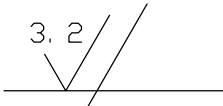


ALL DIMENSIONS ARE IN MILLIMETERS

NOTES: —

1. MANUFACTURING OF BOLT FROM DIN 17440:1.4550 MATERIAL SPECIFICATION IS ALSO PERMISSIBLE.
2. QTY. REQUIRED PER SG:02 NoS.

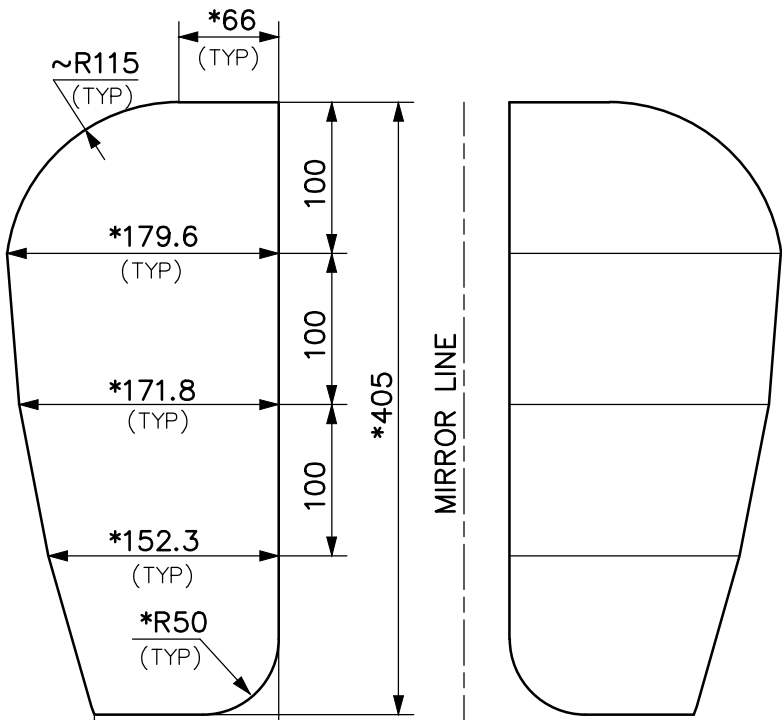


TOLERANCE IF NOT SPECIFIED SHALL BE AS BELOW (REFER IS:2102-m)
(FOR MACHINING)

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'

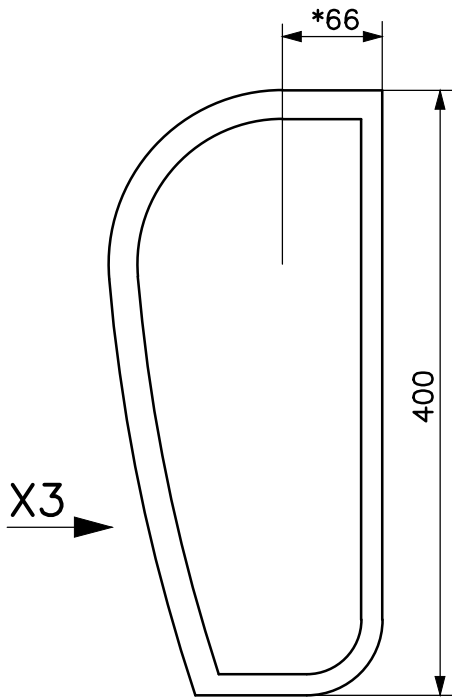
GENERAL TOLERANCES FOR FABRICATION

FOR LINEAR	: ±1.5
FOR ANGLES	: ±1°
FOR MACHINING	: IS2102-m
FOR WELDING	: DIN EN ISO 13920 : 1996-11



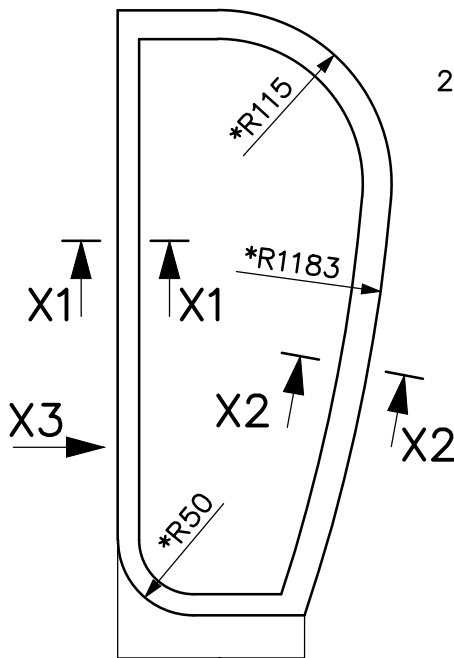
ITEM-04
(1:5)

ITEM-15
(1:5)

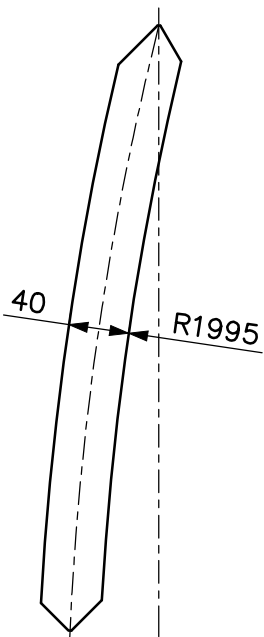


* DIMN. & PROFILE TO SUIT ASSEMBLY

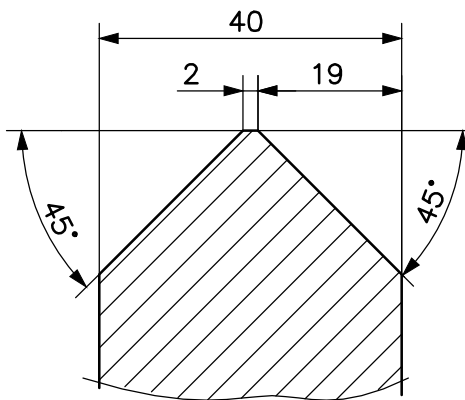
ITEM-04
(1:5)



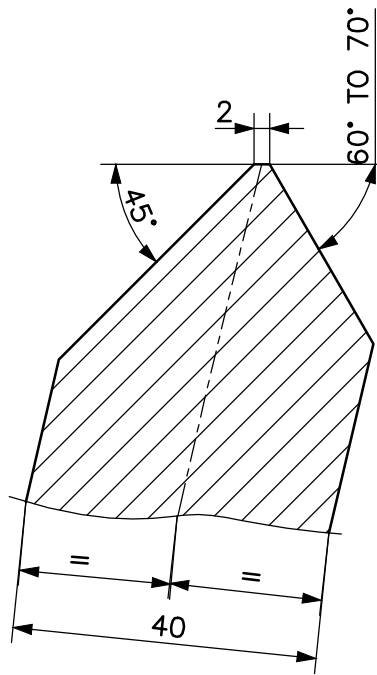
ITEM-15
(1:5)



VIEW-X3



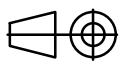
SECTION-X1X1
(1:1)



SECTION-X2X2
(1:1)

VARIANT NUMBER	ITEM NUMBER	DESCRIPTION	STD	DRAWING NUMBER/ SIZE	ITEM NO	MATERIAL CODE	A/C	UNIT	UNIT WEIGHT	GS
					VAR NO	MATERIAL SPECN		D1	QUANTITY	
02		PRI. END PIECE-2 PL 40x200x420				DIN EN 10028-7: 1.4550	A		14.200	
01		PRI. END PIECE-1 PL 40x200x420				DIN EN 10028-7: 1.4550	A		14.200	

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.

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		700MWe/Steam Generator W.O.D157 TO D160-001-1-93-171-GHAVP-1&2 (Customer Drg.: GHAVP-1&2/33111/4168/DD/REV:00) PRODN DRG									
 05-229/D		Bharat Heavy Electricals Ltd UNIT: HIGH PRESSURE BOILER PLANT TIRUCHIRAPALLI - 620014			DRN	NAME A.DL	SIGNATURE <i>A. Chidambaram</i>	DATE 31.08.18	No. OF VAR		
					CHD	RRV	<i>R. R. R.</i>	31.08.18			
					APPD	A.S.	<i>A. S.</i>	31.08.18			
DEPT NC	GRADE OF UNTOL DIM C/M/F		SCALE 1:5 1:1	WEIGHT (Kg) 28.400	REF TO ASSY / OLD DWG 0-93-171-05236 0-93-171-05292			ITEM NO 04,15 04,15	No OF ITEMS		
CODE 150											
TITLE PRI. END PIECE					CARD CODE U 01	DRAWING NO : 3-93-171-05445			RE		

REV	DATE	ALTERED :
01		CHD&APPD :