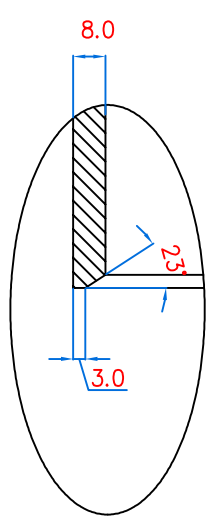
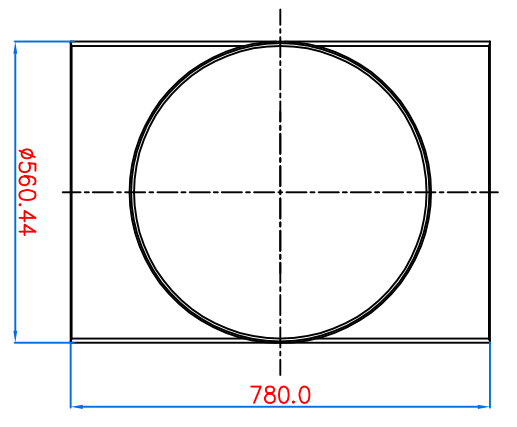
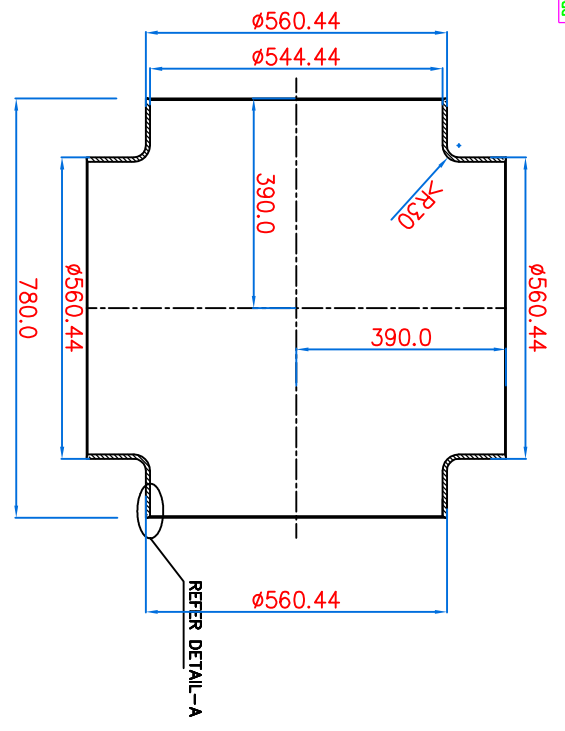
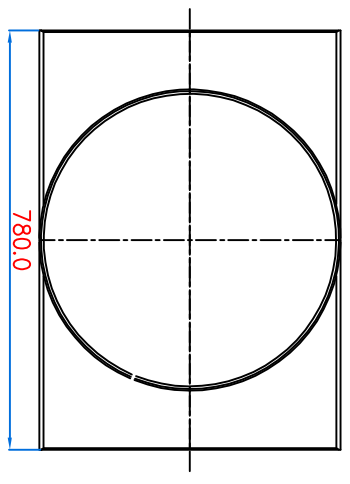


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INVENTORY NO.	SIGN. AND DATE	REF. DRG. NO.
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DETAIL-A



1. ALL SHARP EDGES OF THE PIPE SHALL BE MACHINED TO 0.4x45°.
2. PIPE SHALL BE GROUNDED TO THE DIMENSIONS.

VAR. NO.	REMARKS	VAR. NO.	ITEM NO.	01	STRAIGHT PIPE	RD DG 4 35 0616 0011	SS-304 L	01

REV. DATE	ALTERED CHECKED	REV. DATE	ALTERED CHECKED	DEPT.	GRADE OF TOL DIM C/M/F	SCALE	WEIGHT(KG)	CARD CODE	NO. OF SHEETS
						NTS		RD DG 4 35 0617 0000 1	

		BHARAT HEAVY ELECTRICALS LTD. HYDERABAD	
TYPE OF PRODUCT	NAME OF CUSTOMER	GSM-420	
DEN	NAME	SIGN.	DATE
CKD	KSRAO		20/12/09
APPD	MMRAO		02/01/06
			07/01/06
REF. TO	REF. TO	ITEM NO. OF	NO. OF
		01	ITEMS

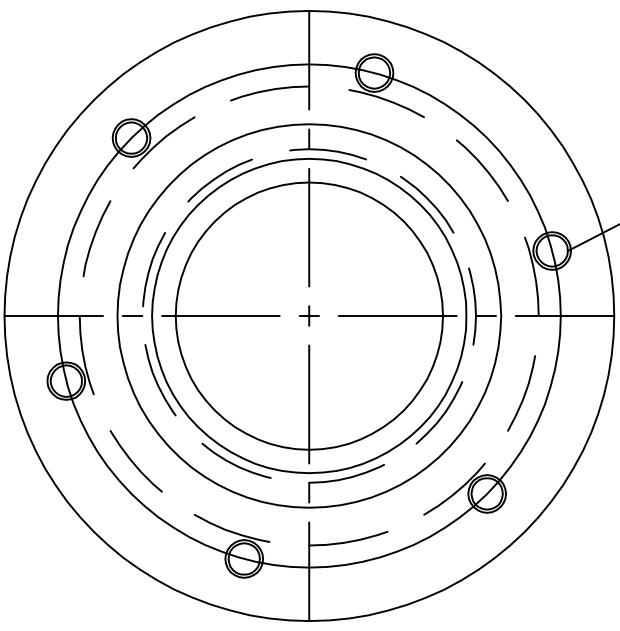
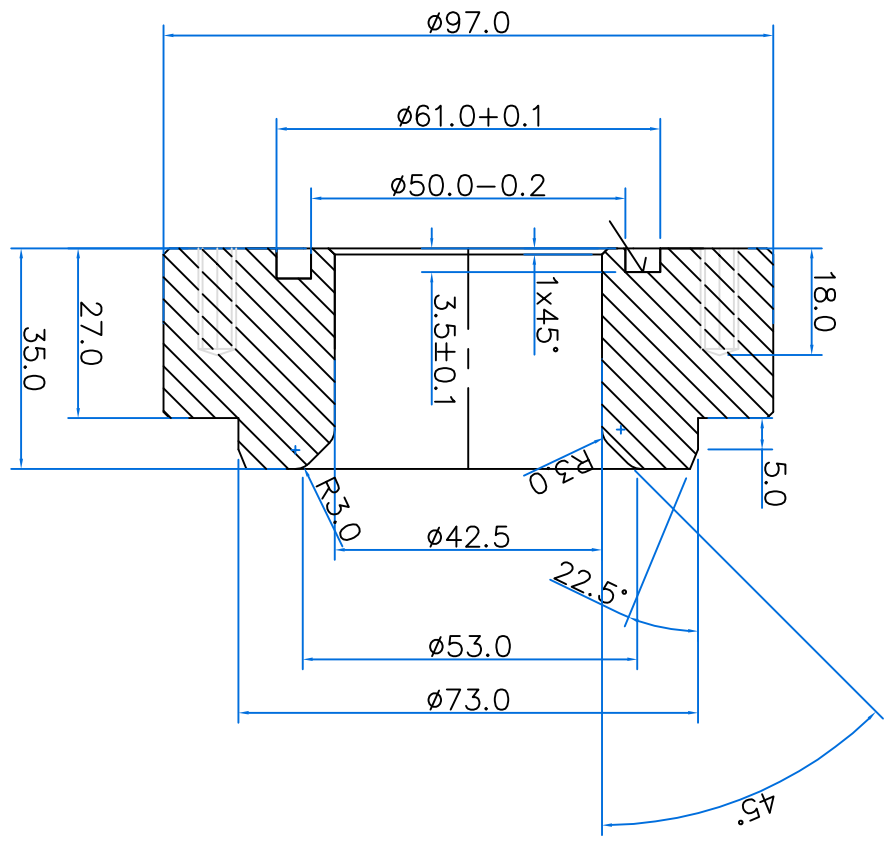
FINAL ON 29/05/14

STRAIGHT PIPE

RD DG 4 35 0617 0011

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



6 No., M6 TAPS @ 80.0 PCD, 18.0 deep

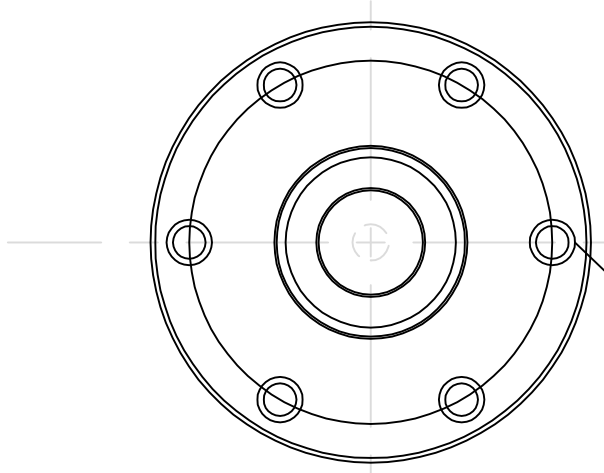
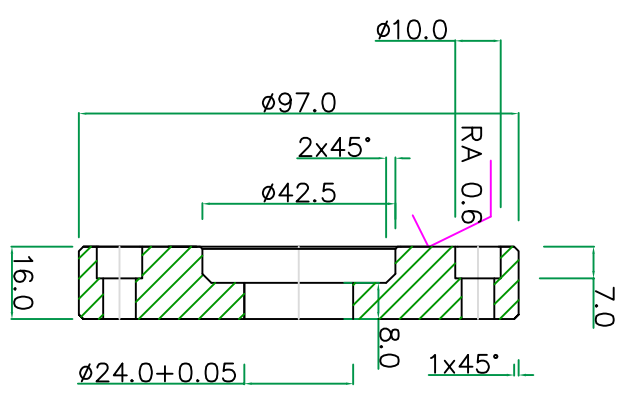
29/05/14

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

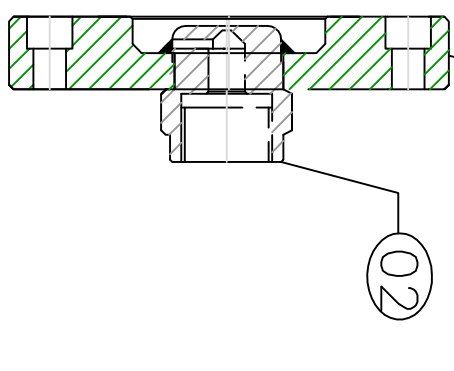
TYPE OF PRODUCT		NAME OF CUSTOMER	
SS BLANK		GSM-420	
VAR.00	REMARKS	VAR. ITEM NO.	01
VAR.00		DESCRIPTION	SS BLANK
		STD	φ100.0X40.0
		DRAWING NO.	
		VAR.	
		ITEM NO.	
		MATL. CODE	SS-304L
		MATL. SPECN.	
		UNIT	01
		QTY.	
		SS	
		ZONE	

DEPT.	GRADE OF TOL. DIM. C/M/F	SCALE	WEIGHT(KG)
		NTS	
BHARAT HEAVY ELECTRICALS LTD.			
HYDERABAD			
DEN	NAME	SIGN.	DATE
CKD	KSRAO		28/12/05
APPD	MMRRAO		02/01/08
			09/01/08
REF. TO		NO. OF	NO. OF
		ITEMS	ITEMS
		01	01

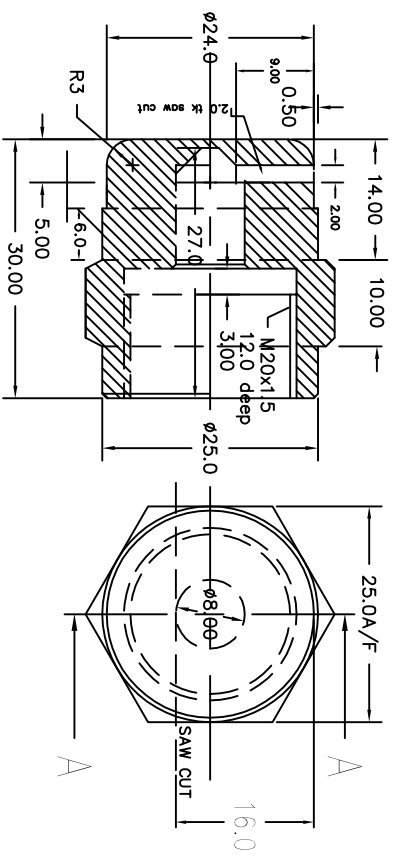
TITLE	CARD CODE	SHEET NO.	NO. OF SHEETS
FLANGE-II		PD DG 4 35 0617 0012	



6 NO., 7.2 CLEAR HOLES WITH COUNTERS
 @80±0.07 PCD WITH 0.4X45° C/F



ASSEMBLY



SECTION AA

GAS STUD (2)

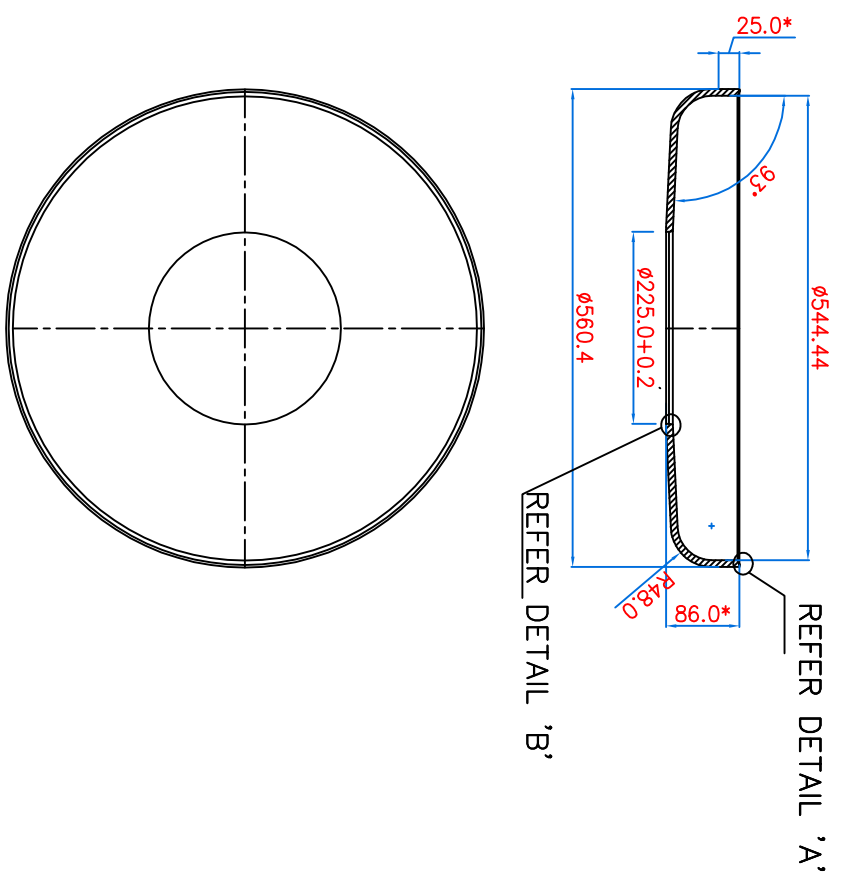
VAR. NO.	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	DRAWING NO.	ITNO.	MATL. CODE	MATL. SPECN.	A	C	UNIT	WT.	QTY.	ZONE
02	GAS STUD			FLANGE - III	RD RD 4 35 0617 0013		SS-304L					0.16 KG	01	
01							SS-304L					2.3 KG	01	

TYPE OF PRODUCT	GSM-420
NAME OF CUSTOMER	GHTEL
TYPE OF PRODUCT	FLANGE - III
NAME OF CUSTOMER	BHARAT HEAVY ELECTRICALS LTD.
	HYDERABAD

DEPT.	GRADE OF	SCALE	WEIGHT(KG)
RD	NTS	2.5	

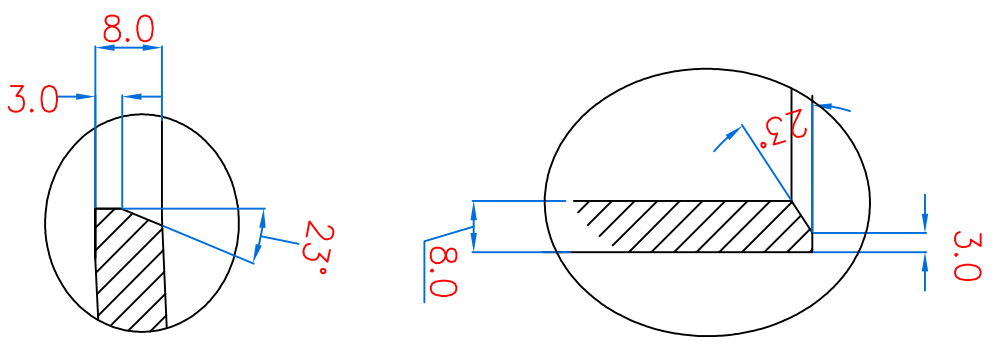
DRN	NAME	SIGN.	DATE
KSRRAO	KSRRAO		26/12/05
APPD	NAME	SIGN.	DATE
MMRRAO	MMRRAO		02/01/06
REF. TO	ITEM NO.	NO. OF	NO. OF
RD DG 4 35 0617 0013	1	1	1

REV.	DATE	ALTERED	CHECKED	ZONE



REFER DETAIL 'A'

REFER DETAIL 'B'



DETAIL--A

DETAIL--B

1. ALL SHARP EDGES OF THE PIPE SHALL BE MACHINED TO 0.4x45°
2. * DIMENSION SHALL BE ADJUSTED SO THAT ASSEMBLY DIMENSIONS ARE ACHIEVED.

VAR. NO.	REMARKS	VAR. NO.	ITEM NO.	01	STRAIGHT PIPE	SS-304 L	01

TYPE OF PRODUCT
NAME OF CUSTOMER
GSM-420

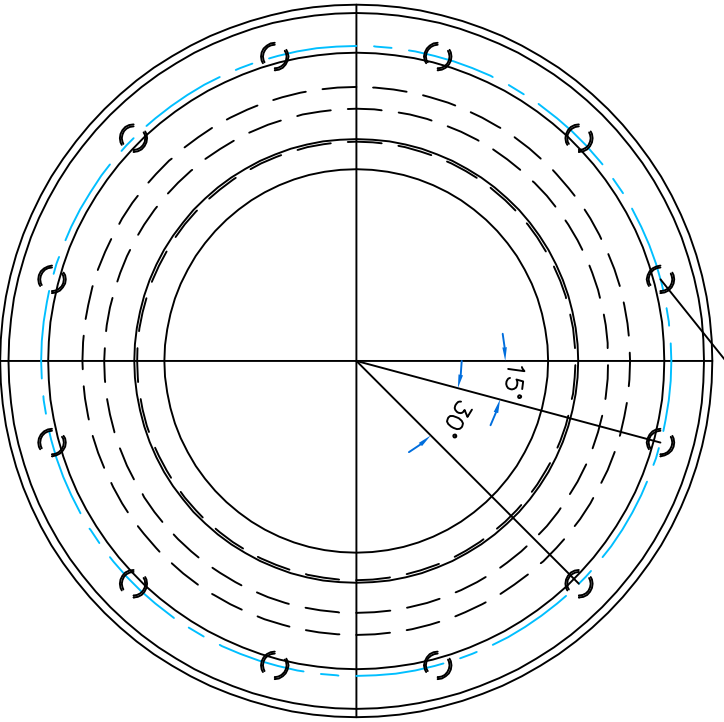
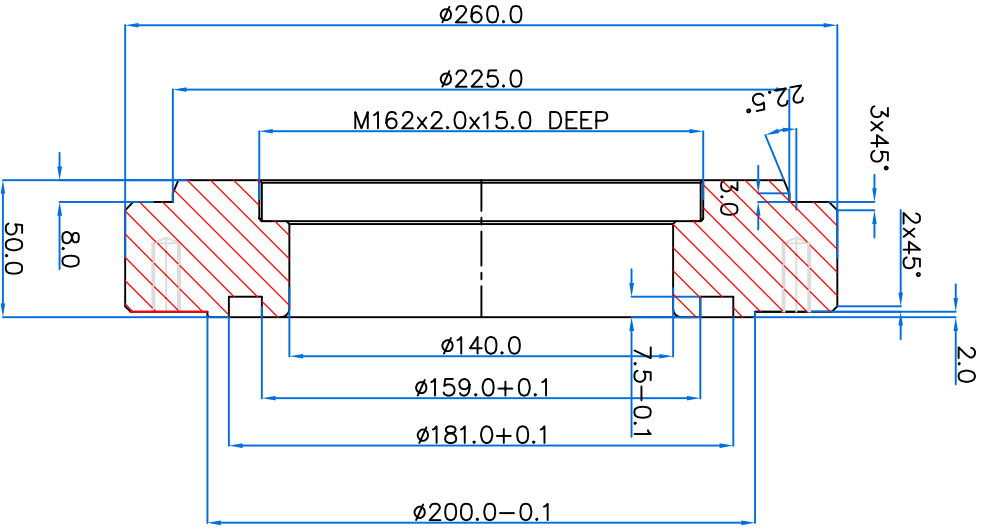
BHARAT HEAVY ELECTRICALS LTD.
HYDERABAD

DEPT. CODE	GRADE OF TUB. DIM. C/M/F	SCALE	WEIGHT(KG)
		NTS	
TITLE			
DISH			

DRN. NAME	SIGN.	DATE	NO. OF
KSRAO		26/12/05	VAR.
MMRAO		02/01/06	01
APPD. MMR		07/01/06	

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

FINAL ON 29/05/14



12 No., M10 TAPS @ 230.0 PCD, 25.0 deep

GROOVE SHALL BE FINISHED TO RA0.6
 ALL SHARP EDGES SHALL BE MACHINED TO 0.5x45°

29/05/14

VAR. NO.	REMARKS	VAR. NO.	ITEM NO.	BLOCK	RD DG 4 35 0617 317	SS-304L	01	ZONE

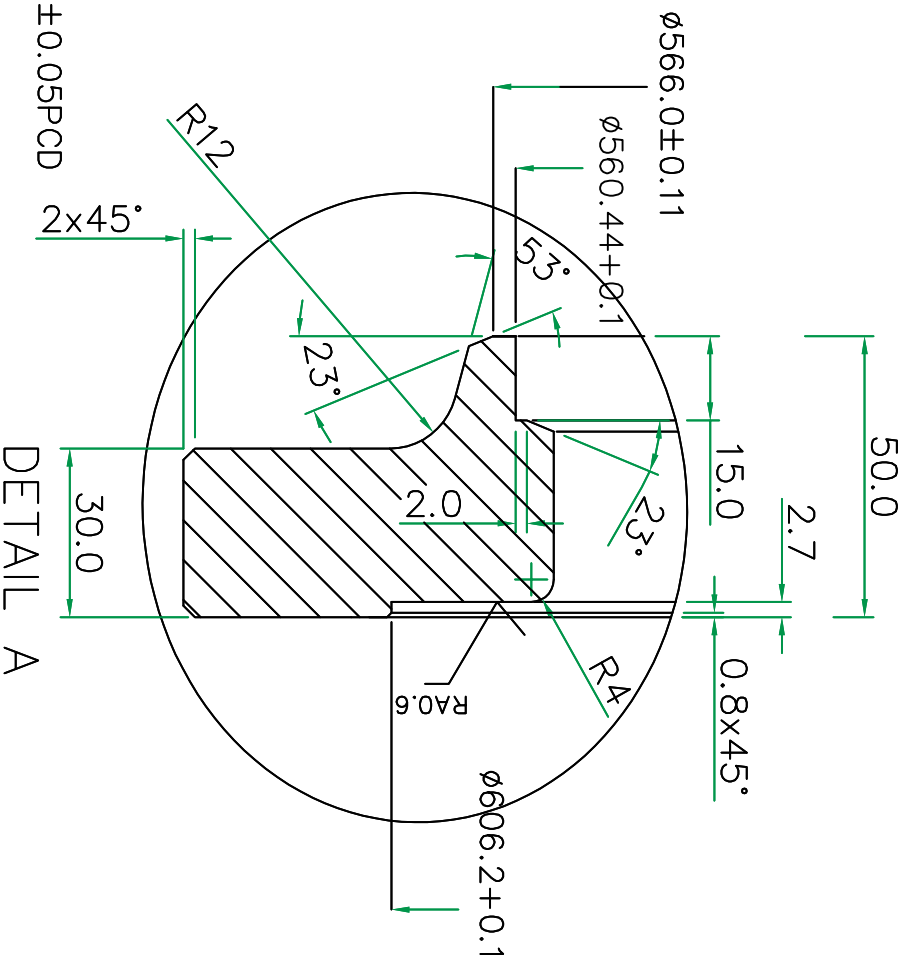
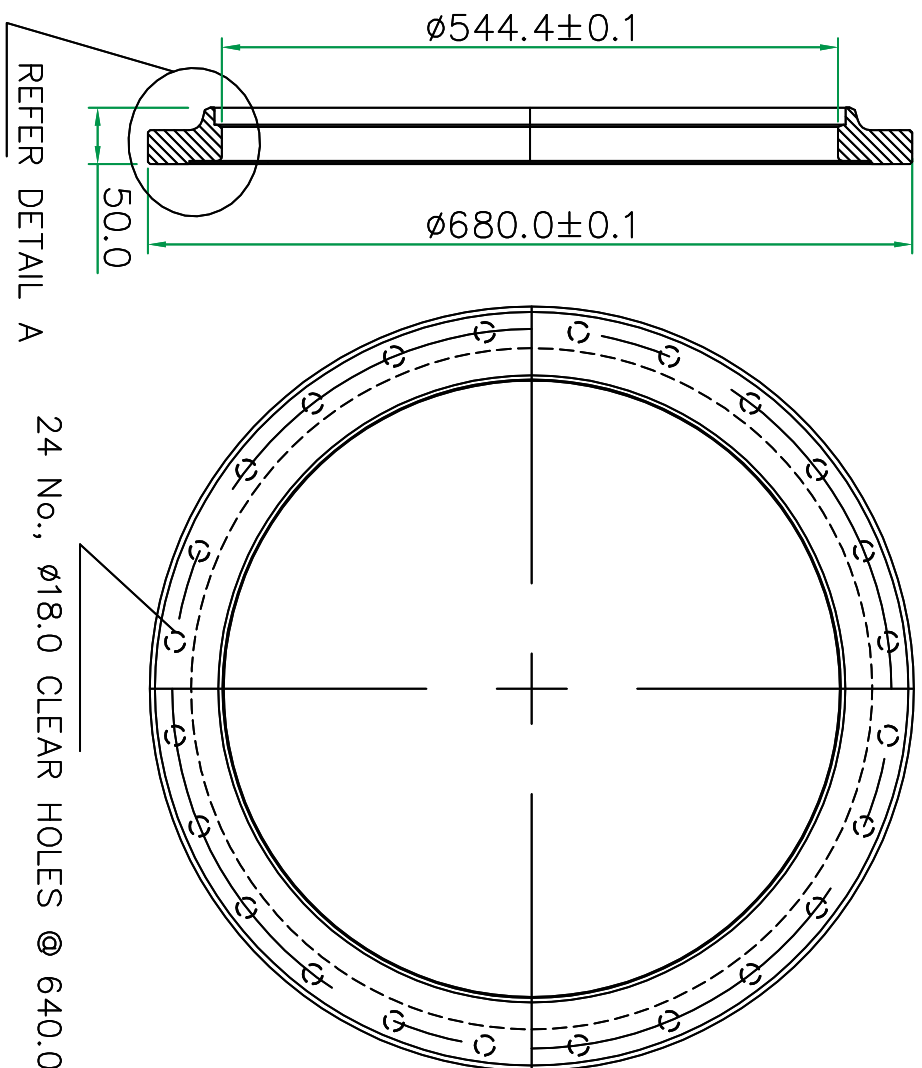
TYPE OF PRODUCT
 NAME OF CUSTOMER
GSM-420
 BHARAT HEAVY ELECTRICALS LTD.
 HYDERABAD

DEPT.	GRADE OF	SCALE	WEIGHT(KG)	REF. TO	ITEM NO.	NO. OF
	TOL. DIM. C/M/F	NTS				

DRN	NAME	SIGN.	DATE	NO. OF
APPD	MIRRAO		02.01.08	VAR.
DRN	KSRRAO		26.12.05	
APPD	MIRRAO		02.01.08	

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

TITLE	CARD CODE	DRAWING NO.	SHEET NO.	NO. OF SHEETS
FLANGE IV	RD DG 4 35 0617 0317	RD DG 4 35 0617 0317		



- 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

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INVENTORY NO.	SIGN. AND DATE	REF. DRG. NO.
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FINAL ON 29/05/14

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

TYPE OF PRODUCT		SS FLANGE		SS-304	45.0 KG
NAME OF CUSTOMER		DESCRIPTION		RD DG 4 35 0617 0951	02
GSM-420		DRAWING NO.		SS-304	02
BHARAT HEAVY ELECTRICALS LTD.		DIN		SS-304	02
HYDERABAD		KSRAO		SS-304	02
MIRRAO		HSJAIN		SS-304	02
APPD		REF. TO		SS-304	02
SCALE		DATE		SS-304	02
N.T.S.		26/12/08		SS-304	02
45.0 KG		02/01/08		SS-304	02
GRADE OF TUB. DIM. C/M/F		02/01/08		SS-304	02
TITLE		NO. OF SHEETS		SS-304	02
FLANGE 1		NO. OF SHEETS		SS-304	02
DRAWING NO.		NO. OF SHEETS		SS-304	02
RD DG 4 35 0617 0951		NO. OF SHEETS		SS-304	02
SHEET NO.		NO. OF SHEETS		SS-304	02
1		NO. OF SHEETS		SS-304	02