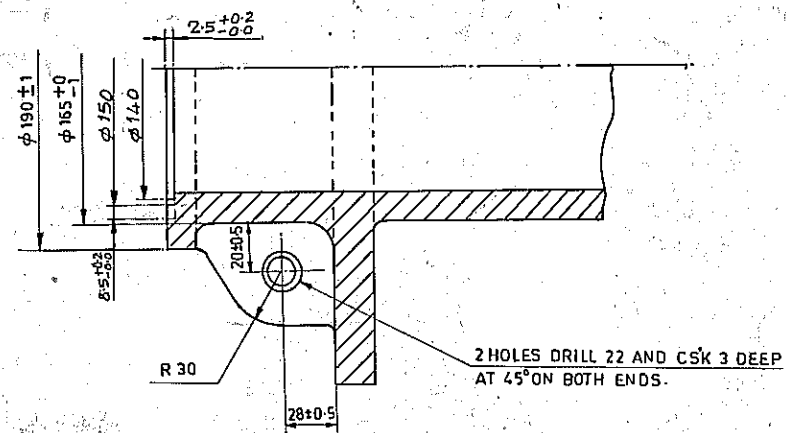
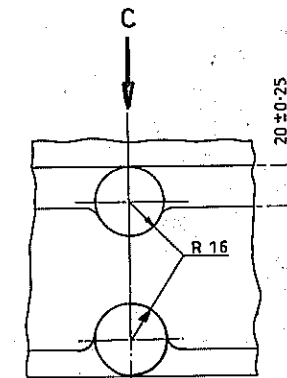


DRG NO. 1 538 04 01008



DETAIL OF RIB



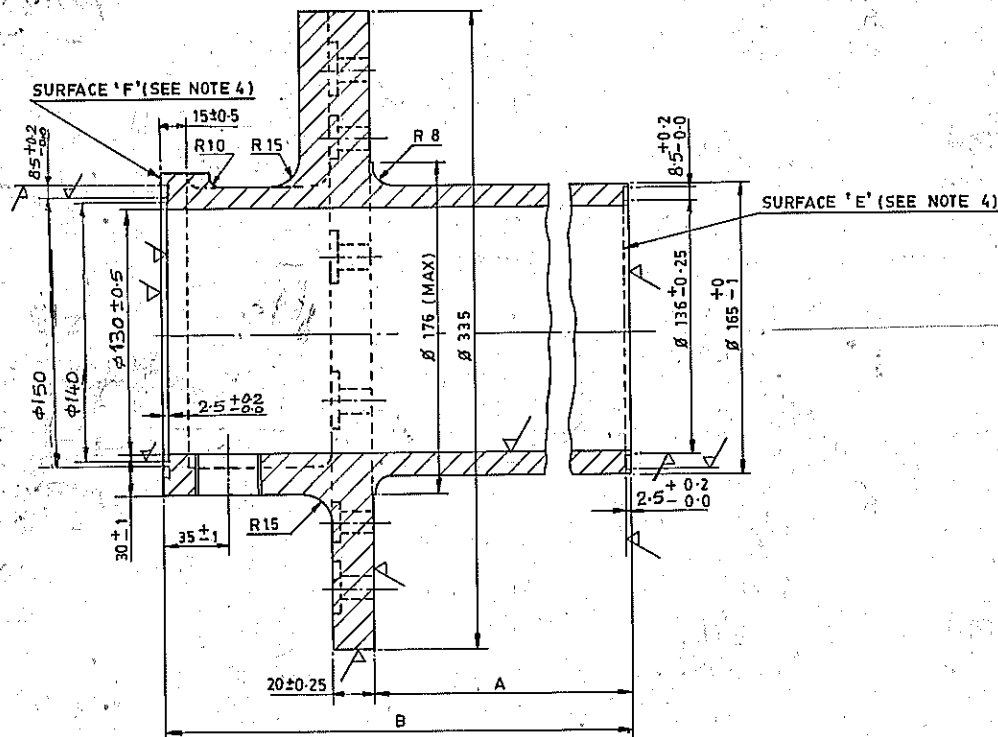
PART VIEW IN DIRECTION -C

STYLE LIST				
STYLE	ITEM INCLUDED	DESCRIPTION	RECORDED DATE	FINISH WT. (Kg)
906738	001	FLANGE	2-9-84	10.0
906739	002	FLANGE	2-9-84	14.0
906740	003	FLANGE	2-9-84	20.0
950515	004	FLANGE	17-6-06	9.200
950516	005	FLANGE	17-6-06	13.200

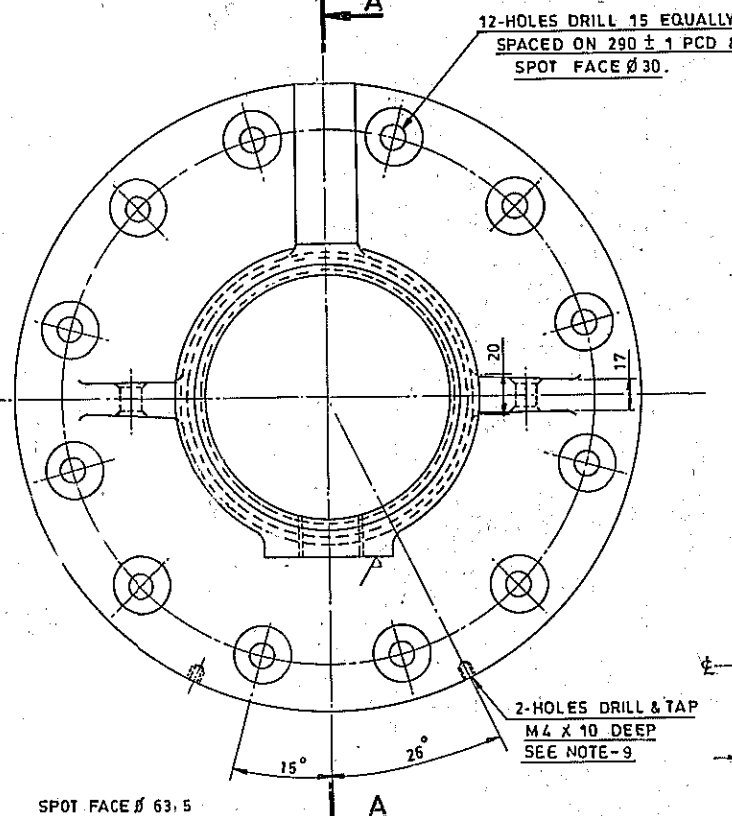
FINISH :- NATURAL

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 3 Kg/Cm<sup>2</sup> WITHOUT ANY LEAKAGE FOR 30 MINUTES AS PER ARRGT. OF FIG. 1 & 2, BOTH.
- MACHINED SURFACE TO BE PROTECTED FROM DENTS & SCRATCHES WHILE HANDLING.
- SUPPLIER SHALL ENSURE AFTER MACHING 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.
- THESE HOLES TO BE DRILLED USING THE TEMPLATE AS SHOWN IN DETAIL - A. AFTER FORMING OF SEGMENT OVER-Ø 335.

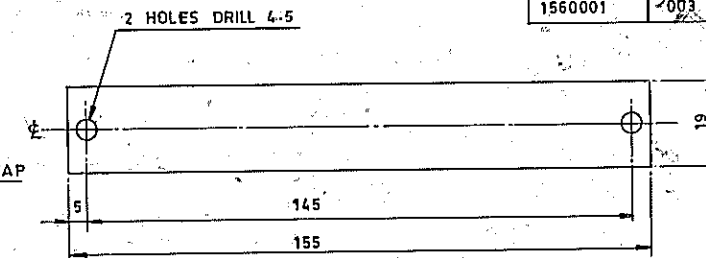


SECTION-AA



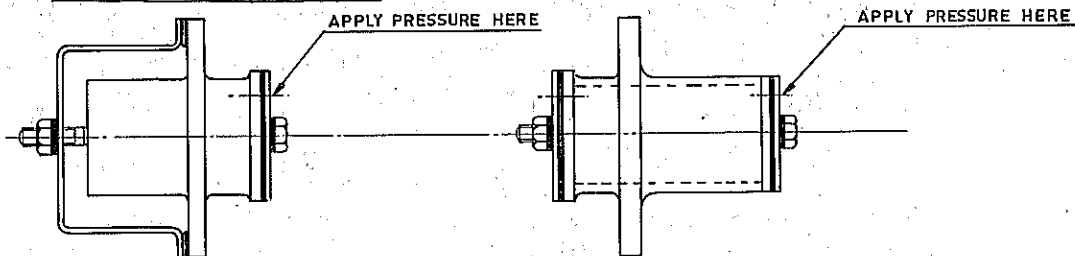
PART VIEW IN DIRECTION -D

TOOL LIST		
TOOL NO.	ITEM	DESCRIPTION
1560001	003	GRAVITY DIE CASTING



DETAIL-A (TEMPLATE)  
(16 TR)

DIMENSION TABLE		
ITEM NO	A	B
001	125	235
002	325	435
003	625	735
004	95	205
005	295	405



ARRGT. OF PRESSURE TESTING  
FIG-1

ARRGT. OF PRESSURE TESTING  
FIG-2

PATT. NO.	ITEM NO.	DESCRIPTION	QTY.	UNIT WT.	REMARKS
1299035	005	MTG. FLANGE CASTING AL. ALLOY	1	1	
1299034	004	MTG. FLANGE CASTING AL. ALLOY	1	1	
1299009	003	MTG. FLANGE CASTING AL. ALLOY	1	1	
1299008	002	MTG. FLANGE CASTING AL. ALLOY	1	1	
1299010	001	MTG. FLANGE CASTING AL. ALLOY	1	1	

ADDITIONAL INFORMATION		145 KV O.I.P. CONDENSER BUSHING	
STATUS OF DRAWING	M	TYPE OF PRODUCT OR NAME OF CUSTOMER / PROJECT	BHARAT HEAVY ELECTRICALS LTD BHOPAL
DISTRIBUTION OF PRINTS	B/E BCM TRX FYM QAX	DRG. RETRACED	NO.

REV.	DATE	ALTERED	DATE	ALTERED	DATE	ALTERED	DATE	ALTERED
18	08-02-08	CHD. APPD.	17	28-7-06	CHECKED APPROVED	16	13-11-00	CHECKED APPROVED
IN DIM. TABLE :- ITEM 004 & 005 DIMS. 95, 205, 295 & 405 WERE 90, 200, 290 & 400 RESPTLY. GROOVE 2.5 ± 0.2 (BOTH ENDS)								
ITEM 004 & 005 ADDED GROOVE DIM. Ø150 X 8.5 ± 0.25 DEEP ADDED								

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.