




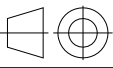
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REV.	DATE	ALTERD	REV.	DATE	ALTERD	REV.	DATE	ALTERD
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GENERAL NOTES:—

- FOR WELDING OF CONDUCTOR REFER DRG. NO. 15410001013.
- FOR WELDING OF ENCLOSURE REFER DRG. NO. 15410001015.
- Ø10mm PILOT HOLES TO BE ENLARGED TO Ø74mm^{+1.00}_{-0.00} IN CHANNEL RING AND ENCLOSURE AFTER CHANNEL RING HAS BEEN WELDED TO ENCLOSURE .
- ABOVE Ø74mm HOLES NOT COMES IN ANY ENCLOSURE WELDING LINE.
- ROLLING OVALITY SHOULD NOT BE MORE THAN 3mm.
- BOTH ENDS OF CONDUCTOR ARE TO BE CHAMFERED AS  4mm FOR MAIN, DELTA
IF END OF CONDUCTOR HAVING ANY HOLE CHAMFERING NOT REQD. ONLY SHARP EDGE REMOVE.
- DO NOT PAINT ENCLOSURE 100mm FROM BOTH ENDS.
- DO NOT PAINT CONDUCTOR 50mm FROM BOTH ENDS.
- ADJACENT DUCTS ARE TO BE STAGGER WELDED (ie LINE OF WELDING OF DIFFERENT DUCT SHOULD NOT COME IN THE SAME AXIS).
- EDGE PREPARATION IS TO BE DONE AS  1.5 IN EACH ITEM OF DUCT. BEFORE WELDING WHEREVER BUTT WELDING JOINT IS COMING IN WELDED ASSY. OF ENCLOSURE OF 6.35 THK. AND ABOVE.
- PARTY WELDER QUALIFICATION TO BE DONE PRIOR TO START OF WELDING.
- FOR TOLERANCES OF BUSDUCT ENCLOSURE AND CONDUCTOR REFER STD. BD-25001T.
- CODE OF PRACTICE FOR ALUMINIUM WELDING IN BUSDUCT REFER STD. BD-15010W.
- FOR PAINTING OF BUSDUCT REFER PROCESS SPEC. JS0674196.
- FOR WELDING PROCEDURE SPEC. REFER STD. BD15001W/A1, & BD15001W/A2, BD 15002W/A1, BD15002W/A2 ALL ARE OF REV. 06.
- CONDUCTIVITY MEASUREMENT (MILLI VOLT DROP) TEST ON ENCLOSURE & CONDUCTOR WELDED JOINT TO BE DONE SAMPLE AS PER BS:159.
- FOR SILVER PLATING REF. DRG. NO. 45410001025 R.11 / 45410000005 R.06 SILVER PLATING THICKNESS TO BE MINIMUM 13 MICRONS.
- SILVER PLATED SURFACE TO BE COVERED WITH SULFIDE FREE PAPER AND WITH POLYTHENE BAGS /SHEETS WRAPPED WITH COTTON TAPPING. ALSO THE S.P. SURFACE TO BE PACKED PROPERLY TO AVOID TRANSPORTATION DAMAGES.
- BUSDUCT/CUBICLES FABRICATION IS TO BE DONE AS PER APPROVED QUALITY PLAN.
- PO NO., PROJECT NAME, BOM NO. & DRG. NO. WILL BE MENTIONED ON ENCLOSURE & CONDUCTOR.
- D.P. TEST TO BE DONE 10% AS PER AA0850129.
- BEFORE START OF MANUFACTURING, FABRICATOR SHOULD TAKE CONFIRMATION OF LATEST REVISION FROM DESIGNER. THIS MAY BE DONE VIA E-MAIL.

FINISH NOTES:—

- FOR FABRICATION OF BUSDUCT, CUBICLES, MARSHALLING BOXES USED MATERIAL AS PER TDS.
- EXTERNAL SURFACES OF ALL BUSDUCT ENCLOSURES, CUBICLES, MARSHALLING BOXES SHALL BE THOROUGHLY CLEANED AND DE-GREASED TO REMOVE MILL SCALE, RUST, GREASE AND DIRT. THE EXTERNAL SURFACE OF ENCLOSURE SHALL BE PAINTED WITH PAINT AS PER REQUIREMENT OF PROJECT (MINIMUM THICKNESS 50 MICRONS. INCLUDING PRIMER THICKNESS).
- INTERNAL SURFACES OF ENCLOSURE & EXTERNAL SURFACES OF CONDUCTOR ARE TO BE PAINTED WITH SELF ECHING MATT. BLACK PAINT TO BP56184. MINIMUM THICKNESS 50 MICRONS.
- INTERNAL SURFACES OF ALL CUBICLES, MARSHALLING BOXES TO BE PAINTED WITH GLOSSY WHITE ENAMEL PAINT MIN. THICKNESS OF PAINT SHOULD BE 50 MICRONS.

VAR 00	REMARKS	ITEM NO.	DESCRIPTION	DRAWING NO.	IT.NO. VAR.	MATL.CODE MATL.SPCN.	WT. QTY.	5 0
CUSTOMER		PROJECT/PRODUCT						
GENERAL		GENERAL						
	BHARAT HEAVY ELECTRICALS LTD RUDRAPUR			NAME	SIGN.	DATE	NO. OF VAR.	
				DRN. RUPESH KUMAR		10/09/13		
				CKD. RUPESH KUMAR		10/09/13		
				APPD. R.K. LAL		10/09/13		
DEPTT. BDE	UNTOL.DIM.GR. C/M/F		SCALE —	WEIGHT—KG —	REF.TO ASSY.DRG. —	IT.NO.	NO.OF ITEM	
TITLE				DRAWING NO.		REV.		
GENERAL NOTES FOR IPBD				41231210099		00		
				SHEET NO.— 01	NO.OF SHEETS— 01	SIZE— A4		