposed to direct action of climatic elements (viz sun, wind, rain, dust, salt, and water).						
2.0 GENERAL: - Aluminum parts to be anodized are made of Al alloy (63400/6063) as per IS-733 and supplied in W P /T6 (temper) condition. - End use of component is for Solar Photovoltaic module framing. - Anodizing process as per Type-I: IS-7088 - Type of sealing as per IS-7088 (Clause 7)						
3.0 DRAWING: 3-988-04-003-10 ALUMINIUM EDGE FRAME 4-988-04-003-10 MAIN EXTRUSION 4-988-04-002-10 CORNER BLOCK EXTRUSION						
4.0 VISUAL REQUIREMENTS: The anodic coating shall be continuous, smooth, adherent, uniform in appearance and shall be free from powdery areas, loose films, and discontinuities such as breaks, scratches or other damage.						
Revision (00):		Issued By	Prepared By	Checked By	Approved By	Date
1 st Issue		SPV Eng.	RKP 	CNP 	CNP 	12.08.17

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