



- TECHNICAL REQUIREMENTS:-**
- DIMENSIONS SHOWN WITHIN () FOR FABRICATION.
 - WELDING INSPECTION TO GRADE-II (UPTO TOTAL WELD DEPTH (-5) MM) OF CORP. STD. AS622101 EXCEPT FILLETS WHICH ARE GR-III.
 - RIBS IT. 11 & 18 TO BE SEAL WELDED WITH 6mm FILLET WELD AT CUTOUT CORNERS.
 - OUTER CYLINDER SEGMENT 5 & 6 TO BE WELDED AFTER WELDING RIBS (IT. 11 & 18).
 - WATER PASSAGE TO BE CLEANED TO GIVE AN UN-OBSTRUCTIVE FLOW.
 - STRESS RELIEVING TO CORP. STD. BP 0640299 TO BE DONE BEFORE MACHINING.
 - HEAT TREATMENT TO BE CARRIED OUT FOR HYDROGEN DIFFUSION TO BP 0640292 BEFORE BABBITTING. ANY WELDING AFTER HYDROGEN DIFFUSION SHALL NOT BE ALLOWED.
 - BABBITTING TO BE DONE AS PER BP 0690080. BONDAGE BETWEEN BABBIT LINING AND BASE METAL TO BE TESTED ULTRASONICALLY. A GOOD BOND NEAR THE EDGES IS REQUIRED OVERALL BONDAGE AREA SHOULD NOT BE LESS THAN 90%. WHITE METAL SPECN. AA12802 (84%TiN BASED ALLOY)
 - RTD. AND DTT HOLES SHOWN IN SECTION CC, C1C1 & DD SHOULD NOT BREAK THROUGH.
 - PAINT & PROTECT TO PROCESS SPECN. HT. 00005 CATEGORIES AS FOLLOWS:-
 - MACHINED & BABBITTED SURFACES :- CAT. G.
 - SURFACE MARKED * :- CAT. C
 - REMAINING SURFACES :- CAT. D
 - THERMOMETER POCKETS (SECTION-DD & CC) TO BE CHECKED AT 9KG/CM2 BEFORE BABBITTING.
 - FOR WELDING OF PIPING REFER DRG. NO. 3 230 29 49066.
 - DRILLING FOR WELDING PIPE IT. 9 & 10 TO BE DONE AFTER MAKING SUB ASSY. OF ITEMS 1 TO 4.
 - WATER PASSAGE TO BE HYDRAULICALLY TESTED AT 9 kg/sq cm FOR 30 MINUTES NO LEAKAGE IS ALLOWED.
 - SURFACES M & N TO BE PARALLEL WITHIN 0.03 & SHALL BE PERPENDICULAR TO VERTICAL AXIS.
 - SEGMENTS TO BE ULTRASONICALLY TESTED TO CHECK SATISFACTORY BONDING OF WHITE METAL LINING AS PER AA 080126.
 - SEGMENTS TO BE CHECKED BY DYE PENETRATION ON EDGES TO AA0850131. NO LINEAR INDICATION ACCEPTABLE (CLAUSE 4.2.1 (iv) OF AA 0850126).
 - VISUAL INSPECTION (EXCEPT DP) OF SEGMENT SURFACES TO BE DONE TO CHECK FOR EXCESSIVE POROSITY (CLAUSE 3 OF AA 0850126)
 - DIMNS. MARKED ϕ ARE TO BE STRICTLY ACHIEVED AND RE-CHECKED ALSO.

NO.	QTY	DESCRIPTION	DATE	REVISION	REVISION	REVISION	REVISION	REVISION	REVISION
020		RIB-III	3-206-01-17508	003	AA10119		52.000		
019		PARALLEL DOWEL 16 NOM. x 22LG.	3-206-01-17505	002			0.034		
50TK	018	RIB-I	3-206-01-17508	001	AA10108		48.300		
45TK	017	SQUARE FLANGE	3-206-01-17506		AA10119		4.00		
107 lg	016	SEAMLESS PIPE 60.3 O/D x 4 tk	4-206-01-17507				0.58		
63TK	015	LOWER JOINT FLANGE	3-206-01-17502		AA10119		58.000		
014		PARALLEL DOWEL 25 NOM. x 30LG.	3-206-01-17505	001			0.120		
32TK	013	UPPER JOINT FLANGE-II	3-206-01-17501	001	AA10119		8.50		
32TK	012	UPPER JOINT FLANGE-I	3-206-01-17501	002	AA10119		8.50		
16TK	011	RIB-II	3-206-01-17508	002			14.200		
010		50NB SHORT RADIUS 90° ELBOW			AA10119		0.500		
3000 lg	009	PIPE CDS 50NB 60.3 O/D x 4TK			BP1041055930		17.5		
90TK	008	BOTTOM FLANGE (HALF)	4-206-01-17502		AA10455		0.01		
56TK	007	CYLINDER (HALF)	2-206-01-17501		AA10119		384.000		
25TK	006	OUTER CYLINDER SEGMENT-2	2-206-01-17504		AA10119		28.00		
25TK	005	OUTER CYLINDER SEGMENT-1	2-206-01-17503		AA10119		32.00		
80TK	004	MIDDLE FLANGE (HALF)	3-206-01-17503		AA10119		1033.00		
20TK	003	RIB	SEE DETAIL		AA1011808137		6.700		
32TK	002	TOP CYLINDER (HALF)	2-206-01-17502		AA10119		205.00		
40TK	001	TOP FLANGE (HALF)	4-206-01-17501		AA10119		75.000		

REV.	DATE	ALTERED BY	SKM	REV.	DATE	ALTERED BY	MG	REV.	DATE	ALTERED BY	YK	REV.	DATE	ALTERED BY	YK	REV.	DATE	ALTERED BY	YK
05	05.08.19	APPR.	AKC	04	24.06.14	APPR.	AKC	03	10.08.13	APPR.	AKC	02	14.09.12	APPR.	AKC	01	30.08.11	APPR.	AKC

DRAWING REVIEW

ADDITIONAL INFORMATION

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT: 4x130MW TAPOVAN VISHNUGAD HYDROELECTRIC POWER PROJECT

STATUS OF DRAWING: DISTRIBUTION OF PRINTS: HTE-2, FBM-7, THX-1, WTM(PLANNING)-1, WTM(STORE)-4

DEPT.: UNTOI. DMS. GR.: SCALE: AS STATED

TITLE: BEARING SHELL

DRAWING NO.: 0-206-01-17502

REV. 05

SHT. NO. 01

NO. OF SHT. 01

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