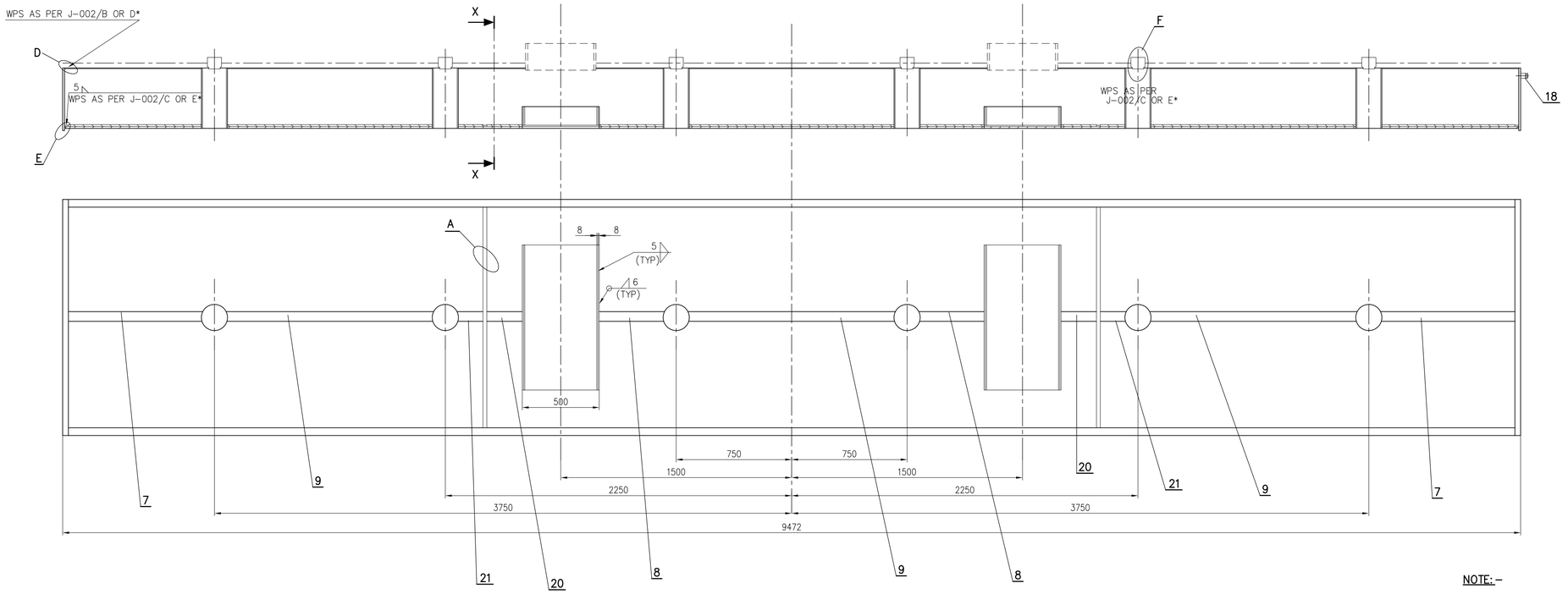
FIRST ANGLE PROJECTION

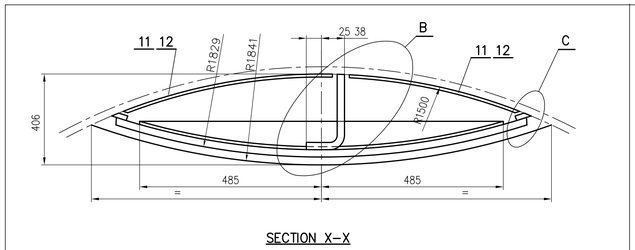
(ALL DIMENSIONS ARE IN mm)

DRG. NO. 1-163-16-11494 SH 1 OF 1

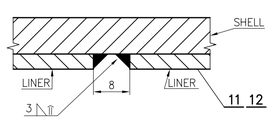



NOTE:-

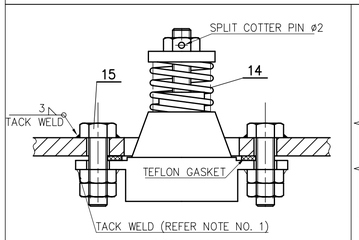
1. AFTER ASSEMBLY OF SPRAY VALVES TO WATER BOX, ALL BOTTOM NUTS OF THE SPRAY NOZZLES SHALL BE TACK WELDED TO THE VALVE BODY AT TWO POSITIONS 180° APART, AFTER ENSURING PERFECT LOCKING OF DOUBLE SELF LOCKING NUTS.
2. i) END PLATE WITH A HOLE (WITH A PLUG INSERTED IN IT) IS FOR VENTING AIR DURING HYDRO TEST PURPOSE, HENCE IT SHOULD BE WELDED ON MAN HOLE SIDE ONLY.
   ii) REMOVE THE PLUG POS. NO. 18, DURING HYDRO TEST AND KEEP IT BACK IN POSITION AFTER HYDROTEST
3. BEFORE CUTTING THE MATERAIL FOR J-STIFFENERS (POS. NO. 7,8,9,20,21) ACTUAL HEIGHT FOR J-STIFFENERS SHALL BE PHYSICALLY MEASURED INSIDE THE SHELL. THIS IS TO TAKE CARE OF ANY CHANGE IN J-STIFFENER HEIGHT DUE TO OVALITY OF THE SHELL.
4. * REFER DEAERATOR HEATER ASSLY. DRG. FOR REQUIREMENT OF PWHT.



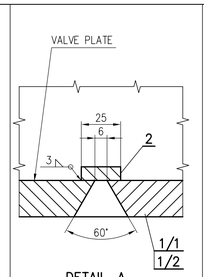

SECTION X-X



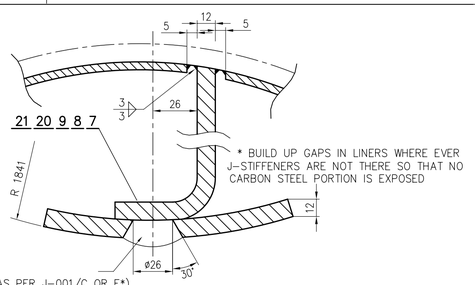

LINER TO LINER JOINT



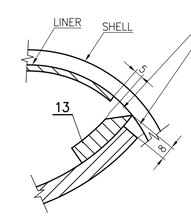

DETAIL-S
SPRAY VALVE FIXING ARRGT



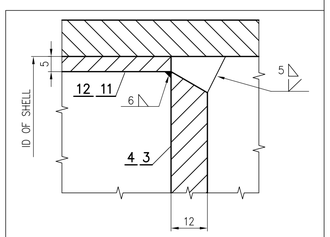

DETAIL-A
(WPS AS PER J-001/C OR E*)



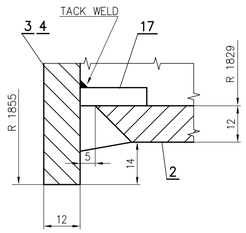

(WPS AS PER J-001/C OR E*)
DETAIL-B



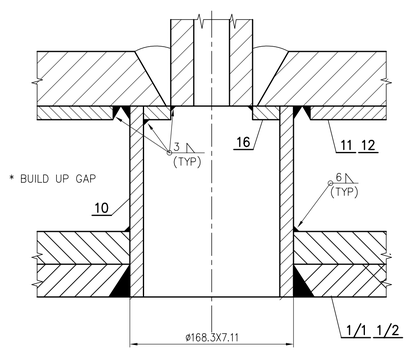

DETAIL-C
(WPS AS PER J-001/B OR D*)




DETAIL-D




DETAIL-E




DETAIL-F

GENERAL DIMENSIONAL LIMITS,FITS & TOLERANCES AS PER HY0230261

| REV. | DATE | ALTERED | CHECKED | APPD |
|---|---|---|---|---|
| ZONE | | | | |

TYPE OF PRODUCT
OR
OF CUSTOMER/PROJECT

BHARAT HEAVY ELECTRICALS LTD.
HYDERABAD

| | NAME | SIGN. | DATE | NO.OF VAR. |
|---|---|---|---|---|
| DRN. | A.L.RAJAM | | 02.11.11 | |
| CHD. | UMESH MENON | | 02.11.11 | N.A |
| APPD. | TSN BHARGAV | | 02.11.11 | |

| 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
WATER BOX ASSLY.

CARD CODE

DRAWING NO. 1-163-16-11494 REV. 00

SHEET No. 1 NO OF SHEETS 1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COMPUTER FILE NAME — REF. DRG. NO. — SIGN. AND DATE — INVENTORY NO

24-11-2011
15:49:02

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