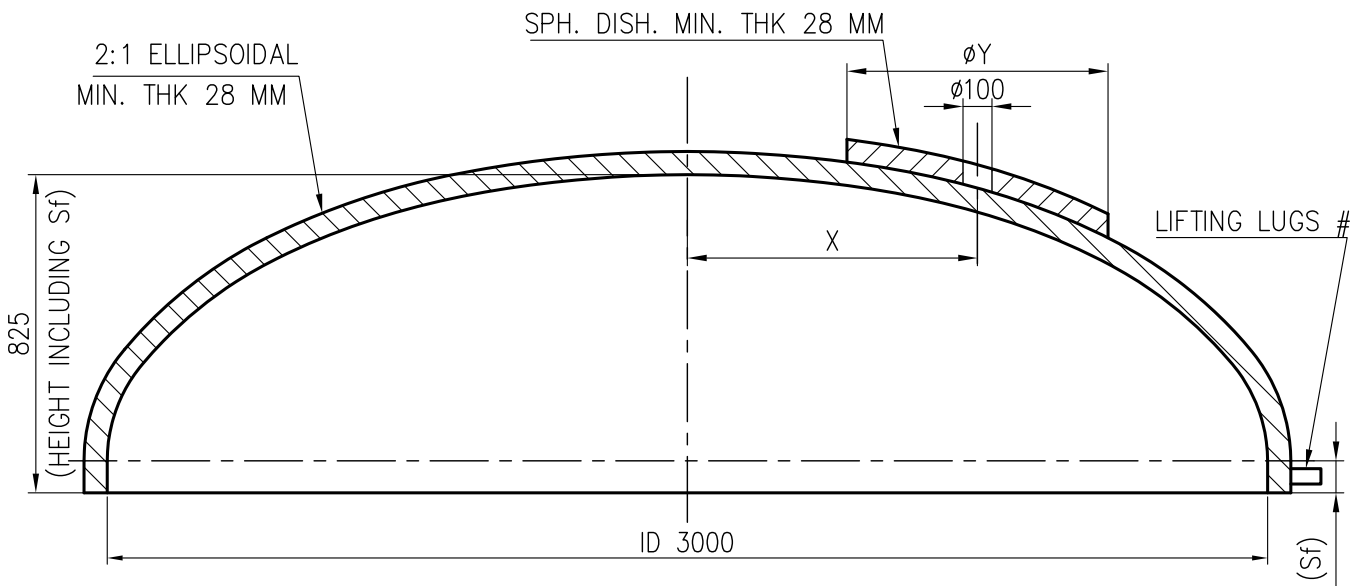


FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

INVENTORY NO. SIGN. AND DATE REF. DRG. NO. 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

REV.	DATE	ALTERED	CHECKED	APPD	REV.	DATE	ALTERED	CHECKED	APPD	ADDITIONAL INFORMATION
01	13.04.15	Uma	[Signature]	[Signature]						STATUS OF DRAWING
REVISED IN-LINE WITH IBR REQUIREMENTS.										DISTRIBUTION OF PRINTS



ITEM	Y	X
01	1700	256
02	950	0
03	500	700

DESIGN PRESSURE: 14 Kg/sq.cm (g)
DESIGN TEMPERATURE: 405° C



NOTES

- MATERIAL SHALL CONFIRM TO SA516 Gr.70 OF ASME SEC-II PART-A YEAR OF EDITION AS PER INDENT/ PO.
 - INSPECTION: BY M/s IBR/DOB & BHEL APPROVED TPIA.
 - CERTIFICATION: IBR FORM III-C.
 - DESIGN CODE: IBR REGULATIONS (CLASS-1 BOILER).
 - PLATE SHALL BE UT TESTED BEFORE FORMING (NOT REQUIRED IF ALREADY UT TESTED AT MILLS)
 - SPHERICAL DISH SHALL BE OF SEAMLESS CONSTRUCTION & PROFILE SHOULD MATCH WITH DISHED DISHED END OD AS SHOWN IN THE DRG.
 - NORMALISING SHALL BE DONE FOR SPHERICAL DISH ALSO AFTER PRESSING.
 - TEST COUPON TESTING IS REQUIRED.
 - TECHNICAL & DELIVER CONDITIONS: AS PER PRODUCT STANDARD HE51370.
- FOR PLATE WELDING REFER DRG. 4-163-10-00618.

3 NOS. LIFTING LUGS TO BE WELDED ON Sf AT 120° AND TO BE DP CHECKED AFTER WELDING.

ITEM NO.	DESCRIPTION	DRAWING NO.	MATL. CODE	UNIT Wt.
			MATL. SPEN.	QTY.

	BHARAT HEAVY ELECTRICALS LTD. HYDERABAD		DRN.	B UMA	Uma SIGN.	DATE	22.04.14	NO.OF VAR.
			CHD.	UMESH MENON	[Signature]	DATE	22.04.14	
			APPD.	TSN BHARGAV	[Signature]	DATE	22.04.14	
DEPT. HED	GRADE OF TOL.DIM. C/M/F		SCALE	NTS	WEIGHT (KG)	REF. TO ASSY DRG.	ITEM NO.	NO.OF ITEMS
CODE	405							

TITLE	SPHERICAL DISH WITH 2:1 ELLIPSOIDAL DISHED END	CARD CODE	DRAWING NO.	4-163-10-00608	REV.	01
			SHEET NO.	1	NO OF SHEETS	