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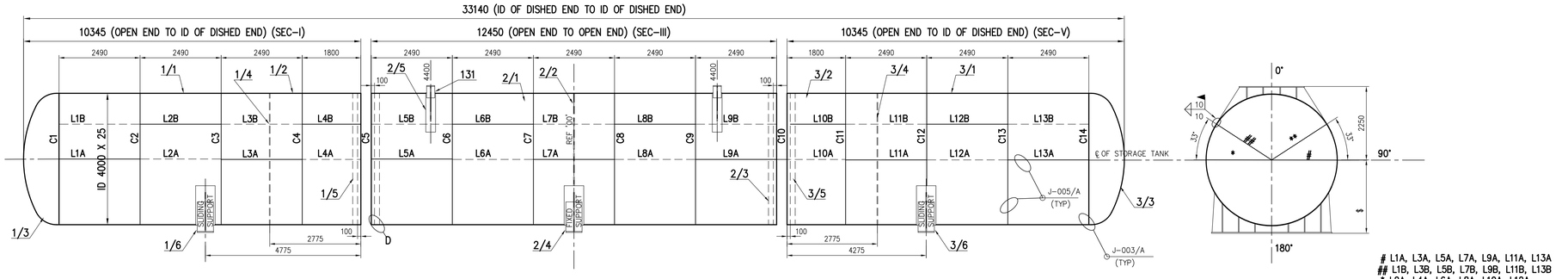
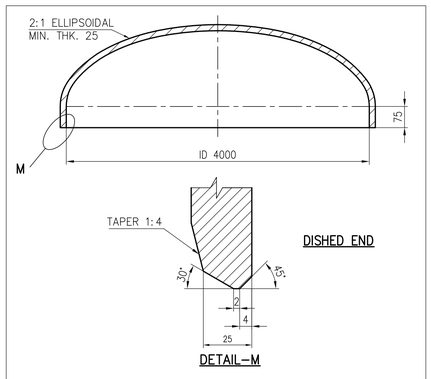


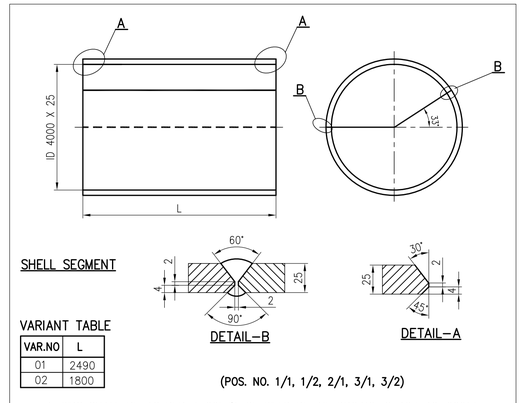
REFER DETAIL-C FOR STIFFENER RING TO SHELL WELDING

\# L1A, L3A, L5A, L7A, L9A, L11A, L13A
\## L1B, L3B, L5B, L7B, L9B, L11B, L13B
* L2A, L4A, L6A, L8A, L10A, L12A
** L2B, L4B, L6B, L8B, L10B, L12B

$ 2250 (FOR FOXED SUPPORT) & 2235 (FOR SLIDING SUPPORT), 15mm DIFFERENCE IN HEIGHT IS COMPENSATED BY TEFLON ASSLY. (REFER DET-B)



(POS. NO. 1/3, 3/3)

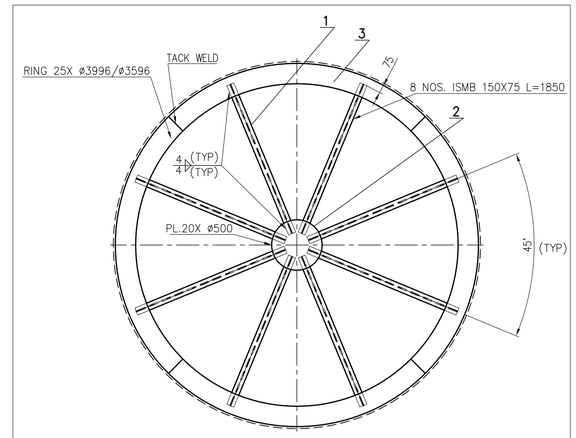


VARIANT TABLE

VAR.NO	L
01	2490
02	1800

(POS. NO. 1/1, 1/2, 2/1, 3/1, 3/2)

1. WPS SHALL BE AS PER J-005/A OF WELD DETAIL DRG.NO. 2-163-10-00014.
2. DEVELOPED LENGTH= 12645 (7490+5155)

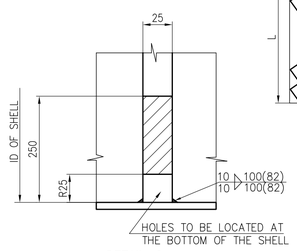


SPIDER ASSLY.

(POS. NO. 1/5, 2/3, 3/5)

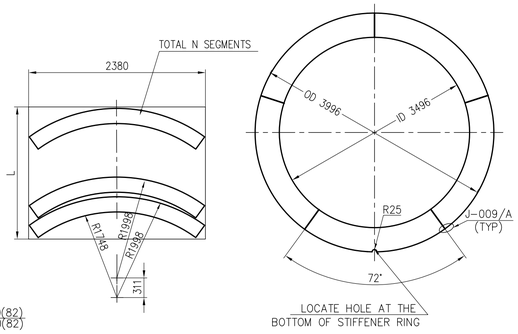
VARIANT TABLE

VAR.NO	L	N	NO. OF RINGS
01	1860	5	1
02	3420	10	2



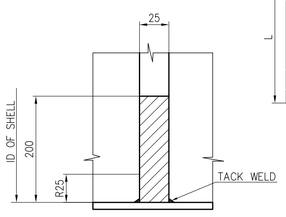
DETAIL-C

(POS. NO. 1/4, 2/2, 3/4)



1. REFER WELD DETAIL DRG NO. 2-163-10-00014
2. PLATE THICKNESS= 25mm

STIFFENER RING



DETAIL-D

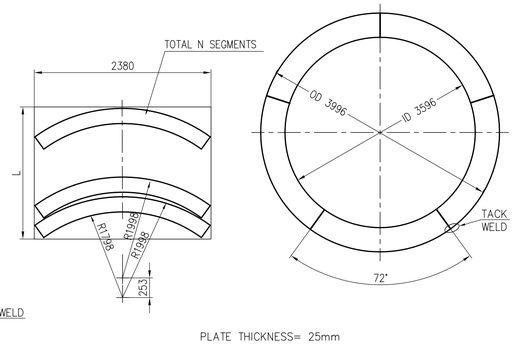


PLATE THICKNESS= 25mm

VARIANT TABLE

VAR.NO	L	N	NO. OF RINGS
01	1590	5	1
02	2850	10	2

RING FOR SPIDER ASSLY.

GENERAL DIMENSIONAL LIMITS,FITS & TOLERANCES AS PER HY0230261

REV.	DATE	ALTERED	CHECKED	APPD
A				

ZONE

COMPUTER FILE NAME | REF. DRG. NO. | SIGN. AND DATE | INVENTORY NO

TYPE OF PRODUCT
OR
NAME OF CUSTOMER/PROJECT

BHARAT HEAVY ELECTRICALS LTD.
HYDERABAD

	NAME	SIGN.	DATE	NO.OF VAR.
DRN.	B UMA		21.04.14	
CHD.	UMESH MENON		10.04.15	N.A
APPD.	ACS		10.04.15	

DEPT.	GRADE OF TOL.DIM. C/M/F	SCALE	WEIGHT (KG)	REF. TO ASSY DRG.	ITEM NO.	NO.OF ITEMS
HEE		NTS	NA	NA	N.A	N.A
CODE 405						

TITLE
SHELL ASSLY
(FOR STORAGE TANK SHELL)

CARD CODE

DRAWING NO. 1-163-11-11433 REV. 00

SHEET No. 1 NO OF SHEETS 1

BHEL-HYD. EDAS Approved
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