



12 HOLES $\phi 12$ ON PCD 310 ± 0.5 (EQUALLY SPACED)
AND $0.5 \times 45^\circ$ CHAMFERED ON BOTH FACES (CTQ)

1. PIPE, BELLOWS AND FLANGE TO BE TIG/MIG WITH SUITABLE SS ELECTRODE.
 2. THE ROOT SHOULD BE HOMOGENEOUS AND CONTINUOUS.
 3. TESTED ASSEMBLY TO BE DEGREASED, SAND BLASTED AND POWDER COATED ON OUTSIDE.
 4. INNER SURFACE SHOULD BE ELECTROPOLISHED.
 5. All inner edges of pipe connecting to bellows should be rounded to R2.
- Note: * Dimensions are tentative and can be changed according to BHEL Specifications.

VAR. NO.	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	QTY	DRAWING NO.	TTM NO.	MATL. CODE	MATL. SPECN.	UNIT	QTY.
			06	Gas Stud	3	520 75 12102		SS-304L			01
			05	Lug				SS-304L			08
			04	TIE ROD				SS-304L			04
			03	FLANGE	3	520 75 12100		SS-304L			02
			02	BELLOWS				SS-304L			02
			01	PIPE				SS-304L			01

GSM-145

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.													
TYPE OF PRODUCT NAME OF CUSTOMER BHARAT HEAVY ELECTRICALS LTD. HYDERABAD			DEPT. TON DIM C/M/F		SCALE NTS		WEIGHT(G) APPD. MMRAD		DEN. NAME SA SA		SIGN.		DATE 07/06/13		NO. OF SHEETS 01	
TITLE EXPANSION JOINT WITH BELLOWS			CODE 35200501302		SCALE NTS		WEIGHT(G) APPD. MMRAD		DEN. NAME SA SA		SIGN.		DATE 07/06/13		NO. OF SHEETS 1	
SHEET NO. 35200501302 A			DRAWING NO. 35200501302		SCALE NTS		WEIGHT(G) APPD. MMRAD		DEN. NAME SA SA		SIGN.		DATE 07/06/13		NO. OF SHEETS 1	