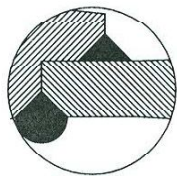
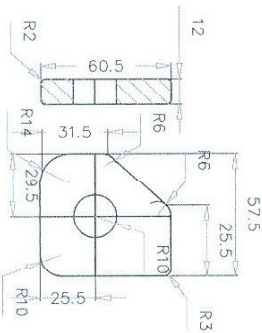
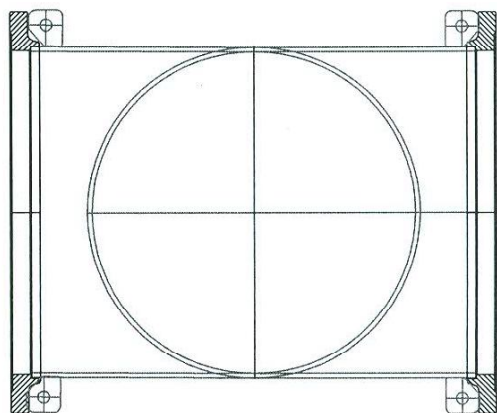
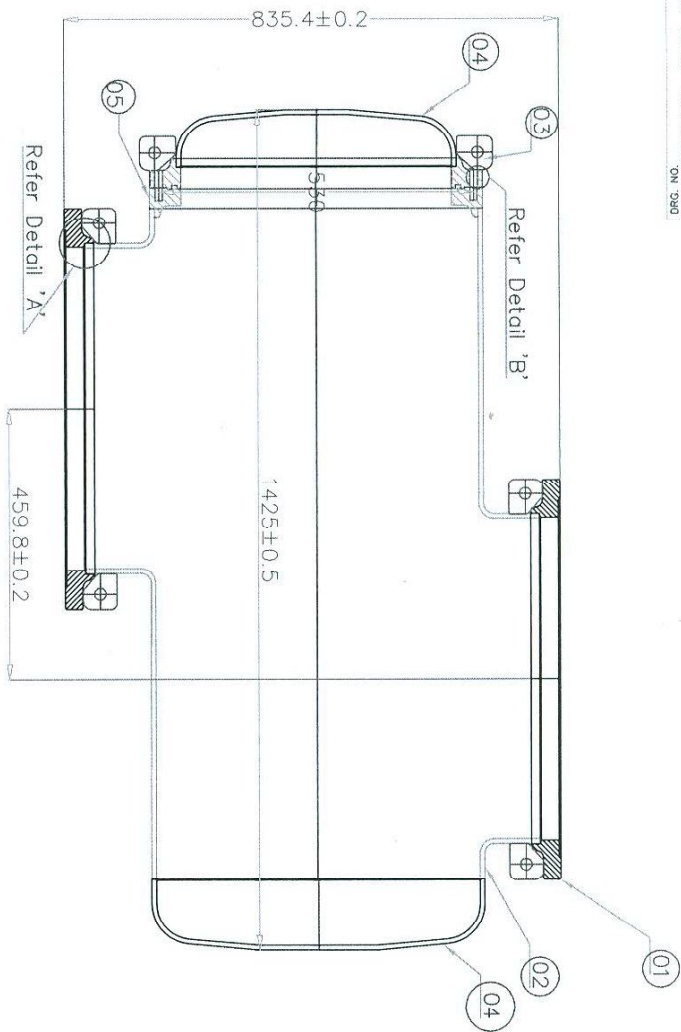


EP00-4190-5349GDD
ON 989

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

(~1.6)



1. The Root should be Homogeneous and Continuous.
2. Pressure Test as per Enclosed Specification.
3. Tested Assemblies to be Degreased, sand Blasted and Powder Coated on Outside.
4. Electro Polish inside Surface.
5. Machining of flanges shall be done after Welding.
6. The PCD of flanges shall be within Tolerances.
7. Pipe and Flanges should be TIG/MIG welded with suitable Electrode.

VAR NO	REMARKS	VAR NO	ITEM NO.	DESCRIPTION	DRWG NO.	ITNO.	MATL CODE	A	C	UNIT WT.	QTY.	ZONE
01	Flange IV	RD DG 435 0617 0651	SS-304L			SS-304L				02		
02	Pipe IV	RD DG 435 0617 043A	SS-304L			SS-304L				01		
03	Dish I	RD DG 435 0617 043B	SS-304L			SS-304L				01		
04	Dish END	RD DG 435 0617 043C	SS-304L			SS-304L				01		
05	Flange II	RD DG 435 0617 044D	SS-304L			SS-304L				01		

TYPE OF PRODUCT
NAME OF CUSTOMER

GSM-420



BHARAT HEAVY ELECTRICALS LTD.
HYDERABAD

DEPT. GRADE OF TOL. DIM. C/M/F



SCALE NTS

WEIGHT(S)

4-way Enclosure Assembly

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

DRW. NO.	DATE	SIGN.	DATE	NO. OF
RD DG 435-0617-0043	01.05.13	SA	01.05.13	1
RD DG 435-0617-0043	01.05.13	MMR	01.05.13	1

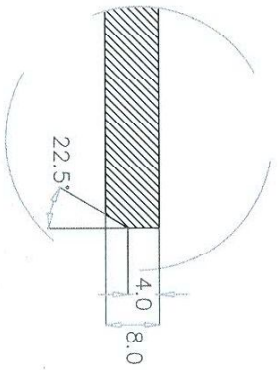
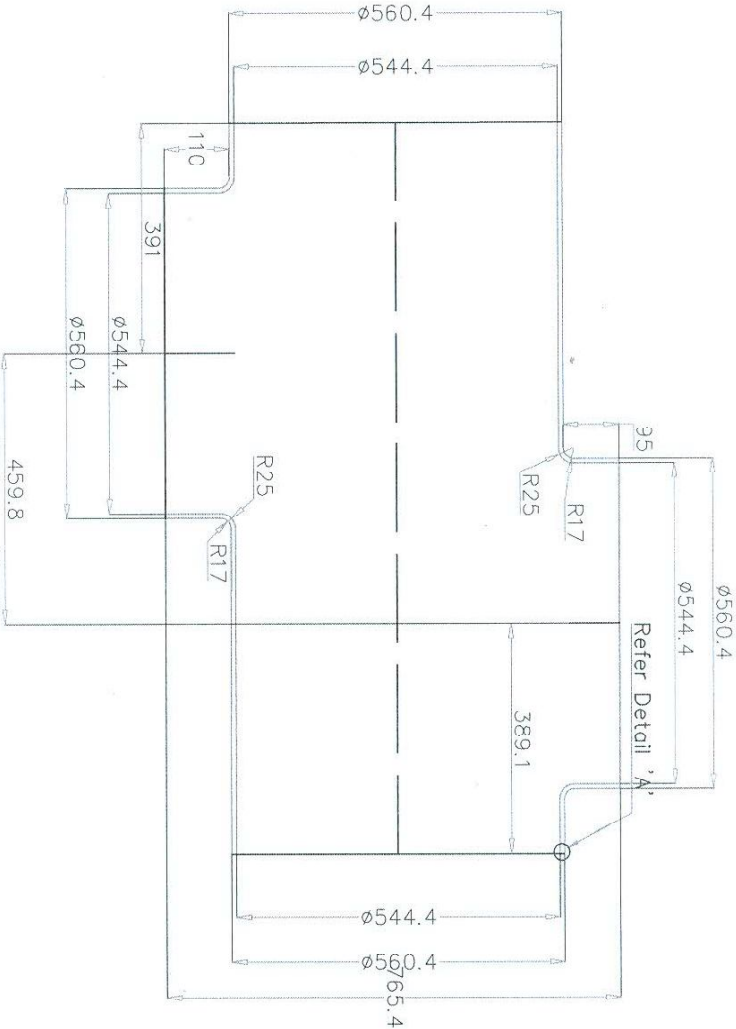
CARD CODE	DRWING NO.	NO. OF SHEETS
RD DG 435-0617-0043		

V4400-1190-05 RDDG435-0617-0043A
ON DRG.

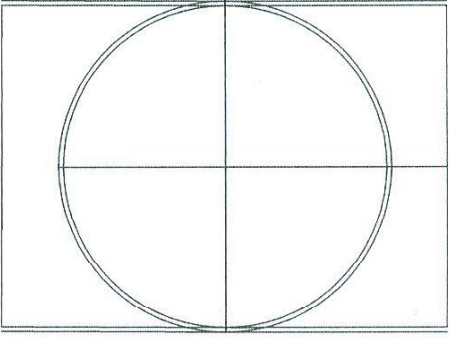
FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

(~1.6)



Enlarged View of 'A'



VAR. NO.	REMARKS	VAR. ITEM NO.	DESCRIPTION	STD.	DRAWING NO.	IT. NO.	MATL. CODE	A	UNIT WT.	NO. OF
								LINE	QTY.	ZONE

TYPE OF PRODUCT: **GSM-420**
NAME OF CUSTOMER: **BHARAT HEAVY ELECTRICALS LTD. HYDERABAD**

DEPT.: **NTS**
SCALE: **1:1**
GRADE OF TOL. DIM. C/M/F: **NTS**
WEIGHT(G):

DRN. NO.: **01.05.13**
DATE: **01.05.13**
SIGN.:

CARD CODE: **RDDG435-0617-0043A**
SHEET NO.:
NO. OF SHEETS:

REV.	DATE	ALTERED CHECKED	ZONE

REMARKS

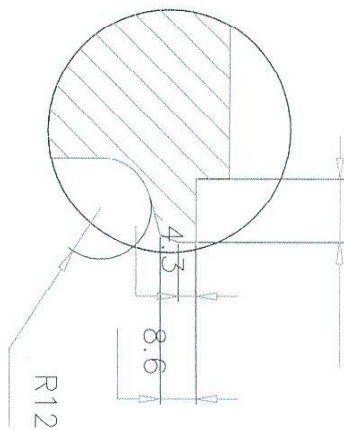
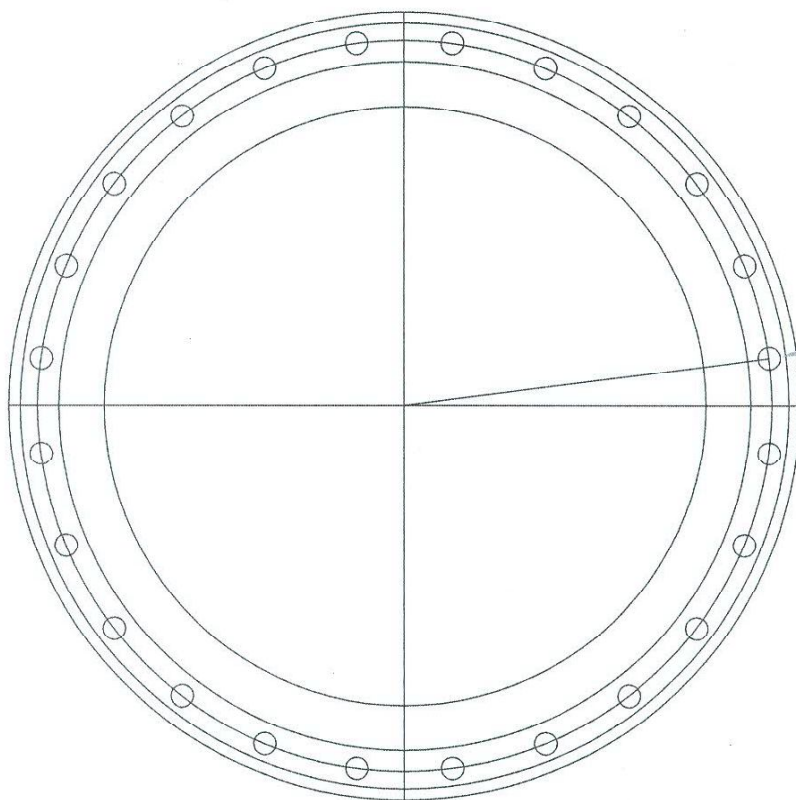
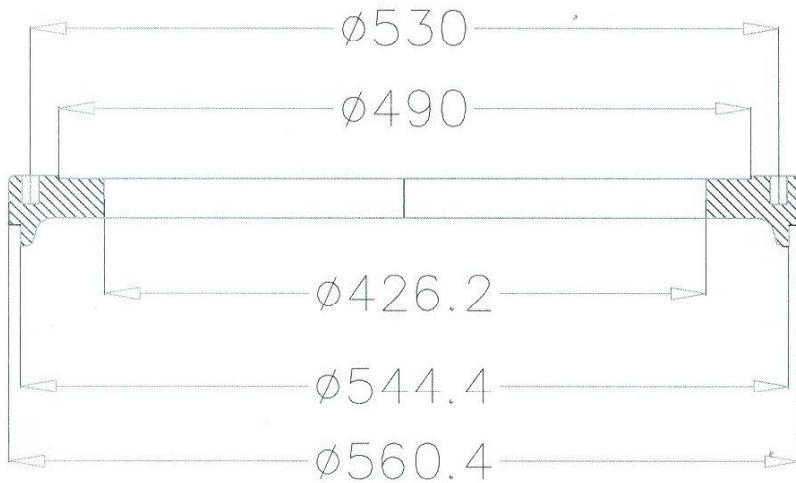
3E400-4190-5E435

ON DRG

FIRST ANGLE PROJECTION

24 Nos of M12 taps @ PCD 530.0

(ALL DIMENSIONS ARE IN mm)



15

VAR. NO.	REMARKS	VAR. ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT. NO.	MATL. CODE	A	UNIT WT.	ZONE
			FLANGE-II		RDDG435 0617 0043E					

TYPE OF PRODUCT
NAME OF CUSTOMER

FLANGE-II



BHARAT HEAVY ELECTRICALS LTD.
HYDERABAD

DRN NAME
SA SA
CHK APPD MMR

DEPT. GRADE OF C/M/J



SCALE

WEIGHT(KG)

REF. TO RDDG435 0617 0043

TITLE

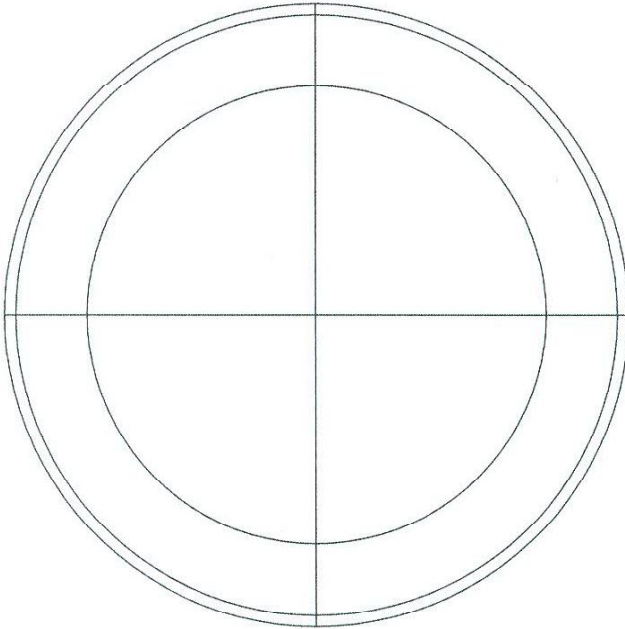
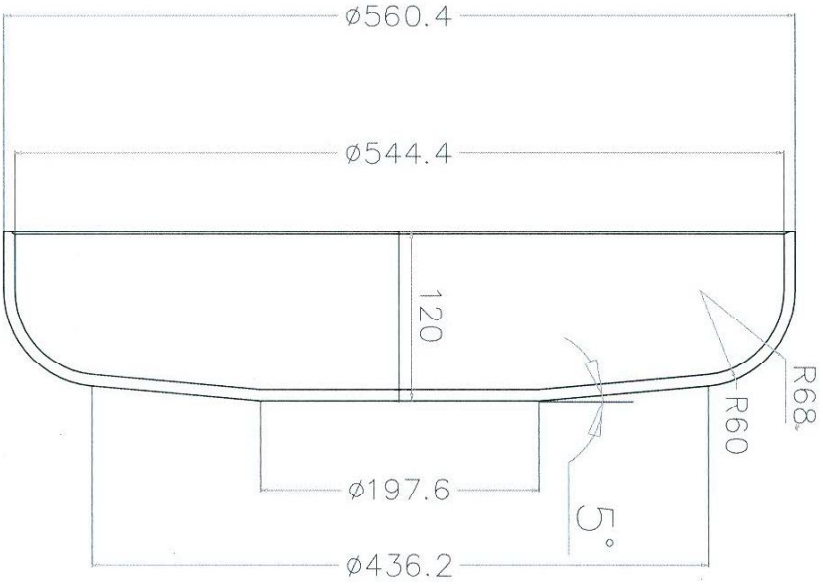
FLANGE-II

FRAMING NO. RDDG435 0517 0043E

NO. OF SHEETS

REV.	DATE	ALTERED	CHECKED	ZONE

REV.	DATE	ALTERED	CHECKED	ZONE



VAR. NO.	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	STD.	DRAWING NO.	VAR.	IT. NO.	MATL. CODE	A	C	UNIT WT.	QTY.	SS	ZONE
01				DISH-I		RD RD 4 35 0617 0043D			SS-304L			01			

TYPE OF PRODUCT
NAME OF CUSTOMER
GSM-420



DRN	SA	NAME	SIGN.	DATE	NO. OF
DKD	MMR/AD	MMR/AD		26/12/15	VAR.
APPR.	MMR/AD			02/01/16	
				03/01/16	
					01

DEPT.	SCALE OF	WEIGHT(KG)	REF. TO	NO. OF
HYDRABAD	1:1			HEADS
	NTS			

TITLE	CARD CODE	DRAWING NO.	REV.
DISH-I		RD DG 4 35 0617 0043D	1
		SHEET NO.	NO. OF SHEETS
		RD DG 4 35 0617 0043D	

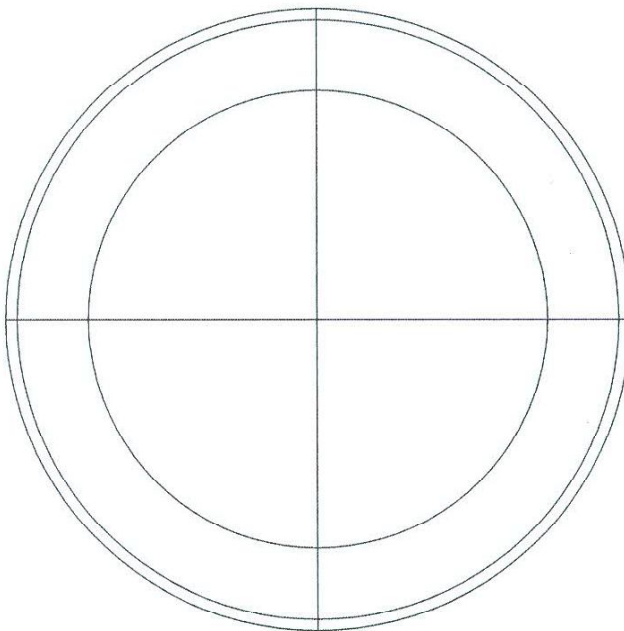
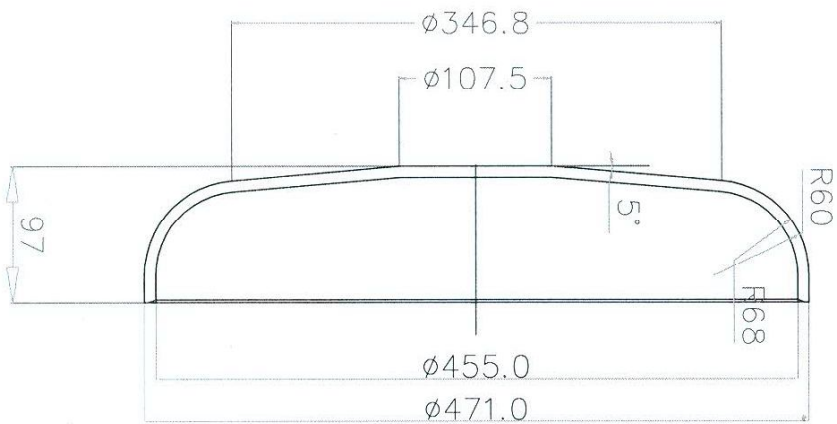
REV.	DATE	ALTERED	REV.	DATE	ALTERED
ZONE	CHECKED	CHECKED	ZONE	CHECKED	CHECKED

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

RD DG 4 35 0617 0043C-1

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)



VAR. NO.	REMARKS	VAR. ITEM NO.	DESCRIPTION	IS	DRAWING NO.	VAR.	IT. NO.	MATL. CODE	C	A	UNIT	WT.	QTY.	ZONE
01			DISH		RD RD 4 35 0617 0043C			SS-304L				01		

TYPE OF PRODUCT
NAME OF CUSTOMER
GSM-420

DEPT. GRADE OF TOL. DIM. C/M/J/F
BHARAT HEAVY ELECTRICALS LTD.
HYDERABAD

SCALE
NTS

TITLE
DISH-II

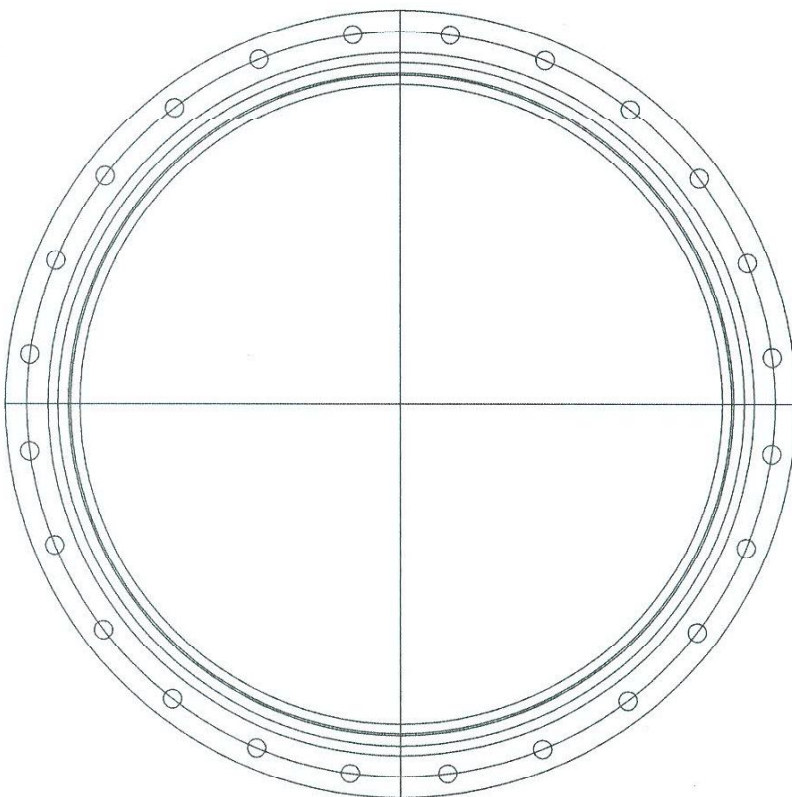
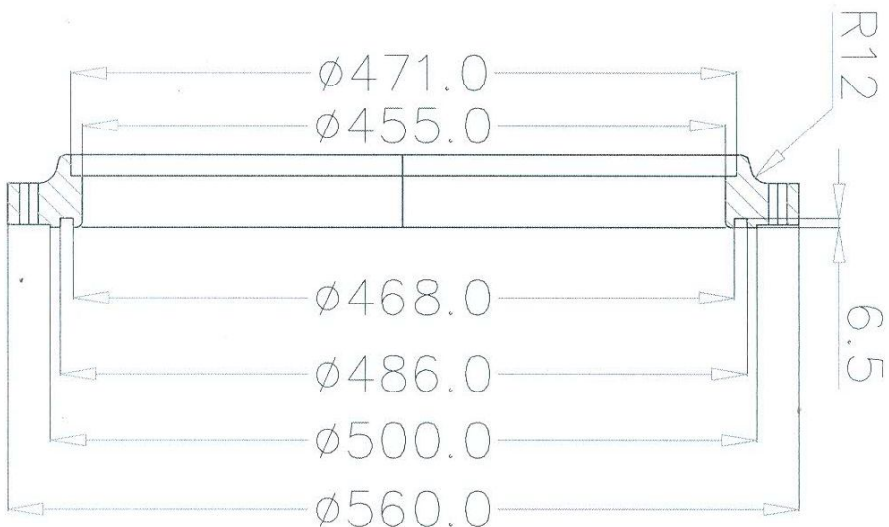
REV.	DATE	ALTERED	REV.	DATE	ALTERED	ZONE	ZONE
		CHECKED			CHECKED		

CARD CODE
RD DG 4 35 0617 0043-1
SHEET NO. NO. OF SHEETS

DRWING NO. 1

NAME SA SA
SIGN. SA SA
DATE 01.01.16 01.01.16
NO. OF 01

5



VAR. NO.	REMARKS	VAR. ITEM NO.	DESCRIPTION	STD.	DRAWING NO.	IT. NO.	MATL. CODE	A UNIT	UNIT WGT.	ZONE

TYPE OF PRODUCT
NAME OF CUSTOMER



BHARAT HEAVY ELECTRICALS LTD.
HYDERABAD

DRN NO. NAME SIGN. DATE NO. OF VAR.

DEPT. CODE GRADE OF C/M/DM SCALE WEIGHT(KG) APPD. REF. TO ITEM NO. OF ITEMS

TITLE CODE RD DG 4 35 0617 0043C-2 DRAWING NO. SHEET NO. NO. OF SHEETS

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

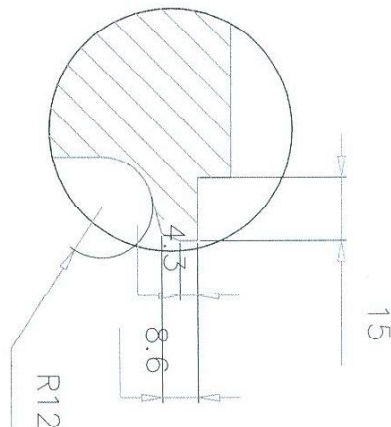
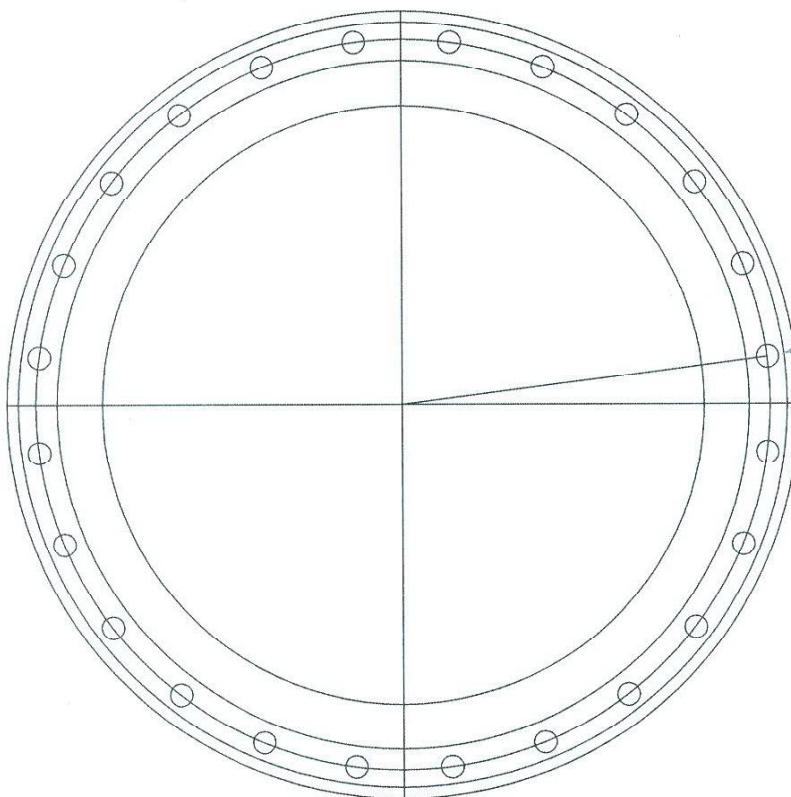
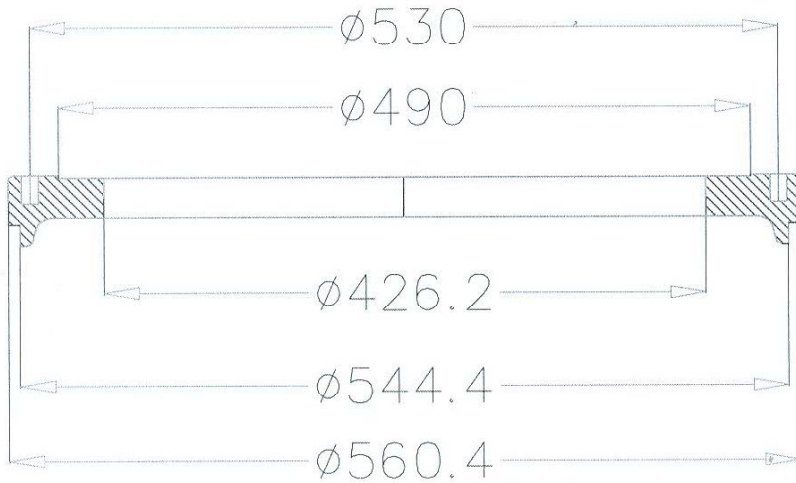
3E7400-1190-0619-05435-000

DRG. NO.

FIRST ANGLE PROJECTION

24 Nos of M12 taps @ PCD 530.0

(ALL DIMENSIONS ARE IN mm)



VAR. NO.	REMARKS	VAR. ITEM NO.	DESCRIPTION	STD.	DRAWING NO.	ITNG. VAR.	MATL. CODE	A. C. LIN.	UNIT WT.	QTY.	ZONE
			FLANGE-II		RDDG435 0617 0043E						

TYPE OF PRODUCT
NAME OF CUSTOMER

FLANGE-II



BHARAT HEAVY ELECTRICALS LTD.
HYDERABAD

DEPT. CODE

GRADE OF TOL. DIM. C/M/F



SCALE

WEIGHT (kg)

DRN. CHKD.	NAME	SIGN.	DATE	NO. OF VARS.
SA	SA			
MMR	MMR			

REF. TO

ITEM NO. OF

RRDDG435 0617 0043

RRDDG435 0617 0043E

CARD CODE

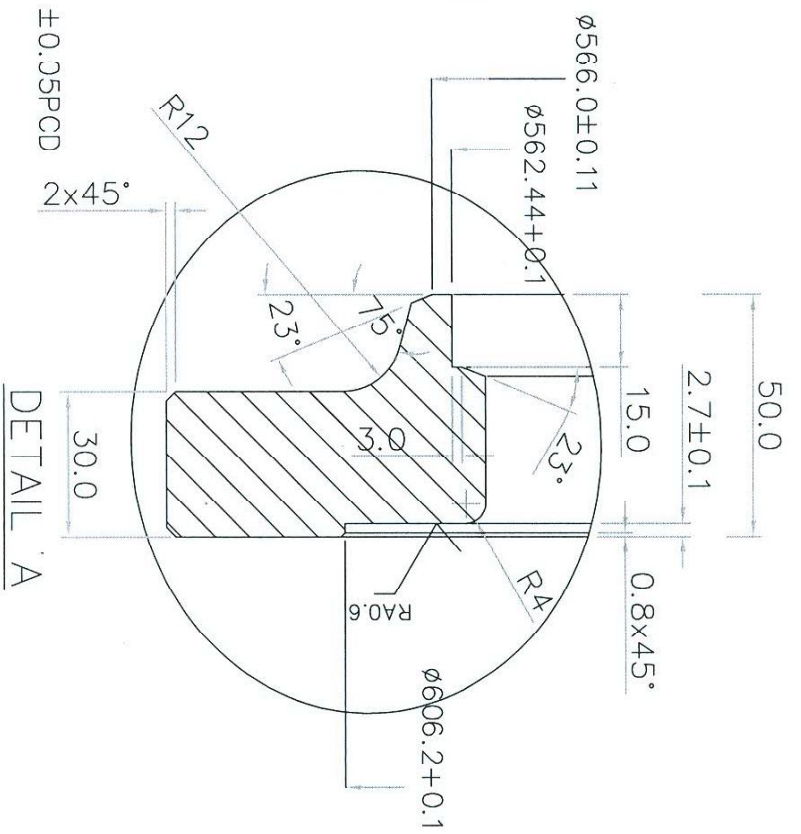
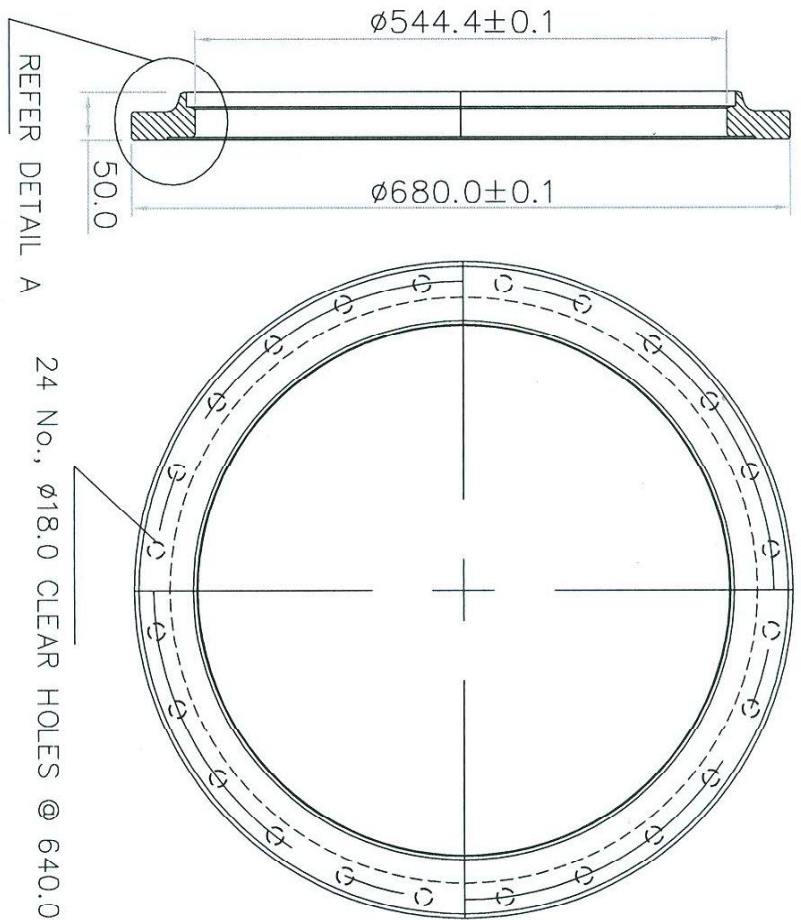
RRDDG435 0617 0043E

REV.

REV.	DATE	ALTERED CHECKED	ZONE

REV.	DATE	ALTERED CHECKED	ZONE

SHEET NO.	NO. OF SHEETS
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Note:

1. Sealing area shall be polished to RA 0.8 or better.
2. ϕ 18.0 holes shall be chamfered uniformly (0.8x45°).
3. PCD and flange centre shall be concentric within ± 0.1
4. Finished flange shall be degreased and packed in 125 micron poly bag and sealed.
5. Component shall be Machined to dimensions after welding to spherical pipe

FINAL ON 29/05/14

VAR. NO.	REMARKS	VAR. NO.	VAR. NO.	SS FLANGE	RD DG 4 35 0617 0113B	SS-304 L	450 KG
01				DESCRIPTION			02

TYPE OF PRODUCT		NAME OF CUSTOMER		SCALE		WEIGHT(KG)		DATE	
SS FLANGE		BHARAT HEAVY ELECTRICALS LTD		NTS		450 KG		28/12/05	
RD DG 4 35 0617 0113B		HYDERABAD		SS-304 L				02/01/08	
SS-304 L		KSRMD		MNS				02/01/08	
450 KG		MNS		SS-304 L				02/01/08	
02		MNS		SS-304 L				02/01/08	
02		MNS		SS-304 L				02/01/08	
02		MNS		SS-304 L				02/01/08	

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

FLANGE I		RD DG 4 35 0617 0951		RD DG 4 35 0617 0951		RD DG 4 35 0617 0951	
RD DG 4 35 0617 0951		RD DG 4 35 0617 0951		RD DG 4 35 0617 0951		RD DG 4 35 0617 0951	
RD DG 4 35 0617 0951		RD DG 4 35 0617 0951		RD DG 4 35 0617 0951		RD DG 4 35 0617 0951	
RD DG 4 35 0617 0951		RD DG 4 35 0617 0951		RD DG 4 35 0617 0951		RD DG 4 35 0617 0951	