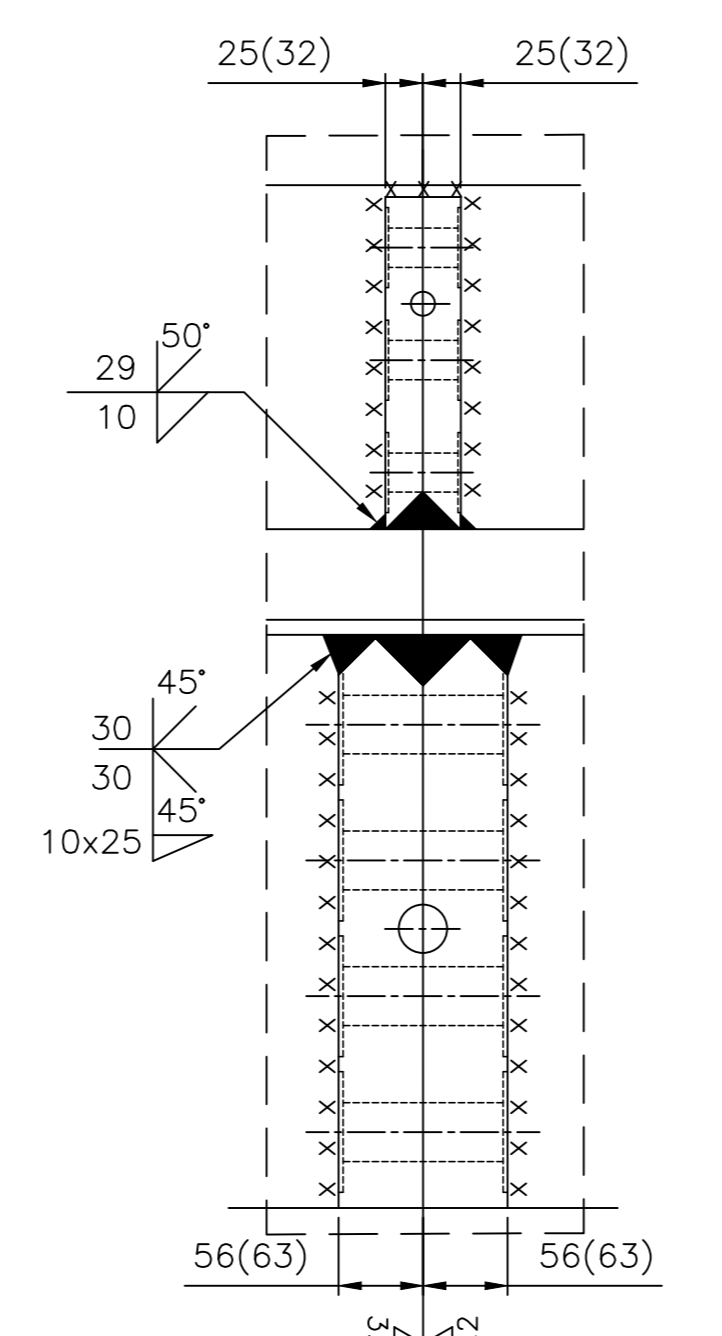
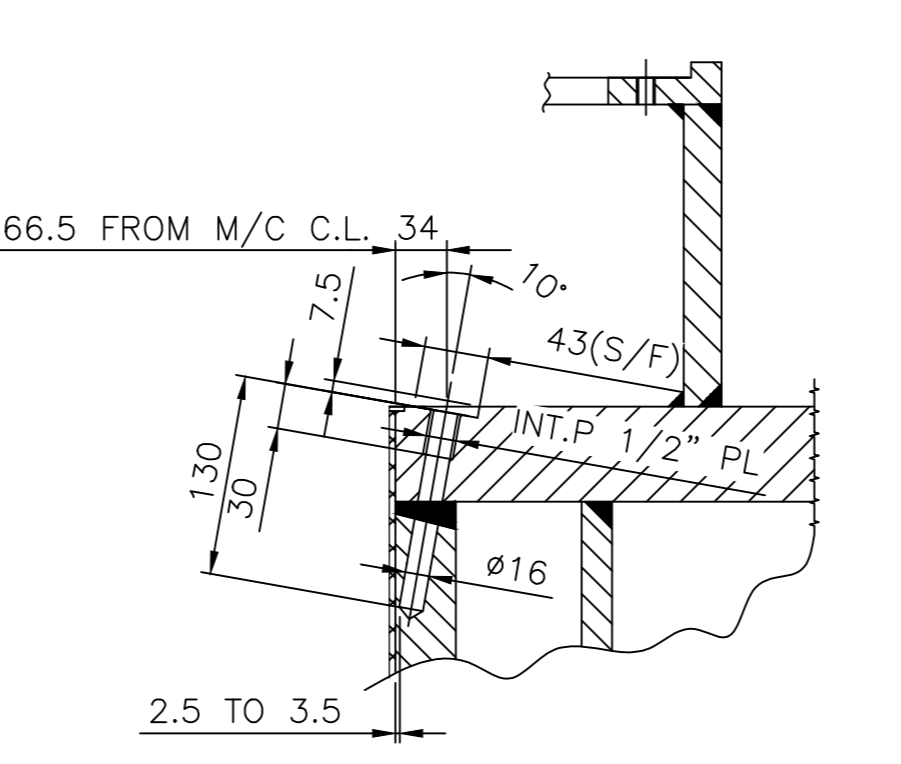


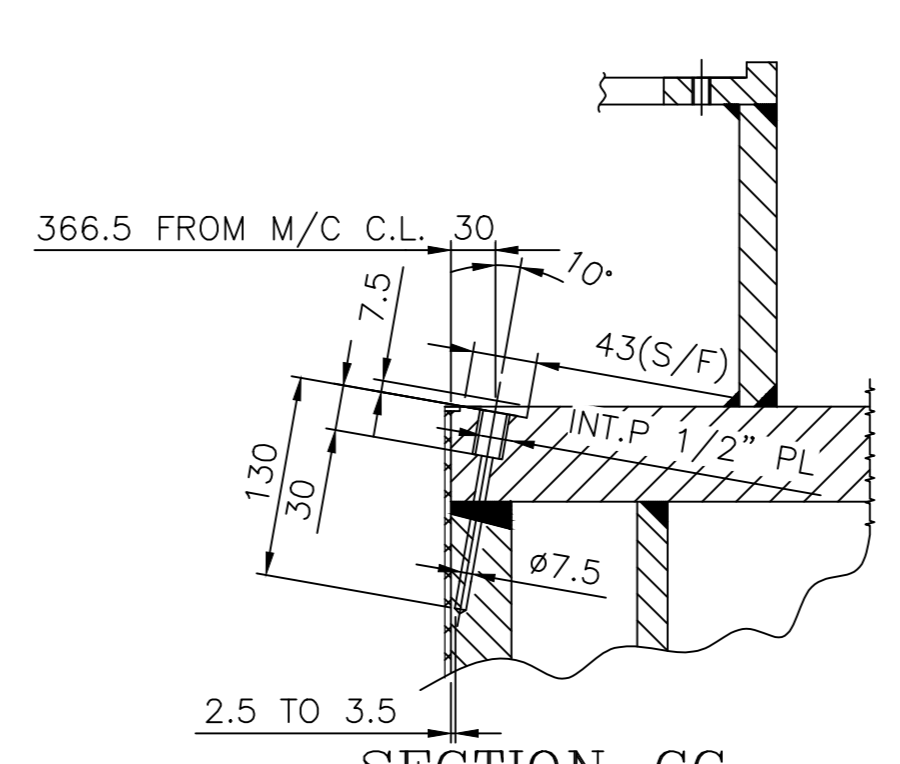
SECTION-AA



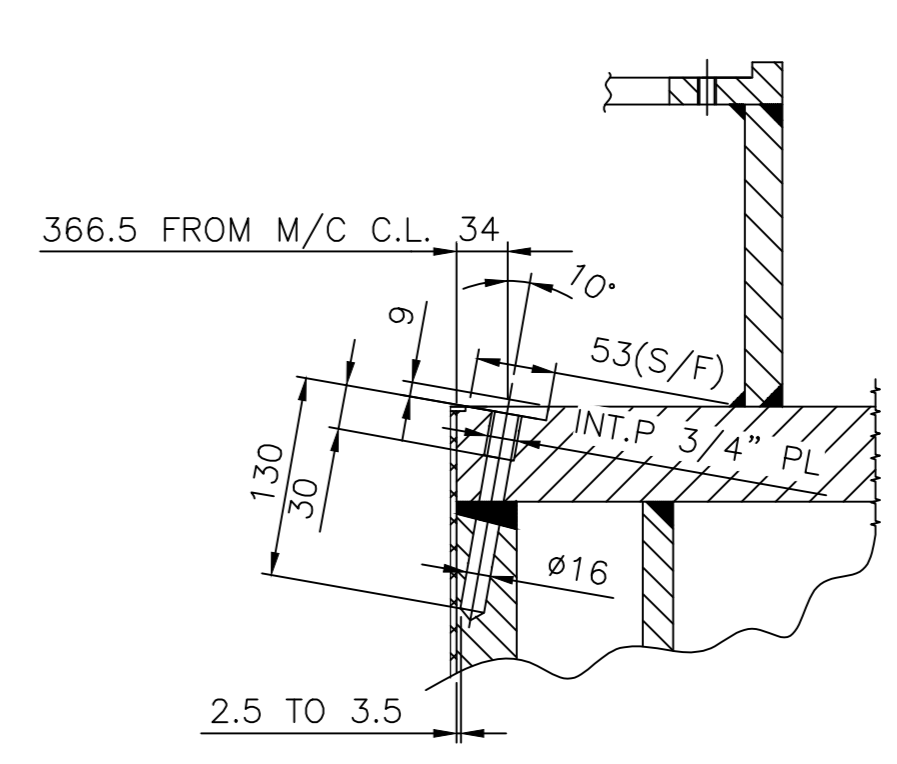
VIEW-G (SCALE 1:5 B-5)



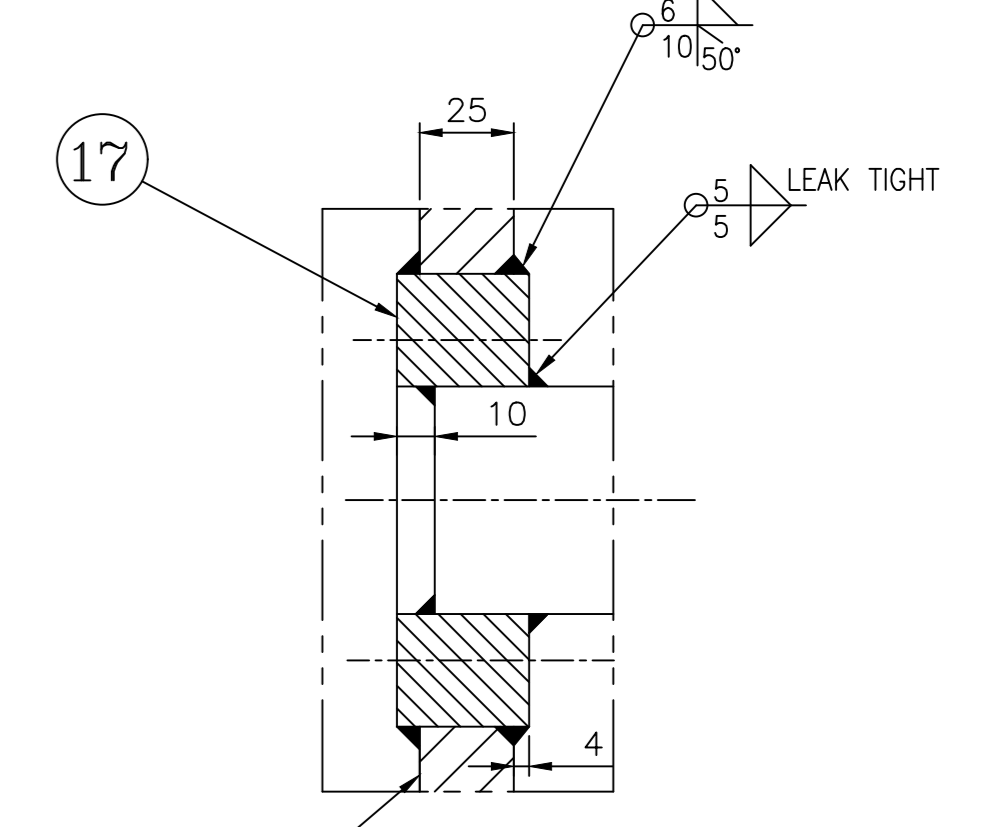
SECTION-C1C1 (SCALE 1:5 G-6,8) (HOLE FOR TEMP. RELAY TO BE ON C/L OF RIB)



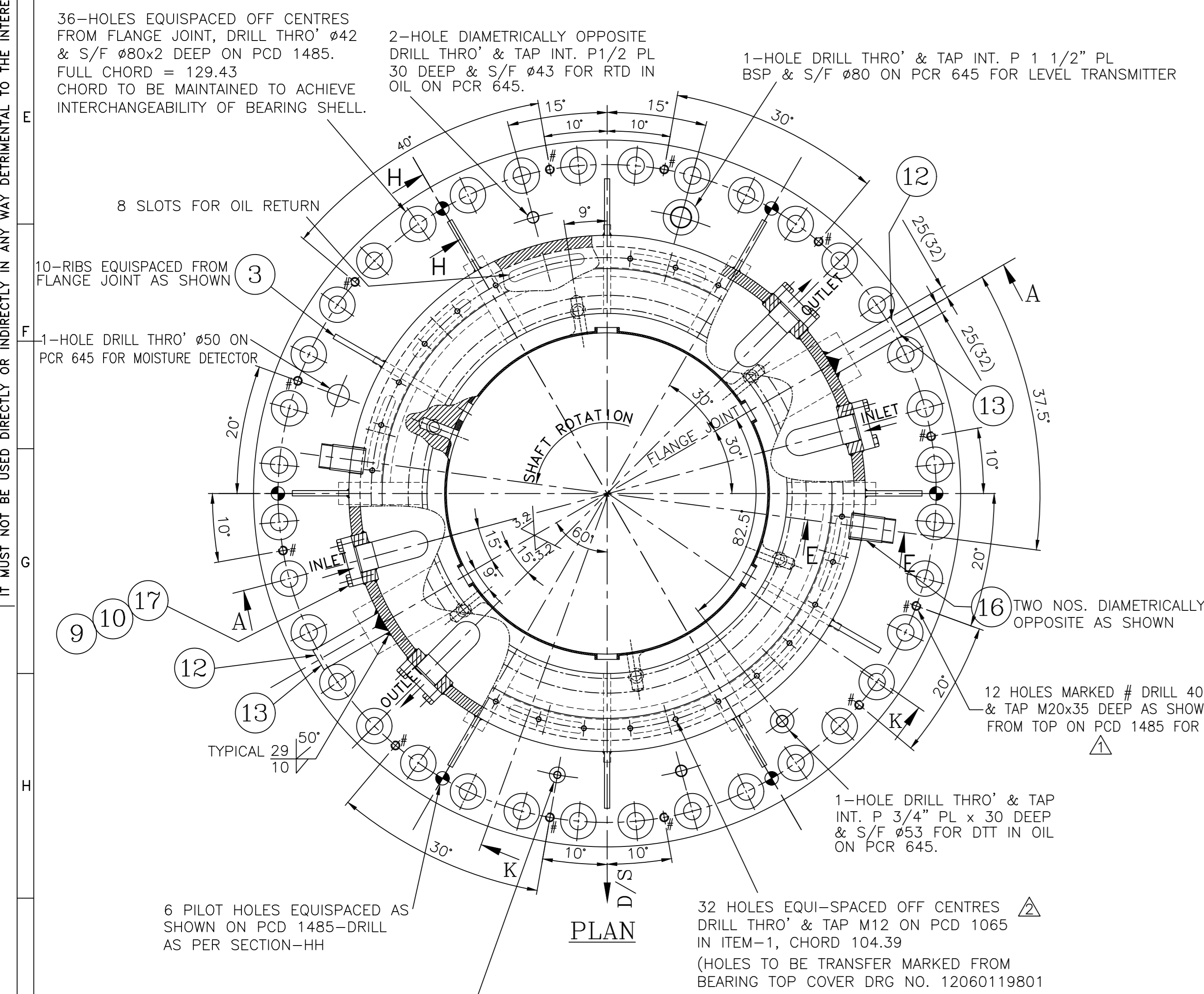
SECTION-CC (SCALE 1:5 F,G-7) (HOLE FOR RTD TO BE ON C/L OF RIB)



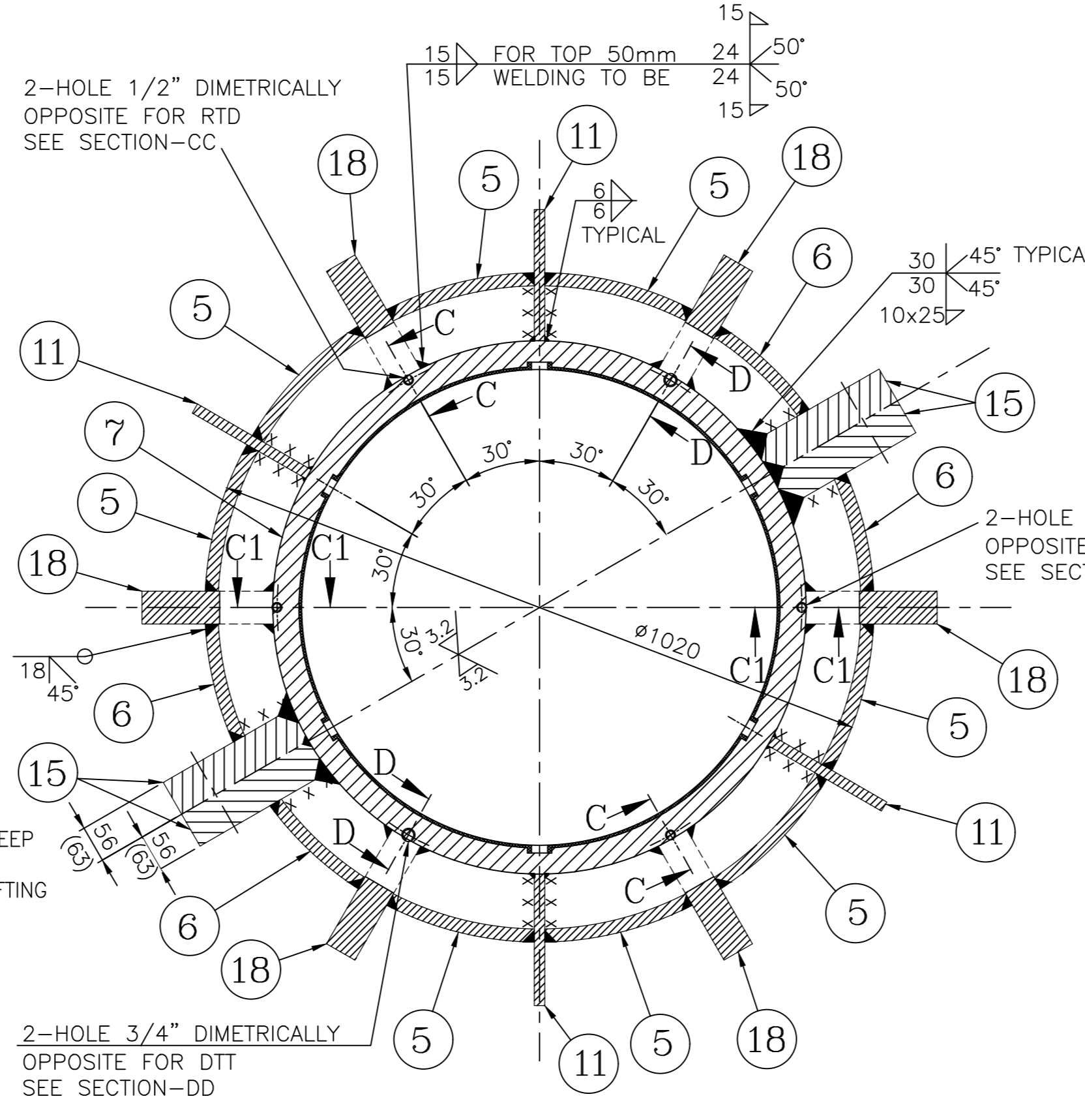
SECTION-DD (SCALE 1:5 F,H-7) (HOLE FOR DTT TO BE ON C/L OF RIB)



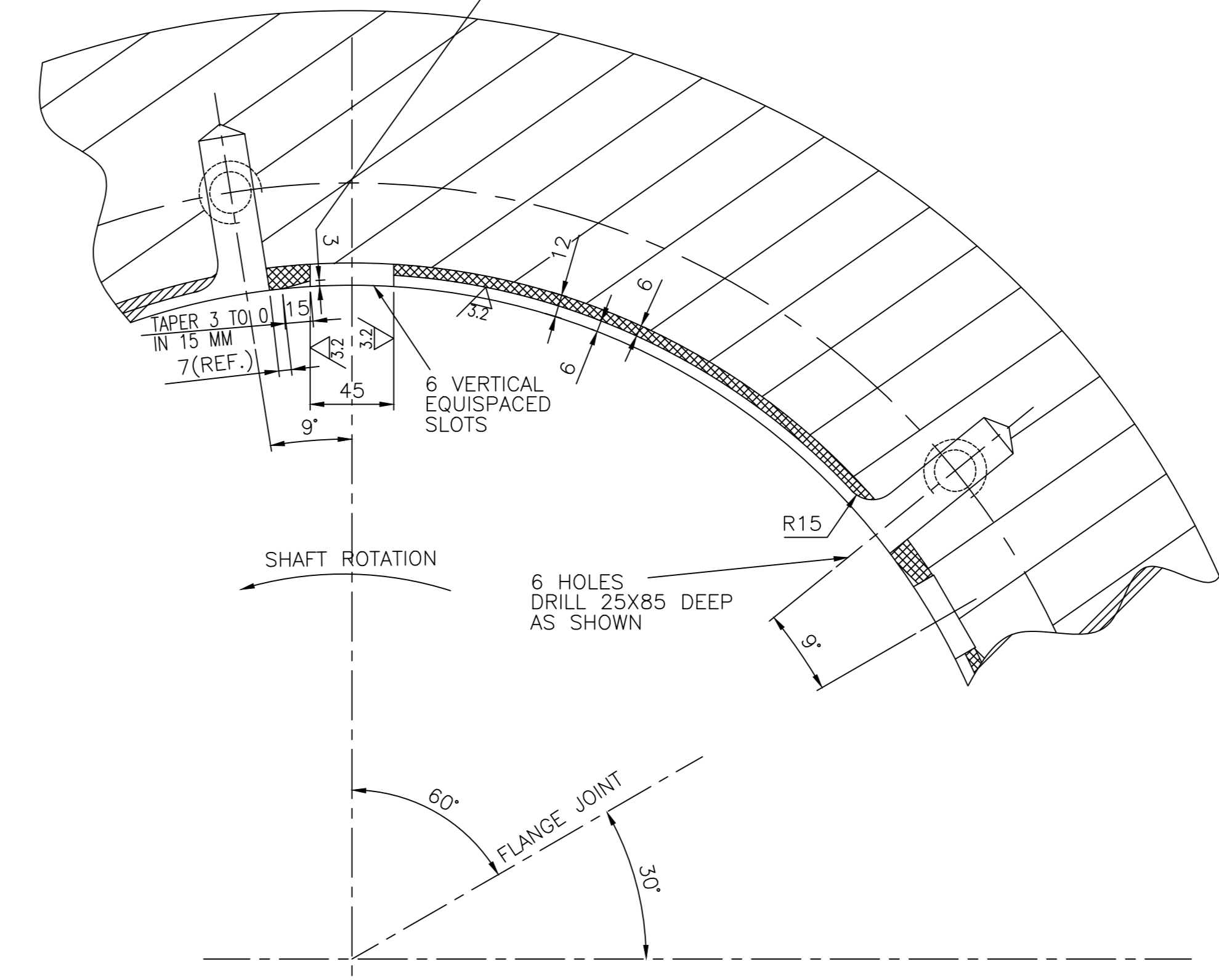
DETAIL-X (SCALE 1:2 A-1)



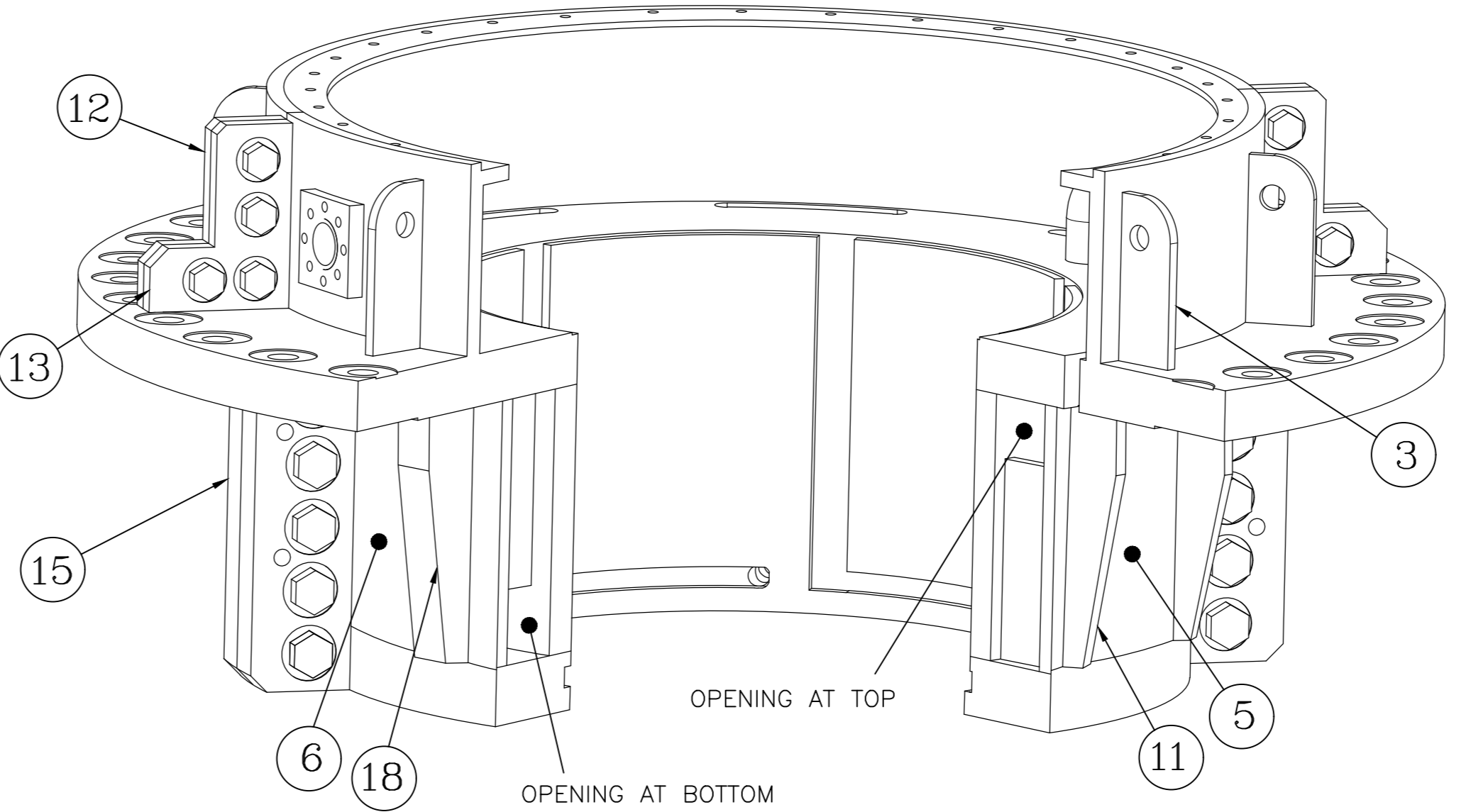
PLAN



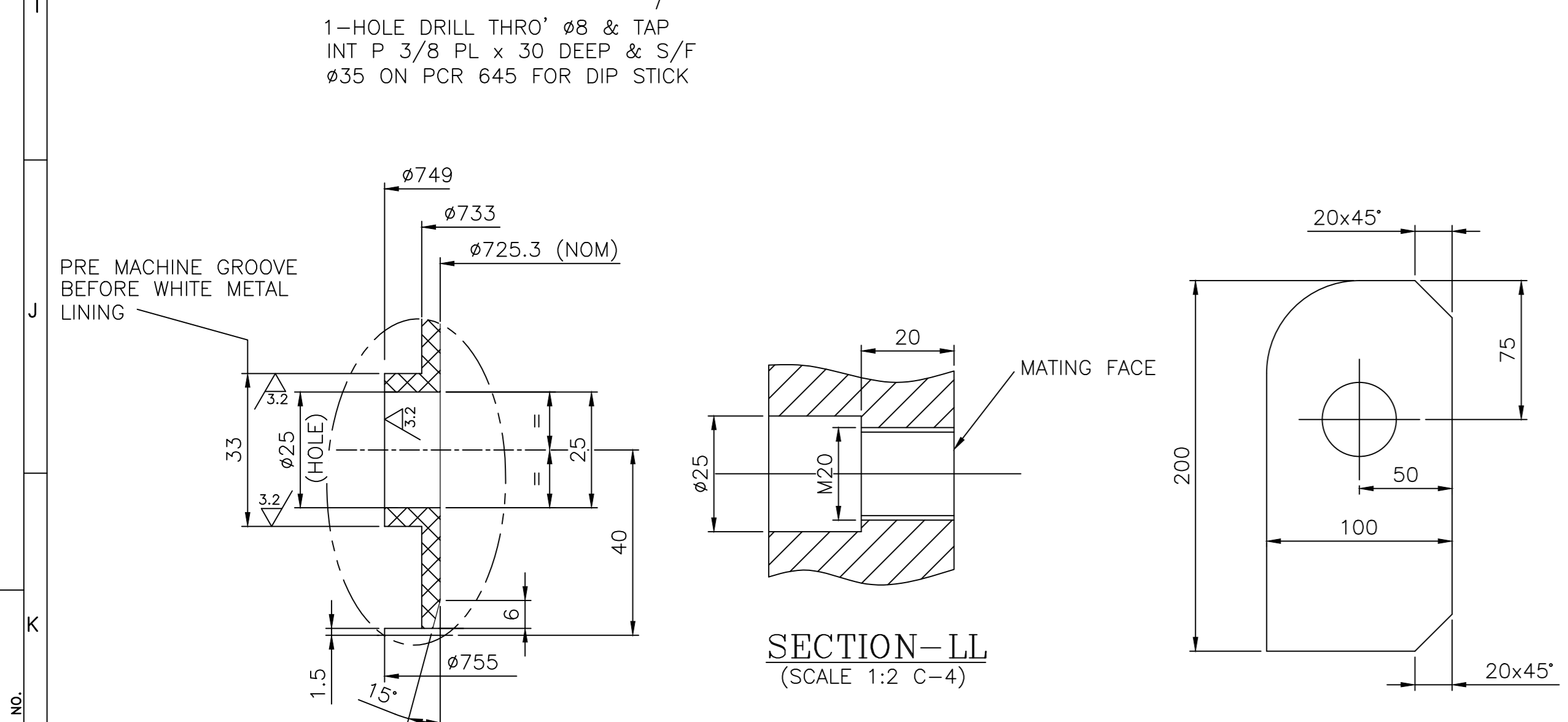
SECTION-BB (ZONE C-2,5)



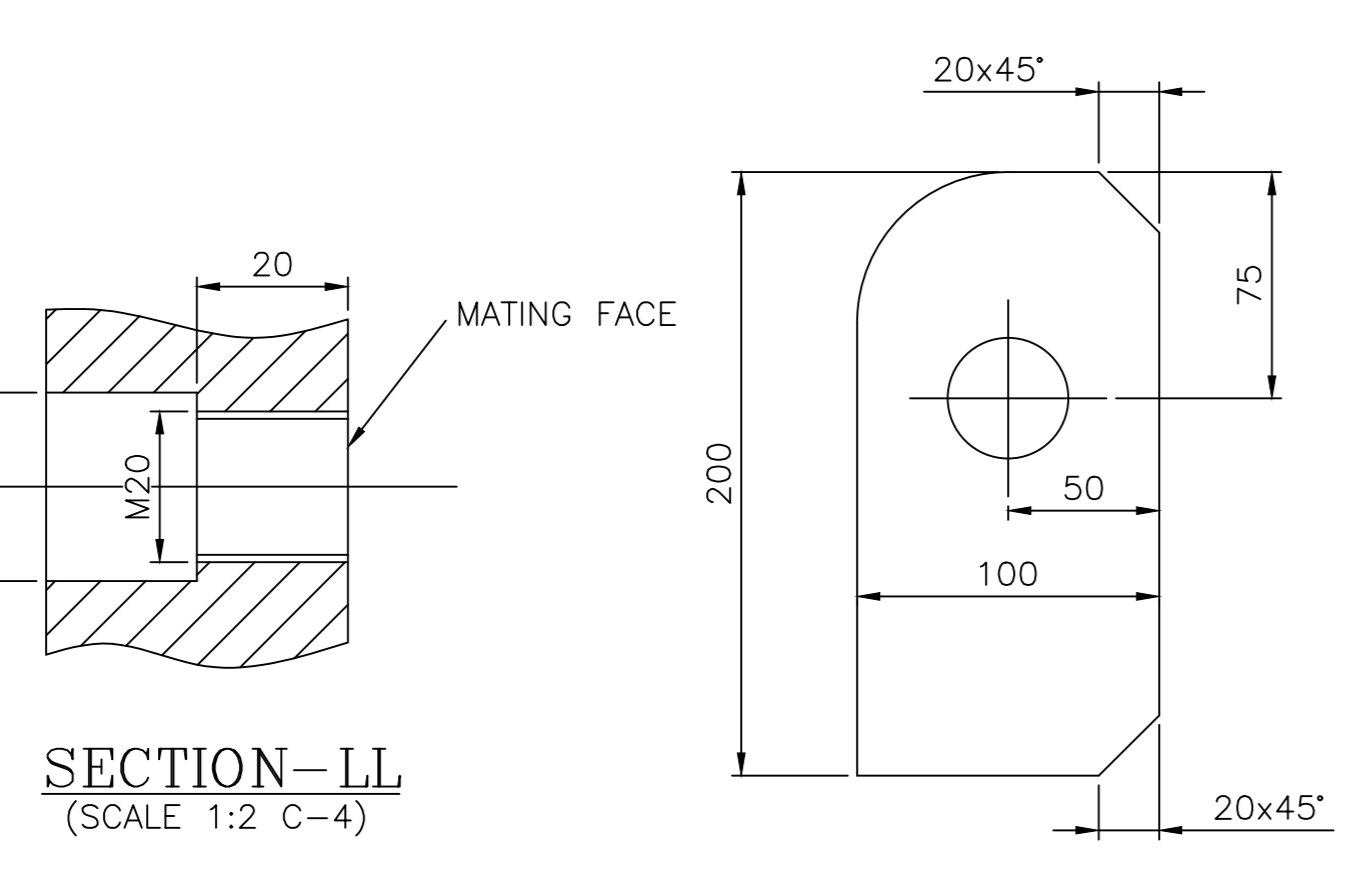
SECTION-GG (SCALE 1:2.5 C-3)



SECTION-KK (ZONE H-2,4) (ISOMETRIC SECTIONAL VIEW)

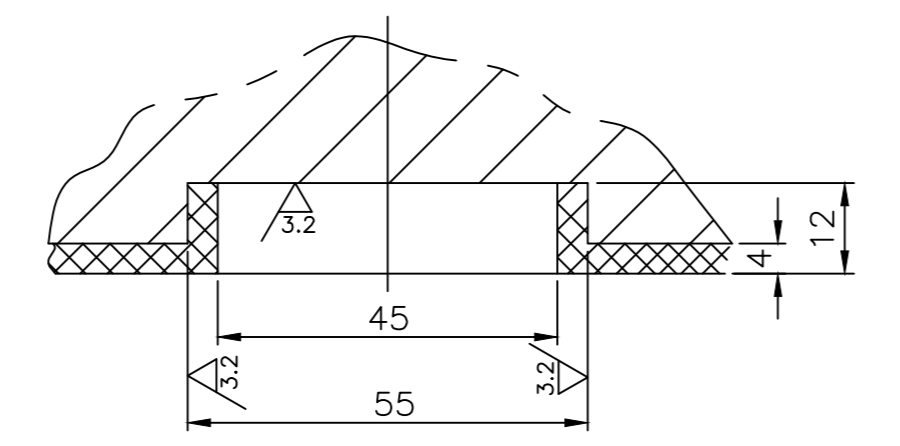


DETAIL-Y (SCALE 1:1 C-2)

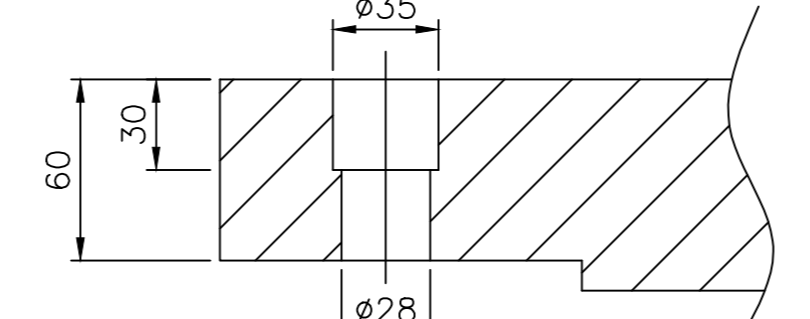


SECTION-LL (SCALE 1:2 C-4)

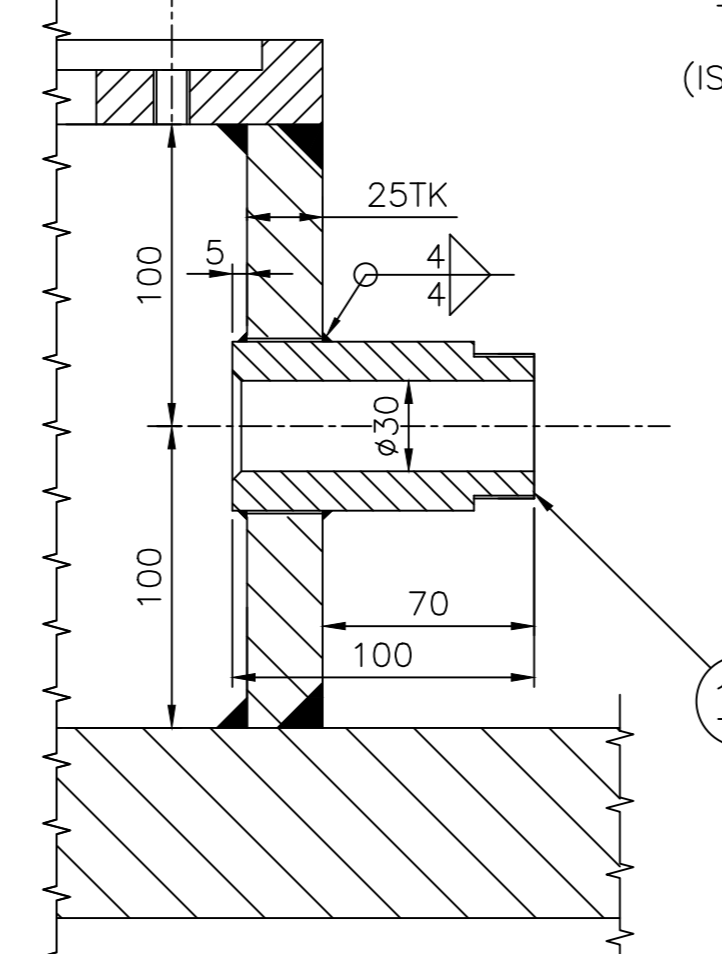
DETAIL OF ITEM-3 (SCALE 1:2.5)



SECTION-FF VERTICAL SLOTS (SCALE 1:1 B-4)



SECTION-HH (SCALE 1:2.5 E-2)



SECTION-EE (SCALE 1:2.5 G-4)

- TECHNICAL REQUIREMENTS:-**
- DIMENSIONS SHOWN WITHIN () FOR FABRICATION.
 - WELDING INSPECTION TO GRADE-II OF CORP. STD. AA0622101 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:-
a) MACHINED & BABBITTED SURFACES :- CAT G.
b) SURFACE MARKED :- CAT C
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.
 - a) SEGMENTS TO BE ULTRASONICALLY TESTED TO CHECK SATISFACTORY BONDING OF WHITE METAL LINING AS PER AA 0850126.
b) SEGMENTS TO BE CHECKED BY DYE PENETRATION ON EDGES TO AA0850131. NO LINEAR INDICATION ACCEPTABLE (CLAUSE 4.2.1 (iv) OF AA 0850126).
c) VISUAL INSPECTION (EXCEPT DP) OF SEGMENT SURFACES TO BE DONE TO CHECK FOR EXCESSIVE POROSITY (CLAUSE 3 OF AA 0850126)
 - DIMNS. MARKED (C) ARE TO BE STRICTLY ACHIEVED AND RE-CHECKED ALSO.

VAR. NO.	REMARKS	DATE	DESCRIPTION	DRAWING NO.	MATL. CODE	UNIT WT.	NO. OF
019	PARALLEL DOWEL 16 NOM. x 22LG.	3-206-01-19807	002 AA1070221104 AA10108	0.034	004		
018	RIB-I	3-206-01-19808	001 AA1011818218 AA10108	16.0	004		
017	SQUARE FLANGE	3-206-01-11910	AA1011819198 AA10119	2.60	004		
016	PIPE	4-206-01-15812	AA1050201191 AA10501	1.40	002		
015	LOWER JOINT FLANGE	3-206-01-19804	AA1011819236 AA10119	34.0	004		
014	PARALLEL DOWEL 25 NOM. x 30LG.	3-206-01-19807	001 AA1010208144 AA10721	0.120	004		
013	UPPER JOINT FLANGE-II	3-206-01-19801	001 AA1011819171 AA10119	4.5	002		
012	UPPER JOINT FLANGE-I	3-206-01-19801	002 AA1011819171 AA10119	4.5	002		
011	RIB-II	3-206-01-19808	002 AA1011818110 AA10108	5.20	004		
010	SONB SHORT RADIUS 90° ELBOW		BP9023532619 W.T. STOCK	0.500	004		
009	PIPE CDS 50NB 60.3 O/D x 4TK		BP1041055930 AA10455	17.5	001		
008	BOTTOM FLANGE (HALF)	4-206-01-19806	AA1011819260 AA10119	131.5	002		
007	CYLINDER (HALF)	2-206-01-19802	AA1011819210 AA10119	142.0	002		
006	OUTER CYLINDER SEGMENT-2	2-206-01-19805	AA1011819139 AA10119	8.2	004		
005	OUTER CYLINDER SEGMENT-1	2-206-01-19804	AA1011819139 AA10119	10.6	008		
004	MIDDLE FLANGE (HALF)	3-206-01-19806	AA1011819244 AA10119	443.0	002		
003	RIB	SEE DETAIL	AA1011808099 AA10108	1.300	010		
002	TOP CYLINDER (HALF)	2-206-01-19803	AA1011819155 AA10119	70.0	002		
001	TOP FLANGE (HALF)	4-206-01-19805	AA1011819171 AA10119	35.50	002		

DRAWING REVIEW

DEPT.	NAME	SIGN.	DATE

ADDITIONAL INFORMATION

STATUS OF DRAWING: U

DISTRIBUTION OF PRINTS: HTE-2 WTM-5 FBM-7 THX-1

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT RAMMAN STAGE-III HEP

DATE 01.07.2017

SCALE 1:7.5

WEIGHT 1850

REF. TO ASSY. DRG. 0-206-01-19801

ITEM NO. 09

NO. OF 19

TITLE BEARING SHELL

DRAWING NO. 0-206-01-19802

REV. 0.3

NO. OF 01

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