

- TECHNICAL REQUIREMENTS:-**
- REMOVE ALL BURRS AND SHARP EDGES. ALL FLAME CUT PORTIONS, MISMATCHES ETC. ARE TO BE GROUND SMOOTH.
  - ALL WELD SHALL BE GR.III OF CORP. STD. AAG622101. AND TO BE 100% D.P. TESTED EXCEPT FILLET WELDS.
  - WELD SIZE TO BE 3/8" IF NOT SPECIFIED OTHERWISE.
  - PIT LINER VAR.01 & 02 ARE TO BE PROOF ASSEMBLED AT WORKS BEFORE DESPATCH TO SITE.
  - TRANSPORT STAYS IT. NO.19 IN RANDOM LENGTH ARE TO BE CUT TO SUIT AND WELD IN POSITION AT BOTH ENDS OF PIT LINER HALVES TO PREVENT DISTORTION DURING TRANSPORTATION AND INSTALLATION. TRANSPORT STAYS SHOULD NOT BE USED FOR LIFTING.
  - CUTOUTS (240 WIDEX636 HEIGHT) FOR 8 NOS ILLUMINATION BOX AT LOCATIONS SHOWN IN ITEM 03,07,08 & 10 ARE TO BE MADE BEFORE WELDING OF ITEM 20,21&22.
  - ITEM 17 TO BE CUT TO SUIT AT PIT ENTRANCE LOCATION.
  - PAINT & PROTECT AS PER HT00005 CAT. AS FOLLOWS.
    - ALL INTERNAL SURFACES TO CAT-F.
    - ALL EXTERNAL SURFACES TO CAT-E.
 LEAVE 100 WIDE ALL ALONG THE SITE JOINTS.

ITEM NO.	QTY	DESCRIPTION	UNIT	PRICE	TOTAL	MATERIAL CODE	UNIT WT.	QTY	TOTAL
002	006	6 TK	022	PLATE-3		AA1011808030	8.80		
				6TKX274X680		AA10108			
004	012	6 TK	021	PLATE-2		AA1011808030	4.00		
				6TKX132X656		AA10108			
004	012	6 TK	020	PLATE-1 6TK	SEE DETAIL	AA1011808030	1.70		
65	70	MTR	019	TRANSPORT STAYS CHANNEL		AA1012708020	7	KG/MTR	
				75X40X4.8X7.5		AA10108			
014	014	10 TK	018	CIRCUMFERENTIAL RIB	SEE DETAIL	AA1011808072	11.0		
						AA10108			
035	015	10 TK	017	CIRCUMFERENTIAL RIB	SEE DETAIL	AA1011808072	23.0		
						AA10108			
--	030	CUT TO SUIT	016	RIB FLAT		AA1011808072	59.00		
				10X150X5000		AA10108			
--	004	10 TK	015	VERTICAL RIB FLAT	SEE DETAIL	AA1011808072	11.00		
				10X150X930		AA10108			
--	016	10 TK	014	VERTICAL RIB	SEE DETAIL	AA1011808072	26.0		
						AA10108			
012	012	013	CLAMP ANGLE	2 201 10 18501	012		2.000		
				75x75x6x250					
009	009	10 TK	012	STIFFNER	SEE DETAIL	AA1011808072	1.280		
						AA10108			
006	002	10 TK	011	VERTICAL RIB	SEE DETAIL	AA1011808072	40.60		
						AA10108			
--	002	10 TK	010	CYLINDER SEGMENT	SEE DETAIL	AA1011808072	280.0		
						AA10108			
--	001	10 TK	009	LOWER CYLINDER HALF	SEE DETAIL	AA1011808072	279.0		
						AA10108			
--	001	10 TK	008	END PLATE	SEE DETAIL	AA1011808072	981.0		
						AA10108			
--	002	10 TK	007	SIDE PLATE	SEE DETAIL	AA1011808072	525.0		
						AA10108			
--	001	10 TK	006	TOP PLATE	SEE DETAIL	AA1011808072	962.0		
						AA10108			
--	001	10 TK	005	BOTTOM PLATE	SEE DETAIL	AA1011808072	927.0		
						AA10108			
001	--	10 TK	004	LOWER CYLINDER HALF	SEE DETAIL	AA1011808072	856.0		
						AA10108			
001	--	10 TK	003	UPPER CYLINDER HALF	SEE DETAIL	AA1011808072	2253.0		
						AA10108			
--	001	10 TK	002	UPPER CYLINDER HALF	SEE DETAIL	AA1011808072	838.0		
						AA10108			
001	001	20 TK	001	BASE PLATE	SEE DETAIL	AA1011808137	187.0		
						AA10108			

**VAR.02 VAR.01**

REVISIONS	DATE	BY	CHKD	APPD

ADDITIONAL INFORMATION: TYPE/RATING: 6x116 MW-SINGLE STAGE VERTICAL FRANCIS PUMP

STATUS OF DRAWING: "U"

DISTRIBUTION OF PRINTS: PROJECT: Dr.B.R.AMBEDKAR PRANAHTA-CHEVELLA-SUJALA SRAVANTHI-L.I.S. LINK-II PACKAGE-VI

HTE-2, WTM(P)-1, WTM(S)-4 FBM - 7, THX - 1

CUSTOMER: IRRIGATION & CAD DEPARTMENT, GOVT. OF TELANGANA

CONTRACTOR: BHARAT HEAVY ELECTRICALS LTD. BHOPLAL

M/S NAVAYUGA-PATEL-BHEL (CONSORTIUM)

SCALE: 1:20

DATE: 2020718401

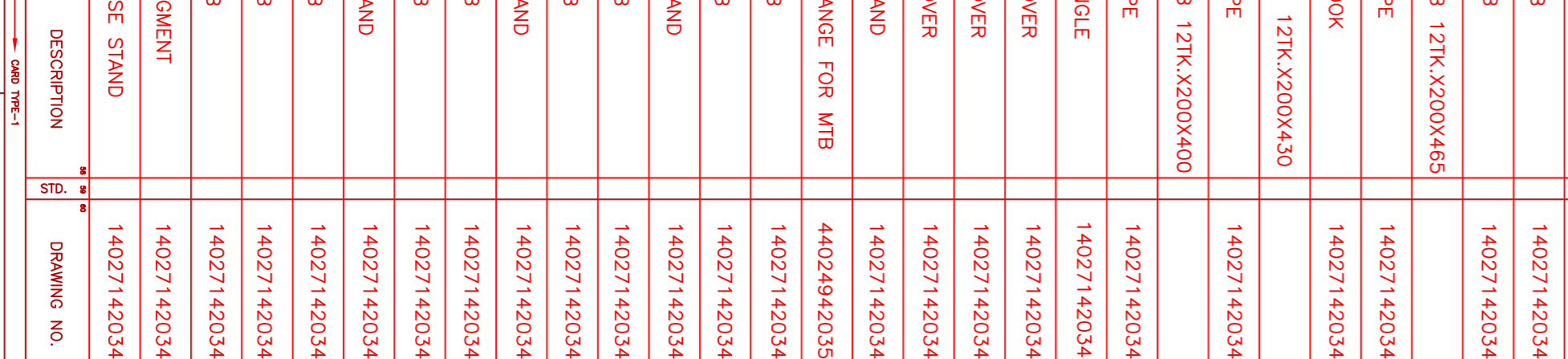
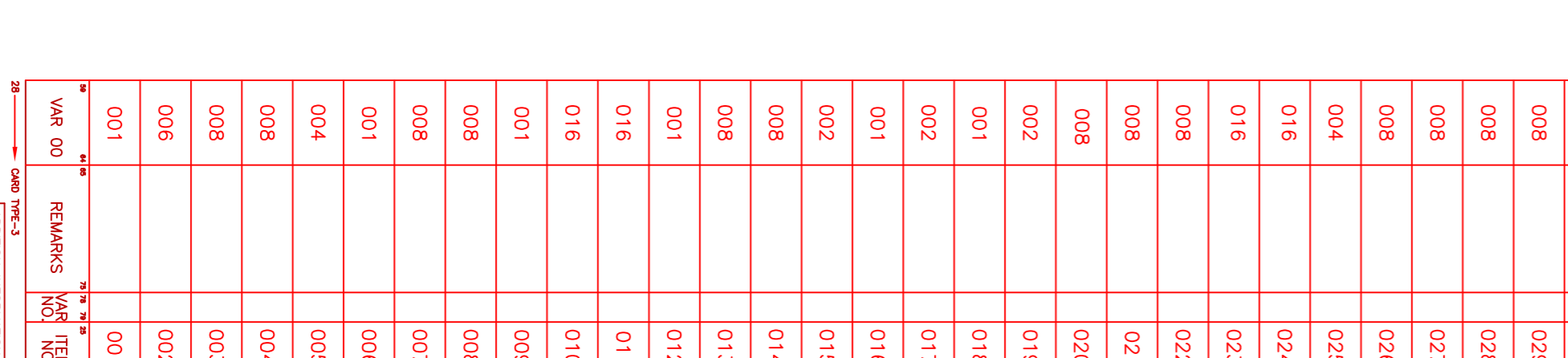
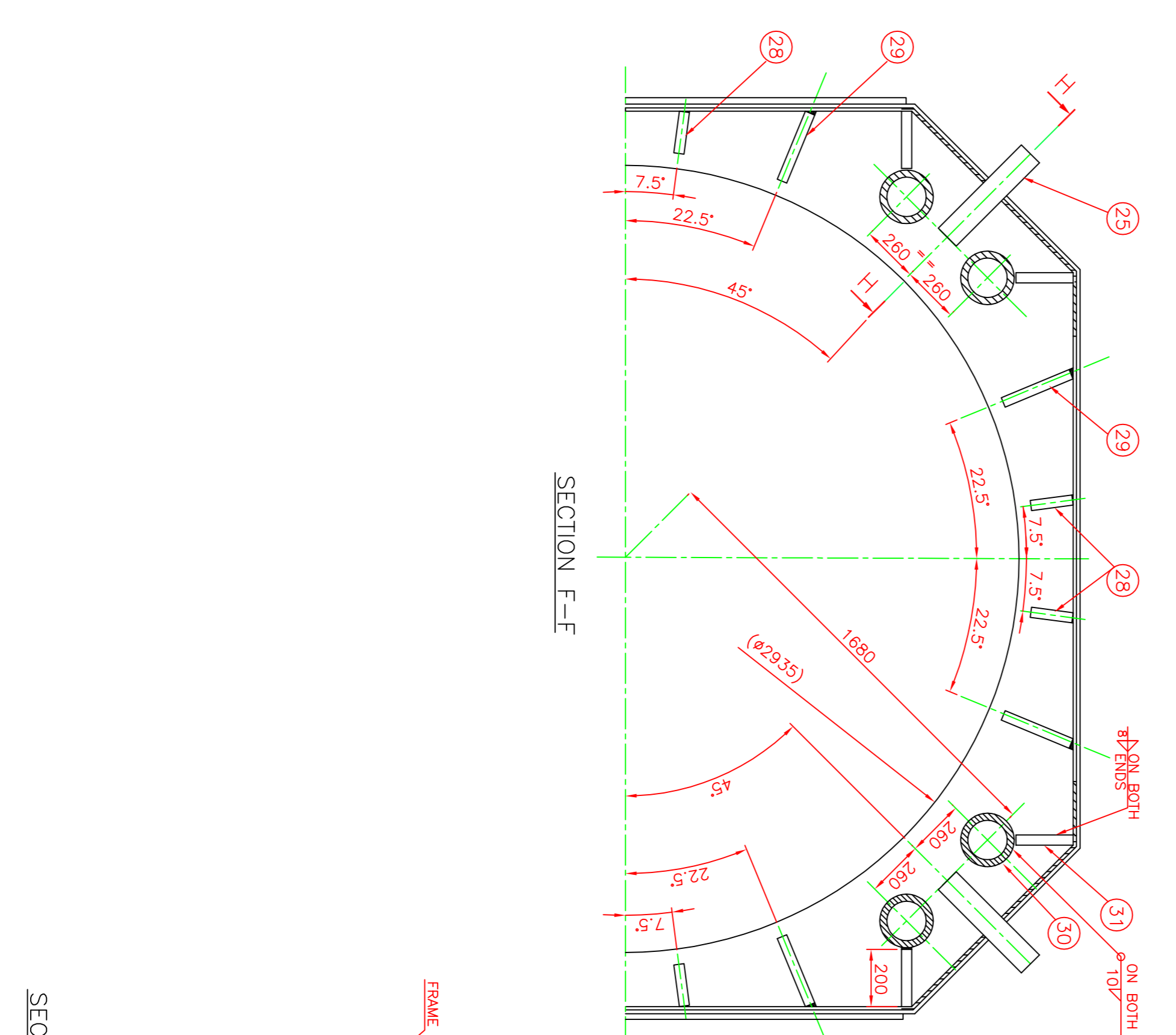
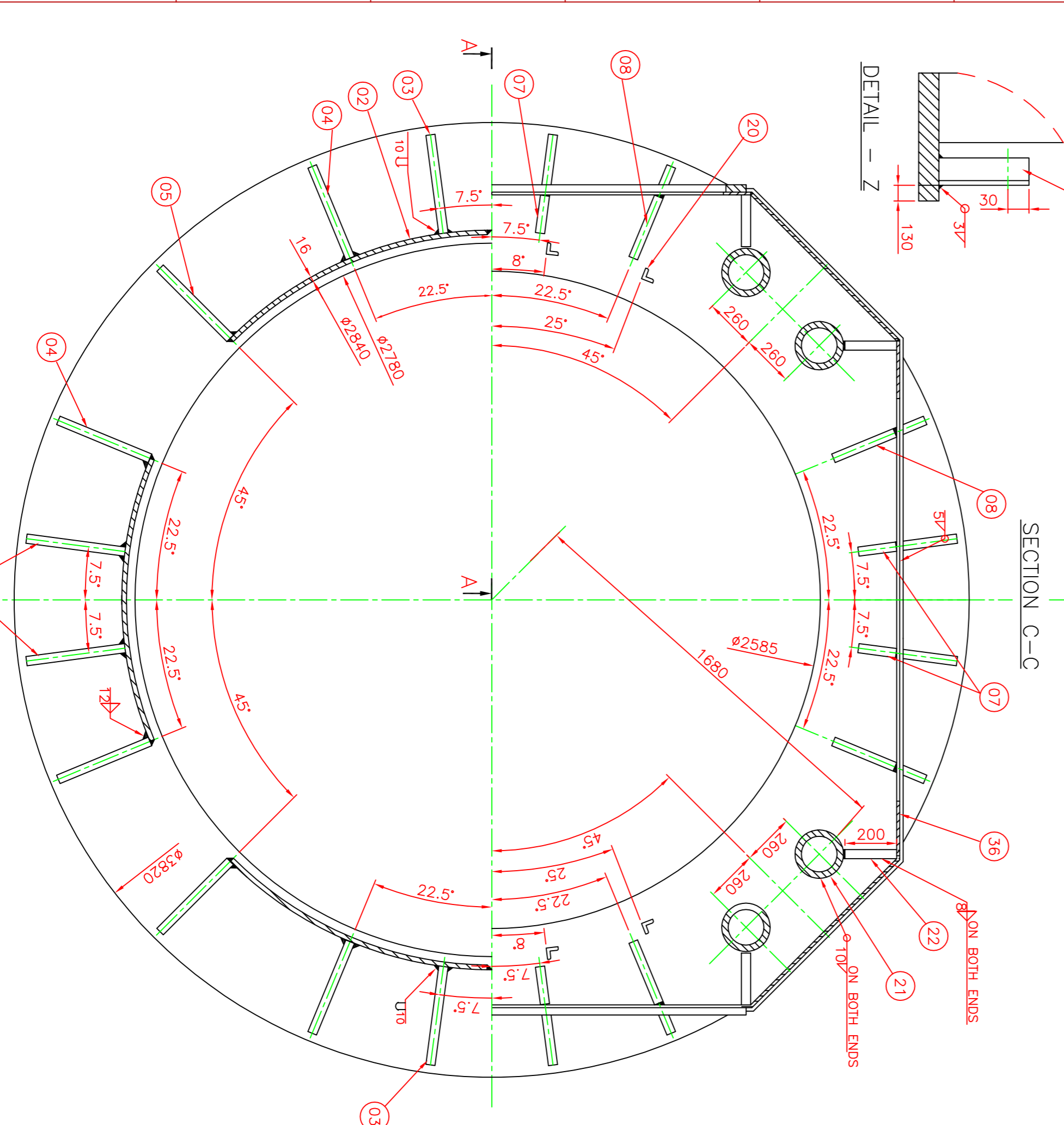
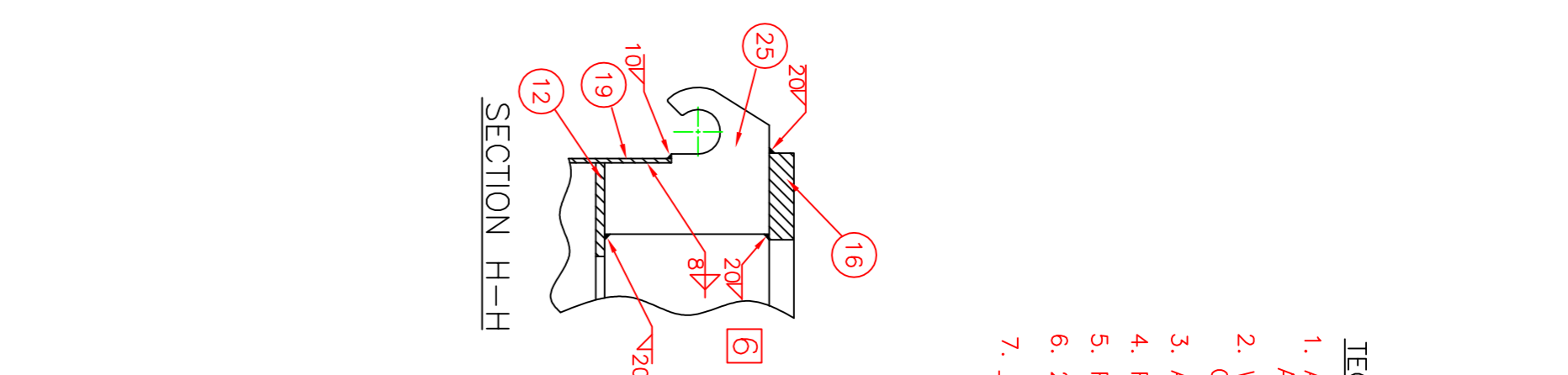
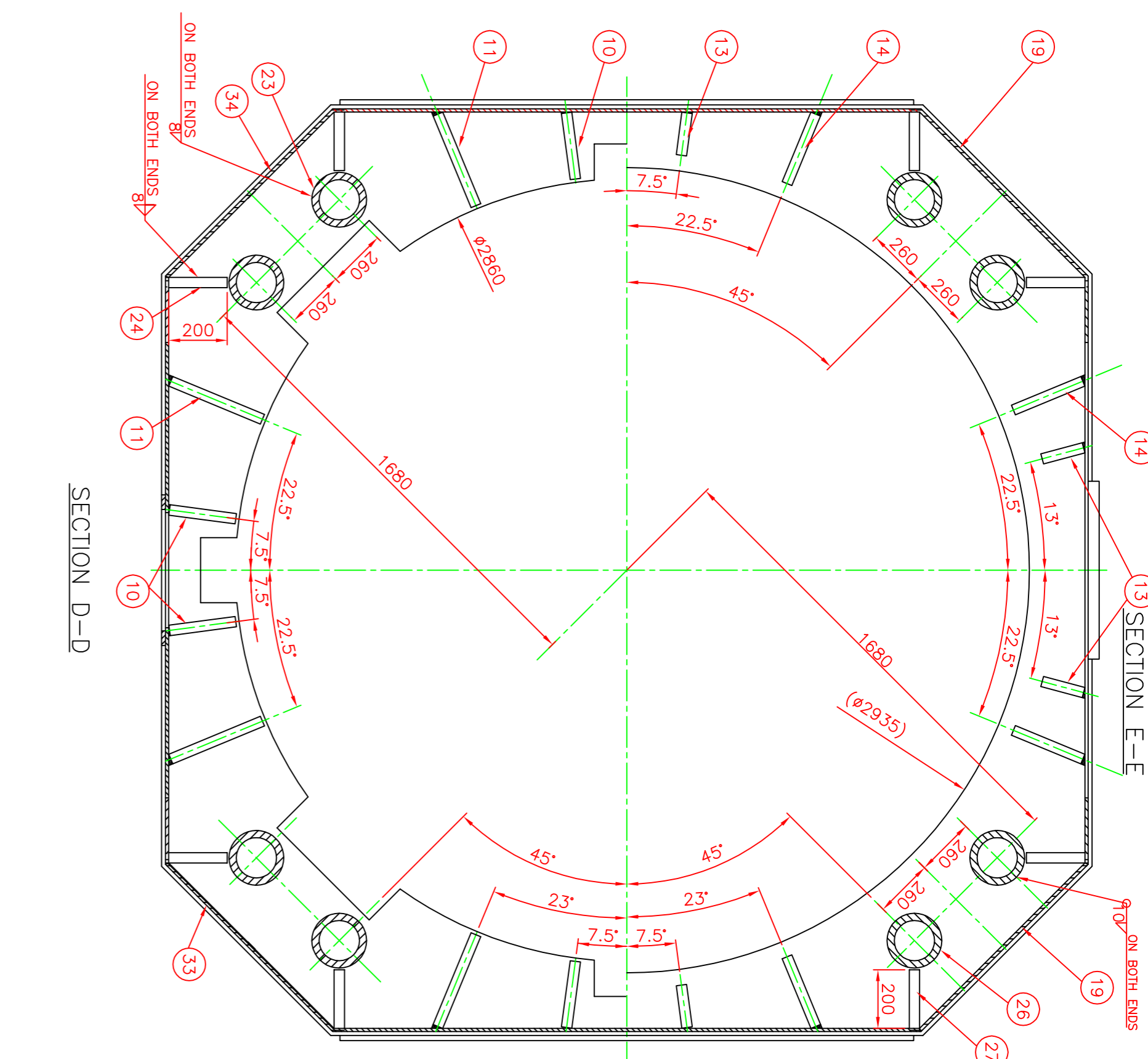
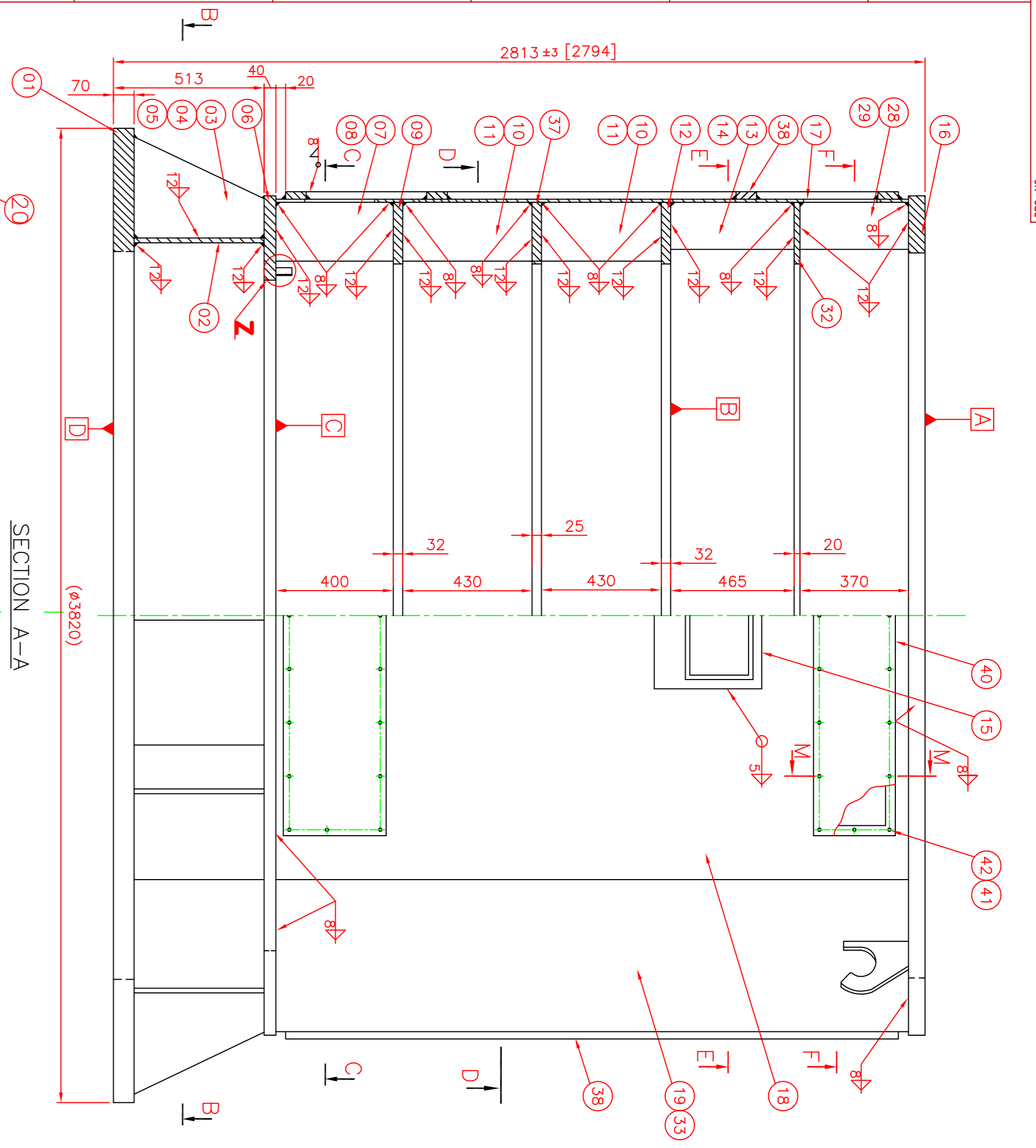
ITEM NO.: 022

TITLE: PIT LINER (WELDED ASSEMBLY)

DRAWING NO.: 02020718402

REV: 00

INVENTORY NO. SIGN. & 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



- TECHNICAL REQUIREMENTS:-**
1. ALL EXTERNAL WELDS TO BE 8 mm. CONTINUOUS UNLESS OTHERWISE STATED.
  2. ALL INTERNAL WELDS 6 mm CONTINUOUS UNLESS OTHERWISE STATED.
  3. WHERE EVER CHAMFERS ARE REQUIRED IN WELDABLE ITEMS, SUITABLE CHAMFERES CAN BE PROVIDED BY FBM.
  4. ALL ITEMS TO BE FLAME CUT ON N.C. M/C/S.
  5. FLATNESS OF SURFACES A, B, C, D SHOULD BE MAINTAINED WITHIN 3 mm MAXIMUM.
  6. FOR WELDING REFER WELDING INSTRUCTION 052-6152 PART 10.
  7. 20 mm WELD TO BE D.P. TESTED, AS PER CORP. STD. AA6622101 GRADE III
  8. IMPORTANT:- STATOR TO BE SHOT BLASTED BEFORE PRIMER PAINTING TO AMS4173.

GES. NO. 404837186 VAR. 00

VAR NO	REMARKS	QTY	UNIT	WGT	UNIT WGT	NO
080	042 WASHER MCD					
080	041 SCREW HEX. M8x16					
004	040 COVER	34021042072	00		18	
004	039 FLANGE	34027140473	00		7.5	
002	038 FLANGE	34027140426	00		135	
001	037 STAND 25 TK.	14027142034	28		664	
001	036 COVER	14027142034	31		266	
001	035 COVER	14027142034	30		158	
001	034 COVER	14027142034	11		158	
001	033 COVER	14027142034	07		530	
008	031 X 200 X 370	AA1011808099	16		22.5	
008	030 PIPE	14027142034	024		22.8	
008	029 RIB	14027142034	023		11.6	
008	027 RIB 12TKX200X465	AA1011808099	015		8.76	
008	026 PIPE	14027142034	015		28.1	
004	025 HOOK	14027142034	09		50	
016	024 RIB 12TKX200X430	AA1011808099	014		7.6	
016	023 PIPE	14027142034	013		26.1	
008	022 RIB 12TKX200X400	AA1011808099	013		7.66	
008	021 PIPE	14027142034	013		25.00	
008	020 ANGLE	14027142034	08		5.0	
002	019 COVER	14027142034	10		158	
001	018 COVER	14027142034	02		250	
002	017 COVER	14027142034	01		276	
001	016 STAND	14027142034	06		1586	
002	015 FLANGE FOR NTB	44024942035	01		31	
008	014 RIB	14027142034	022		28.6	
008	013 RIB	14027142034	021		14.6	
001	012 STAND	14027142034	029		850	
016	011 RIB	14027142034	020		34.6	
016	010 RIB	14027142034	019		24.3	
001	009 STAND	14027142034	05		950	
008	008 RIB	14027142034	018		34.6	
008	007 RIB	14027142034	017		22.6	
001	006 STAND	14027142034	04		1616	
004	005 RIB	14027142034	025		50	
008	004 RIB	14027142034	027		40	
008	003 RIB	14027142034	026		38	
006	002 SEGMENT	14027142034	012		62	
001	001 BASE STAND	14027142034	03		2362	

INVENTORY NO. SIGN & DATE REF. DRG. NO.

DATE: 15/11/15

DESIGNER: NTS

CHECKER: NTS

APPROVER: NTS

SCALE: 1:1

DRAWING NO: 1 402 71 40 657

REV: 01

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