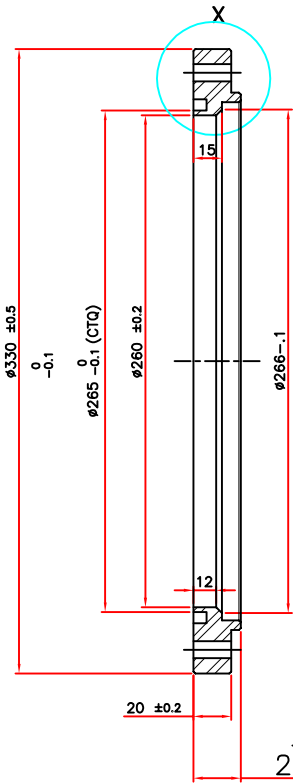
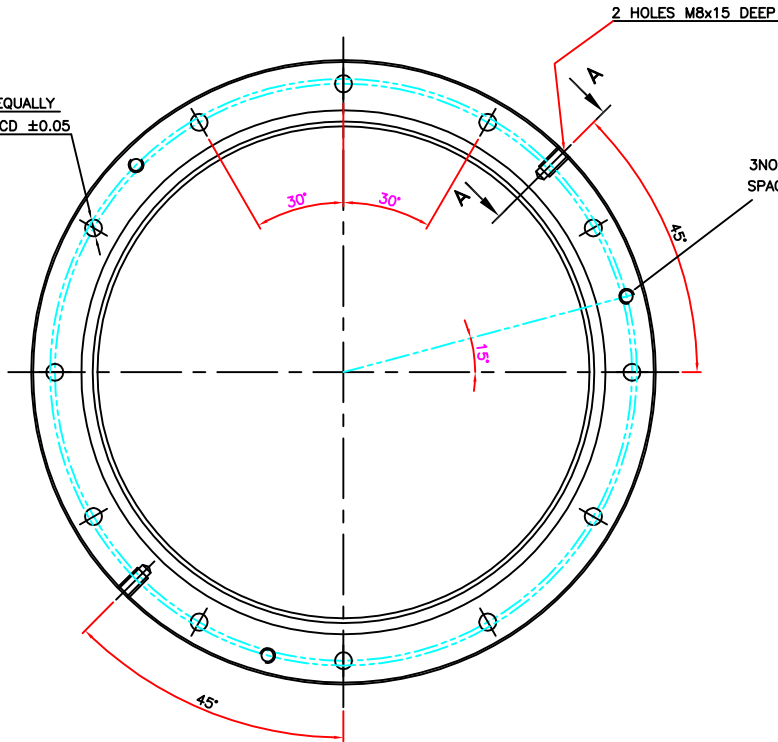


DRAWING NO. RDDG43513050\_1112

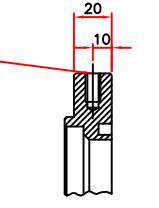
(~3.2)



12 HOLES  $\phi 9$  EQUALLY  
SPACED ON 305 PCD  $\pm 0.05$



3 NOS., M8 HOLES EQUALLY  
SPACED ON 310 PCD  $\pm 0.05$

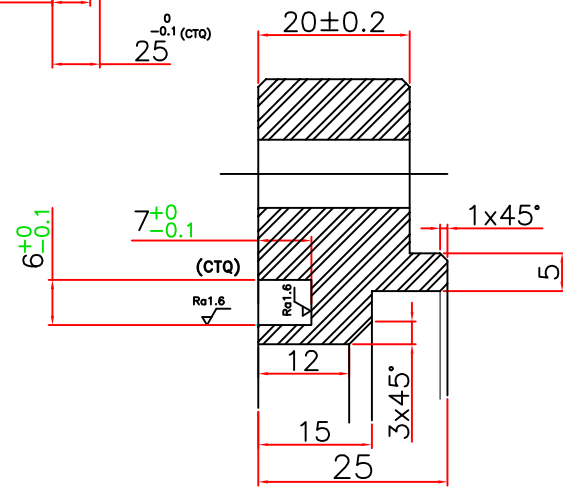


SECTION-AA

NOTES:-

1. FINISHED (FINAL) DIMENSIONS ARE GIVEN IN THIS DRG. HOWEVER THE SUPPLIER SHOULD PROVIDE NECESSARY MACHINING ALLOWANCES AS FINAL MACHINING TO BE DONE AFTER WELDING TO ACHIEVE DESIRED ACCURACY
2. THIS DIMENSION SHOULD CORRESPOND TO O.D

CTQ :- CRITICAL TO QUALITY



ENLARGED DETAIL-X

25	001	L TK.x330x330 STAINLESS S. PLATE	4.686
26	AA10740		01
27	IT.ND.	34	MATL. CODE
28	VAR.	33	MATL. SPON.
29	UNIT WT.	65	KG.
30	QTY.	71	CS.
31	ZONE		

ADDITIONAL INFORMATION: TYPE OF PRODUCT: **33kV/40kA DOUBLE BUS GIS**  
STATUS OF DRAWING: DR. NAME OF CUSTOMER / PROJECT: **BHARAT HEAVY ELECTRICALS LTD. BHOPAL**

DISTRIBUTION OF PRINTS			DRN. NAME	SIGN	DATE	NO. OF
SWE	SWM		CKD.	MMR		14.12.13
1	3	1	APPD.	NB		

REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED
		CHECKED			CHECKED			CHECKED			CHECKED			CHECKED
		APPROVED			APPROVED			APPROVED			APPROVED			APPROVED

DEPT. SWE	UNTL. DIMS. GR.	SCALE	WEIGHT < K.G. >	REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEM
409		1:1		RDDG43513050_1110		
TITLE: <b>FLANGE-1</b>			DRAWING NO. <b>RDDG43513050_1112</b>		REV. <b>00</b>	
			SHEET NO. 01		NO. OF SHEETS 01	

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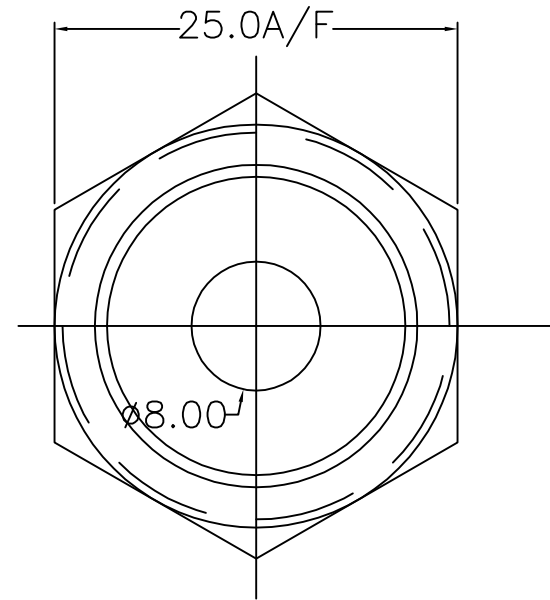
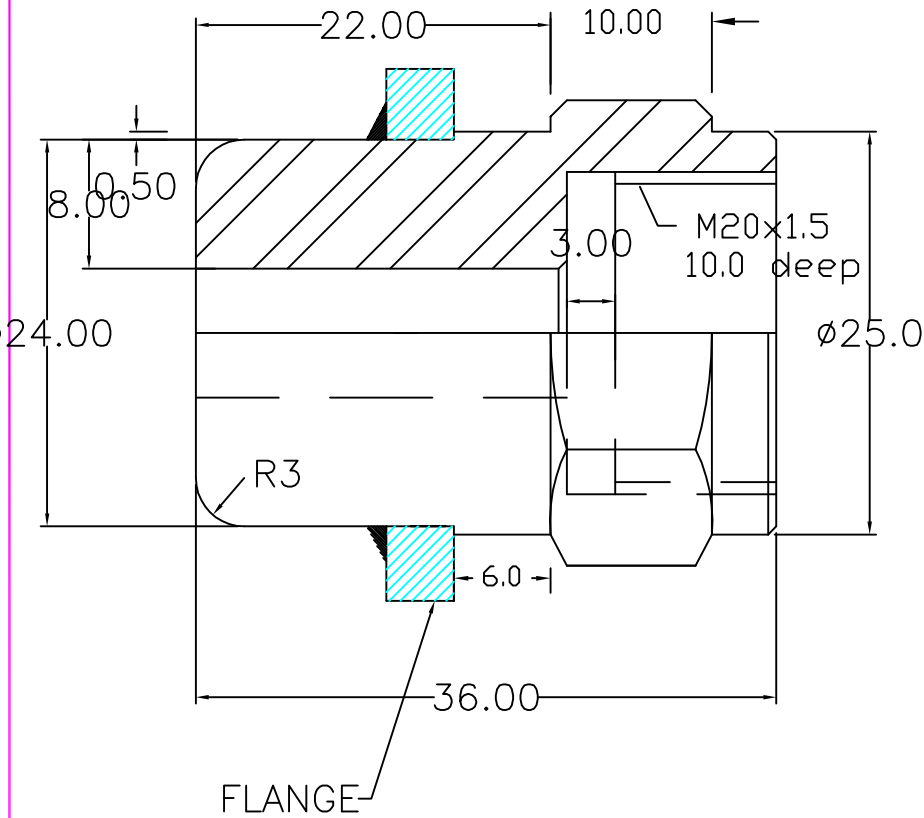
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FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

(~3.2)

DRG. NO. RDDG43513050\_1304



			01	HEX ROD		25 A/FX35		ST.STEEL		0.16 KG.		
								AISI 304-L		1		
VAR.00	REMARKS	VAR NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.ND.	MATL. CODE	A C	UNIT	UNIT WT.	ZONE
							VAR	MATL. SPECN.			QTY.	GS

NOTE:-

To be welded to terminal flange  
 Drill and deburr  $\phi 24.0$  hole in base  
 and weld full on external surface.  
 Remove all sharp corners use R 0.2

TYPE OF PRODUCT		36kV / 40kA DOUBLE BUS GIS									
NAME OF CUSTOMER		36kV / 40kA DOUBLE BUS GIS									
	BHARAT HEAVY ELECTRICALS LTD.		DRN	NAME	SIGN.	DATE	NO.OF				
	HYDERABAD		CKD	SNK		11.02.14	VAR.				
			APPD	MMR			-				
DEPT.	GRADE OF TOL. DIM. C/M/F	SCALE	WEIGHT(KG)	REF. TO	ITEM NO.	NO.OF					
CODE		NTS		RDDG43513050_1300	-	ITEMS					
TITLE			CARD CODE	DRAWING NO.	REV.						
GAS STUD				RDDG43513050_1304	00						
				SHEET NO.	NO. OF SHEETS						

REV.	DATE	ALTERED	REV.	DATE	ALTERED
		CHECKED			CHECKED
ZONE			ZONE		

REF. DRG. NO.

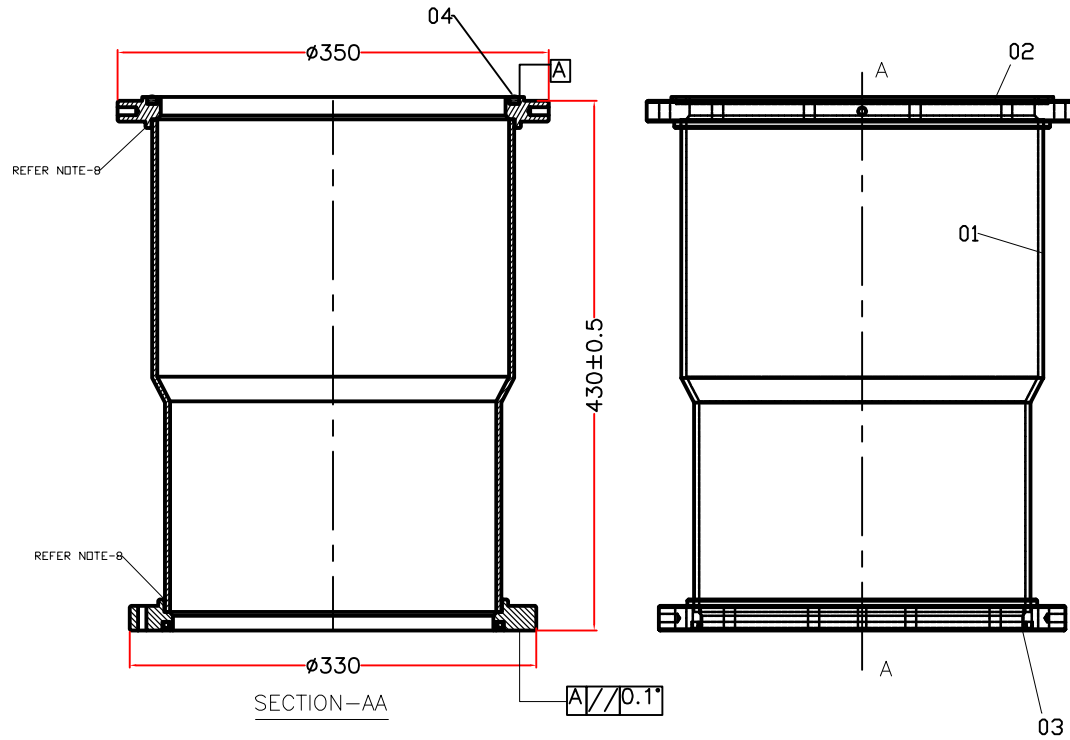
SIGN. AND DATE

INVENTORY NO.

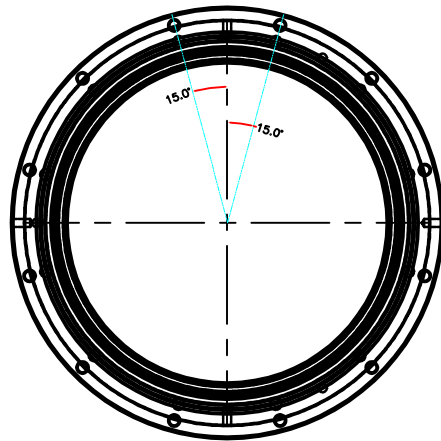
RDDG43513050\_1710

DRAWING IN ENGLISH

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SECTION-AA



**NOTES :-**

1. THE DIMENSIONS GIVEN IN THIS DRG. INCLUDING DIMENSIONS OF DETAILED COMPONENT ARE TO BE MAINTAINED BY MACHINING IN THIS ASSEMBLY. DETAILED COMPONENT DRAWINGS ARE SHOWING FINAL DIMENSIONS AND NECESSARY MACHINING ALLOWANCES ARE TO BE KEPT BY THE SUPPLIER FOR MACHINING/WELDING.
2. PARALLELISM AND PERPENDICULARITY OF ITEM 002 & 003 FLANGES SHOULD BE MAINTAINED THROUGH WELDING/FIXTURE/MACHINING.
3. ALL INSIDE WELDS SHOULD BE GROUND SMOOTH.
4. PIPE TO BE ZINC PLATE INSIDE SURFACE TO BE ELECTRO POLISHED.
5. POWDER COAT ALL EXTERNAL SURFACES (SIMENS GRAY) AFTER THROUGH CLEANING AND DEGREASING ASSEMBLY IN SOLVENT. PROTECT SEALING SURFACES USING SUITABLE MASK (AVOID USING GREASE, COTTON WASTE).
6. ALL FLANGE FACES SHOULD BE PROTECTED USING SUITABLE MASK BEFORE PACKING FOR DESPATCH.
7. ALL JOINTS TO BE TIG / FUSION WELDED TO HAVE MINIMUM DISTORTION.
8. LEAK TEST WILL BE DONE AT R&d USING 2 DUMMY FLANGES.

CTQ :- CRITICAL TO QUALITY

ITEM NO.	DESCRIPTION	QTY.	UNIT	WT. KG.	ZONE
005	GASKET	1	PC	-	01
004	O-RING 286	1	PC	-	01
003	FLANGE-1	1	PC	-	01
002	FLANGE-2	1	PC	-	01
001	VT ENCLOSURE	1	PC	-	01

ADDITIONAL INFORMATION		TYPE OF PRODUCT 33kV/40kA DOUBLE BUS GIS	
STATUS OF DRAWING		NAME OF CUSTOMER / PROJECT	
DISTRIBUTION OF PRINTS		DR. SNK CKD. MMR APPD. NB	
SWE	SWM	TCX	
1	3	1	
REV.	DATE	ALTERED	DATE
		CHECKED	
		APPROVED	
DEPT. SWE		UNTO. DIMS. GR.	SCALE
CODE 409			1:1
TITLE		VEIGHT < K.G. >	REF. TO ASSY. DRG.
VT ENCLOSURE ASSY.			RDDG43513050_1700
		DRAWING NO.	REV
		RDDG43513050_1710	00
		SHEET NO. 01	NO. OF SHEETS 01

INVENTORY NO. SIGN & DATE

ZONE	REV.	DATE	ALTERED	ZONE	REV.	DATE	ALTERED	ZONE	REV.	DATE	ALTERED	ZONE	REV.	DATE	ALTERED
			CHECKED				CHECKED				CHECKED				CHECKED
			APPROVED				APPROVED				APPROVED				APPROVED

RDDG43513050\_1711

4.19

$\phi 293.88 \pm .1$   
 $\phi 285.5$

400 ± 0.5

4.19

170 ± 0.5  
190 ± 0.5

$\phi 264.72$

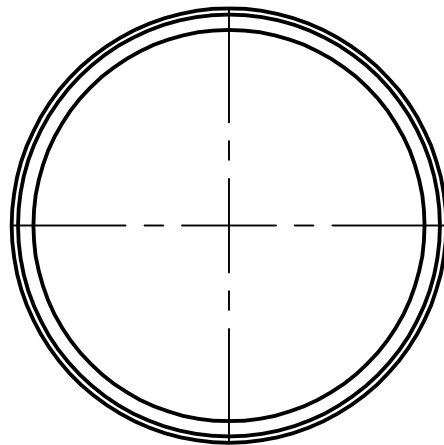
$\phi 273.1$

SECTION-AA

TIG WELDING

152.55°

(~3.2)



		001		PIPE		M.S		-	
REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	DRAWING NO.	STD	UNIT WT.	QTY.	UNIT WT.	ZONE

- NOTE:
1. ENDS SHOULD BE PARALLEL (IN 0.2 MM) AND COAXIAL.
  3. THE PIPE SHOULD BE WITH MINIMUM OVALITY AND STRAIGHT.

ADDITIONAL INFORMATION				TYPE OF PRODUCT OR NAME OF CUSTOMER / PROJECT			
STATUS OF DRAWING				33kV/40kA DOUBLE BUS GIS			
DISTRIBUTION OF PRINTS				Bharat Heavy Electricals Ltd. Bhopal			
SWE	SWM	TCX		DRN. CKD.	NAME	SIGN	DATE
1	3	1		MMR			07.02.14
				APPD.	NAME		NO. OF VAR
				NB			
REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE
		CHECKED			CHECKED		
		APPROVED			APPROVED		
DEPT. SWE				UNTL. DIMS. GR.			
CODE 409				SCALE 1:1			
TITLE				WEIGHT < K.G. >			
VT ENCLOSURE				REF. TO ASSY. DRG.			
				ITEM NO.			
				RDDG43513050_1711			
				DRAWING NO.			
				R00			
				SHEET NO. 01			
				NO. OF SHEETS 01			

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