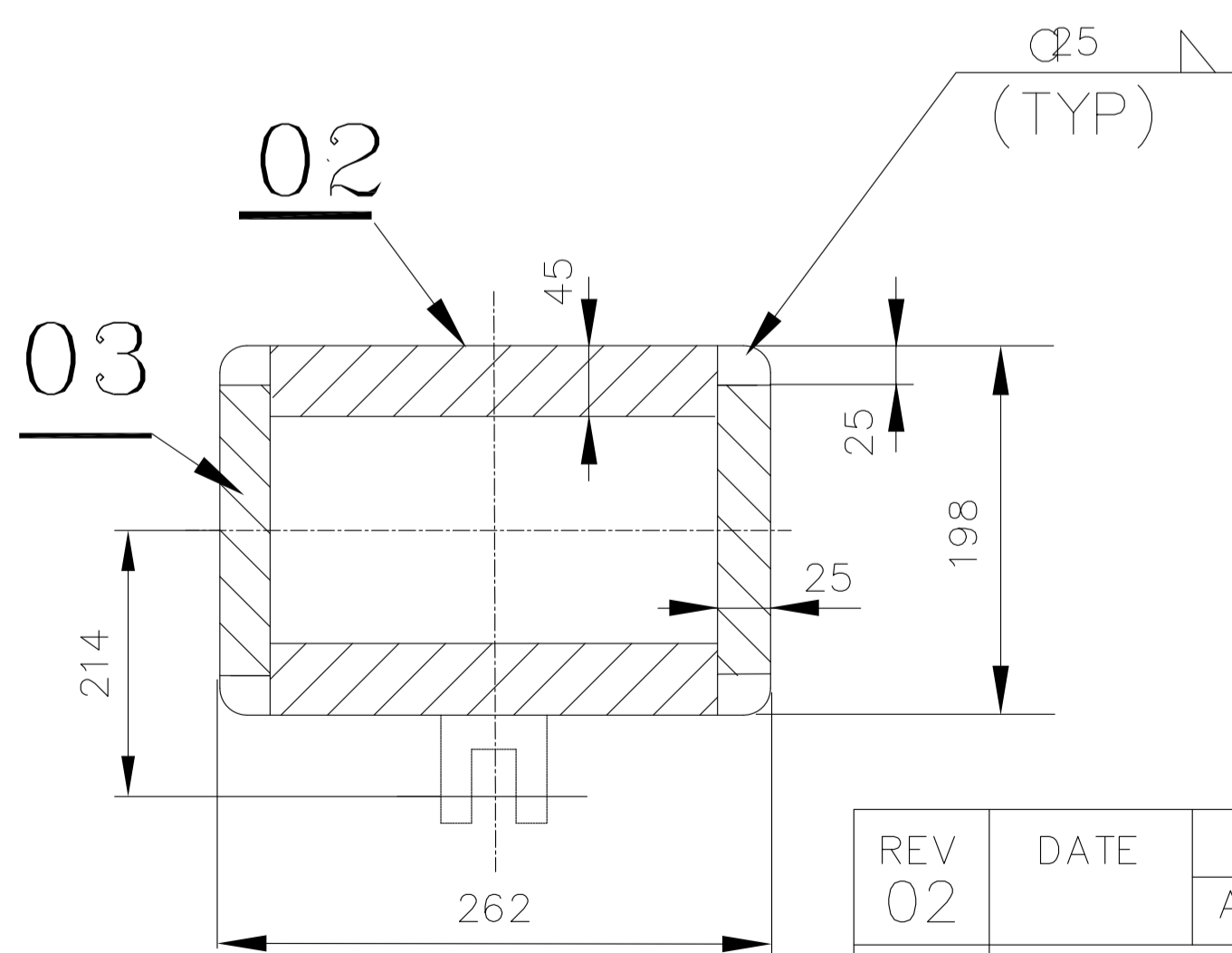
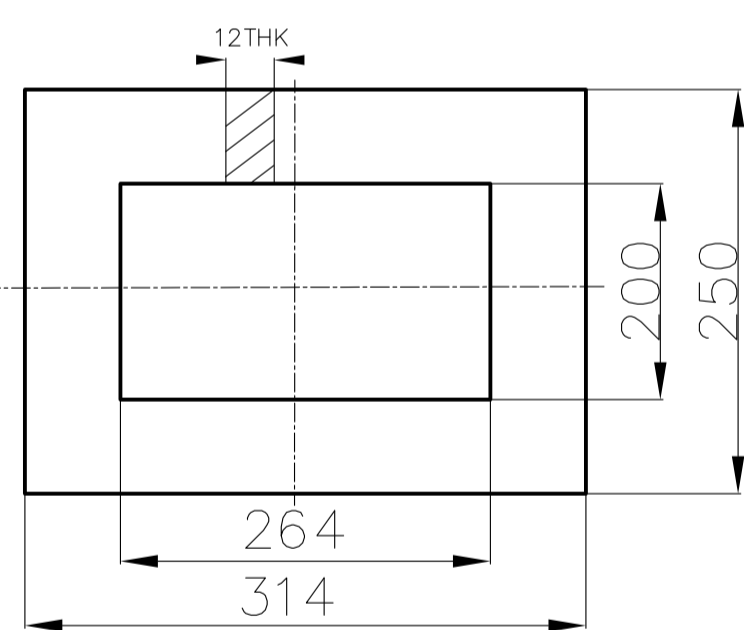
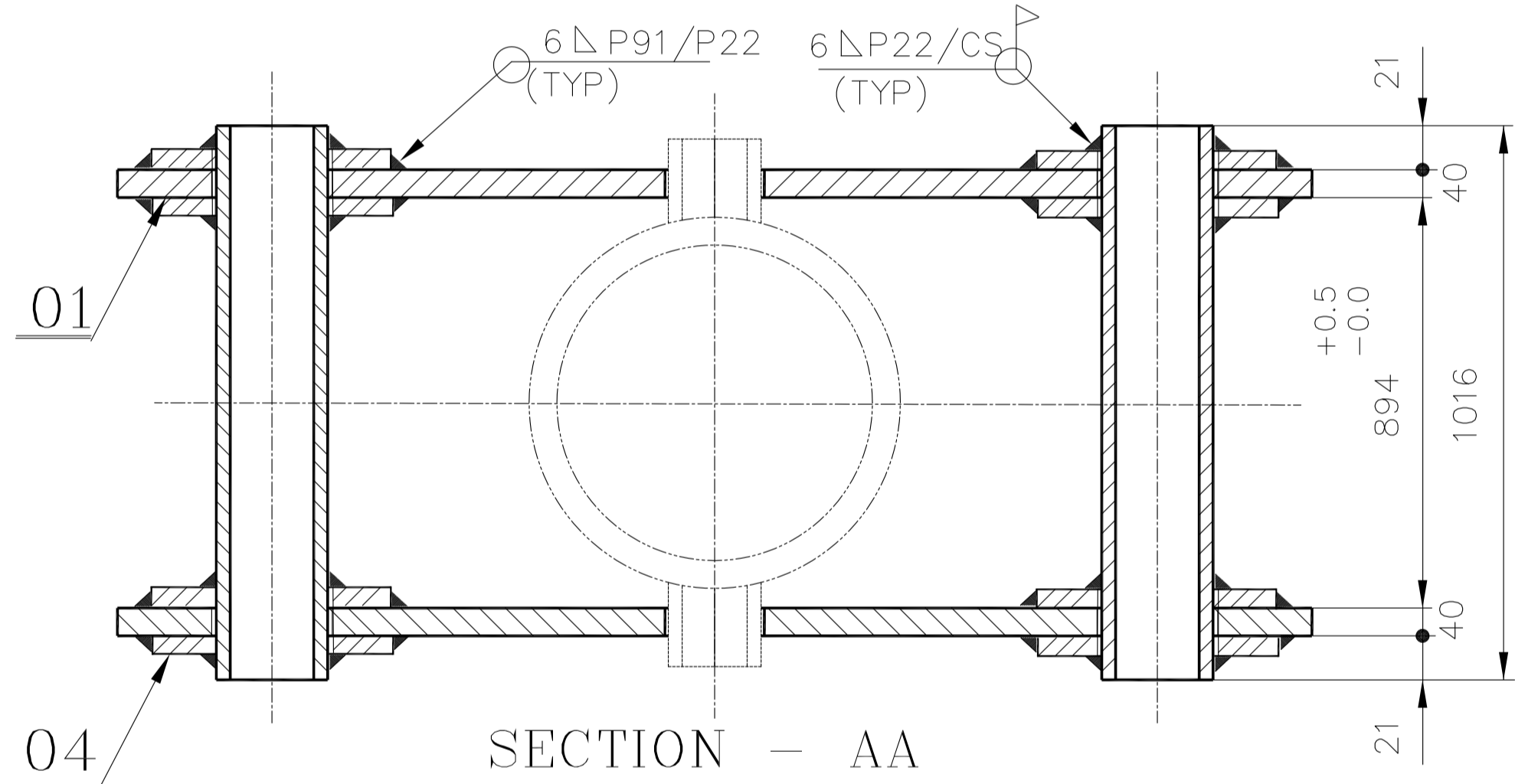
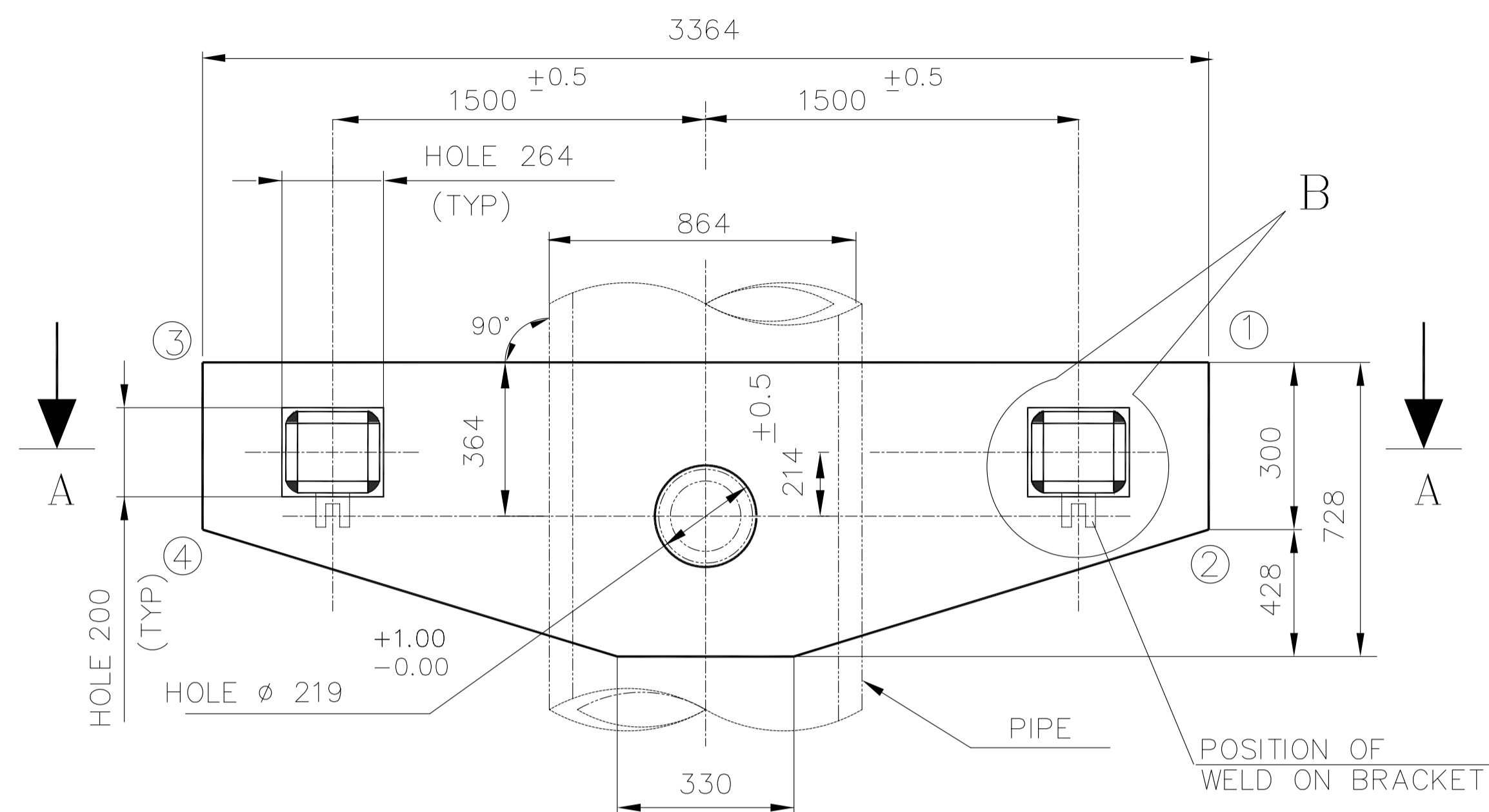


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DRAWING No
3-80-921-31204

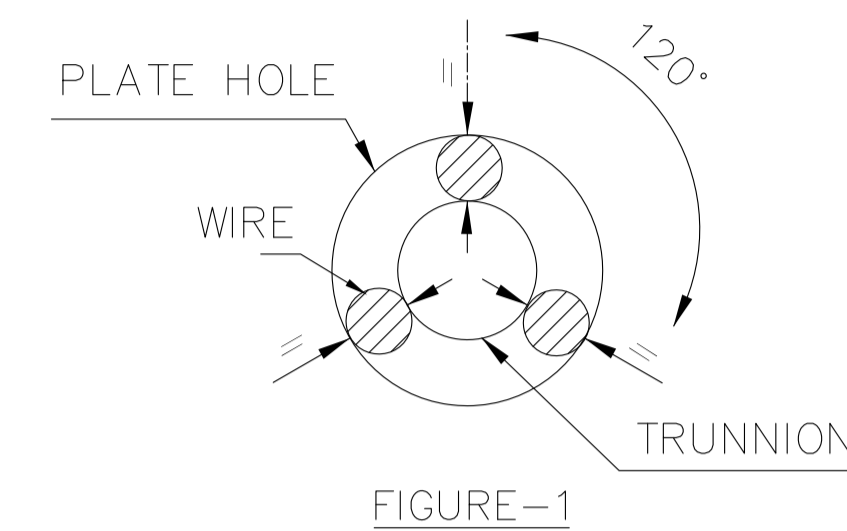


A. NOTES FOR PRODUCTION

- 1, THE CLAMP PLATE & BOX PLATE ARE TO BE TACK WELDED AT SHOP AND SENT AS A SINGLE DESPATCHABLE UNIT,
- 2, W.O NO & DU NO ARE TO BE MARKED IN BOTH THE CLAMP PLATE AS WELL AS IN BOTH THE BOXES BEFORE DESPATCH.
- 3, REQUIRED SURFACE FINISH IS
 - a, FOR HOLE: 6.3 μm
 - b, OTHER MACHINED SURFACE : 12.5 μm

B. NOTES FOR ERECTION

- 1, BEFORE TACK WELDING OF PLATE WITH BOX, THE FOLLOWING ARE TO BE ENSURED
 - a, UNIFORM GAP BETWEEN PLATE HOLE AND TRUNNION ALONG THE CIRCUMFERENCE AS SHOWN IN FIGURE -1, THIS COULD BE ENSURED BY INSERTING THIN SHEETS OF SUITABLE THICKNESS OR WIRES OF SUITABLE DIAMETER AT 3 PLACES 120° APART.
 - b, PARALLELITY OF THE TWO PLATES BY MEASURING THE INNER SURFACE TO INNER SURFACE DIMENSION AT THE FOUR CORNER POINTS ((1)-(4)) OF THE PLATES MARKED IN THE DRG. ALL THE FOUR MEASUREMENT SHALL BE TO THE DIMENSIONS GIVEN IN THE DRAWING TAKING IN TO CONSIDERATION THE TOLERANCE.
- 2, BEFORE FINAL WELDING OF BOXES TO PLATE, ROTATION OF CLAMP ABOUT TRUNNIONS IS TO BE ENSURED.
- 3, LOCATION OF WELD ON BRACKET SHALL BE AS INDICATED IN THIS DRAWING. ORIENTATION OF WELD ON BRACKET SHALL BE AS PER THE GUIDELINES GIVEN IN THE ERECTION NOTES FOR PIPING HANGERS AND SUPPORTS (DRG.NO. 4-80-999-99321)
- 4, CORRECT ELECTRODE TO BE USED FOR WELDING PLATE WITH BOX CONSIDERING PLATE & BOX MATL.SPECIFICATION.

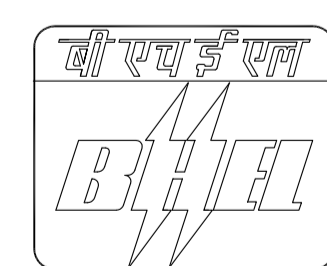


VAR NO.	ITEM NO.	DESCRIPTION	DRAWING NO.	ITEM NO.	MATERIAL CODE	A	UNIT WT.
				VAR NO.	MATERIAL SPEC.	C	QTY.
	04	STOPPER PLATE 12 x 250 x 314	3-80-921-31204		159422690000 SA387GR22CL2	C	7.39
	03	BOX PLATE 2 25 x 148 x 1016	3-80-921-31204		159421140000 SA 515 Gr70	C	29.51
	02	BOX PLATE 1 45 x 212 x 1016	3-80-921-31204		159421180000 SA 515 Gr70	C	76.087
	01	CLAMP PLATE 40 x 728 x 3364	3-80-921-31204		159421570000 SA387GR91CL2	C	520.12

1. DESIGN LOAD : 300 KN
2. MEDIUM TEMP : 596 °C
3. WELD ON BRACKET : 250 KN
4. TRUNNION SIZE : 218 ± 0.08
5. HYDRO LOAD : 300 KN

TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT

TAG No.



BHARAT HEAVY ELECTRICALS LTD.,
PIPING CENTRE,
CHENNAI 600 017

DRN	NAME YOGESH	SIGN	DATE	NO OF ITEMS
CHD	DEEPAK		08.01.14	
APPD	MANO		08.01.14	

REV	DATE	ALTERED	APPROVED	REV	DATE	ALTERED	APPROVED
02				01			
ZONE				ZONE			

DEPT.	GRADE OF UN TOL. DIM	SCALE	WEIGHT (Kg).	REF TO ASSY / OLD DRG	ITEM No.
	C/M/F		1462.628		
TITLE			CARD CODE	DRAWING No.	REV
TRUNNION CLAMP (PIPE OD 864)			U 01	3-80-921-31204	00

DETAIL - B