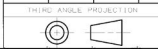


THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED IN WHOLE OR IN PART FOR ANY PURPOSE WITHOUT THE WRITTEN PERMISSION OF THE COMPANY.

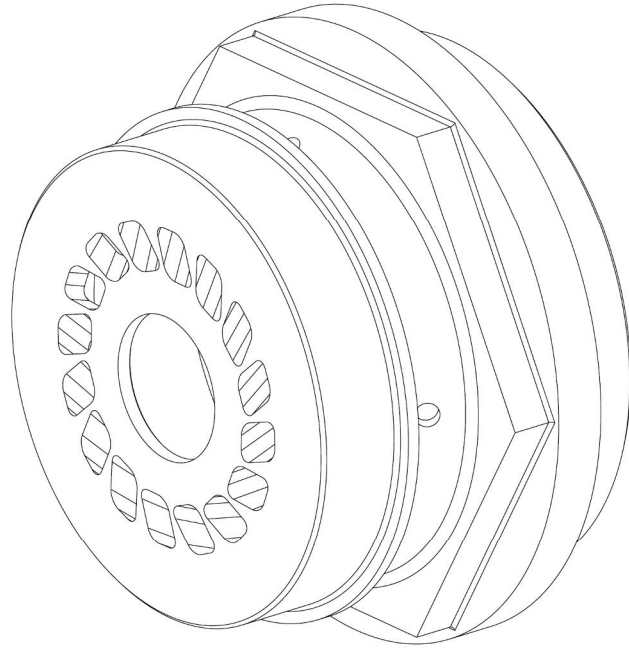
THIS DRAWING IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED IN WHOLE OR IN PART FOR ANY PURPOSE WITHOUT THE WRITTEN PERMISSION OF THE COMPANY.

GENERAL DIMENSIONAL LIMITS, FITS & TOLERANCES AS PER HY02030261

B	C6	2
A	D7	2
DATUM	ZONE	SHEET



- NOTES :
- UNLESS OTHERWISE SPECIFIED, ALL FILLET RADIUS SHALL BE **R 0.8**.
 - CTO> ALL FINISHED PARTS MUST FALL WITHIN THE GIVEN EFFECTIVE AREA FLOW LIMITS AS TESTED. ALSO, THE RANGE OF EFFECTIVE AREA FOR A MACHINE SET OF GAS FUEL NOZZLE ASSEMBLIES OR TIPS SHALL NOT EXCEED FIVE PERCENT (+2.5%).
 - APPLY HVOF B50A960 COATING PER ITEM 2 THICKNESS **0.25 ± 0.05** AND **6.35** R_o MAX OBTAINED BY CLOTHING.
 - COEFFICIENT DISCHARGE (CD) HAS BEEN ASSUMED AS .81 FOR ALL GROUPS.
 - PROCESS AND PERMANENTLY MARK PER ITEMS 4 AND 6 WITH THE DRAWING NUMBER, PART NUMBER, REVISION LETTER AND SERIAL NUMBER ON THE FLAT OF HEX.
 - FINISHED PART TO BE PROCESSED PER ITEM 5. AFTER PART IS SATISFACTORILY PROCESSED, PERMANENTLY MARK "F.T. SPEC" ON THE FLAT OF HEX.
 - PROTECT TIP FACES AND THREADS FROM DAMAGE DURING SHIPPING AND HANDLING. MOLDED PLASTIC CAPS ARE RECOMMENDED AS A METHOD OF PROTECTION. WAX OR POLYMER DIPPING IS NOT ALLOWED.
 - PARTS ARE TO BE CLEAN, DRY, AND FREE OF CONTAMINANTS. PARTS ARE TO BE SHIPPED IN SEALED BAGS, AND SUITABLY BOXED. FOAM DUNNAGE NOT ALLOWED.
 - CTO> PER ITEM 1, PARAGRAPH 6.1.3 AND ITEM 3.
 - UNLESS OTHERWISE SPECIFIED, ALL DIAMETERS SHALL BE $\phi \pm \text{0.25}$ A.
 - ALL DIMENSIONS ARE IN MM.
 - TOLERANCE FOR UNTOLERATED DIMENSIONS
1 PLACE DECIMALS ± 0.25
2 PLACE DECIMALS ± 0.13



VAR NO.	(Ø A)	B-QTY HOLES	Ø "C" VENT HOLES	CTO FLOW TEST REQUIREMENTS (SEE NOTE 2)		MATERIAL
				GAS EFFECTIVE AREA (MM²) AT 1.25 PRESSURE RATIO (SEE NOTE 4)		
				MEAN	TOLERANCE (± %)	
XXX	OMIT	OMIT	OMIT	_____	_____	AMS 5639 OR ASTM A479 GRADE 304 OR B7A31A3
01	OMIT	OMIT	OMIT	_____	_____	
02	OMIT	OMIT	4.78 ± 0.04	_____	_____	B50A463 OR AMS 5754 (HAST-X)
03	3.71	16	OMIT	130.0	2.0	AMS 5639 OR ASTM A479 GRADE 304 OR B7A31A3
04	3.45	16	OMIT	120.968	2.0	AMS 5639 OR ASTM A479 GRADE 304 OR B7A31A3

GAS ONLY

GAS ONLY

6 IDENT-TYPE/GEN PARTS AND MATL	P23A-A02	GT1044
5 FLOW TEST PROCESS	P24F-A01	GT1048
4 SPEC. PROC-GEN REQ	P3B-A01.4	GT1049
3 CTO DATA COLLECTION	P2BA-AL-000	
2 HVOF WEAR COATING	P16B-A01.1	GT1070B
1 APPLD PRAC, GENL MACH	348A9200	HY0202061
IT. NOMENCLATURE	IDENT	BHEL SPECS
LIST OF COMPLEMENTARY DOCUMENTS		
TYPE OF PRODUCT OR		
NAME OF CUSTOMER/PROJECT		
HYDERABAD		
DRN	NAME	BOOK
CHS	PARVATHI	03.10.15
APPS	KDG	03.10.15
SCALE	1:4Kg	03540661013
WEIGHT	1.4Kg	03540661013
REV	REV	REV
001	001	001
002	002	002
003	003	003
004	004	004
005	005	005
006	006	006
007	007	007
008	008	008
009	009	009
010	010	010
011	011	011
012	012	012
013	013	013
014	014	014
015	015	015
016	016	016
017	017	017
018	018	018
019	019	019
020	020	020
021	021	021
022	022	022
023	023	023
024	024	024
025	025	025
026	026	026
027	027	027
028	028	028
029	029	029
030	030	030
031	031	031
032	032	032
033	033	033
034	034	034
035	035	035
036	036	036
037	037	037
038	038	038
039	039	039
040	040	040
041	041	041
042	042	042
043	043	043
044	044	044
045	045	045
046	046	046
047	047	047
048	048	048
049	049	049
050	050	050
051	051	051
052	052	052
053	053	053
054	054	054
055	055	055
056	056	056
057	057	057
058	058	058
059	059	059
060	060	060
061	061	061
062	062	062
063	063	063
064	064	064
065	065	065
066	066	066
067	067	067
068	068	068
069	069	069
070	070	070
071	071	071
072	072	072
073	073	073
074	074	074
075	075	075
076	076	076
077	077	077
078	078	078
079	079	079
080	080	080
081	081	081
082	082	082
083	083	083
084	084	084
085	085	085
086	086	086
087	087	087
088	088	088
089	089	089
090	090	090
091	091	091
092	092	092
093	093	093
094	094	094
095	095	095
096	096	096
097	097	097
098	098	098
099	099	099
100	100	100