

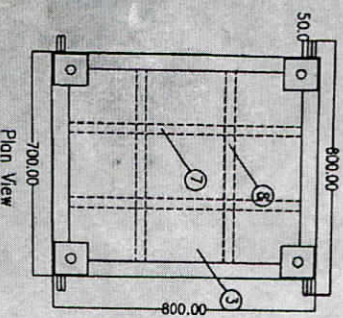
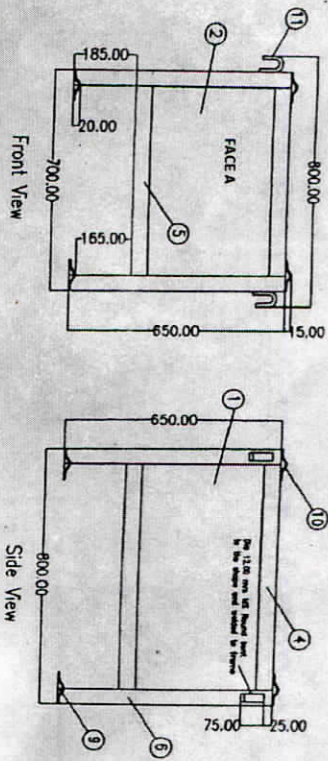
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Storage Bin for Automated Storage and Retrieval System

FINAL SCALE PRODUCTION

ALL DIMENSIONS ARE IN MM



ITEM	DESCRIPTION	QTY
1	M/S SHEET 2.0 THK X 788 WIDE X 450 HIGH (SIDE SHEET)	2 NOS
2	M/S SHEET 2.0 THK X 688 WIDE X 450 HIGH (SIDE SHEET)	2 NOS
3	M/S SHEET 2.0 THK X 788 WIDE X 688 LONG (BOTTOM SHEET WITH HOLES)	1 NO
4	M/S ANGLE 50 X 50 X 5 - 800 LONG TOP & BOTTOM FLANGE	4 NOS
5	M/S ANGLE 50 X 50 X 5 - 700 LONG TOP & BOTTOM FLANGE	4 NOS
6	M/S ANGLE 50 X 50 X 5 - 650 LONG VERTICAL MEMBERS	4 NOS
7	M/S ZPLAT 25 X 3 - 800 LONG	2 NOS
8	M/S ZPLAT 25 X 3 - 700 LONG	2 NOS
9	M/S PLATE 100 X 100 X 5 - WITH 200 SPHERE ROUNDED (BOTTOM)	4 NOS
10	M/S PLATE 100 X 100 X 5 - WITH RLS SPHERE ROUNDED (TOP)	4 NOS
11	20CIS PLAT 35 X 8 X 150 MM LONG BENT TO THE SHAPE	4 NOS

FOR DETAILS OF HOOPS, AND LOCATIONS (ITEM NOS) REFER SHEET NO. 02
FOR DETAILS OF DRAIN HOLES IN THE BOTTOM SHEET REFER SHEET NO. 03

- TECHNICAL REQUIREMENTS:**
1. CENTRE LINES OF ALL PLATE JOINTS WITH 200 SPHERE ROUNDED (BOTTOM) AND ALL PLATE JOINTS WITH RLS SPHERE ROUNDED SHOULD BE MADE FOR EACH & CONNECT TO ACCOMMODATE VERTICAL STAGING OR POSITION OVER ANOTHER.
 2. ALL DIMENSIONS ARE IN MM
 3. ALL THE 4 SIDE SHEETS & BOTTOM SHEET ARE TO BE STITCH WELDED BY ARC WELDING. (WELD LENGTH 10MM, EQUALLY SPACED WELD ELEMENTS) TO THE ANGLE FRAME.
 4. ALL OTHER WELDINGS: ANCS, FULL WELDING, ALL WELDING DIMENSIONS DENOTE LEG LENGTH.
 5. ELECTRODE TO BE USED: E6013
 6. ALL THE RESTING SURFACES SHOULD BE IN ONE PLANE.
 7. THE BINS ARE TO BE COATED WITH RED OXIDE AND TWO COATS OF SATIN BLUE COLOUR.
 8. THE BOXES SHOULD BE ABLE TO CARRY LOAD OF MINIMUM 3000 KG AND AS THE TRANSPORTATION SHALL BE DONE WITH OVERHEAD CRANES, THE LOADING SHALL BE IMPACT LOADING.
 9. SHARP EDGES ARE TO BE ROUNDED OFF.

1. THE FACE 'A' & THE OPPOSITE FACE OF THE BOX SHALL BE PAINTED WITH A DIGHT RED COLOURED NUMBER (CHARACTER SIZE 60MMX100MM). THE NUMBERS SHALL BE INITIALIATED AT THE TIME OF THE DISPATCH. INSPECTION CALL BY THE VENDOR TO BHEL.

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INVENTORY NO.	DRG. NO.	REV. NO.	DATE	DESCRIPTION	BY	APPD.	APPROVED	R. Dns	NAME	SIGN.	DATE
07	IS-3-350-105292										
06											
05											
04											
03											
02											
01											

CUSTOMER/PROJECT	NEW BLADE SHOP - BHEL, HARIDWAR AUTOMATIC STORAGE AND RETRIEVAL SYSTEM-II
TITLE	BHARAT HEAVY ELECTRICALS LIMITED INDUSTRIAL SYSTEMS GROUP, BANGALORE
JOB NO.	IS-1-07-2020
DRG. NO.	IS-3-350-105292
DIR.	ASRS
FILE NO.	10529201
NO. OF SHEETS	
SHEET NO.	

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DRG. NO. IS-3-350-105292

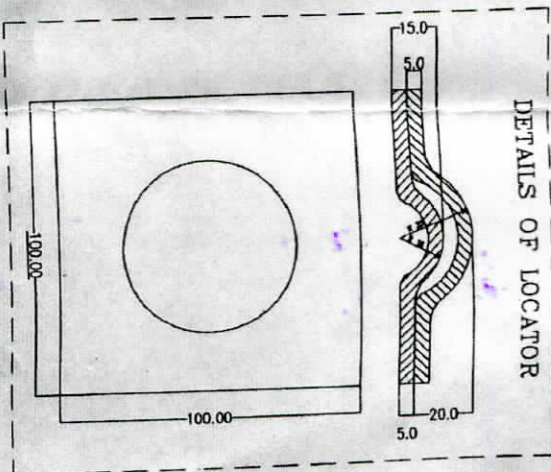
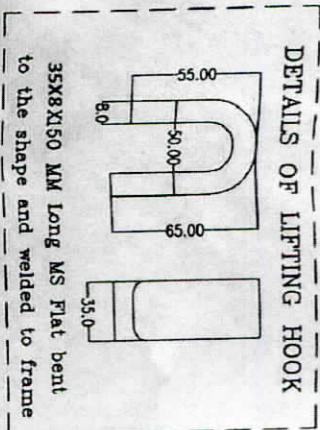
INVENTORY NO.

07
06
05
04
03
02
01
REV. NO.
DATE

Storage Bin for Automated Storage and Retrieval System

FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN MM



NOTE: 1. AS MENTIONED IN POINT TECHNICAL REQUIREMENTS IN SHEET 1, LIFTING HOOK AND LOCATOR BEAR LOAD OF MINIMUM 3000 KG AND ALSO WORK UNDER IMPACT LOADING CONDITION WHILE BEING LIFTED BY OVERHEAD CRANE.

2. LOCATORS WITH R18 SPHERE ARE TO BE WELDED AT THE FOUR TOP CORNERS OF THE BIN
3. LOCATORS WITH R25 SPHERE ARE TO BE WELDED AT THE FOUR BOTTOM CORNERS OF THE BIN

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NO.	DATE	BY	APPR.	APPROVED	RIDS	NAME	SIGN	DATE
DESIGNED	20.02.2008	R.Das						20.02.2008
DRAWN	20.02.2008	Padmanabh						20.02.2008
CHECKED	20.02.2008	Padmanabh						20.02.2008
APPROVED	20.02.2008							20.02.2008



CUSTOMER/PROJECT : NEW BLADE SHOP - BHEL, HARIDWAR
AUTOMATIC STORAGE AND RETRIEVAL SYSTEM-I

BHARAT HEAVY ELECTRICALS LIMITED
INDUSTRIAL SYSTEMS GROUP, BANGALORE

TITLE : DETAILS OF COVER, LIFTING HOOK & LOCATOR FOR BIG BIN
(GENERAL ARRANGEMENT DRAWING FOR BIG BIN)

DIR : ASRS
FILE NO. : 10529201

WTS JOB NO. IS-1-07-2020 DRG. NO. IS-3-350-105292

NO. OF SHEETS

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DRG. NO. IS-3-350-105292

INVENTORY NO.

REV. NO.	DATE
01	
02	
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DESCRIPTION	BY	APPROVED	APPROVED	R.Dos	NAME	SIGN.	DATE

DESIGNED	DRAWN	CHECKED	APPROVED	R.Dos	NAME	SIGN.	DATE

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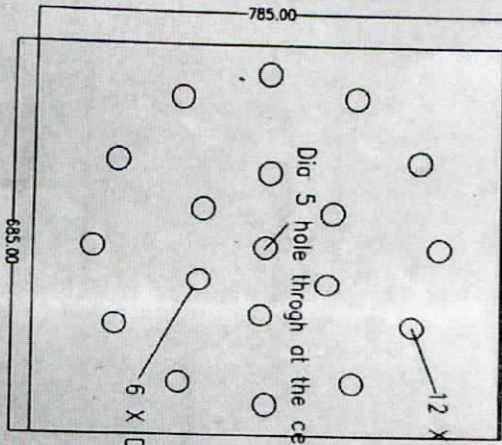
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DESIGNED	DRAWN	CHECKED	APPROVED	R.Dos	NAME	SIGN.	DATE

NOTE:
The holes in the bottom sheet are provided for draining the Oil



BOTTOM SHEET

FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN MM

CUSTOMER/ NEW BLADE SHOP - BHEL, HARIDWAR

BHARAT HEAVY ELECTRICALS LIMITED
INDUSTRIAL SYSTEMS GROUP, BANGALORE

DETAILS OF BOTTOM SHEET FOR BIG BIN
(GENERAL ARRANGEMENT DRAWING FOR BIG BIN)

SCALE 1:1 JOB NO. IS-1-07-2020 DRG. NO. IS-3-350-105292

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