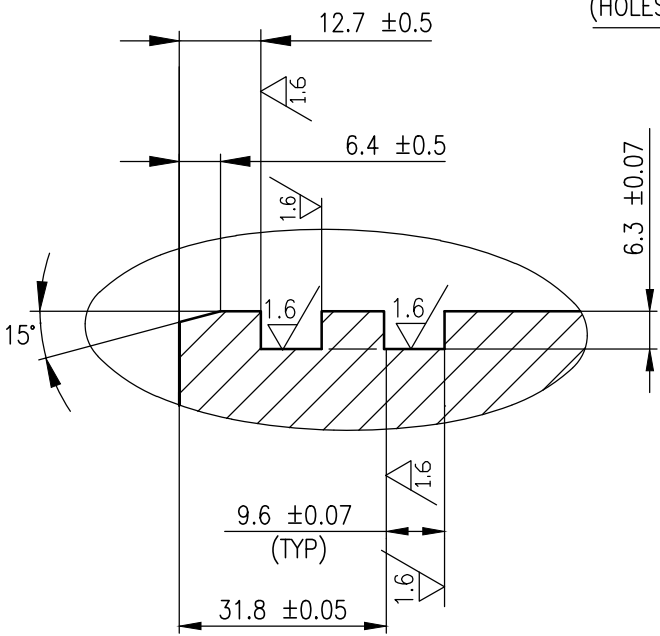
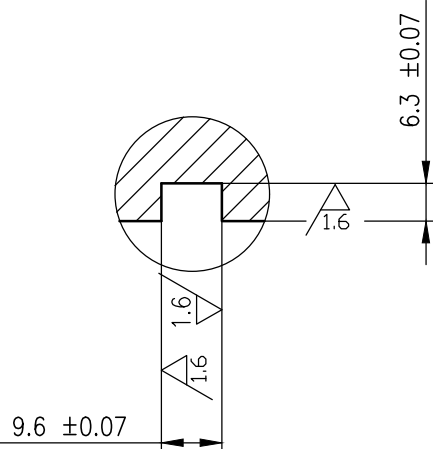
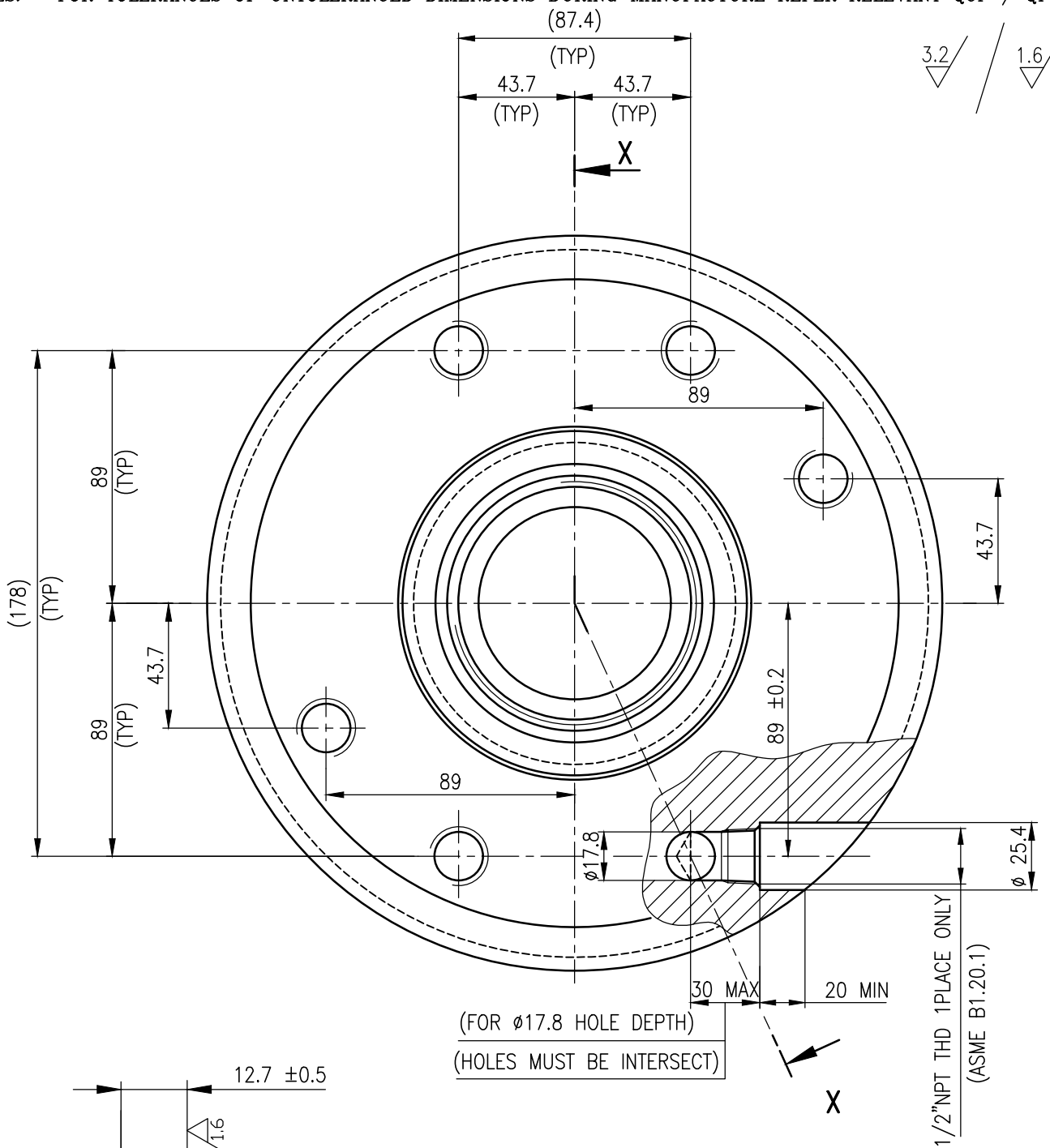
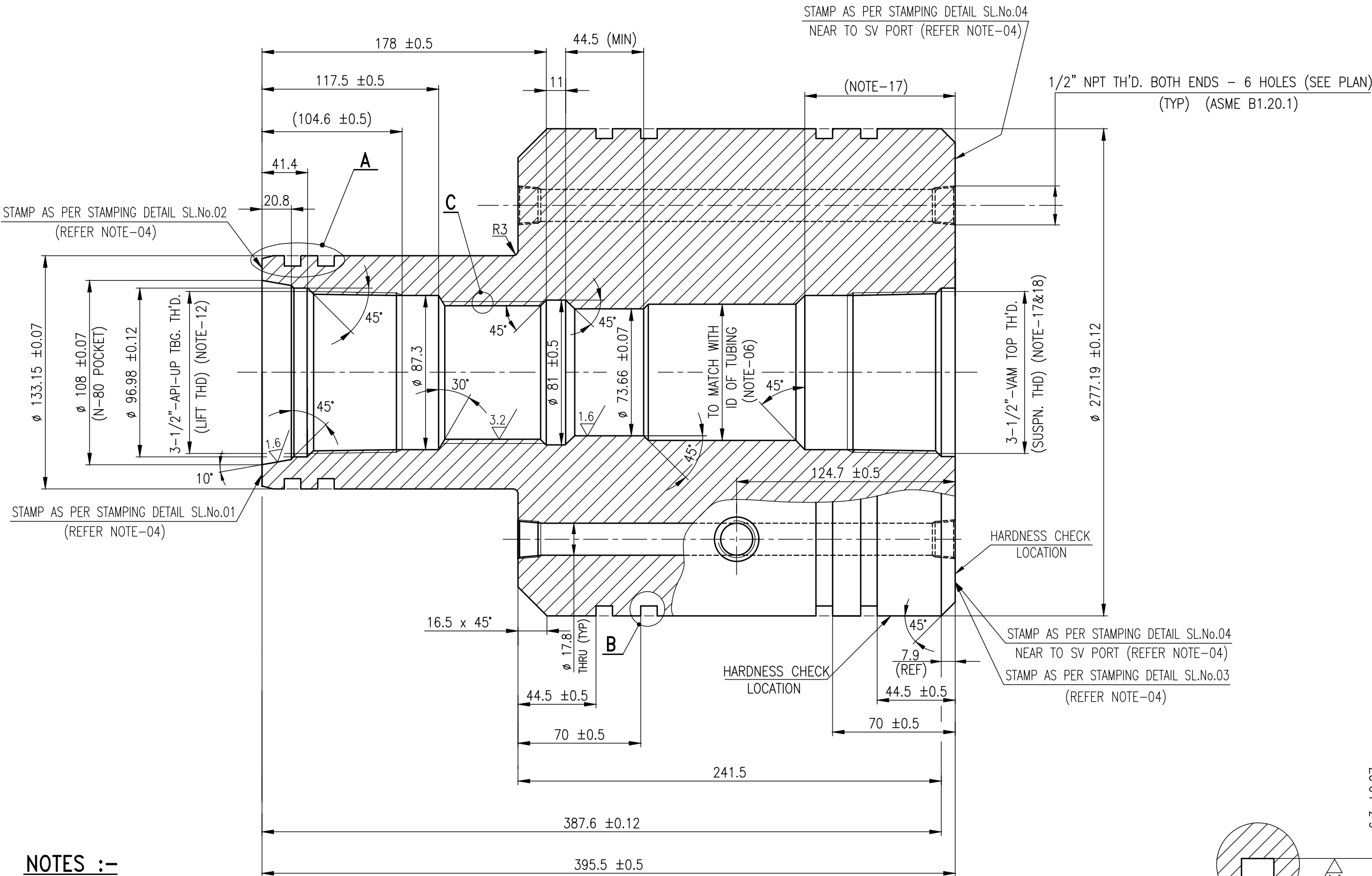


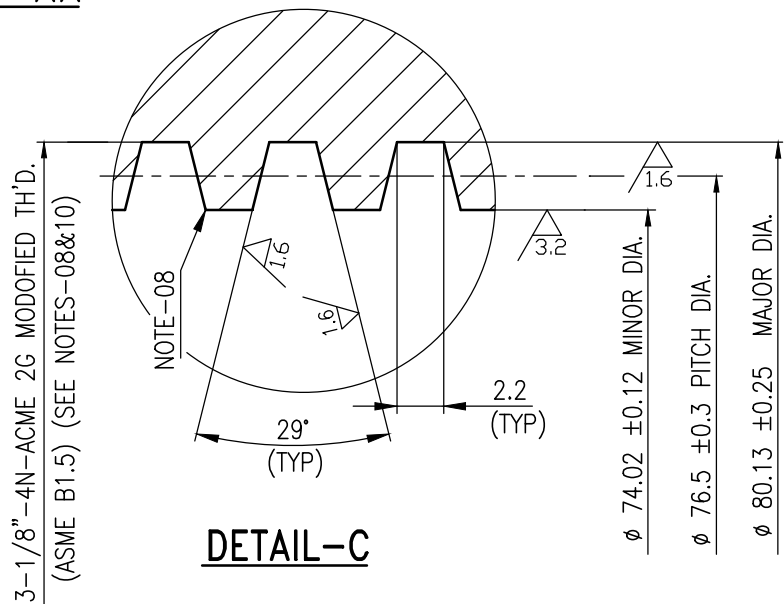
DRAWING NO: 2-V-4M85-20340

ALL DIMENSIONS ARE IN MILLIMETRES. FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP / QP



- NOTES :-**
- UNLESS OTHERWISE SPECIFIED :
 - MACHINING TOLERANCE : ± 0.25 MM
 - ANGLE TOLERANCE : $\pm 1/2^\circ$
 - AFTER FINAL MACHINING, COAT RUST PREVENTIVE COATING.
 - BREAK ALL SHARP EDGES BY 0.25 MM.
 - CHECK AND PUNCH ACTUAL HARDNESS VALUE.
 - DRILLED HOLES MUST INTERSECT, CHECK AFTER DRILLING.
 - THRO' BORE MUST BE CHECKED AFTER THREADING TO MATCH ID OF TUBING.
 - USE MASTER GAUGES FOR THREAD GAUGING.
 - LIFT THIN SECTION OF ACME THREAD TO HALF THREAD WIDTH ON BOTH ENDS.
 - ACME THREADS MUST BE FREE OF RAG & BURRS. BREAK CREST R0.13 TO R0.25
 - AFTER MACHINING, NITRIDE THE ACME THREADS FOR A CASE DEPTH OF 0.08MM TO 0.15MM FOLLOWED BY CLEANING IN ORDER TO REMOVE ALL GRIT, SCALE & SALT.
 - SEALING SURFACES, THREADING AREA AND OD OF HANGER ARE TO BE POLISHED AND DIMENSIONS TO BE ENSURED AFTER NITRIDING.
 - THREAD MACHINING AND GAUGING SHALL BE DONE AS PER API-6A & API-5B. USE MASTER GAUGE FOR THREAD GAUGING.
 - CHARPY IMPACT TEST SHALL BE CARRIED OUT AS PER LATEST APPLICABLE QUALITY PROCEDURE TO PSL-3 REQUIREMENTS. (AT RAW MATERIAL STAGE)
 - MATERIAL SHALL COMPLY WITH REQUIREMENTS OF LATEST APPLICABLE QUALITY PROCEDURE FOR PRESSURE CONTAINING PARTS TO PSL-3 REQUIREMENTS.
 - 100% UT TO BE CARRIED OUT AS PER PSL-3 REQUIREMENTS. (AT RAW MATERIAL STAGE)
 - ALL ACCESSIBLE SURFACES SHALL BE EXAMINED BY WET FLUORESCENT METHOD (WET MPI) AS PER LATEST APPLICABLE QUALITY PROCEDURE FOR PSL-3 REQUIREMENTS.
 - THREAD LENGTH, COUNTER BORE, THREAD RELIEF DIA. THREAD FINISH ETC TO SUIT THE 3 1/2" VAM TOP SUSPENSION THREAD.
 - COAT THE SUSPENSION THREAD AS PER THREAD LICENSEE INSTRUCTIONS.
 - PROTECT THE THREADS DURING TRANSIT.
 - RAW MATERIAL PROCUREMENT, INSPECTION, TESTING, ACCEPTANCE CRITERIA AND RECORDS ARE TO BE FOLLOWED & SUBMITTED AS PER LATEST REVISION OF TDC:0409

SECTION - XX



STAMPING DETAILS:-

SL.No.	DETAILS TO BE PUNCHED
01	BHEL-6A-974650430000-BDP4H5-6SV-11"-5000 PSI 3 1/2" EUE LIFT x 3 1/2" VAM TOP SUSPN-N80-BPV 3" NOM PR1 PSL 3 U HH MIN. BORE 2.897"-API 6ACRA N07718-150K -HARDNESS VALUE
02	3-1/2"-UP TBG (LIFT TH'D.)
03	3-1/2"-VAM TOP (SUSP. TH'D.) "DOWN"
04	1/2"-14 NPT

UNLESS OTHERWISE SPECIFIED			
BREAK SHARP CORNERS	: 0.25		
FILLET RADII	: 0.76 ± 0.12		
CONCENTRICITY	: 0.25 FIM		
SQUARNESS	: 0.25 IN 254		
PARALLELISM	: 0.25 IN 254		
RFS EXCEPT WHEN (M) MODIFIED.			

DCP No.	ALTD:	APPD:
REV	CHD:	DT:
ZONE		

CAUTION: The information on this document is the property of BHARAT HEAVY ELECTRICALS LTD. It must not be used directly or indirectly in any way detrimental to the interest of the company.

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		11" NOM. X 3 1/2" EUE LIFT & VAM TOP SUSPN. WITH N80 BDP4H5-6SV-3" NOM BPV (1/2" NPT LINE)							
Bharat Heavy Electricals Ltd. UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI-620014.		DRN	D. LOGESH KUMAR	SIGN	D.L	DATE	04.11.20	NO. OF VAR.	
365-120/A 09.09.20		CHD	ARUNKUMAR P	P.A	04.11.20				
APPD		ARUNKUMAR P	P.A	04.11.20					
DEPT	V L	SCALE	NTS	WEIGHT (KG).	~ 118.5	REFERENCE INFORMATION			
CODE	340	OF				DRAWING NO.		REV	
TITLE				CARD CODE	U 01	2-V-4M85-20340		00	