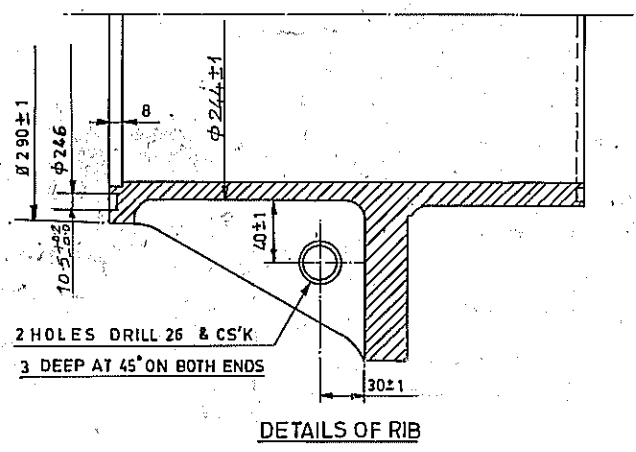
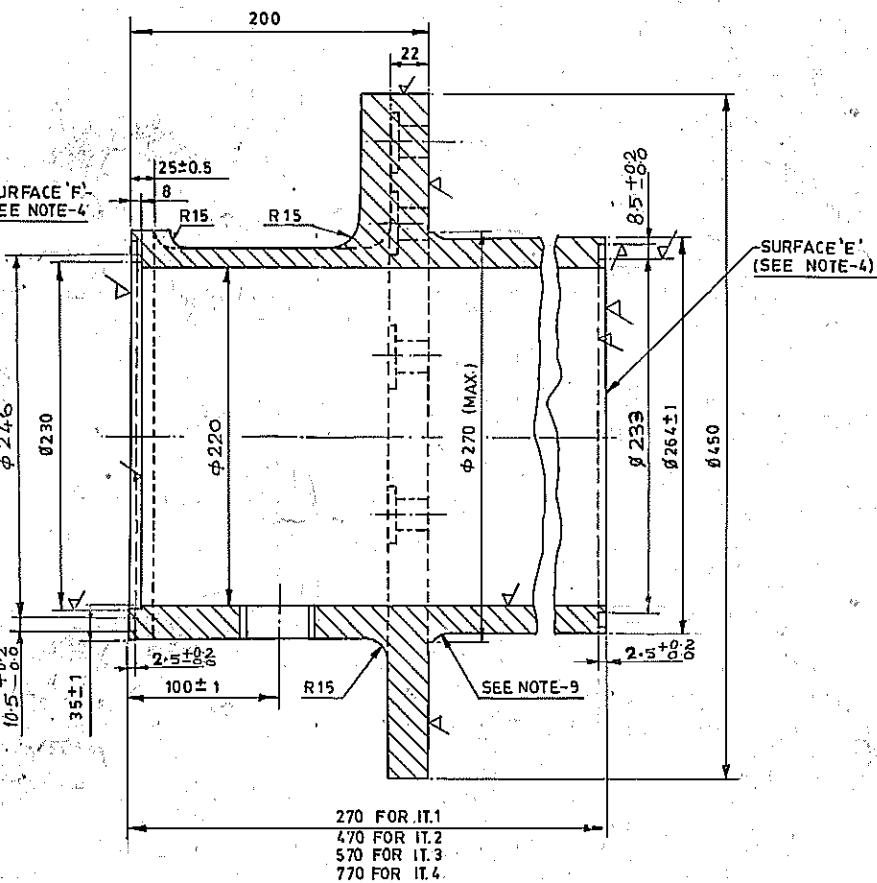


95010 90 838 00 01036



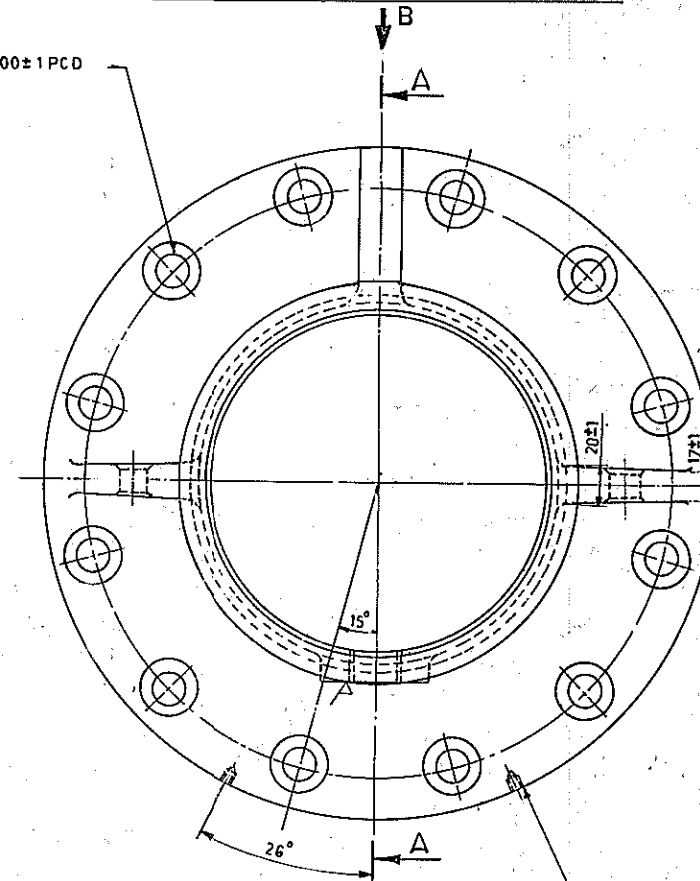
DETAILS OF RIB



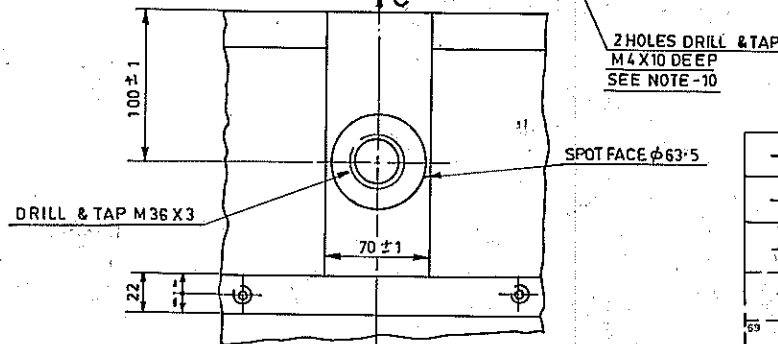
SECTION-AA

12 HOLES DRILL 20 ON 400 ± 1 PCD AND SPOTFACE 63.5 EQUALLY SPACED

VIEW IN DIRECTION ARROW-B



VIEW IN DIRECTION ARROW-C

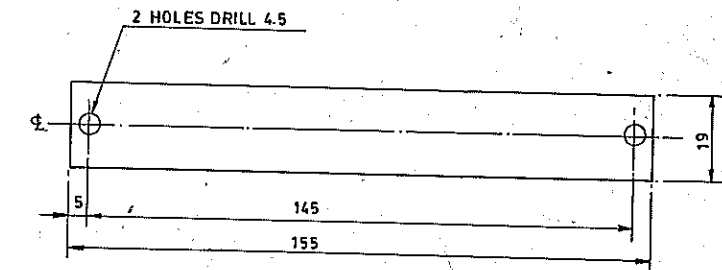


STYLE LIST				
STYLE	ITEM INCLUDED	DESCRIPTION	RECORDED DATE	FINISH WEIGHT IN KG.
950302	001	FLANGE (FOR 100 C.T. LENGTH)	29.4.94	17.5 00
950303	002	FLANGE (FOR 300 C.T. LENGTH)	29.4.94	28.000
950304	003	FLANGE (FOR 400 C.T. LENGTH)	29.4.94	33.000
950305	004	FLANGE (FOR 600 C.T. LENGTH)	29.4.94	43.500

NOTES:-

- CASTING SHOULD BE FREE FROM BLOW HOLES & CRACKS. OUTER SURFACE SHOULD BE FREE FROM ANY SHARP EDGES & SHOULD BE SMOOTH FINISHED.
- FINISHED MACHINED CASTING MUST BE AIR PRESSURE TESTED AT 3KG/CM² WITHOUT ANY LEAKAGE FOR 30 MINUTES AS PER ARRGT. OF FIG.1 & 2 BOTH.
- MACHINED SURFACE TO BE PROTECTED FROM DENTS AND SCRATCHES WHILE HANDLING.
- SUPPLIER SHALL ENSURE AFTER MACHINING OF THE FLANGE THAT THE SURFACE E & F SHALL BE PROTECTED ENOUGH WITH CUSHION MATERIALS TO AVOID ANY DAMAGE DURING TRANSIT & HANDLING.
- MACHINING TOLERANCE ± 0.25 UNLESS SHOWN OTHERWISE.
- TOLERANCE ON ANGULAR DIMENSION TO BE ± 0.5°
- TOLERANCE ON RADDI TO BE ± 0.2
- THREADS: PITCH COARSE TO LATEST REV OF IS: 4218 (PART-IV) TOLERANCE QUALITY MEDIUM CLASS-6H.
- DURING CASTING SUITABLE RADIUS MAY BE TAKEN TO AVOID BLOW HOLES
- THESE HOLES TO BE DRILLED USING THE TEMPLATE AS SHOWN IN DETAIL-A AFTER FORMING OF SEGMENT OVER 450.

TOOL LIST		
TOOL NO.	ITEM	DESCRIPTION
1560 116	004	GRAVITY DIE CASTING



DETAIL-A (TEMPLATE) (1.5 TK)

PATT. NO.	ITEM NO.	DESCRIPTION	QTY	MATL. CODE	UNIT	UNIT WT.	NO. OF
1299040	004	MTG. FLANGE CAST AL. ALLOY	1	AA19950	KG	1	
1299039	003	MTG. FLANGE CAST AL. ALLOY	1	AA119950	KG	1	
1299038	002	MTG. FLANGE CAST AL. ALLOY	1	AA19950	KG	1	
1299037	001	MTG. FLANGE CAST AL. ALLOY	1	AA19950	KG	1	

245 KV-Q.I.P COND. BUSHING

STATUS OF DRAWING: M

DISTRIBUTION OF PRINTS: B/E-1 BCM-1 FYM-2 QAX-1 TCX-1

ADDITIONAL INFORMATION: DRG. RETRACED. POS. OF RIBS, PAD IN VIEW 'B', PAD IN VIEW 'C' & 2 HOLES M4 X 10 DEEP ALTERED. 270 (MAX) & ONE PAD R16 IN VIEW 'B' ADDED.

REV. DATE ALTERED CHECKED APPROVED

REV. DATE ALTERED CHECKED APPROVED

REV. DATE ALTERED CHECKED APPROVED

REV. DATE ALTERED CHECKED APPROVED

SCALE: N.T.S.

STYLIST: R. K. A.

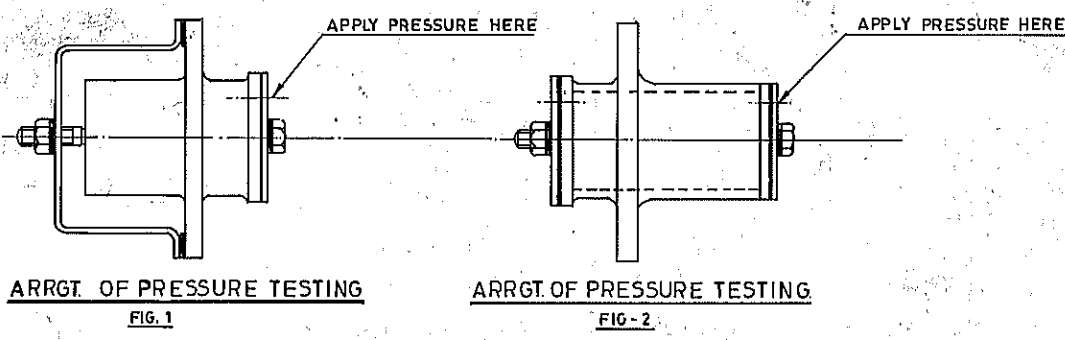
DATE: 02.06.94

TITLE: **FLANGE**

NO. OF SHEETS: 05

SHEET NO.: 05

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ARRGT. OF PRESSURE TESTING FIG. 1

ARRGT. OF PRESSURE TESTING FIG. 2