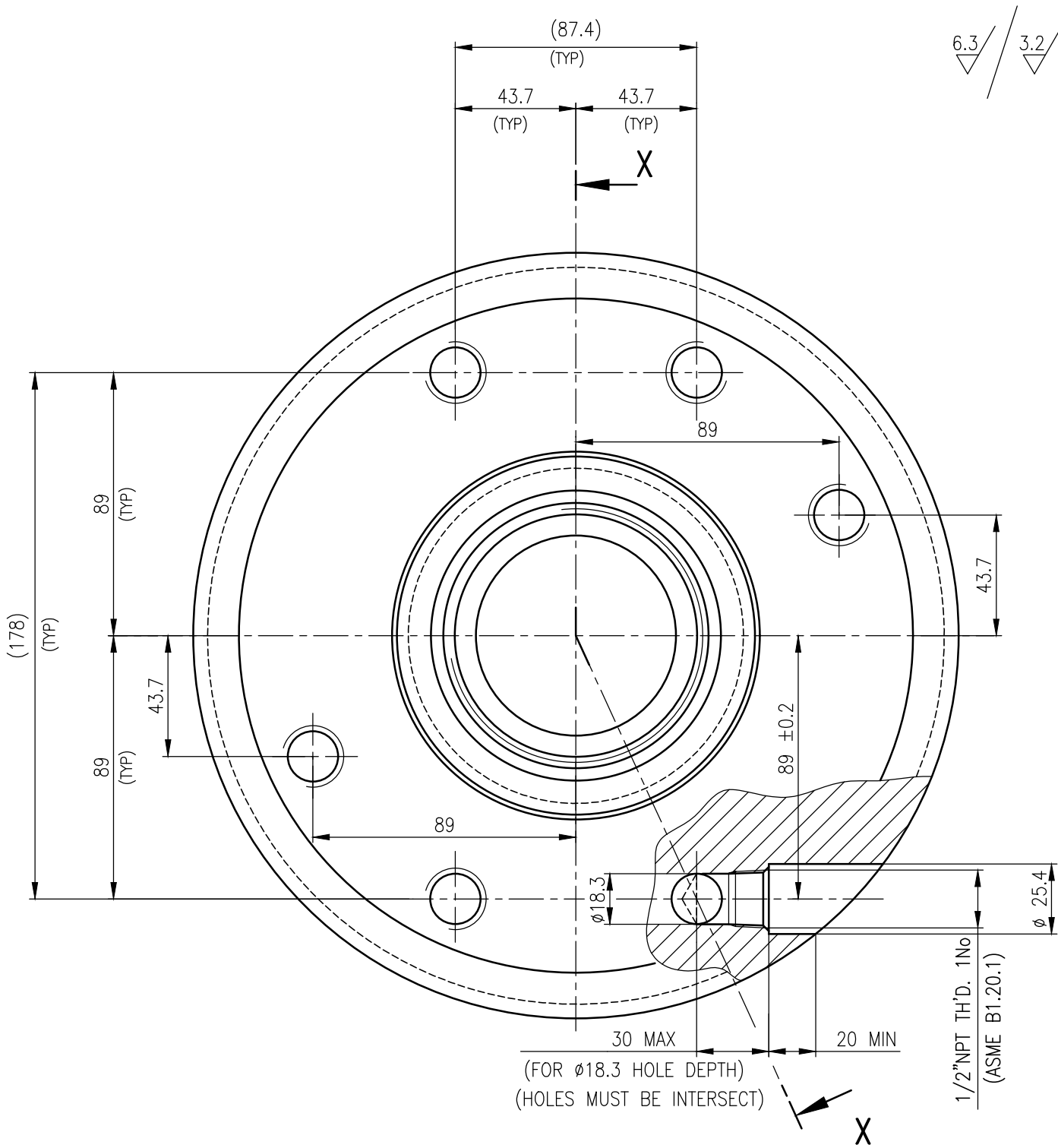
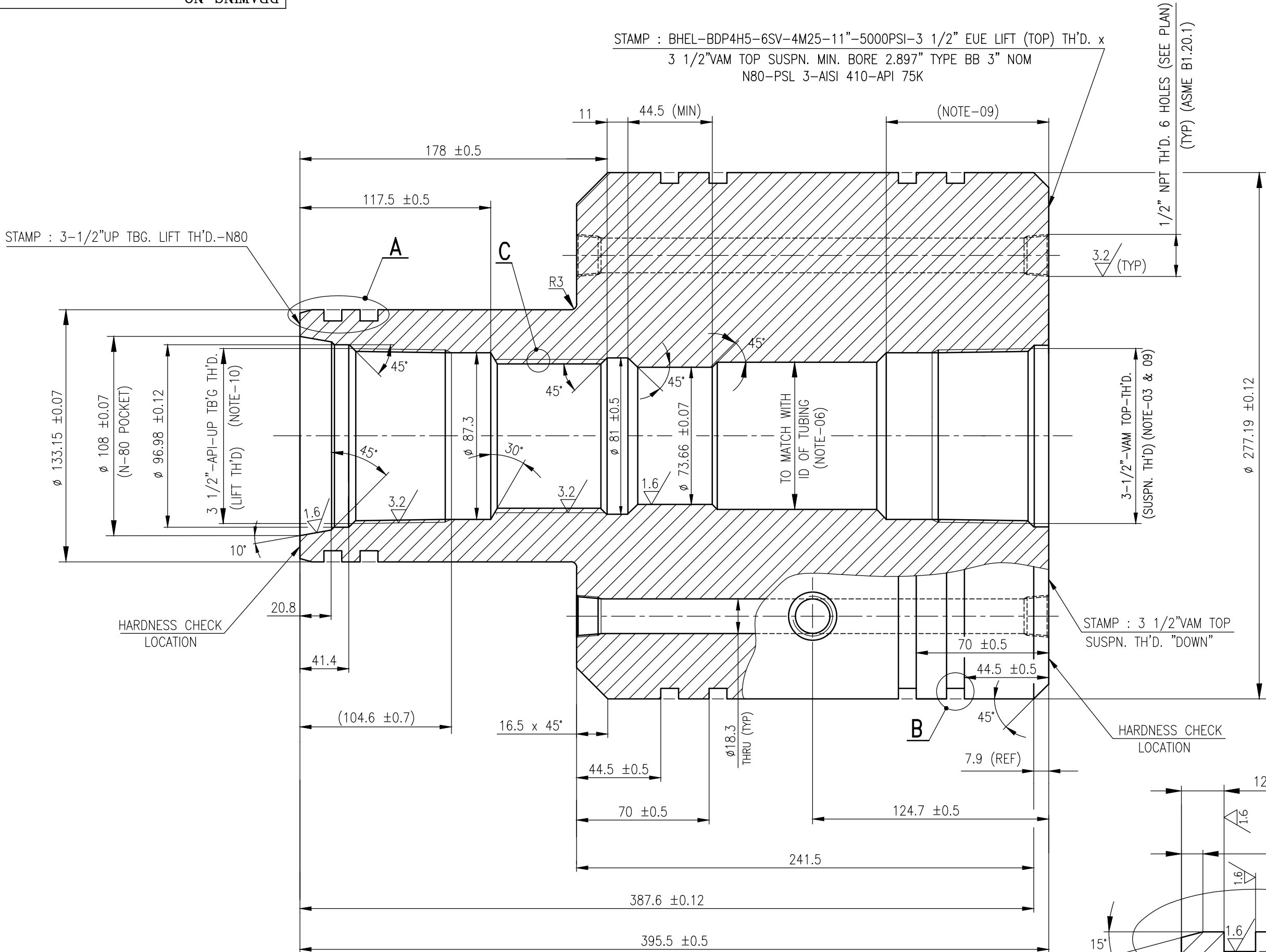


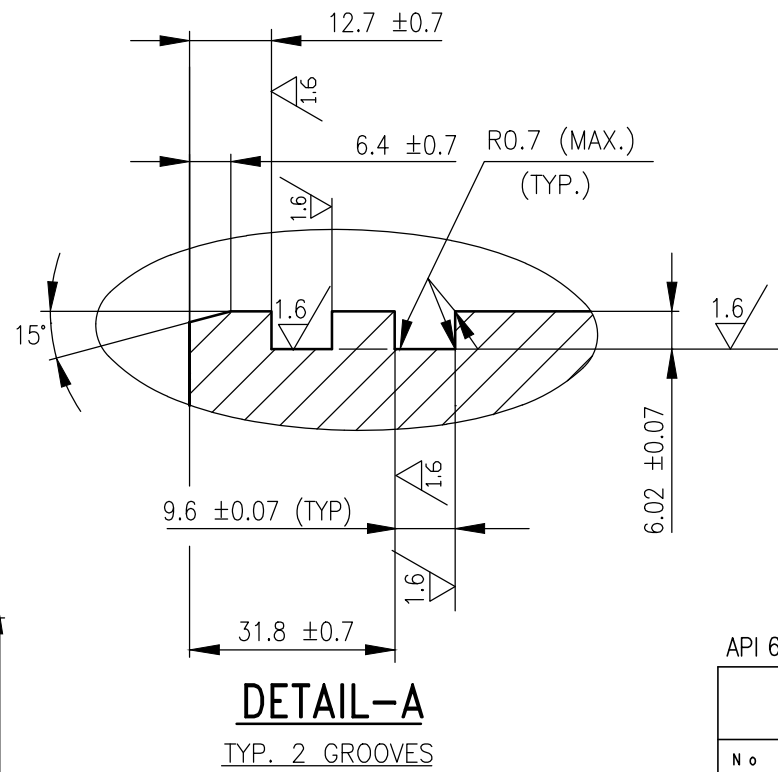
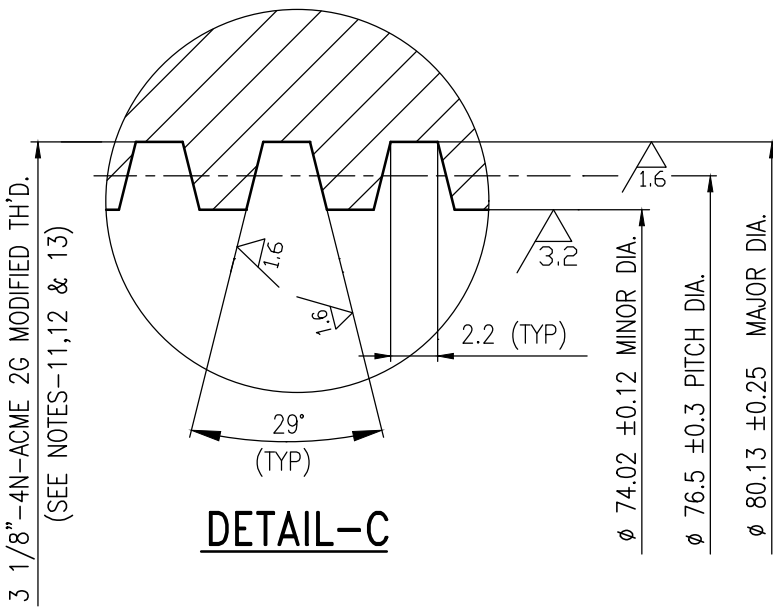
DRAWING NO: 2-V-4M25-20323

ALL DIMENSIONS ARE IN MILLIMETRES. FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP / QP



NOTES :-

- UNLESS OTHERWISE SPECIFIED :
 - MACHINING TOLERANCE : ± 0.25 MM
 - ANGLE TOLERANCE : $\pm 1/2^\circ$
- AFTER FINAL MACHINING, COAT OUTDOOR RUST PREVENTIVE COATING.
- COAT THE LIFT & SUSPENSION THREAD AS PER THREAD LICENSEE INSTRUCTIONS.
- CHECK AND PUNCH ACTUAL HARDNESS VALUE.
- BREAK ALL SHARP EDGES BY 0.25 MM.
- ID TO MATCH WITH THE INDICATED PPF VALUE, TO ENSURE METAL TO METAL NOSE SEAL.
- DRILLED HOLES MUST INTERSECT, CHECK AFTER DRILLING.
- THRO' BORE MUST BE CHECKED AFTER THREADING TO MATCH ID OF TUBING.
- THREAD LENGTH, COUNTER BORE, THREAD RELIEF DIA. THREAD FINISH ETC TO SUIT THE 3 1/2" VAM TOP SUSPENSION THREAD.
- THREAD MACHINING & GAUGING SHALL BE DONE AS PER API-5B. USE MASTER GAUGES FOR THREAD GAUGING.
- LIFT THIN SECTION OF ACME THREAD TO HALF THREAD WIDTH ON BOTH ENDS.
- ACME THREADS MUST BE FREE OF RAG & BURRS. BREAK CREST R0.13 TO R0.25
- AFTER MACHINING, NITRIDE THE ACME THREADS FOR A CASE DEPTH OF 0.08MM - 0.15MM FOLLOWED BY CLEANING IN ORDER TO REMOVE ALL GRIT, SCALE & SALT.
- SEALING SURFACES, THREADING AREA AND OD OF HANGER ARE TO BE POLISHED AND DIMENSIONS TO BE ENSURED AFTER NITRIDING.
- PROTECT THE THREADS DURING TRANSIT.
- MATERIAL SHALL COMPLY WITH REQUIREMENTS OF LATEST APPLICABLE QUALITY PROCEDURE FOR PSL-3 REQUIREMENTS.
- ALL ACCESSIBLE SURFACES SHALL BE EXAMINED BY WET FLUORESCENT METHOD (WET MPI) AS PER LATEST APPLICABLE QUALITY PROCEDURE FOR PSL-3 REQUIREMENTS.
- 100% UT & CHARPY IMPACT TEST TO BE CARRIED OUT AS PER LATEST API-6A (AT RAW MATERIAL STAGE)



UNLESS OTHERWISE SPECIFIED			
BREAK SHARP CORNERS	: 0.25		
FILLET RADII	: 0.76 ± 0.12		
CONCENTRICITY	: 0.25 FIM		
SQUARNESS	: 0.25 IN 254		
PARALLELISM	: 0.25 IN 254		
RFS EXCEPT WHEN (M) MODIFIED.			

DCP No.	ALTD:	APPD:
REV	CHD:	DT:
ZONE		

CAUTION: The information on this document is the property of BHARAT HEAVY ELECTRICALS LTD. It must not be used directly or indirectly in any way detrimental to the interest of the company.

API 6A : TUBING HANGER									
No OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
		974650420000	AISI-410-75K NOTE 15 & 16	H & T 197-235 BHN		113			001
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT									
11"-NOM.x 3-1/2" EUE LIFT x 3 1/2"VAM TOP SUSPN. W/N-80 FOR 3" NOM. BPV BDP4H5 W/6 SV PORTS									
BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI-620014.				DRN	D.LOGESH KUMAR	SIGN	DATE	NO.OF VAR.	
365-120				CHD	ARUNKUMAR P	P. Arj	28.02.19		
				APPD	ELAYARAJA R	Elayar	28.02.19		
DEPT	V L	SCALE	WEIGHT (KG).	REFERENCE INFORMATION				NO. OF	
CODE	340	OF	NTS						
TITLE						CARD CODE	DRAWING NO.	REV	
BODY-TBG. HANGER						U 01	2-V-4M25-20323	00	