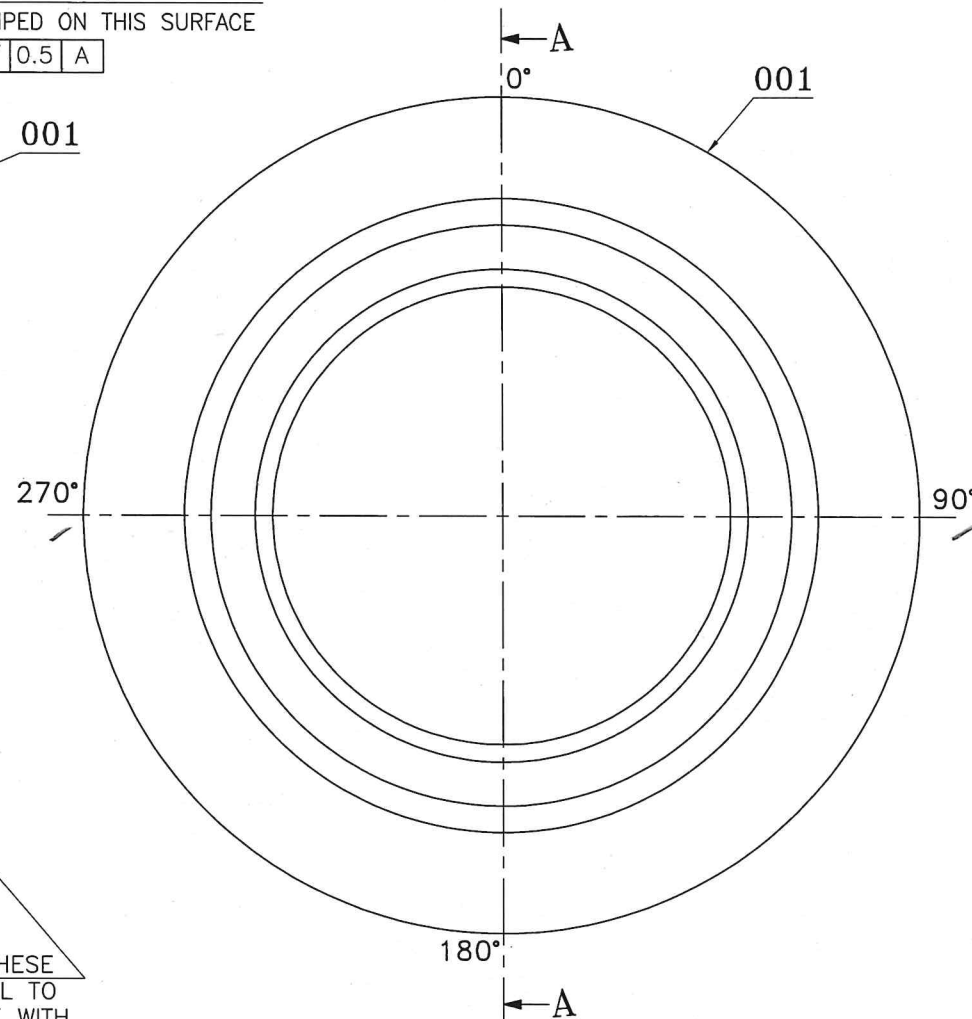


//	0.5	A
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SECTION : A-A

1. SUPPLY CONDITION : HEAT TREATED AND PROOF MACHINED ALL OVER.
2. ALL TECHNICAL AND TESTING REQUIREMENTS SHALL BE AS PER NPCIL APPROVED SPECIFICATION No. BHEL/NPCIL/30599/CS-FORGINGS/CDE-19-3411.
3. NO REPAIRS/WELDING SHALL BE PERMITTED WITHOUT PRIOR APPROVAL OF NPCIL.
4. TEST COUPON FOR TESTING SHALL BE FORMED AS PER SPECIFICATION NO.— BHEL/NPCIL/30599/CS-FORGINGS/CDE-19-3411.
5. IDENTIFICATION TO BE STAMPED AT LOCATION SHOWN WITH FOLLOWING INFORMATION:
 - a). PURCHASE FORGING NUMBER.
 - b). HEAT NUMBER
 - c). BHEL PO NUMBER
 - d). MATERIAL DESIGNATION.
6. MATERIAL OF CONSTRUCTION : SA 350 LF2 CLASS-1.
7. TEMPORARY OIL BASED RUST PREVENTIVE TO BE APPLIED AFTER MACHINING THE TUBE SHEET ON ALL SURFACES.
8. 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.
9. ALL DIMENSIONS INDICATED ARE IN mm.
10. UNLESS OTHERWISE MENTIONED THE TOLERANCE ON LINEAR AND ANGULAR DIMENSIONS SHALL BE IN ACCORDANCE TO IS:2102.
11. THE SURFACE FINISH OF FORGINGS SHALL BE 3.2 OR BETTER.

ALL DIMENSIONS ARE IN mm.
MACHINE ALL OVER.
SURFACE FINISH TO BE $\sqrt{16}$ OR BETTER.
REMOVE ALL BURRS.
REMOVE ALL EXTERNAL SHARP CORNERS
AND EDGES BY CHAMFERING TO $0.15 \pm 0.40 \times 45^\circ$.
ROUND ALL INTERNAL CORNERS AND
EDGES TO R 0.15 ± 0.40 .
TOLERANCES ON RADII AND CHAMFERS
(IS : 2102)

REDII AND CHAMFERS	0.5-3	3-6	6-30
TOLERANCES	± 0.2	± 0.5	± 1.0

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

CDE - 1 HCM - 4 FWM - 4

APPD.			
(कि.ग्रा.) WT (K.G.)	उसे. डाईंग का संदर्भ REF. TO ASSY. DRG.	मद क्र. ITEM NO.	मद संख्या NO. OF ITEM
	3. 12527, 12528		

300.0	3-16503-408/8	001	-
डा. क. / DRAWING NO.			पुन. / REV.

TUBE SHEET FORGING

3-16503-40877

03,

पृष्ठ क्र./ SHT. NO. 01	पृष्ठों की संख्या/ NO. OF SHT. 01
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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 ☐ संविधान को आगे बढ़ाए / PROCEED WITH/HOLD FABRICATION ☐ अंतिम दृष्टिकोण एवं प्रतियाँ भेजें / SEND FINAL TRANSPARENCIES & PRINTS ☐ संशोधन करें एवं अनुमोदन के लिए पुनः प्रस्तुत करें / REVISE & RESUBMIT FOR APPROVAL		
जाँचकर्ता / CHECKED BY	समीक्षकर्ता / REVIEWED BY	अनुमोदनकर्ता / APPROVED BY
[Signature] 13/5/19	[Signature] 13/5/19	[Signature] 13/5/19
किए जानेवाले कार्य का अनुमोदन आपूर्तिकर्ता संविदाकार को विनिर्देशनों 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		ø950				001		TUBE SHEET						B.O.		A		KG		1300.0	
														SA350 LF2Cl.1							
59	64	65	75	78	79	25	27	29	58	59	60	77	29	31	34	45	55	57	58	65	72
VARQO QTY.-Nos		REMARKS		VAR. NO.		ITEM NO.		DESCRIPTION		STD		DRAWING NO.		IT.NO.		MATL. CODE		UNIT WT.		UNIT	
														32 33 46		54		68		71	
														VAR.		MATL. SPCN.				GS	
28		CARD TYPE-3		28		CARD TYPE-1		28		CARD TYPE-2		28		CARD TYPE-2		28		CARD TYPE-2		28	



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 : GHAVP-1&2/33311/2007/DD REV.00

EQUIPMENT NAME :

REGENERATIVE COOLER

TAG NO. :

(3331-HX-1)

बी एच ई एल
BHEL

भारत हेवी इलेक्ट्रिकल्स लिमिटेड
भोपाल
BHARAT HEAVY ELECTRICALS LTD
BHOPAL

	नाम/ NAME	हस्ता./ SIGN	दिनांक/DATE	वे रि.
बनाया DRN.	विजय कुमार कुशवाहा		08/03/2019	की संख्या
जॉय CKD.	नागेन्द्र सिंह		08/03/2019	NO. OF VAR.
उत्तमोदित	ए.के. माहौर		08/03/2019	

विभाग DEPT. CDE	अन.टल. नाप की श्रेणी UNTOL. DIMS. GR
कोड 111	M

	अनुपात SCALE	भार WEIGHT
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APPD.			
(कि.ग्रा.) WT (K.G.)	उसे. डाईंग का संदर्भ REF. TO ASSY. DRG.	मद क्र. ITEM NO.	मद संख्या NO. OF ITEM
	3. 12527, 12528		

CODE 411	AA0203208
शीर्षक/ TITLE	

	-	13
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300.0	3-16503-408/8	001	-
डा. क. / DRAWING NO.			पुन. / REV.

TUBE SHEET FORGING

3-16503-40877

03,

पृष्ठ क्र./ SHT. NO. 01	पृष्ठों की संख्या/ NO. OF SHT. 01
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