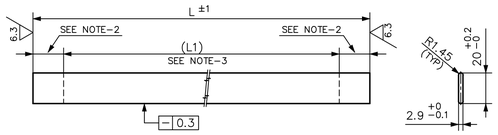
DRAWING NO: 1-93-172-05246

ALL DIMENSIONS ARE IN MILLIMETERS



ITEM NO.01 TO 41

(1:2)

(SMALL GRID FLAT NO.100.006 TO 100.046)

ITEM NO.	FLAT NO.	(L1)	L	ITEM NO.	FLAT NO.	(L1)	L
01	100.006	512.3	657.9	21	100.026	2074.8	2115.5
02	100.007	666.9	784.2	22	100.027	2066.1	2106.9
03	100.008	789.2	890.6	23	100.028	2056.3	2097.3
04	100.009	892.8	983.6	24	100.029	2045.5	2086.7
05	100.010	983.4	1066.5	25	100.030	2033.6	2075.1
06	100.011	1138.1	1210.6	26	100.031	2006.6	2048.6
07	100.012	1205.5	1274.1	27	100.032	1991.5	2033.8
08	100.013	1267.7	1333.2	28	100.033	1975.2	2017.8
09	100.014	1325.4	1388.2	29	100.034	1957.7	2000.7
10	100.015	1379.3	1439.8	30	100.035	1939.0	1982.5
11	100.016	1429.8	1488.2	31	100.036	1919.1	1963.0
12	100.017	1477.1	1533.7	32	100.037	1897.9	1942.3
13	100.018	1521.7	1576.7	33	100.038	1875.4	1920.3
14	100.019	2103.6	2143.7	34	100.039	1826.3	1872.3
15	100.020	2106.4	2146.5	35	100.040	1799.5	1846.2
16	100.021	2108.3	2148.3	36	100.041	1771.2	1818.6
17	100.022	2109.2	2149.2	37	100.042	1741.2	1789.5
18	100.023	2095.0	2135.3	38	100.043	1709.6	1758.7
19	100.024	2089.3	2129.7	39	100.044	1676.1	1726.2
20	100.025	2082.6	2123.1	40	100.045	1640.7	1691.8
				41	100.046	1603.3	1655.6

NOTE

1. FOR TOLERANCES, REFER TECHNICAL SPECIFICATION PC-M-963
2. LENGTH 'L±1' INCLUDES ALLOWANCE FOR MACHINING (TO R=1074.65 DURING ASSY.)
3. LENGTH OF GRID FLAT IN BRACKET IS INDICATED FOR REFERENCE ONLY, AND IS AFTER MACHINING.
4. CONTACT WITH FERRITIC MATERIAL SHALL BE AVOIDED AT ALL STAGES OF MANUFACTURE.
5. ENSURE TOLERANCES AS PER TECHNICAL SPECIFICATION PC-M-963 BEFORE AND AFTER MACHINING
6. IDENTIFY THE GRID FLATS WITH IDENTIFICATION NO. (100.XXX) AFTER MACHINING.
7. ALL SHARP CORNERS SHALL BE CAREFULLY DEBURRED.
8. FOR ALUMINOUS BLASTING, REFER GRID FLATS ASSEMBY DRG. NO. 0-93-172-05345
9. EXTRA LENGTH OF GRID FLAT SHALL BE EQUAL ON EITHER SIDE BEFORE MACHINING, THIS EXTRA LENGTH SHALL BE REMOVED ON ASSY. DURING FINAL CIRCUMFERENTIAL MACHINING.
10. MANUFACTURING OF SMALL GRID FLATS (ITEM NO.01 TO 41) FROM DIN 17440-1.4550 MATERIAL SPECIFICATION IS ALSO PERMISSIBLE.

VARIANT NUMBER	ITEM NUMBER	DESCRIPTION	STD	DRAWING NUMBER/SIZE	ITEM NO / VAR NO	MATERIAL CODE / MATERIAL SPECN	A/C	UNIT / D1	UNIT WEIGHT / QUANTITY	GS	ZONE
	41	SMALL GRID FLAT FL 2.9x20...1656LG				DIN EN10028-7:1.4550	A		0.725 / 4		
	40	SMALL GRID FLAT FL 2.9x20...1692LG				DIN EN10028-7:1.4550	A		0.742 / 4		
	39	SMALL GRID FLAT FL 2.9x20...1727LG				DIN EN10028-7:1.4550	A		0.758 / 4		
	38	SMALL GRID FLAT FL 2.9x20...1759LG				DIN EN10028-7:1.4550	A		0.773 / 4		
	37	SMALL GRID FLAT FL 2.9x20...1790LG				DIN EN10028-7:1.4550	A		0.788 / 4		
	36	SMALL GRID FLAT FL 2.9x20...1819LG				DIN EN10028-7:1.4550	A		0.801 / 4		
	35	SMALL GRID FLAT FL 2.9x20...1847LG				DIN EN10028-7:1.4550	A		0.814 / 4		
	34	SMALL GRID FLAT FL 2.9x20...1873LG				DIN EN10028-7:1.4550	A		0.826 / 4		
	33	SMALL GRID FLAT FL 2.9x20...1921LG				DIN EN10028-7:1.4550	A		0.848 / 4		
	32	SMALL GRID FLAT FL 2.9x20...1943LG				DIN EN10028-7:1.4550	A		0.858 / 4		
	31	SMALL GRID FLAT FL 2.9x20...1963LG				DIN EN10028-7:1.4550	A		0.868 / 4		
	30	SMALL GRID FLAT FL 2.9x20...1983LG				DIN EN10028-7:1.4550	A		0.877 / 4		
	29	SMALL GRID FLAT FL 2.9x20...2001LG				DIN EN10028-7:1.4550	A		0.885 / 4		
	28	SMALL GRID FLAT FL 2.9x20...2018LG				DIN EN10028-7:1.4550	A		0.893 / 4		
	27	SMALL GRID FLAT FL 2.9x20...2034LG				DIN EN10028-7:1.4550	A		0.900 / 4		
	26	SMALL GRID FLAT FL 2.9x20...2049LG				DIN EN10028-7:1.4550	A		0.908 / 4		
	25	SMALL GRID FLAT FL 2.9x20...2076LG				DIN EN10028-7:1.4550	A		0.920 / 4		
	24	SMALL GRID FLAT FL 2.9x20...2087LG				DIN EN10028-7:1.4550	A		0.925 / 4		
	23	SMALL GRID FLAT FL 2.9x20...2098LG				DIN EN10028-7:1.4550	A		0.930 / 4		
	22	SMALL GRID FLAT FL 2.9x20...2107LG				DIN EN10028-7:1.4550	A		0.934 / 4		
	21	SMALL GRID FLAT FL 2.9x20...2116LG				DIN EN10028-7:1.4550	A		0.938 / 4		
	20	SMALL GRID FLAT FL 2.9x20...2124LG				DIN EN10028-7:1.4550	A		0.942 / 4		
	19	SMALL GRID FLAT FL 2.9x20...2130LG				DIN EN10028-7:1.4550	A		0.945 / 4		
	18	SMALL GRID FLAT FL 2.9x20...2136LG				DIN EN10028-7:1.4550	A		0.948 / 4		
	17	SMALL GRID FLAT FL 2.9x20...2150LG				DIN EN10028-7:1.4550	A		0.954 / 4		
	16	SMALL GRID FLAT FL 2.9x20...2149LG				DIN EN10028-7:1.4550	A		0.954 / 4		
	15	SMALL GRID FLAT FL 2.9x20...2147LG				DIN EN10028-7:1.4550	A		0.953 / 4		
	14	SMALL GRID FLAT FL 2.9x20...2144LG				DIN EN10028-7:1.4550	A		0.951 / 4		
	13	SMALL GRID FLAT FL 2.9x20...1577LG				DIN EN10028-7:1.4550	A		0.688 / 4		
	12	SMALL GRID FLAT FL 2.9x20...1534LG				DIN EN10028-7:1.4550	A		0.668 / 4		
	11	SMALL GRID FLAT FL 2.9x20...1489LG				DIN EN10028-7:1.4550	A		0.647 / 4		
	10	SMALL GRID FLAT FL 2.9x20...1440LG				DIN EN10028-7:1.4550	A		0.624 / 4		
	09	SMALL GRID FLAT FL 2.9x20...1389LG				DIN EN10028-7:1.4550	A		0.599 / 4		
	08	SMALL GRID FLAT FL 2.9x20...1334LG				DIN EN10028-7:1.4550	A		0.573 / 4		
	07	SMALL GRID FLAT FL 2.9x20...1275LG				DIN EN10028-7:1.4550	A		0.546 / 4		
	06	SMALL GRID FLAT FL 2.9x20...1211LG				DIN EN10028-7:1.4550	A		0.515 / 4		
	05	SMALL GRID FLAT FL 2.9x20...1067LG				DIN EN10028-7:1.4550	A		0.445 / 4		
	04	SMALL GRID FLAT FL 2.9x20...984LG				DIN EN10028-7:1.4550	A		0.404 / 4		
	03	SMALL GRID FLAT FL 2.9x20...891LG				DIN EN10028-7:1.4550	A		0.357 / 4		
	02	SMALL GRID FLAT FL 2.9x20...785LG				DIN EN10028-7:1.4550	A		0.301 / 4		
	01	SMALL GRID FLAT FL 2.9x20...658LG				DIN EN10028-7:1.4550	A		0.231 / 4		

GENERAL TOLERANCES:
FOR FABRICATION : ±1.5
FOR ANGLES : ±1°
FOR MACHINING : IS 2102-m
FOR WELDING : EN ISO 13920 - BF

TOLERANCE IF NOT SPECIFIED SHALL BE AS BELOW (REFER IS 2102-m)

LINEAR				ANGULAR	
0.5 TO 3	±0.1	400 TO 1000	±0.8	0 TO 10	± 1°
3 TO 6	±0.1	1000 TO 2000	±1.2	10 TO 50	± 30'
6 TO 30	±0.2	2000 TO 4000	±2.0	50 TO 120	± 20'
30 TO 120	±0.3	—	-	120 TO 400	± 10'
120 TO 400	±0.5	—	-	OVER 400	± 5'

REV	DATE	ALTERED :
		CHD&APPD :

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TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT: 700MWe Steam Generator
W.O.No.D167-001-1-93-172-FLEET
(Customer Drg.: 700FLEET/33111/4045/DD/REV.00)

PRODN.DRG.

Bharat Heavy Electricals Ltd
UNIT: HIGH PRESSURE BOILER PLANT
TIRUCHIRAPALLI - 620014

05-227/D

	NAME	SIGNATURE	DATE	NO. OF VAR
DRN	RAMESH S		06.09.21	
CHD	NKK		08.09.21	
APPD	MA		15.09.21	

DEPT	GRADE OF UNTOL DIM	SCALE	WEIGHT (Kg)	REF TO ASSY / OLD DWG	ITEM NO	No OF ITEMS
NC	C/M/F	1:2	124.6	0-93-172-05345	03	41
CODE 150						

TITLE: SMALL GRID FLATS

CARD CODE: U 01

DRAWING NO : 1-93-172-05246

REV 00

Size A1