FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm

DRG. NO. 2 251 06 42614

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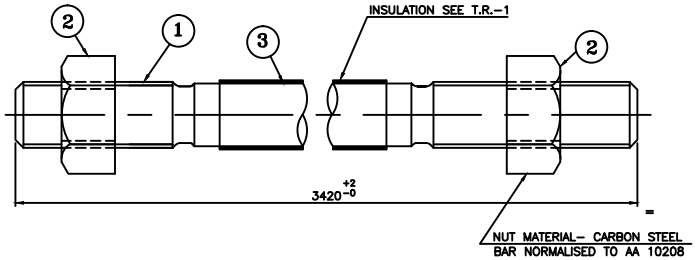
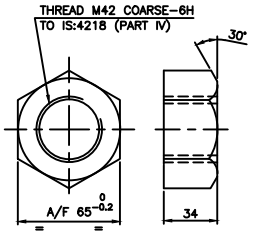
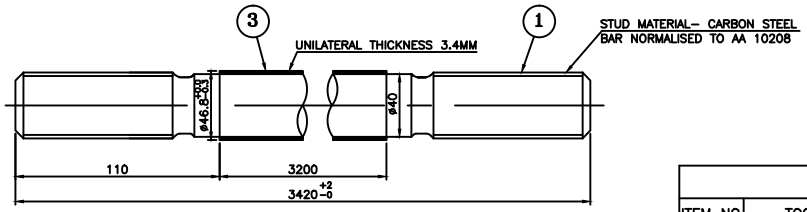


SET OF INSULATED CORE STUD & NUT



HEX. NUT TO IS:1364–S6

② ▽ ALL OVER



INSULATED STUD ASSY.

TECHNICAL REQUIREMENTS:–

1. STUDS ARE TO BE INSULATED WITH EPOXY MICA PAPER GLASS TAPE/CLOTH WITH RESIN SYSTEM TO CLASS 'F'. INSULATED SURFACE AFTER MACHINING SHALL BE SMOOTH & FREE FROM DEFECTS LIKE FOLDS, BULGES, SEAMS, RESIN GLOBULES,WRINKLES ETC. FINISHED STUDS SHALL BE GIVEN A THIN COAT OF CLASS 'F' AIR DRYING VARNISH.
2. RADIAL THICKNESS OF INSULATION SHALL BE UNIFORM ALL AROUND AND ALL ALONG THE LENGTH.
3. STUD SHALL BE WITHIN 0.4MM OVER ENTIRE LENGTH AFTER INSULATING AND MACHINING.
4. STUD MAY BE KNURLED / ROUGHENED, IF REQUIRED FOR BETTER ADHESION OF INSULATION.
5. 100% STUDS ARE TO BE HV TESTED AT 21 KV ACRMS W.R.T. STUD TO CONFIRM EFFICIENCY OF INSULATION.
6. SURFACE FINISH OF MACHINED SURFACE SHALL BE 3.2 MICRONS OR BETTER.
7. ITEM 1 SHOULD BE STRAIGHT WITHIN 0.4MM OVER ENTIRE LENGTH.
8. THREADS TO BE CHECKED BY PROPER GUAGES & NUTS ARE TO BE INTERCHANGEABLE.
9. EACH STUD TO BE FITTED WITH ONE NUT EACH SIDE.
10. STUDS ARE TO BE COATED WITH ANTIRUST COMPOUND BEFORE DISPATCH ON THREADED PORTION.

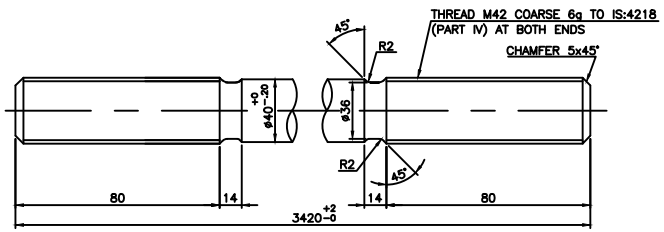
IMPORTANT NOTES:–

1. IT IS MANDATORY FOR SUPPLIERS TO CONFIRM THE FOLLOWING CLEARLY IN THEIR OFFERS:–

1.1 TO CONFIRM MEETING OF ALL TECHNICAL REQUIREMENTS GIVEN ON DRAWING.
1.2 TO CONFIRM MEETING CLAUSE BY CLAUSE REQUIREMENTS OF SPECIFICATION AA10208 FOR IT.1.
1.3 TO CONFIRM MEETING DRG. TOLERANCE.
1.4 CLAUSE BY CLAUSE COMPLIANCE OF QA PLAN NO. QSP/HG/101 FOR IT. 1.
1.5 ITEMS ARE TO BE PACKED IN WATER PROOF BOXES FOR LONG TERM STORAGE OF 5 YEARS.
1.6 DEVIATION IF ANY SHALL BE CLEARLY BROUGHT OUT IN THE OFFER.
1.7 OFFERS NOT MEETING THE ABOVE REQUIREMENT, IN FIRST INSTANCE WILL BE REJECTED.
1.8 ITEM TO BE SUPPORTED ON MINIMUM 6 POINTS TO AVOID ANY DEFORMATION/BEND/SAGGING.

TOOL LIST

ITEM NO.	TOOL NO.	DESCRIPTION



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EXPORT

AS REQD.	SEE TR.1&4		003	INSULATION				NA	KG	2.60		
002			002	HEX NUT M42	1		AA10208	NA	NO	0.64		
001			001	CORE STUD	1		AA10208	NA	NA	33.50		
VAR00	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.NO. / VAR.	MATL. CODE / MATL. SPCN.	C	UNIT	QTY.		ZONE
28 — CARD TYPE-3			28 — CARD TYPE-1				28 — CARD TYPE-2					

ADDITIONAL INFORMATION
W.O. 32008 TO 11-X-231-51

STATUS OF DRAWING 'U'

DISTRIBUTION OF PRINTS
HGE–2 HGM–2
TEX–1

उत्पाद का प्रकार या ग्राहक/परियोजना का नाम
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT

HGT–606/290–16D
MANGDECHHU HEP, BHUTAN

भारत हेवी इलेक्ट्रिकल्स लिमिटेड भोपाल
BHARAT HEAVY ELECTRICALS LTD. BHOPAL

	NAME	SIGN/DATE	REMARKS/DATE	REV. OF ITEM
DRN	SKN		23.12.14	00
CHD	AG/BK		23.12.14	
APPD	AD/BKS		23.12.14	

DEPT	HGE
CODE	403 32500001404

SCALE 1:1 | WEIGHT (KG) 37.38 | REF. TO ASSY. DRG. 02510642601 | ITEM NO. 17 | NO. OF ITEM 003

TITLE
SET OF INSULATED CORE STUD & NUT

DRAWING NO. 2 251 06 42614 | REV. 00

SHT. No. 01 | NO. OF SHT. 01

REV.	DATE	ALTERED / CHECKED / APPROVED