

APPLY PRESSURE HERE

APPLY PRESSURE HERE

ARRGT FOR PRESSURE TEST FIG. 1

ARRGT FOR PRESSURE TEST FIG. 2

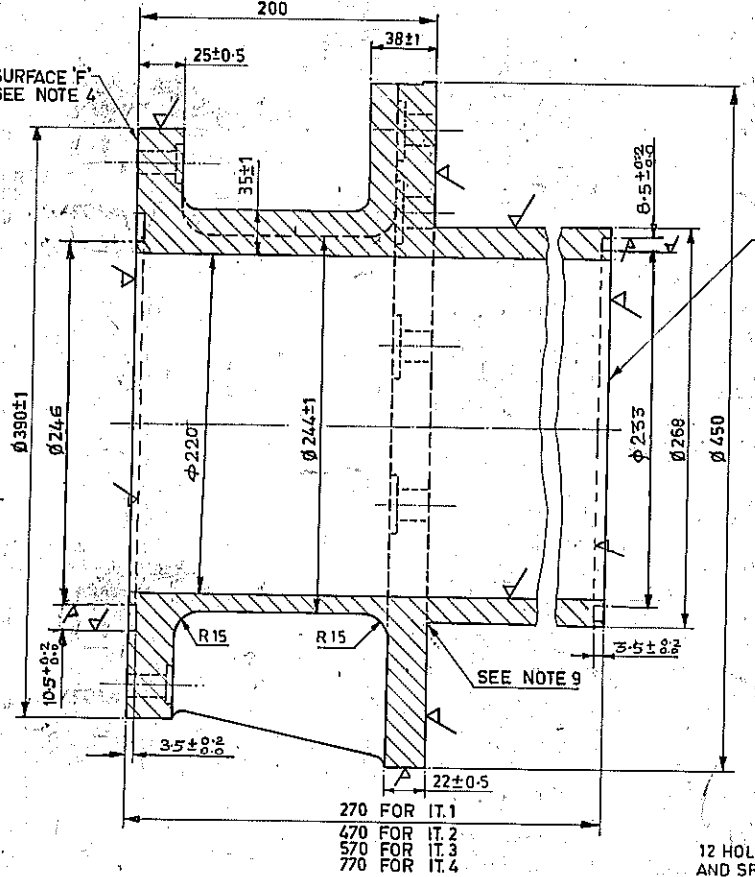
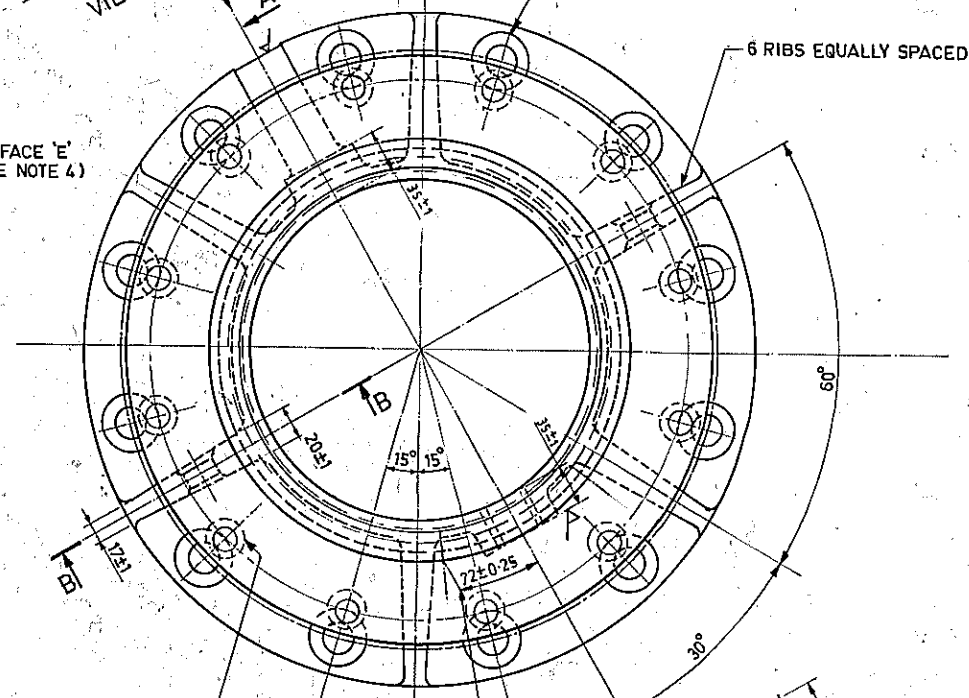
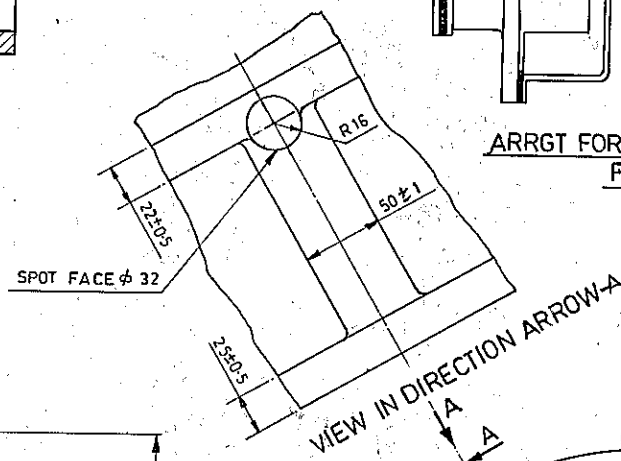
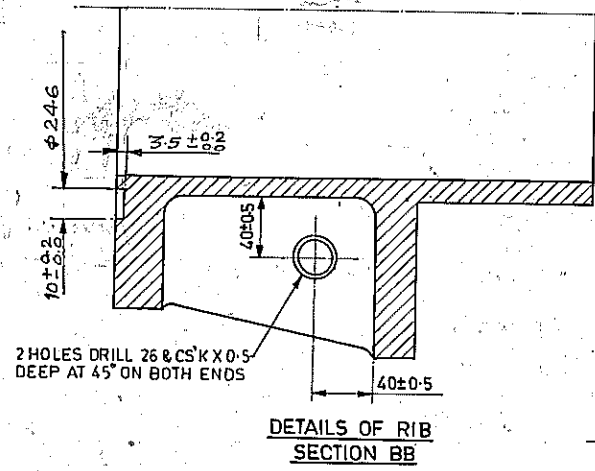
STYLE LIST					
STYLE	ITEM INCLUDED	DESCRIPTION	RECORDED		FINISH WEIGHT IN Kg
			DATE	SIG	
950315	001	FLANGE (FOR 100 C.T. LENGTH)	17-6-94	[Signature]	23-50
950316	002	FLANGE (FOR 300 C.T. LENGTH)	17-6-94	[Signature]	33-50
950317	003	FLANGE (FOR 400 C.T. LENGTH)	17-6-94	[Signature]	38-50
950318	004	FLANGE (FOR 600 C.T. LENGTH)	17-6-94	[Signature]	48-50

NOTES :-

- CASING 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 AND 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/FINE 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 φ 390.

TOOL LIST

TOOL NO.	ITEM	DESCRIPTION.
1560117	004	GRAVITY DIE CASTING



12 HOLES DRILL 18 ON 350±1 PCD AND SPOTFACE φ 32 EQUALLY SPACED

2 HOLES DRILL & TAP M 4 X 6 DEEP SEE NOTE-10

DRILL & TAP M36X3 THROUGH

SECTION-AA

DETAIL-A (TEMPLATE: 1-6TK) SEE NOTE-10

VAR. NO.	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	DRAWING NO.	MATL. CODE	UNIT WT.	ZONE
-	PATT. NO. 1299044	004	004	MTG. FLANGE CAST AL. ALLOY. (LM9)	1	AA 19953	1	-
-	PATT. NO. 1299043	003	003	MTG. FLANGE CAST AL. ALLOY. (LM9)	1	AA 19953	1	-
-	PATT. NO. 1299042	002	002	MTG. FLANGE CAST AL. ALLOY. (LM9)	1	AA 19953	1	-
-	PATT. NO. 1299041	001	001	MTG. FLANGE CAST AL. ALLOY. (LM9)	1	AA 19953	1	-

ADDITIONAL INFORMATION

STATUS OF DRAWING: M

DISTRIBUTION OF PRINTS: BCE-1 BCM-1 FYM-2 QAX-1 TCX-1

245 KV O.I.P. BUSHING. (HIGHER CREEPAGE)

NAME OF CUSTOMER/PROJECT: BHARAT HEVY ELECTRICALS LTD. BHOPAL

DATE: 18-6-94

ITEM NO.: 05380101025

DRAWING NO.: 1 538 04 01037

FLANGE

REV.	DATE	ALTERED	CHECKED	APPROVED	REV.	DATE	ALTERED	CHECKED	APPROVED	REV.	DATE	ALTERED	CHECKED	APPROVED
03	26-5-06	GROOVE φ 21.6 X 10-5 X 3-5 DEEP IN PLACE OF φ 29.0 X 2 DEEP.	[Signature]	[Signature]	02	24-3-98	POSITION OF 2 HOLES M4 ALTERED IN VIEW-B. NOTE-10, DETAIL-A M/C MARK AT φ 390 & REF TO ASSY.DRG. ADDED.	[Signature]	[Signature]	01	23-7-96	PAD TO R16 ADDED. SECTION-AA & VIEW IN DIRECTION OF ARROW-A MODIFIED.	[Signature]	[Signature]

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.