

DRG. NO. 3-16505-40166

NOTES :-

(1) MATERIAL

- (g) BASE TUBE TO ADM. BRASS TO SPECIFICATION SB111C44300 IN ANNEALED TEMPERED CONDITION SUITABLE FOR EXPANSION AT BOTH ENDS.
- (b) FINS COPPER TO IS:191 OF ELECTRICAL GRADE HAVING CONDUCTIVITY 97% MIN.
- (c) SOLDER TO IS 193 GRADE SN 60.

(2) PROCESS

- (b) CRIMPED FINS TO BE FIRMLY SECURED WITH TUBES TO GIVE EFFECTIVE HEAT TRANSFER AND TO WITH-STAND TRANSPORT AND OPERATIONAL HAZARDS.
- (c) INSIDE SURFACE OF TUBES TO BE CLEAN FROM CARBONEOUS MATERIAL , DUST, OIL AND SOLDER ETC.
- (d) ENDS OF THE TUBE TO BE SQUARE AND OUTSIDE OF THE TUBE (WITHOUT FIN) AT THE ENDS TO BE FREE FROM SOLDER & ANY TOOL MARK FOR TUBE EXPANSION.

(3) TESTS

FOLLOWING TESTS TO BE CONDUCTED ON TUBES AS PER AA12128.

- (d) MECHANICAL TEST (b) CHEMICAL COMPOSITION TEST
- (b) EDDY CURRENT TEST BEFORE WINDING AS PER AA12128.
- (c) HYDRAULIC TEST AT 70 kg/cm²(g) FOR BASE TUBE AND AT 20 kg/cm²(g) AFTER FINNING
- (d) MERCURIUS NITRATE / AMMONIA VAPOUR CRACKING TEST AND MICROSCOPIC EXAMINATION.
- (e) FLATTENING AND EXPANSION TEST.

(4) TEST CERTIFICATES

4 COPIES EACH FOR ABOVE TESTS INSPECTION

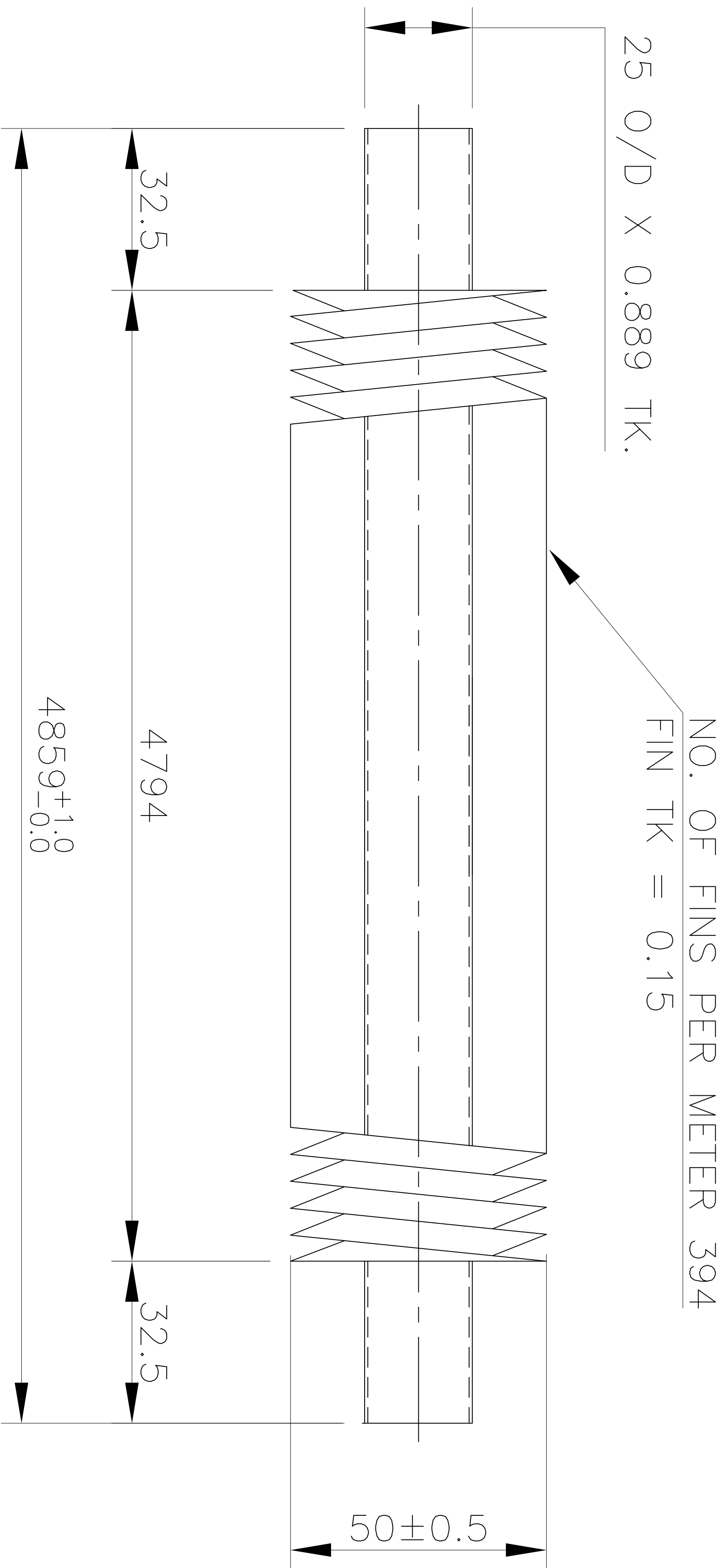
- (g) FOR DETAIL QAP, REFER BHEL STANDARD QAP CDE-16-3096. IN CASE OF ANY CONFLICT BETWEEN THIS DRG AND QAP, QAP SHALL GOVERN FINALLY.

(5) TOLERANCE

- (c) ALL DIMENSIONS +1 UNLESS OTHERWISE SPECIFIED EXCEPT TUBE OD, TUBE AND FIN THICKNESS AS PER MATERIAL SPECIFICATION.

(6) PACKING AND MARKING

- (a) TUBE TO BE SUITABLY PACKED TO AVOID MOVEMENT & RUBBING AS PER STD AA0490002.
- (b) THE CONSIGNMENT SHOULD BE MARKED AND DISPATCHED AS PER STD AA0490002.
- (c) THE END OF TUBE TO BE CAPPED BEFORE DISPATCH.



DETAIL OF ITEM-01

WEIGHT OF ELEMENTS Kg. (APPROX)			
IT.	Cu	Zn	TOTAL
1.	6.92	0.84	7.76

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