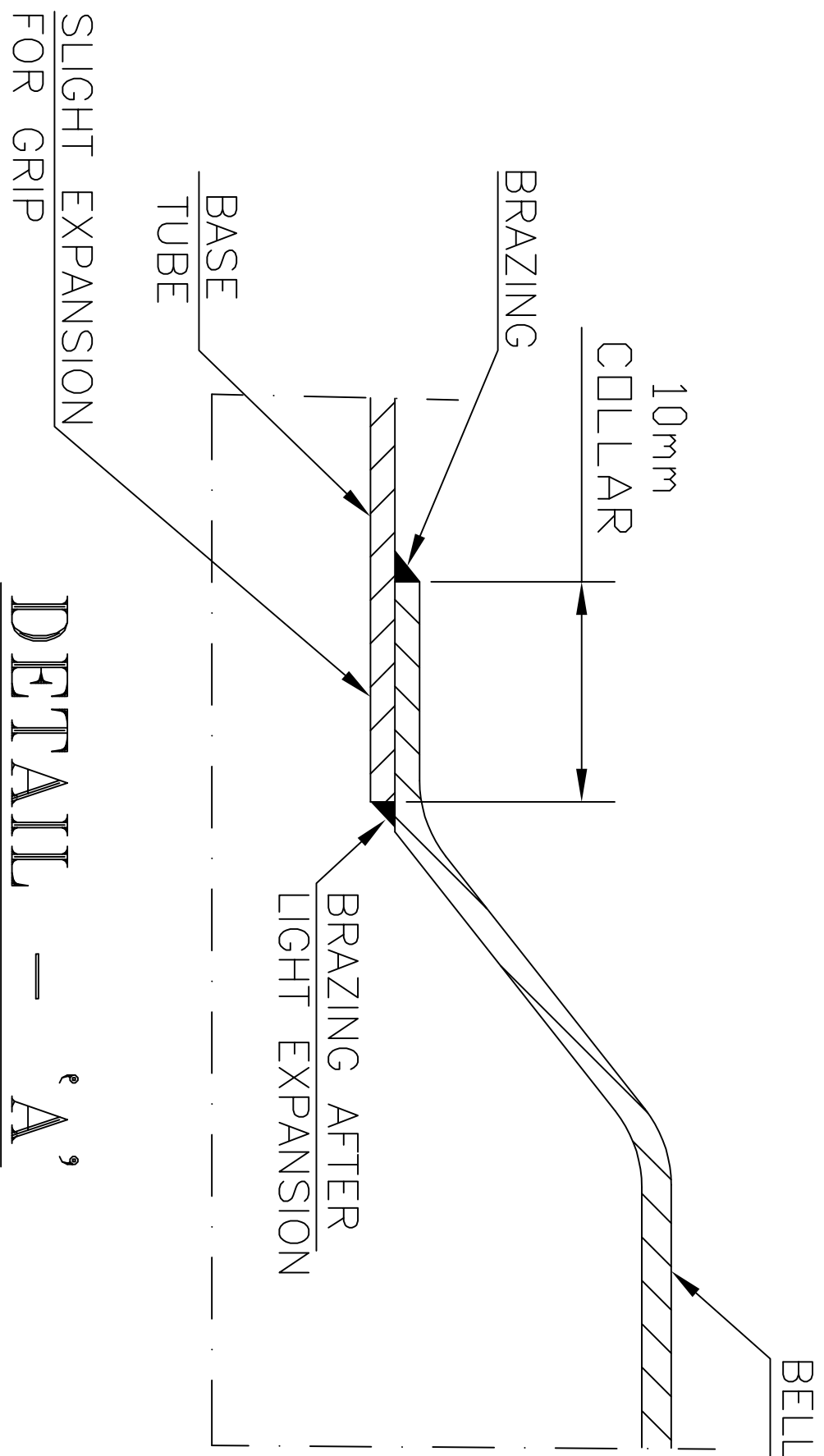
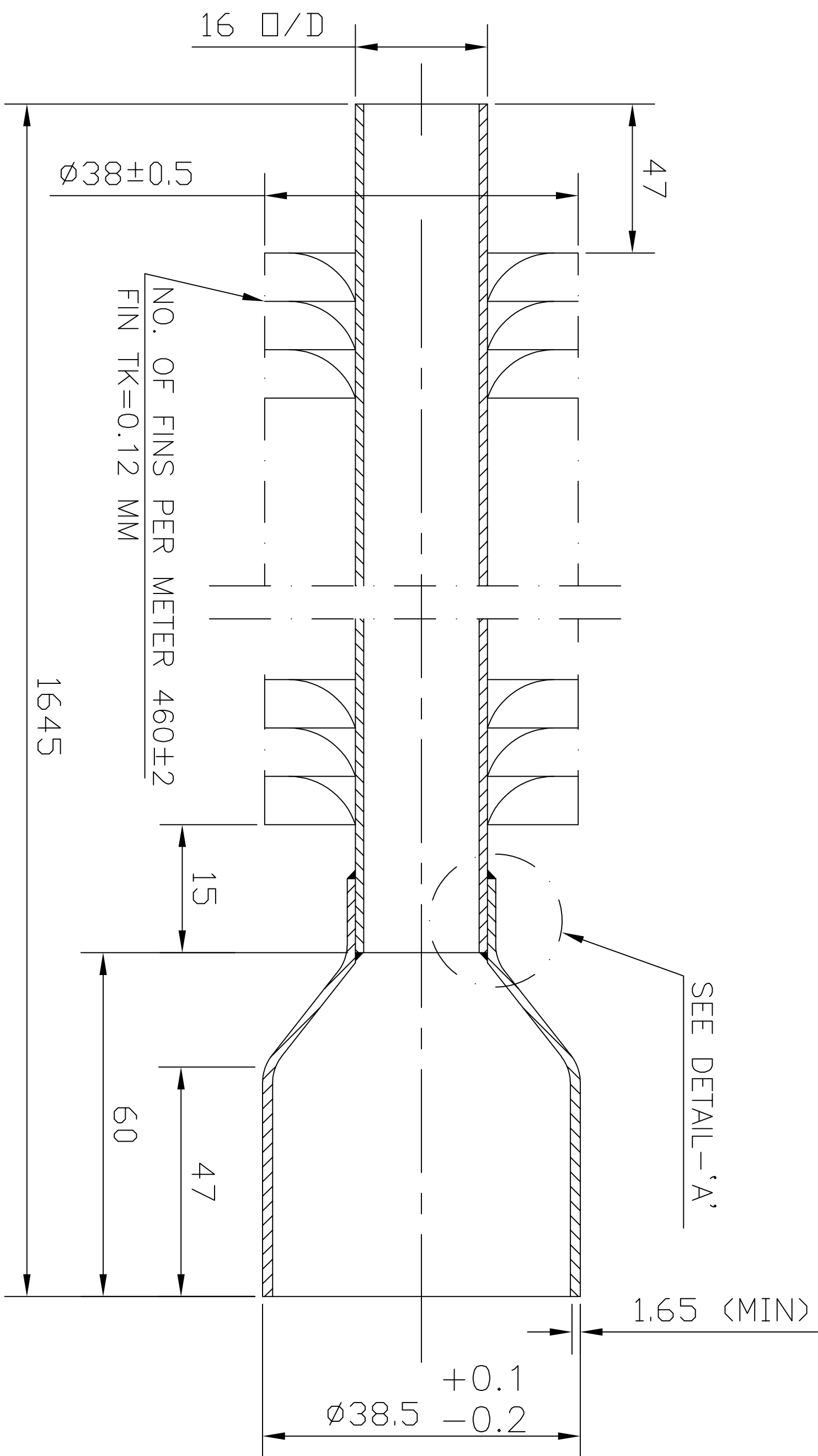


DRG. NO. 3-16606-40202



	BASE TUBE	BELL	PIN	TOTAL
MATERIAL	90-10 Cu-Ni	90-10 Cu-Ni	Cu TO IS-191	-
WEIGHT / TUBE	0.667 KG	0.11 KG	0.99 KG	1.767 KG
WEIGHT (Cu) / TUBE	0.600 KG	0.099 KG	0.99 KG	1.689 KG
WEIGHT (Ni) / TUBE	0.067 KG	0.011 KG	-	0.078 KG

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IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN THE WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

INVENTORY NO.	SIGN. & DATE	REF. DRG. NO.
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NOTES :-

- (1) MATERIAL
 - (a) BASE TUBE TO 90-10 CU.NI TO SPECIFICATION AA12130 IN BRIGHT ANNEALED CONDITION SUITABLE FOR EXPANSION AT BOTH ENDS.
 - (b) FINS COPPER TO IS:191 (ETP GRADE) HAVING CONDUCTIVITY 97% IACS (MIN.).
 - (c) SOLDER TO IS 193 GRADE SN 60.
- (2) PROCESS
 - (a) TUBE TO BE CONTINUOUSLY WOUND WITH COPPER CRIMPED FINS. NO JOINT IN BETWEEN WILL BE ALLOWED.
 - (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 FOR TUBE EXPANSION.
 - (e) ONE END TO BE BELL MOUTHED AS SHOWN, OTHER END PLAN BELL MOUTHED MATERIAL 90/10 CUPRO-NICKEL-TOLERANCE AS SPECIFIED.
- (3) TESTS
 - FOLLOWING TESTS TO BE CONDUCTED ON TUBES AS PER AA12130.
 - (a) MECHANICAL TEST (b) CHEMICAL COMPOSITION TEST
 - (b) EDDY CURRENT TEST BEFORE WINDING AS PER AA12130.
 - (c) HYDRAULIC TEST AT 70 Kg/cm (g) FOR BASE TUBE AND AT 20 Kg/cm(g) AFTER FINNING.
 - (d) MERCUPOUS NITRATE / AMMONIA VAPOUR CRACKING TEST AND MICROSCOPIC EXAMINATION.
 - (e) FLATTENING AND EXPANSION TEST.
 - (f) BELL POINTS TO BE 100% D.P. TESTED BEFORE HYDROTEST.
- (4) TOLERANCE
 - (a) ALL DIMENSIONS ± 1 UNLESS OTHERWISE SPECIFIED EXCEPTION TUBE OD, TUBE AND FIN THK
 - (b) TUBE OD AND THICKNESS AS PER AA12130, EXCEPT BELL.
- (5) PACKING AND MARKING
 - (a) TUBE TO BE SUITABLY PACKED TO AVOID MOVEMENT & RUBBING.
 - (b) THE CONSIGNMENT SHOULD BE ENDORSED WITH TUBES FOR CACW COOLER & P.O. NO.
 - (c) THE END OF TUBE TO BE CAPPED BEFORE DISPATCH.

[illegible]

28 → CARD TYPE-3	28 → CARD TYPE-1	28 → CARD TYPE-2
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ADDITIONAL INFORMATION	उत्पत्ति का स्रोत या प्रक्षेत्र / परियोजना का नाम	5x46 GENERATOR AIR COOLER ARUN-III HEP
STATUS OF DRAWING	TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT	

[illegible]

REV. DATE	ALTERED	विभाग DEPT.CODE	उत्तराखण्ड, राज्य की श्रेणी UNTO. DIMS. GR.		उत्पत्ति SCALE	भारत की मानक WEIGHT(K.G.)	उत्पत्ति का संदर्भ REF. TO ASSY. DRG.	संग्रह क्र. ITEM NO.	संग्रह संख्या NO. OF ITEM
	CHECKED				NTS	1.767	21660640258	—	1
	APPROVED	कोड CODE 4 1 1	AA0230208						
ZONE									

CRIMPED FIN TUBES

3-16606-40202 00

पृष्ठ क्र./ SHT. NO. 1 पृष्ठों की सं. NO. OF SHT. 1