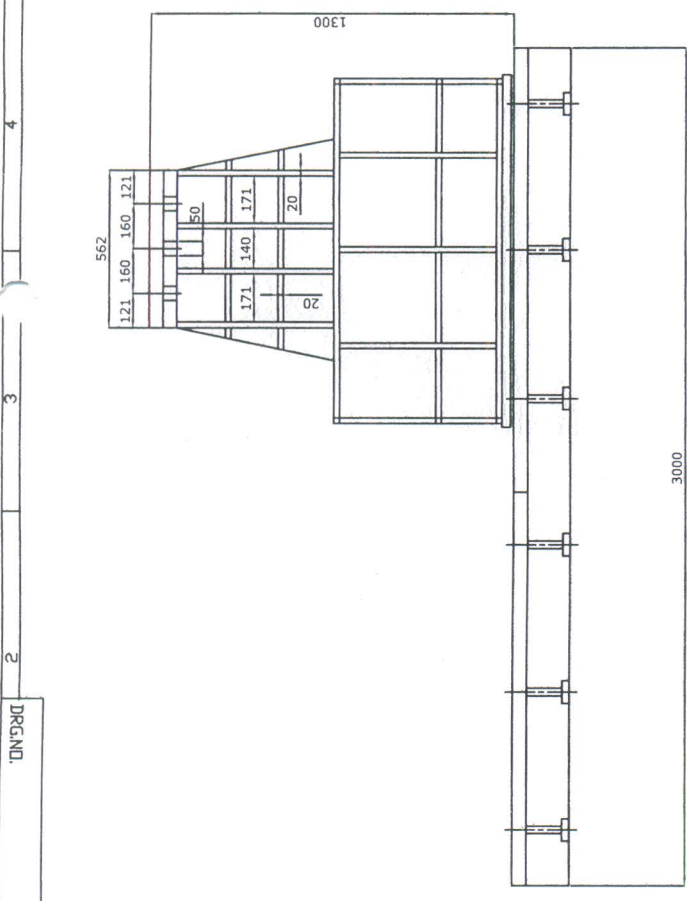


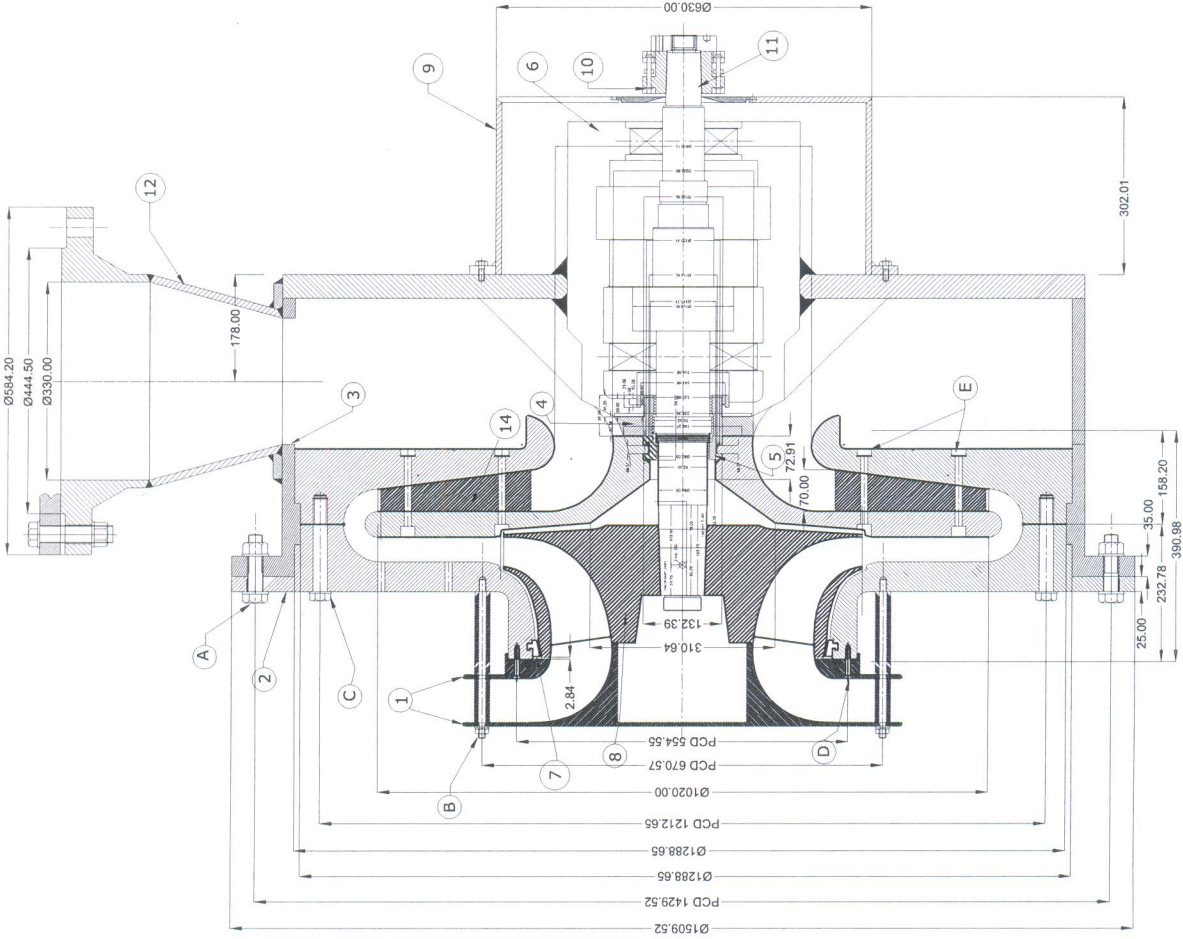
Scope: 1) Fabrication of 2 nos. pedestals of size 562 X 668 mm.
 2) Machining of pedestal top by milling
 3) Welding of 2 nos. pedestals to existing base frame.
 4) Welding of strips 2 nos on base frame below the pedestals - 4 nos x 10 mm

Base frame modification



INVENTORY NO. REF. DRG. NO. COMP. FILE NAME THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

ITEM NO.	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG. NO. OR FORGING DRG. NO.	MATERIAL CODE	MATERIAL SPECN.	NET WT.	GROSS WT.	QUANTITY
TYPE OF PRODUCT HIGH SPEED COMPRESSOR TEST RIG OR NAME OF CUSTOMER/PROJECT FOR 600 MM DIA. IMPELLER BHARAT HEAVY ELECTRICALS LIMITED Corp. R&D Division, Vikasnagar HYDERABAD - 500 093 DEPT. 050 SCALE NTS CODE TML TITLE SUPPORT STAND FOR CASING									
THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED... 1. REF. TO HY0230261 FOR UNSPECIFIED TOLERANCES. 2. CHAMFER M/CD SHARP EDGES 1.2 TO 1.0 AT 45°. 3. INTERNAL M/CD CORNER RADIUS 1 TO 0.7. 4. THE SURFACE ROUGHNESS WHEREVER NOT SHOWN SHALL BE TAKEN FROM THE SURFACE ROUGHNESS SHOWN OUT SIDE BACK SLASHES GIVEN AT THE TOP MOST RIGHT CORNER OF THE DRG.									
DRG. VINA Y KUMAR		DATE 23.10.2013		NAME SGNL.		NO. OF VAR.		NO. OF ITEMS	
CHK. KSR SWAMY		DATE 23.10.2013		APPR. P G SHANKAR		REF. TO ASSY DRG.		DRAWING NO.	
RD. R&D DIVISION, VIKASNAGAR, HYDERABAD - 500 093		SCALE NTS		TITL		REV.		NO. OF SHEETS : 01	
SHEET NO. : 01		NO. OF SHEETS : 01		NO. OF SHEETS : 01		NO. OF SHEETS : 01		NO. OF SHEETS : 01	



THIS DRG. IS TENTATIVE

- NOTE :**
- THIS DRAWING IS STUDY DRAWING WHICH SHOWS THE NEW PARTS TO BE MANUFACTURED FOR HIGH SPEED COMPRESSOR TEST RIG.
 - ITEMS MARKED (*) IN THE LIST BELOW EXCLUDED FROM THE VENDOR'S SCOPE OF SUPPLY.
 - ALL DIAPHRAGMS SHOULD BE MADE OF 2062-FE-410-W
 - ALL FASTENERS SHOULD BE ALONG WITH NUTS, WASHERS AND LOCK WASHERS WHEREVER NEEDED

GENERAL NOTE :

- IN CASE OF DOUBT, DON'T ASSUME, PLEASE ASK.
- GENERAL TOLERANCE WHERE IT IS NOT SPECIFIED IS ± 0.1.
- GENERAL SURFACE FINISH WHERE IT IS NOT MENTIONED IS 1.6 MICRONS.
- ALL MECHANICAL SEALS ARE HORIZONTAL SPLIT SEALS.
- REFERENCE DRAWINGS FURNISHED ARE COMMON FOR BOTH STAGE-1 AND STAGE-16.

ITEM NO	DESIGNATION	SIZE	QTY.
E	HEX. HEADED SCREWS	M12 X 103 L	20
D	COUNTER SUNK SCREW	M8 X 55 L	10
C	HEX. HEADED BOLTS	M24 X 170 L	10
B	STUD BOLTS	M12 X 170 L	10
A	HEX. HEADED BLOLTS	M24 X 100 L	10

FASTNNER LIST

ITEM	DESCRIPTION	DRAWING NO	No. of Sht.	MATERIAL
*14	RETURN CHANNEL VANES			
*13	LOCK NUT			
*12	DISCHARGE NOZZLE			
*11	SHAFT			
*10	COUPLING			
*09	BEARING HSG. END COVER			
*08	IMPELLER			
*07	SEAL ON IMPLER			
*06	BEARING HOUSING			
*05	SEAL ON SHAFT			
*04	SEAL ON BEARING			
*03	DIAPHRAGM CASING			
	DAIPHGRAM ASSEMBLY	RD DG 3 TM 13 0102	01	IS : 2062 FE 410 W
	DAIPHGRAM PART-3	RD DG 3 TM 13 0105	02	IS : 2062 FE 410 W
02	DAIPHGRAM PART-2	RD DG 3 TM 13 0104	02	IS : 2062 FE 410 W
	DAIPHGRAM PART-1	RD DG 3 TM 13 0103	01	IS : 2062 FE 410 W
	SUCTION CASING ASSEMBLY	RD DG 3 TM 13 0113	01	IS : 2062 FE 410 W
	SLEAVE FOR INLET CASING	RD DG 3 TM 13 0108	01	IS : 2062 FE 410 W
01	SUCTION CASING PART-2	RD DG 3 TM 13 0107	01	IS : 2062 FE 410 W
	SUCTION CASING PART-1	RD DG 3 TM 13 0106	01	IS : 2062 FE 410 W

TYPE OF PRODUCT: NEW BT4-1 (HIGH FLOW) IMPELLER DIA. 600 MM
 NAME OF CUSTOMER/PROJECT: COMPRESSOR STAGE TESTING



BHARAT HEAVY ELECTRICALS LIMITED
 Corp. R&D Division, Vikasnagar
 HYDERABAD - 500 093

DEPT.	050	SCALE	NTS	WEIGHT(Kg)	---
CODE	TML				
NO. OF ITEMS	---	REF. TO ASSY. DRG.	---		
NO. OF SHEETS	01	DRAWING NO.	RD DG 3 TM 13 0101	REV.	0

