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REF. DRG. NO.

SIGN. & DATE

INVENTORY NO.

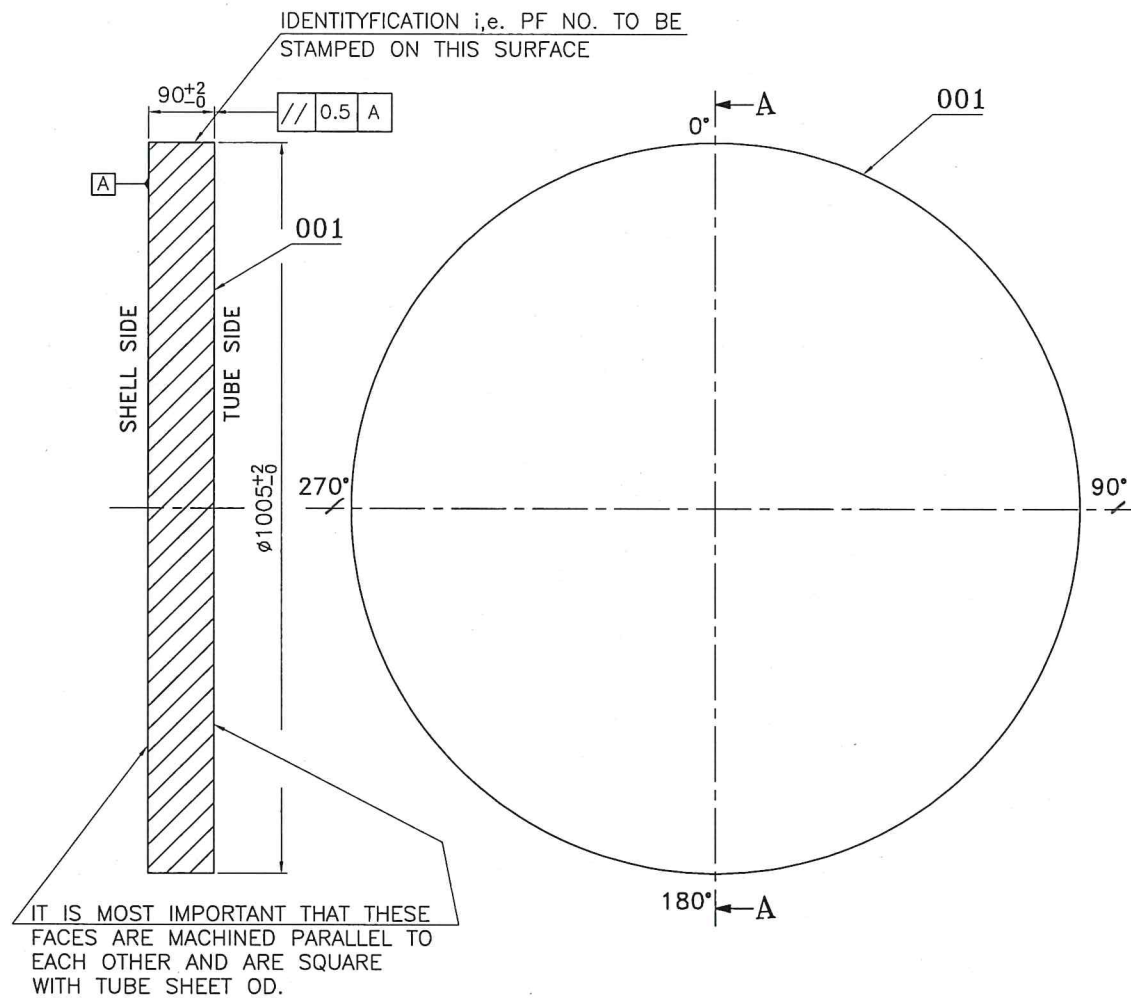
FIRST ANGLE PROJECTION

Tab-1

ALL DIMENSIONS ARE IN MM

Soft copy rec on 13/5/19

98807-89091-8
DRAWING NO.



SECTION : A-A

TECHNICAL REQUIREMENTS (TR):-

- SUPPLY CONDITION : HEAT TREATED AND PROOF MACHINED ALL OVER.
- ALL TECHNICAL AND TESTING REQUIREMENTS SHALL BE AS PER NPCIL APPROVED SPEC. No. BHEL/NPCIL/30599/CS-FORGINGS/CDE-19-3411.
- NO REPAIRS/WELDING SHALL BE PERMITTED WITHOUT PRIOR APPROVAL OF NPCIL.
- TEST COUPON FOR TESTING SHALL BE FORMED AS PER SPECIFICATION NO.- BHEL/NPCIL/30599/CS-FORGINGS/CDE-19-3411.
- IDENTIFICATION TO BE STAMPED AT LOCATION SHOWN WITH FOLLOWING INFORMATION:
 - PURCHASE FORGING NUMBER.
 - HEAT NUMBER
 - BHEL PO NUMBER
 - MATERIAL DESIGNATION.
- MATERIAL OF CONSTRUCTION : SA 350 LF2 CLASS-1.
- TEMPORARY OIL BASED RUST PREVENTIVE TO BE APPLIED AFTER MACHINING THE TUBE SHEET ON ALL SURFACES.
- THE TUBE SHEET SHALL BE FORGED IN SUCH A WAY THAT FACE CORRESPONDING TO TUBE SIDE (CLADDING SIDE) SHALL CORRESPOND TO THE BOTTOM OF INGOT.
- ALL DIMENSIONS INDICATED ARE IN mm.
- UNLESS OTHERWISE MENTIONED THE TOLERANCE ON LINEAR AND ANGULAR DIMENSIONS SHALL BE IN ACCORDANCE TO IS:2102.
- THE SURFACE FINISH OF FORGINGS SHALL BE 3.2 OR BETTER.

NOTE-A

MOCKUP BLOCK REQUIRED FOR PROCESS QUALIFICATION AND PROCESS CONTROL SHALL BE OF SAME HEAT TREATMENT CONDITION AND MATERIAL OF TUBE SHEET FORGING. FOR QUANTITY AND SIZE FOR DIFFERENT MOCKUP BLOCKS REFER ENQUIRY/PO.

न्यूक्लियर पावर कॉर्पोरेशन ऑफ इंडिया लिमिटेड Nuclear Power Corporation of India Limited		
☒ अनुमोदित / APPROVED		
☐ टिप्पणी के अनुसार अनुमोदित / APPROVED AS NOTED		
☐ संशोधन को आगे बढ़ाएं / सेकें / PROCEED WITH/HOLD FABRICATION		
☐ अंतिम दस्तावेज़ों एवं प्रतियों भेजें / SEND FINAL TRANSPARENCIES & PRINTS		
☐ संशोधन करें एवं अनुमोदन के लिए पुनः प्रस्तुत करें REVISE & RESUBMIT FOR APPROVAL		
जाँचकर्ता / CHECKED BY	समीक्षकर्ता / REVIEWED BY	अनुमोदन कर्ता / APPROVED BY
13/5/19	13/5/19	13/5/19
किए जानेवाले कार्य का अनुमोदन आपूर्तिकर्ता संविदाकार को निर्देशनों के अनुसार आपूर्ति करने के उत्तरदायित्व से मुक्त नहीं करता है। This approval of the work to be done does not relieve the supplier of the responsibility of supply according to specifications.		

01	1005	001	TUBE SHEET	B.O.	560.0
VAR00	QTY.-Nos	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION
59	64	65	75	78	79
25	27	29	50	59	60
77	28	31	34	45	55
56	57	58	59	60	61
62	63	64	65	66	67
68	69	70	71	72	73
74	75	76	77	78	79
80	81	82	83	84	85
86	87	88	89	90	91
92	93	94	95	96	97
98	99	100	101	102	103

NUCLEAR POWER CORPORATION OF INDIA LIMITED (A GOVERNMENT OF INDIA ENTERPRISE) PROJECT : GORAKHPUR HARIYANA ANU VIDHYUT PARIYOJANA 1&2 (700 MWe) NPCIL PURCHASE ORDER NO. : CMM/FTP/10-33-1-1149/e-PO/30599, DATED 25.01.2019 NPCIL DRAWING NO : GHVP-1&2/33331/2001/DD REV.00			
EQUIPMENT NAME : INVENTORY ADDITION & RECOVERY SYSTEM TAG NO. : (3333-HX-1)			
भारत हेवी इलेक्ट्रिकल्स लिमिटेड भोपाल BHARAT HEAVY ELECTRICALS LTD BHOPAL		नाम/ NAME विजय कुमार कुशवाहा हस्ता/ SIGN दिनांक/ DATE 08/03/2019 वे. री. की संख्या NO. OF VAR.	
विभाग DEPT. CDE कोड CODE 411		अनुपात SCALE 1:10 भार (कि.ग्रा) WEIGHT (K.G.) 560.0	
अनुमोदित APPD.		असे. ड्राइंग का संदर्भ REF. TO ASSY. DRG. 3-16503-40887	
शीर्षक/ TITLE TUBE SHEET FORGING		मद क. ITEM NO. 001	
ड्राइंग क्र./DRAWING NO. 3-16503-40886		मद संख्या NO. OF ITEM 03	
पृष्ठ क्र./ SHT. NO. 01		पृष्ठों की संख्या/ NO. OF SHT. 01	

DO NOT SCALE THE DRAWING.
UNLESS OTHERWISE STATED:-
ALL DIMENSIONS ARE IN mm.
MACHINE ALL OVER.
SURFACE FINISH TO BE $\sqrt{32}$ OR BETTER.
REMOVE ALL BURRS.
REMOVE ALL EXTERNAL SHARP CORNERS
AND EDGES BY CHAMFERING TO $0.15 \times 45^\circ$.
ROUND ALL INTERNAL CORNERS AND
EDGES TO R 0.15 .
TOLERANCES ON RADII AND CHAMFERS
(IS : 2102)
REDII AND CHAMFERS 0.5-3 3-6 6-30
TOLERANCES ± 0.2 ± 0.5 ± 1.0

TOLERANCE ON LINEAR DIMENSIONS (IS:2102)			
DIMENSIONS	TOL.	DIMENSIONS	TOL.
UP TO 6	± 0.1	315 - 1000	± 0.8
6 - 30	± 0.2	1000-2000	± 1.2
30 - 120	± 0.3	2000-4000	± 2.0
120 - 315	± 0.5	4000-8000	± 3.0
TOLERANCE ON LINEAR DIMENSIONS			
SPECIFIED DIMENSIONS		TOLERANCE	
XX		± 0.40	
XX.X		± 0.40	
XX.XX		± 0.25	
TOLERANCE ON ANGULAR DIMENSIONS : 0° - 0.5°			

ADDITIONAL INFORMATION
DRG. LIST : 4-16503-40362
STATUS OF DRAWING
W/O. NO. : 18085/86-W-04801
DISTRIBUTION OF PRINTS
CDE - 1 HCM - 4 FWM - 4

REV.	DATE	ALTERED	विवरण	REVISION	REV.	DATE	ALTERED	विवरण	REVISION	REV.	DATE	ALTERED	विवरण	REVISION
03	10/05/19	CHECKED	नागेन्द्र सिंह	नगेन्द्र सिंह	02	03/05/19	CHECKED	नागेन्द्र सिंह	नगेन्द्र सिंह	01	20/03/19	CHECKED	नागेन्द्र सिंह	नगेन्द्र सिंह
		APPROVED	ए.के.माहौर	ए.के.माहौर			APPROVED	ए.के.माहौर	ए.के.माहौर			APPROVED	ए.के.माहौर	ए.के.माहौर
ZONE	DRAWING REVISED TO INCORPORATE NPCIL COMMENTS DTD. 09/05/2019.				ZONE	DRAWING REVISED TO INCORPORATE NPCIL COMMENTS DTD. 10/04/2019.				ZONE	DRAWING REVISED BASED ON NPCIL COMMENTS DTD. 15/03/2019. TOLERANCE TABLE ADDED. NOTE-A ADDED.			