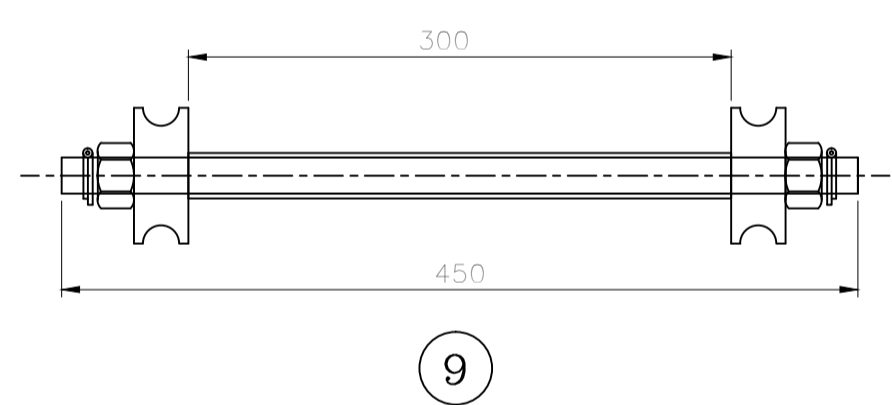
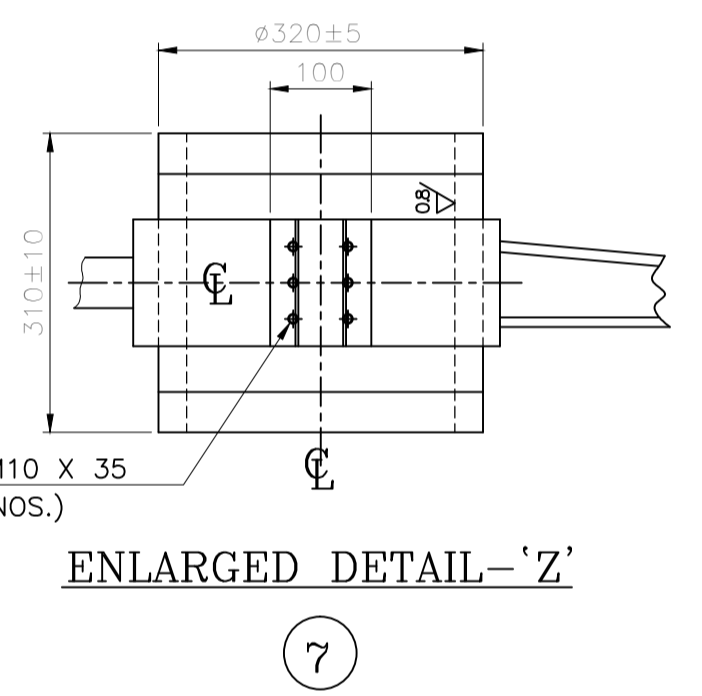
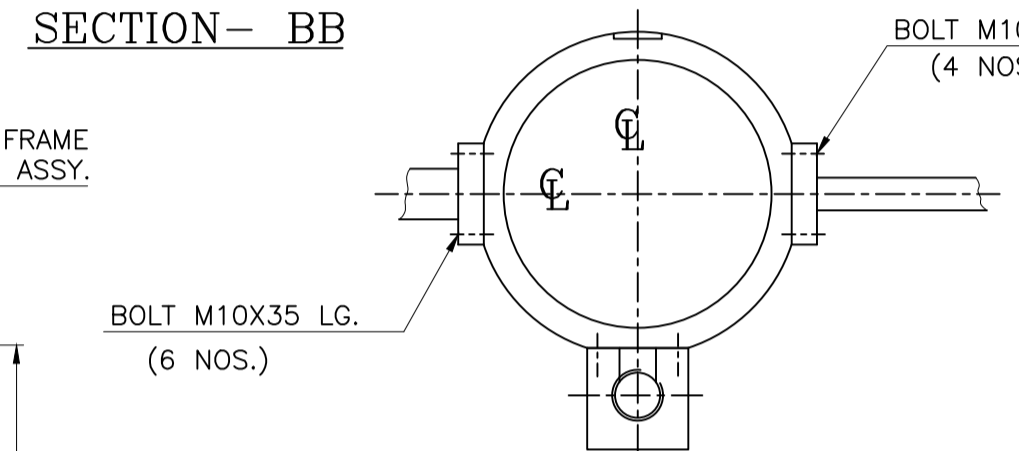
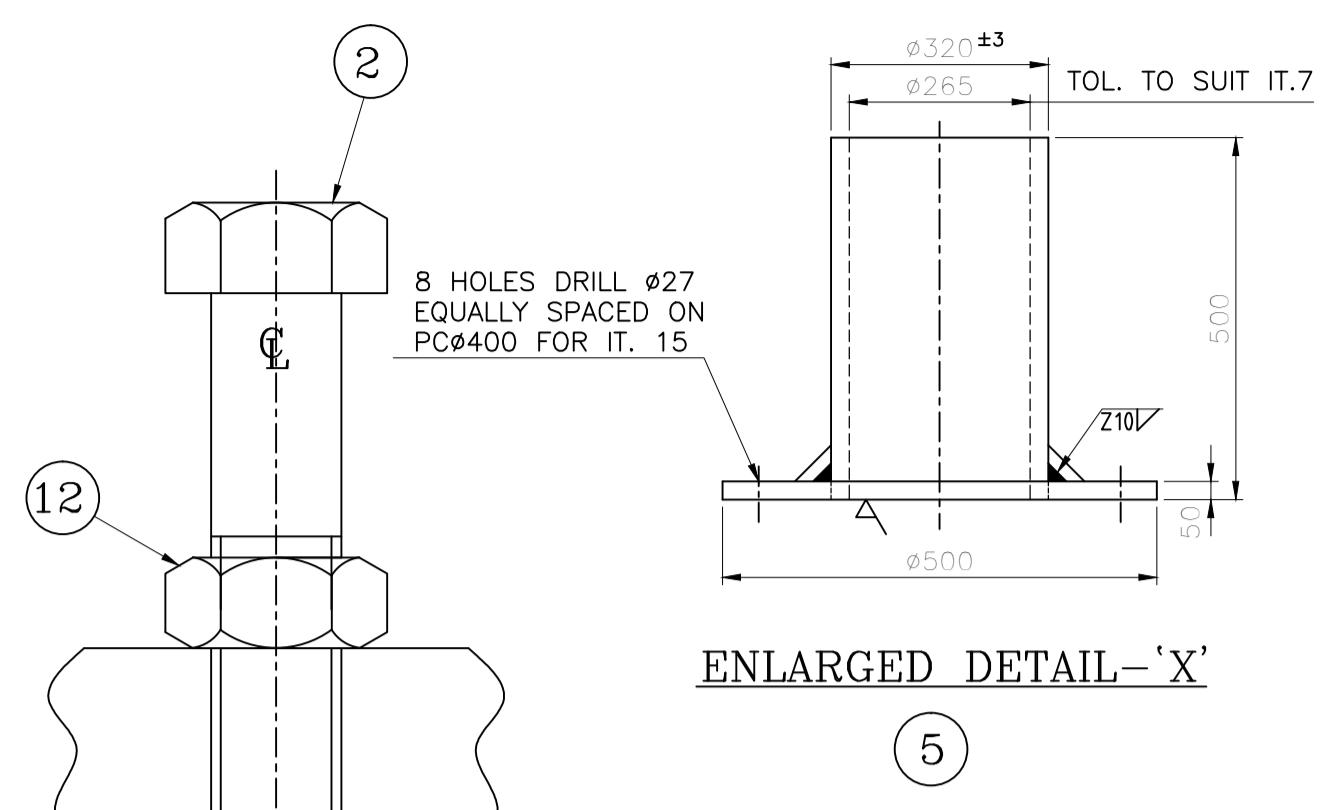
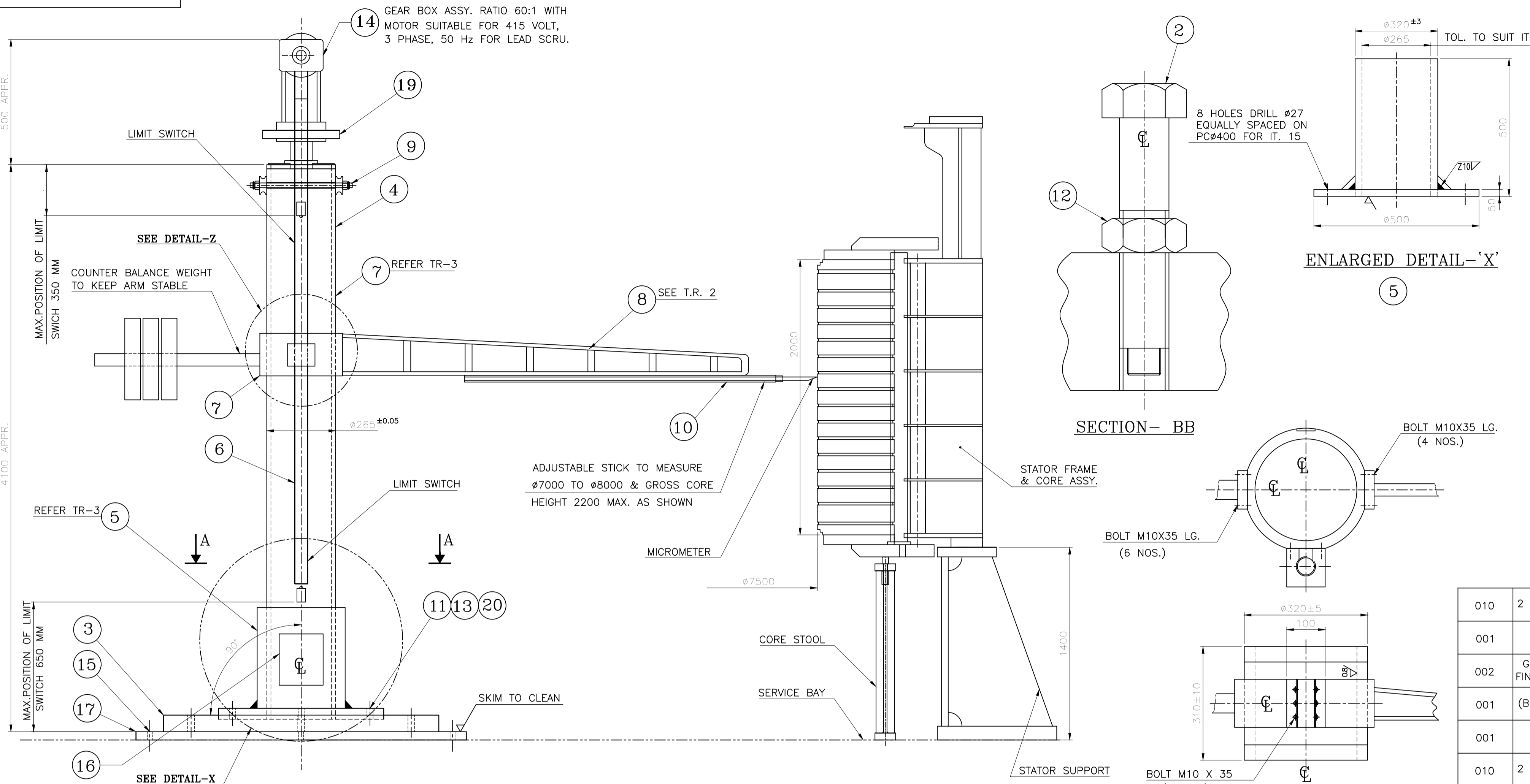
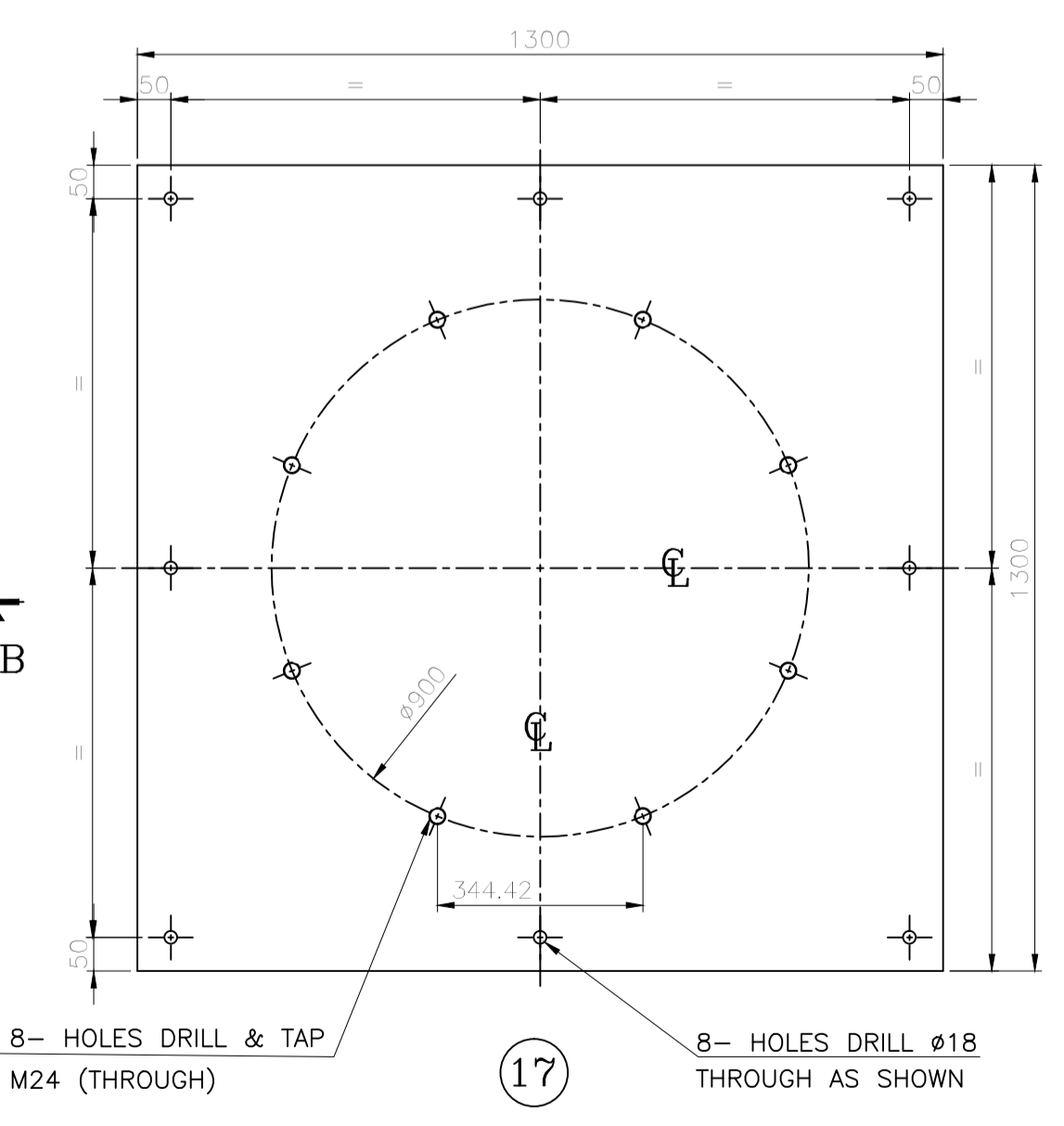
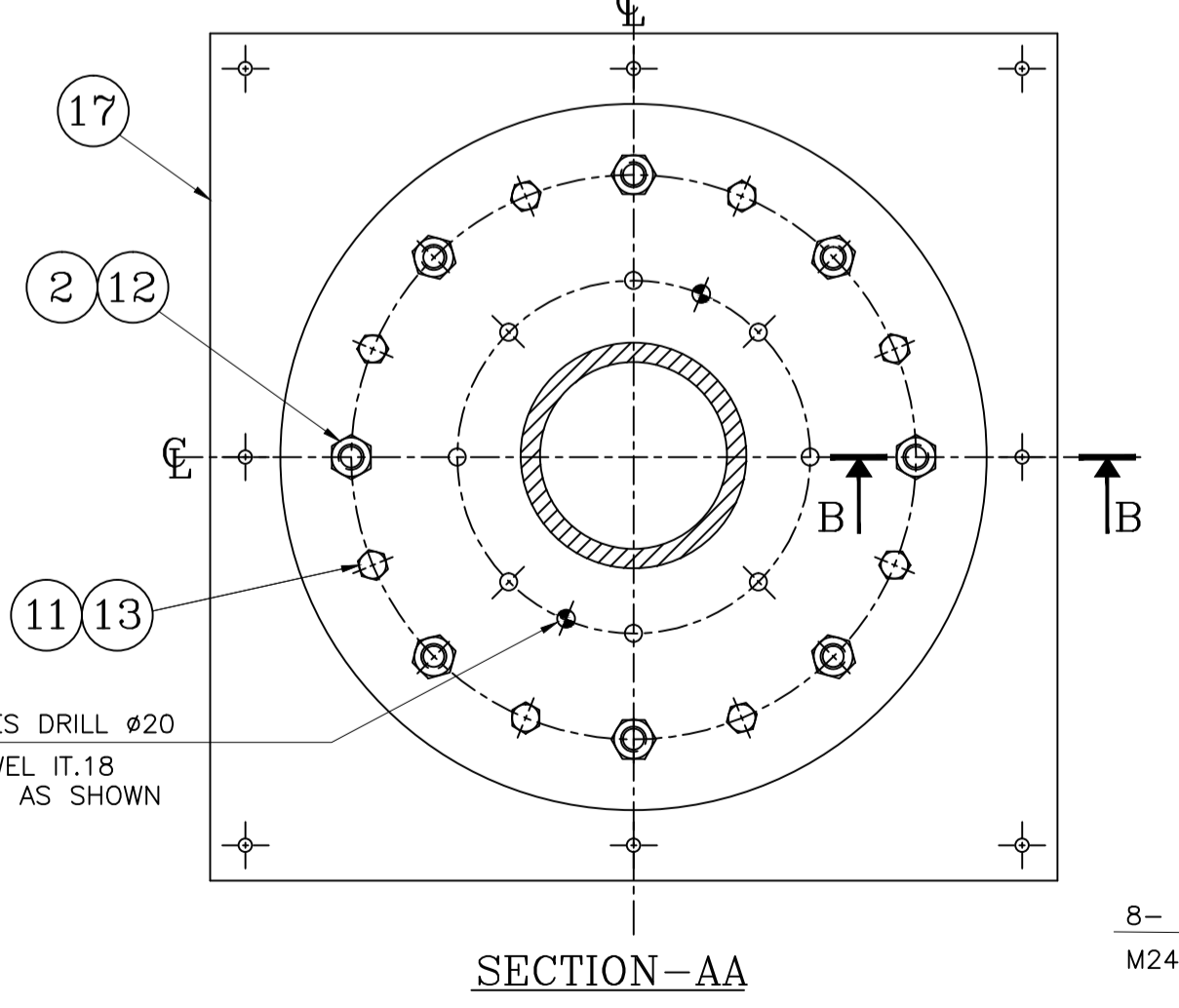
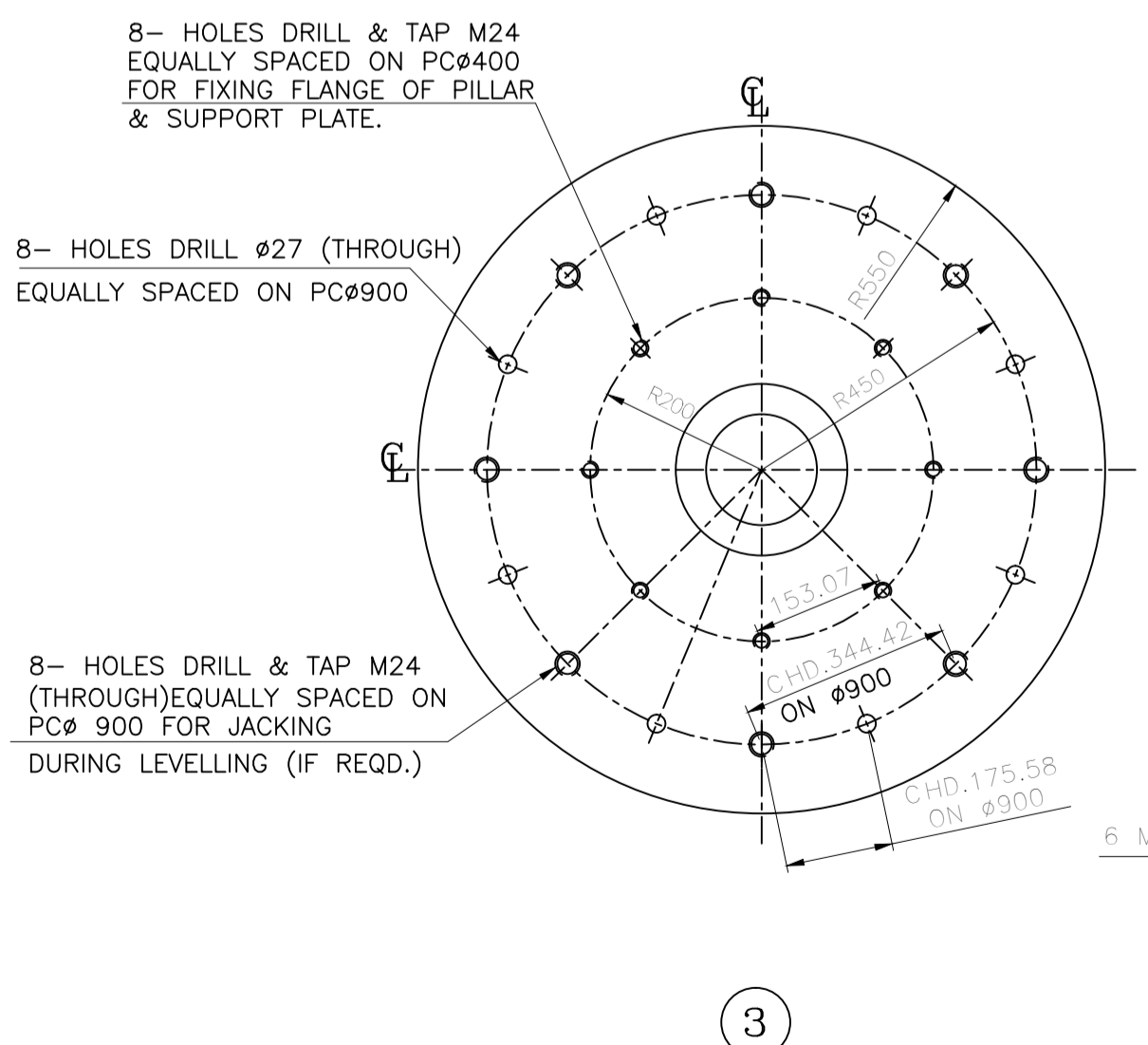


DRG. NO. 1 251 51 32617



**ARRANGEMENT OF SWEEP GAUGE FOR CORE BUILDING IN SERVICE BAY.**

1 ARRGT.



**TECHNICAL REQUIREMENTS:-**

1. THE SWEEP GAUGE IS MANUFACTURED FOR BUILDING STATOR CORE OF HYDRO-GENERATOR.
2. THE ROTATING ARM & ENTIRE STRUCTURE SHALL BE SUFFICIENTLY STIFF TO AVOID BENDING & DISTORTION DUE TO IT'S OWN WEIGHT.
3. CENTRAL PILLAR IT. 4 SHALL BE GROUND TO GIVE 0.8 MICRONS SURFACE FINISH. IT. WILL BE SHRINK FIT IN SUPPORT BAR IT.5 AND SHALL HAVE SLINDING FIT WITH BUSH IT.7.
4. THE ROTATING ARM SHALL BE MADE FROM TUBULAR FRAME STRUCTURE.
5. MOTORISED LEAD SCRU ARRANGEMENT SHALL BE PROVIDED TO LIFT THE BUSH & ARM ASSY. THE CONTROL PANNEL WITH LIMIT SWITCHES AT UPPER & LOWER POSITIONS SHALL BE PROVIDED TO STOP THE MOVEMENT OF BUSH BEYOND PERMISSIBLE LIMITS.
6. POINTER STICK IT.10 SHALL BE TACK WELDED AT SITE AFTER CHECKING WITH MICROMETER (SITE SCOPE).
7. ALL SURFACES EXCEPT MACHINED SURFACES, SHALL BE PAINTED TO AA 0674112.
8. THE SWEEP GAUGE SHALL BE INSPECTED BY B.H.E.L. INSPECTOR AT SUPPLIER'S WORKS.
9. THE VERTICALITY OF THE PILLAR SHALL BE WITHIN 0.05MM.
10. SURFACE FINISH OF MACHINED SURFACE SHALL BE 3.2 MICRONS OR BETTER UNLESS OTHERWISE STATED.
11. MACHINED SURFACE EXCEPT PILLAR SHALL BE PROTECTED BY APPLYING TEMPORARY RUST PREVENTIVE (TRP) & MACHINED SURFACE OF PILLAR SHALL BE PROTECTED BY APPLYING GREASE.
12. AFTER FINAL POWER SUPPLY CONNECTIONS TO MOTOR STARTER BOX, ENSURE CORRECT MOVEMENT THROUGH UP & DOWN LIMIT SWITCH (THAT IS UP SWITCH FOR UPWARD MOVEMENT & DOWN SWITCH FOR DOWNWARD MOVEMENT). OTHERWISE INTERCHANGE CONNECTION OF TWO PHASES AT STARTER BOX INCOMING SUPPLY, IF NECESSARY.
13. ONE SET CONSISTS OF ITEMS & QUANTITIES AS GIVEN IN THE VAR-00 OF THE DRAWING.
14. GROUTING PLATE (IT.17 BHEL SUPPLY) TO BE LEVELLED 0-0 AT SITE BY ERECTION GROUP (SITE SCOPE).

**IMPORTANT NOTE FOR SUPPLIER:-**

1. DEVIATION IF ANY SHALL BE CLAERLY BROUGHT OUT IN THE OFFER.
2. THE SUPPLIER SHALL BE SUBMIT 4 COPIES OF DETAIL DRG. FOR B.H.E.L. APPROVAL BEFORE THE START OF MANUFACTURING.

QTY	VAR00	REMARKS	ITEM NO.	DESCRIPTION	DRAWING NO.	STD	UNIT	QTY	ZONE
010	2 NOS EXTRA		020	MACHINED WASHER M24		NA	NA	0.025	
001	SET		019	MISC. ITEMS		NA	NA	100.00	
002	GROUND TO FINISH AT SITE		018	DOWEL PIN 20.0		NA	NA	0.20	
001	(BHEL SCOPE)		017	GROUTING PLATE 32 TK.X1300X1300 LG. S.S.S.Q. PLATE		AA10108	NA	424.00	
001			016	MOTOR STARTER BOX WITH PENDANT SWITCH FOR CONTROL OF UP & DOWN MOVEMENT OF BUSH ASSY.		NA	NA	5.00	
010	2 NOS EXTRA		015	RAWL BOLT M16		NA	NA	1.50	
001			014	GEAR BOX WITH MOTOR ASSY.		NA	NA	25.00	
010	2 NOS EXTRA		013	SPRING WASHER M24		NA	NA	0.030	
010	2 NOS EXTRA		012	LOCKING NUT M24		NA	NA	0.40	
010	2 NOS EXTRA		011	SCREW M24X90 LG.		NA	NA	0.40	
001			010	ADJUSTABLE STICK		NA	NA	3.00	
001			009	LIFTING ARRANGEMENT 25 X 450 LG.		AA10108	NA	8.00	
001	SEE TR.2		008	ARM ASSY.		AA10108	NA	25.00	
001			007	BUSH 320 O/D X 310LG. (CAST IRON)		NA	NA	65.00	
001			006	LEAD SCRU 2" SQ. THREADX3600 LG.		AA10108	NA	50.00	
001			005	SUPPORT BAR (2323) WITH FLANGE 50TKx500 LG.		AA10108	NA	186.00	
001			004	PILLAR (SEAMLESS PIPE) 265(NOM.)X4000 LG.		NA	NA	480.00	
001			003	SUPPORT PLATE 56TKx1100 S.S.S.Q. PLATE		AA10108	NA	370.00	
010	2 NOS EXTRA		002	JACKING SCREW M24X120LG.		AA10108	NA	2.20	
000			001	SWEEP GAUGE ASSY.		NA	NA	1500.00	

ADDITIONAL INFORMATION: mRikn dk i-dkj; k xk-gd@fj;kstuk dk uke

STATUS OF DRAWING: U

DISTRIBUTION OF PRINTS: HGE-3, TEX-1, PLM-4

GENERAL ARRANGEMENT OF SWEEP GAUGE

HGS 860/200-24D

PHPA/PUNTSANGCHHU HEP,BHUTAN

HAksiky BHARAT HEAVY ELECTRICALS LTD. BHOPAL

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1 251 51 32617

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