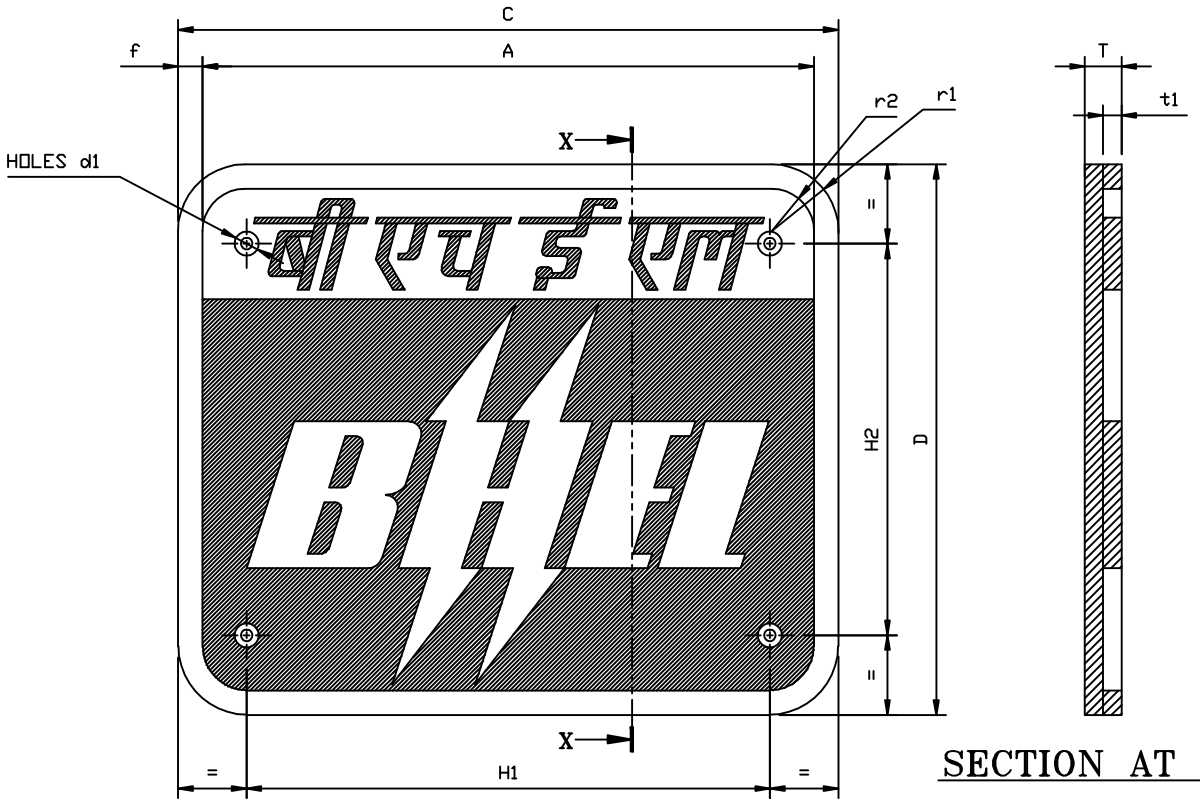
FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm

DRG. NO. 2 721 10 10299



SECTION AT X–X

TABLE–1

ITEM NO.	NOM SIZE A	STAINLESS STEEL PLATE								TOL ON T & f (±)	HOLE CENTER DISTANCE		HOLE DIA		NOM SIZE OF FIXING SCREW	APPROX WEIGHT PIECE IN Kg.	STYLE NO.
		C	D	TOL ON C D	r1	r2	BORDER f	THICKNESS T	THICKNESS t1		HORIZONTAL H1	VERTICAL H2	ø d1	CSK DIA ø d2			
001	100	113	94	+1 −0	13.5	7	6.5	6	3	0.5	89	58	3.2	6.4	M3	0.50	BP9908125796
002	160	181	152	+1 −0	21.5	11	10.5	6	3	0.5	142	93	4.3	8.3	M4	1.30	BP9908125800
003	250	282	236	+1.5 −0	33.5	17.5	16	6	3	0.75	222	146	5.3	10.4	M5	4.15	BP9908125818
004	400	452	378	+2 −0	54	28	26	6	3	1.0	356	234	8.4	16.5	M8	13.4	BP9908125826

NOTES FOR SHOP :–

1) **MATERIAL :–** ALL LETTERS & BORDER SHALL BE TO AA 10737 (S.S. 304) & 3mm THICK.
THE LETTERS & BORDER SHALL BE RIVETED TO THE BACK PLATE FROM OUTSIDE.
THE BACK PLATE SHALL BE 3mm THICK ie MS TO AA10108/AA10119.

2) **LETTER SIZE :–** AS PER CS SHT. AA0401120 TO REV.–02.

3) **BORDER :–** AS PER TABLE–1.

4) **FIXING :–** LETTERS & BORDER TO BE RIVETED FROM BACK SIDE.

5) **LETTER CUTTING :–** MACHINE CUT.

6) **FINISH :–**

6.1) THE STAINLESS STEEL LETTERS IN HINDI AND ENGLISH AND BORDER SHALL BE POLISHED TO GIVE BRIGHT FINISH.

6.2) BACK GROUND OF ENGLISH LETTERS SHALL BE BLACK WRINKLE FINISH SYNTHETIC STOVING ENAMEL PAINT.

6.3) BACK GROUND OF HINDI LETTER SHALL BE WHITE SYNTHETIC STOVING ENAMEL PAINT.

COMPUTOR DRG FILE NO. 27211010199

7) **TEST REQUIREMENTS:–**

7.1) HUMIDITY TEST :– WHEN TESTED BY SUSPENDING THE STAINLESS STEEL PLATE IN A CORROSION CABINET MAINTAINED AT 100 PERCENT RELATIVE HUMIDITY AND A TEMPERATURE CYCLE OF 42° TO 48° (FOR 5 DAYS, THERE SHALL BE NO SIGNS OF BLISTERING AND FLACKING OF PAINT FILM.

7.2) RESISTANT TO SALT SPRAY :– STAINLESS STEEL PLATE SHALL SHOW NO SIGN OF BLISTERING AND FLAKING OF PAINT FILM AFTER CONTINUOUS EXPOSURE FOR 4 DAYS IN SALT SPRAY CABINET.

7.3) MONOGRAM PLATES SHALL SHOW NO PEELING/REMOVAL OF PAINT WHEN SUBJECTED TO CROSS CUT TAPE TEST TO ASIM D 3359.

7.4) ACCELERATED WEATHERING TEST (TYPE TESI) :– THE PAINT SHOULD NOT SHOW ANY SIGN OF DETERIORATION WHEN SUBJECTED TO ACCLERATED WEATHERING TEST OF 21 DAYS IN ACCORDANCE WITH CLAUSE A4 OF IS:2932.

7.5) THICKNESS OF COATING :– THE THICKNESS OF THE COATING AND ITS VARIOUS LAYERS SHALL BE MEASURED AT ANY POINT ON THE SIGNIFICANT SURFACE AS PER IS 4942–1983. (REF. 7.2 ALSO)

7.6) ADHESION :– THE COATED PLATE SHALL BE SUBJECTED TO ANY ONE OF THE TESTS FOR ADHESION AS GIVEN IN APPENDIX G & H OF IS: 4942–1983.(REFER 7.3 ALSO)

7.7) CORROSION RESISTANCE :– THE COATED PLATE SHALL BE SUBJECTED TO ONE OF THE CORROSION TESTS GIVEN IN TABLE 30F IS:4942–1983.(REFER 7.4 ALSO)

8) **FIXING :–**

8.1) HOLES :– THE COUNTER SUNK HOLE SIZES OF MONOGRAM PLATE ARE INIDICATED IN TABLE–1

8.2) SCREWS :– THE MONOGRAM PLATE SHALL BE FIXED BY SCREWS SLOTTED COUNTER SUNK HEAD PRECISION GRADE A COARSE PITCH TO TR 20137S (STAINLESS STEEL)

8.3) AFTER FIXING THE SCREWS ON THE PLATES SLOTS OF HEAD SHALL BE SUITABLY FILLED WITH PUTTY AND SHALL BE FINISHED WITH WHITE AND BLACK PAINT SO THAT THE APPEARANCE OF THE FASTENERS MERGES WITH THE WHITE AND BLACK BACKGROUD.

9) **MARKING & PACKING :–**

9.1) IDENTIFICATION MARKING :– MONOGRAM PLATE SIZE STANDARD NUMBER AND THE SUPPLIER'S NAME/ TRADE MARK SHALL BE ENGRAVED AT THE BACK OF EACH PLATE.

9.2) PACKING :– EACH MONOGRAM PLATE SHOULD BE COVERED WITH WHITE PAPER AND THEN SUITABLY PACKED IN POLYETHENE COVERS(250 MICRONS THICKNESS) OR RIBBED KHAKI PAPER ENVELOP (60 GSM) SO THAT THE FINISH WILL NOT BE AFFECTED DURING TRANSIT/STORAGE BEFORE FIXING UP THE SAME.

10) **NOTES :–** WEIGHTS GIVEN IN TABLE–1 ARE APPROXIMATE AND HAVE BEEN CALCULATED ON THE BASIS THAT STAINLESS STEEL WEIGHT 7.86 g/cm^3

10.1) SHARP EDGES SHALL BE ROUNDED OFF.

10.2) THIS STANDARD INCORPORATES THE RECOMMENDATIONS OF IPSC WORKING GROUP FOR RATING PLATES.

VAR00	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.NO. / VAR.	MATL. CODE / MATL. SPCN.	A C	UNIT	UNIT WT. / QTY.	GS	ZONE
	SEE TABLE–1		004	MONOGRAM PLATE 452Lg STAINLESS ST.							13.40		
	SEE TABLE–1		003	MONOGRAM PLATE 282Lg STAINLESS ST.							4.15		
	SEE TABLE–1		002	MONOGRAM PLATE 181Lg STAINLESS ST.							1.30		
	SEE TABLE–1		001	MONOGRAM PLATE 113Lg STAINLESS ST.							0.50		

28 → CARD TYPE–3 28 → CARD TYPE–1 28 → CARD TYPE–2

ADDITIONAL INFORMATION STD

STATUS OF DRAWING U

DISTRIBUTION OF PRINTS
D.C. – 1
RFM–4 (TCX RFM)–1

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

भारत हेवी इलेक्ट्रिकल्स लिमिटेड भोपाल
BHARAT HEAVY ELECTRICALS LTD. BHOPAL

	नाम/NAME	हस्ता./SIGN.	दिनांक/DATE	ये R. की संख्या NO. OF VAR.
बनाया DRN.	RSR		28.08.08	–
जाँचा CKD.	RV			
स्वीकृत APPD.	RKV			

REV.	DATE	ALTERED / CHECKED / APPROVED
REV.	DATE	ALTERED / CHECKED / APPROVED
REV.	DATE	ALTERED / CHECKED / APPROVED
REV.	DATE	ALTERED / CHECKED / APPROVED

विभाग DEPT ORE	उन.टान.नाप की त्रुटि UNTOL. DIMS. GR.	अनुपात SCALE	भार (कि.ग्रा.) WEIGHT (K.G.)	उसे.ड्रॉइंग का संदर्भ REF. TO ASSY. DRG.
कोड CODE 425	REF.CG06503	NTS	–	–

मद क. ITEM NO.	मद संख्या NO. OF ITEM
–	004

शीर्षक/TITLE
MONOGRAM PLATE
STAINLESS STEEL WITH BORDER

ड्रॉइंग क./DRAWING NO. 2 721 10 10299

पुन. REV. 00

पृष्ठ क./SHT. NO. 01 पृष्ठों की संख्या/NO. OF SHT. 01

FILE NAME:– KANSARA– A2

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REF. DRG. NO. | SIGN AND DATE | INVENTORY NO.