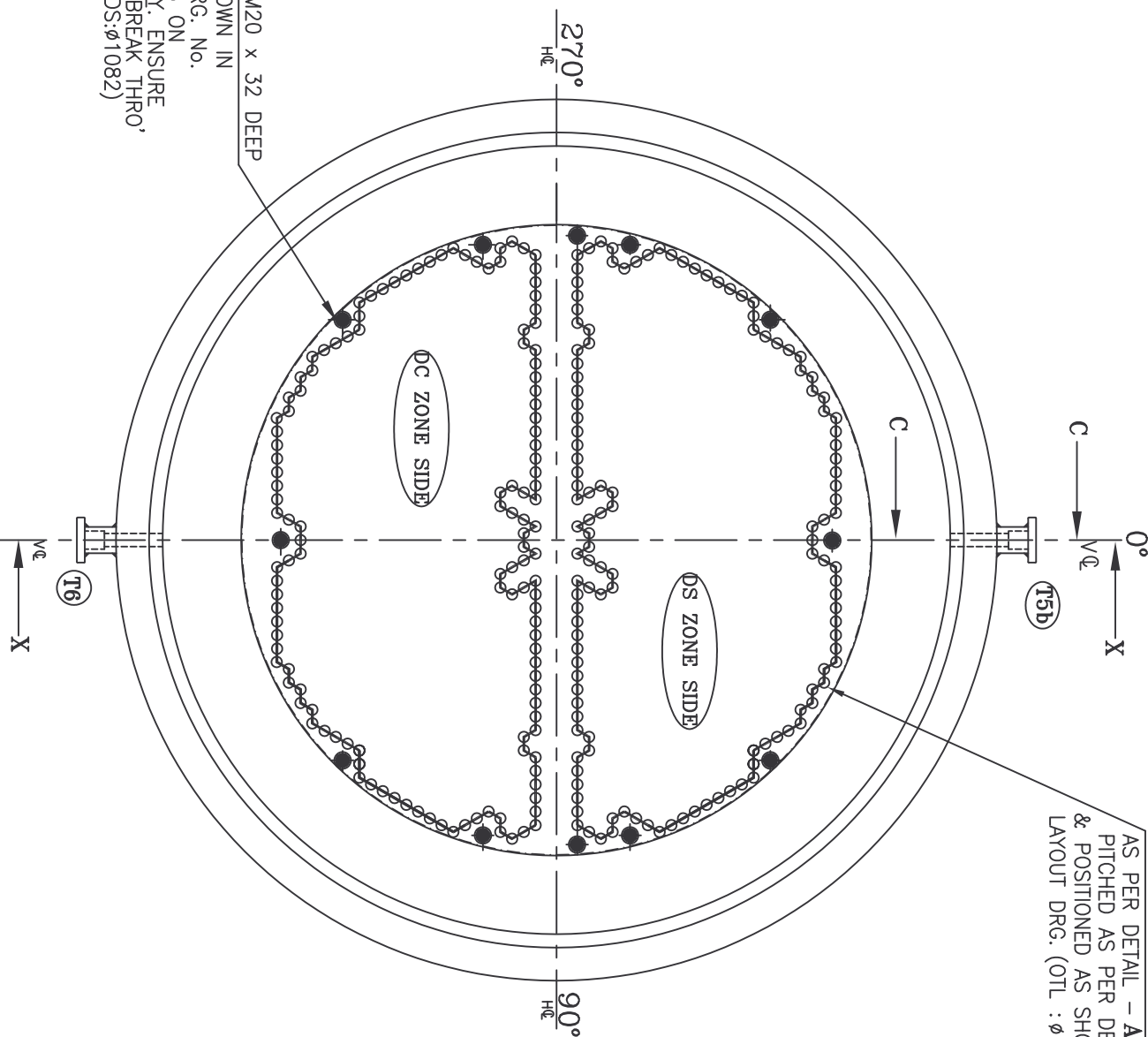
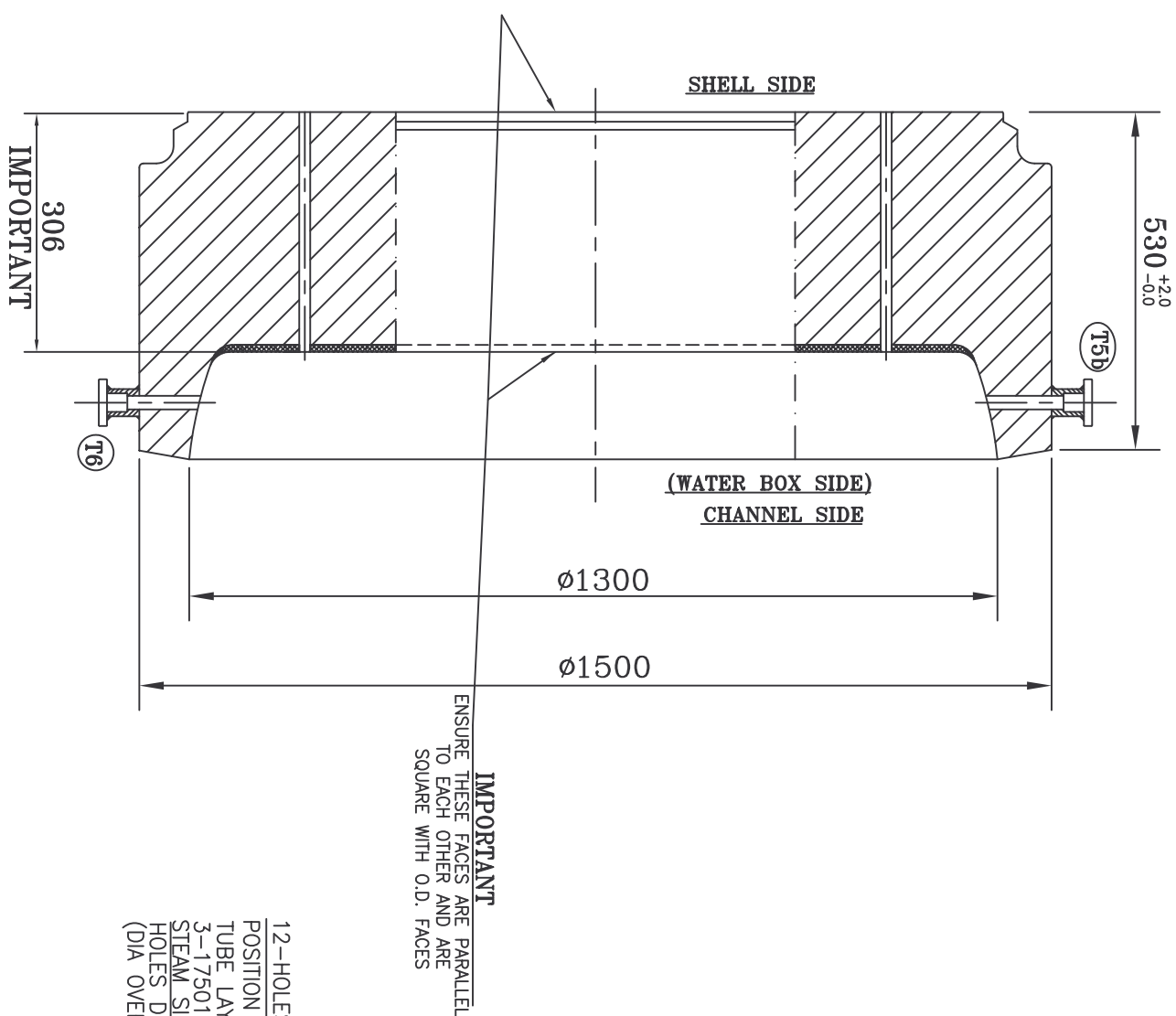


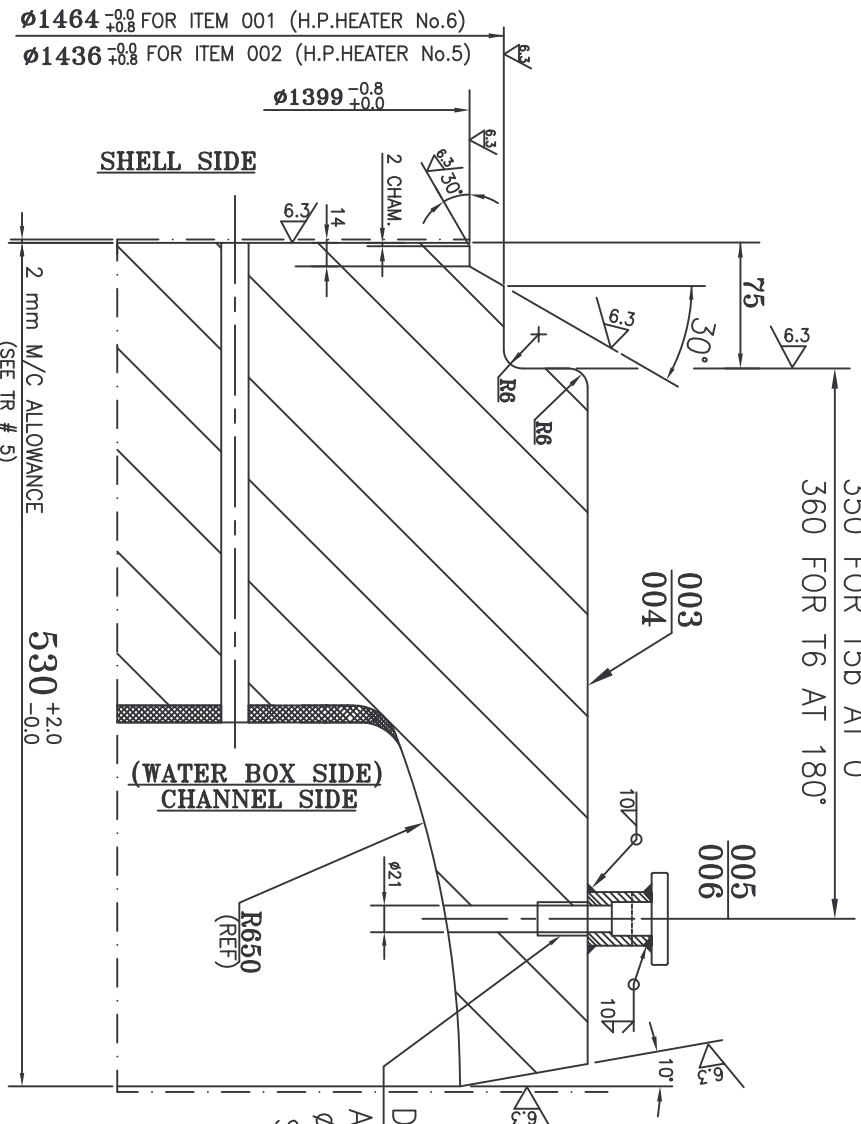
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2140 - TUBE HOLES
AS PER DETAIL - A
PITCHED AS PER DETAIL - P
& POSITIONED AS SHOWN, IN TUBE
LAYOUT DRG. (OTL : Ø1067)

TECHNICAL REQUIREMENTS(TR)

1. ALL WELDS PREPARATION TO BE CHECKED BY MAGNETIC PARTICLE EXAMINATION, AS PER AA-0850185.
2. ALL PREPARATIONS TO BE MADE BY MACHINING. MACHINE FINISH SHALL BE 6.3 MICRONS OR BETTER, UNLESS OTHERWISE SPECIFIED.
3. TOLERANCE ± 1 UNLESS OTHERWISE SPECIFIED.
4. SURFACE TO BE COATED WITH INHIBITIVE OIL AS TEMPORARY RUST PROTECTION.
5. ONLY 2 mm MACHINING ALLOWANCE PROVIDED ON THE SHELL SIDE FACE OF TUBEPLATE. MACHINE (IF REQUIRED) FOR SETTING THE TUBEPLATE DIMENSIONS FOR EDGE MACHINING. ELSE MACHINING OF TUBEPLATE FACE IS NOT REQUIRED.
6. COUPLING ITEM 005 TO BE WELDED ON FINAL ASSEMBLY TO FACILITATE HEATER ROLLING FOR WELDING.
7. COUPLING ITEM 005 TO BE WELDED BY IBR QUALIFIED WELDERS ONLY & WELD TO BE CRACK DETECTION TESTED AS PER AA-0850185.
8. ITEM 006 IS TEMPORARY BLANK FOR HYDROSTATIC TESTING. HENCE IBR INSPECTION IS NOT REQUIRED.
9. TUBE HOLE DRILLING TOLERANCES : AS PER TEMA/HE-04012.
10. FOR TUBE LAYOUT REFER DRG. NO. 3-17501-40428

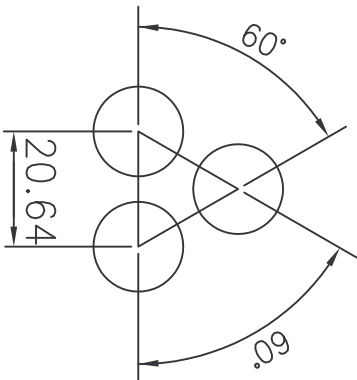
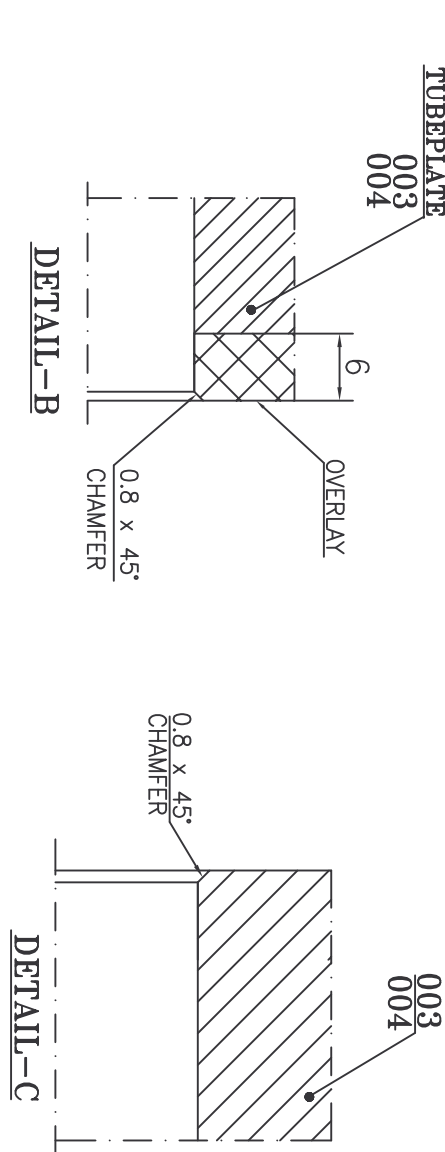


DRILL Ø 21 & TAP RP 1x35 DEEP
AS SHOWN & SPOT FACE
Ø 53 FOR CORRECT
SEATING OF COUPLING (#005)

SECTION X-X

DETAIL OF ITEM:001,VAR.00 & ITEM:002VAR.01


(VIEW LOOKING FROM SHELL SIDE)



DETAIL - P
TUBE HOLE PITCHING

(20.64x60°)

[illegible]

I.B.R.	ADDITIONAL INFORMATION		3 रेफर को प्रकार या TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		H.P. HEATER No.5 & 6 NATIONAL THERMAL POWER CORPORATION (NTPC) 3x250 MW BONGAIGAON TPP, Unit-1,2&3	
	DRG. LIST No.4-17500-40071	STATUS OF DRAWING W.O. No.17258.59.60-A-141-39/40				
TOOL LIST	DISTRIBUTION OF PRINTS CDE-1 FBM-4 HCM-4					
REF. DRG. No. 4-17500-40051						
			भारत हेवी इलेक्ट्रिकल्स लिमिटेड भोपाल BHARAT HEAVY ELECTRICALS L.TD. BHO PAL			
			संस्था DRN.	गैर/NAME	एकित/ SIGN.	दिनांक/DATE
			M.L.THAWANI			09.12.08
			श्रीत CKD.			09.12.08
			संस्था APPD.			09.12.08
			SAWENA S.			VAR.
			TAURANI M.L.			02

TUBE PLATE MACHINING

2-17505-40372	00	पूरा/REV.
ड्राईंग क्र./DRAWING NO.	पुर्णों की संख्या/NO. OF SHT.	पृष्ठ क्र./SHT. NO.