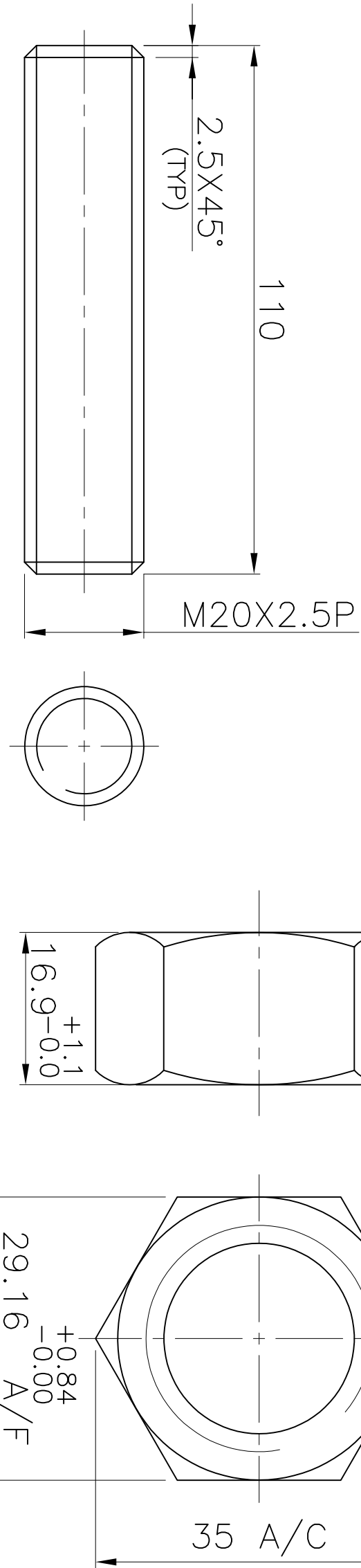
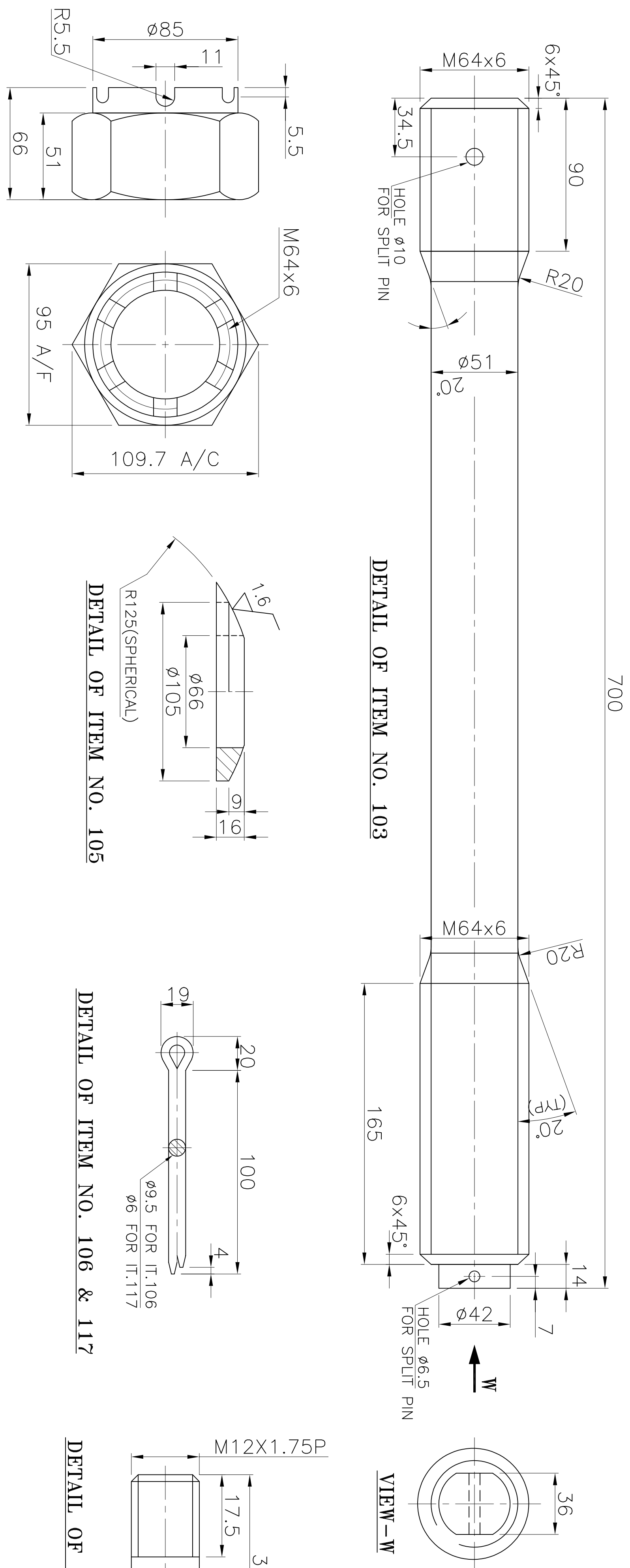




TECHNICAL REQUIREMENTS (TR) :-

1. THE THREADED SURFACE AND MACHINE SURFACE SHALL BE SUITABLY PROTECTED AGAINST MECHANICAL DAMAGE & PRESERVED CLEAN.
2. THE STANDARD NUT DIMENSIONS SHALL BE AS PER IS 1364 (PART 3) : 2002.
3. PROTECT ALL MACHINED SURFACE AND THREADED CONNECTIONS WITH RUST PREVENTIVE IMMEDIATELY AFTER NOE & MACHINING.
4. THREADING SHALL BE AS PER ISO# ANSI B1.1
5. ALL SHARP CORNERS SHALL BE CHAMFERED OFF TO SMOOTH RADUS.
6. THREADS OF ALL STUDS/NUTS SHALL BE APPLIED WITH MOLYBDENUM DISULFIDE.

NOTE - QTY. MENTIONED IN BOM ARE FOR 1 NO. HEAT EXCHANGER

DO NOT SCALE THE DRAWING.
UNLESS OTHERWISE STATED:-

MACHINE ALL OVER.			
SURFACE FINISH TO BE $\frac{1}{2}$ OR BETTER.			
REMOVE ALL BURS.			
REMOVE ALL EXTERNAL SHARP CORNERS			
AND EDGES BY CHAMFERING TO $0.05 \times 45^\circ$.			
ROUND ALL INTERNAL CORNERS AND			
EDGES TO R 0.05			
TOLERANCES ON RADI AND CHAMFERS			
(F.S. $\pm .010$)			
REBELL AND CHAMFERS	0.5-3	3-6	6-30
TOLERANCES	± 0.2	± 0.5	± 1.0

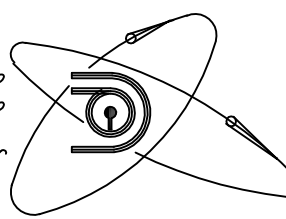
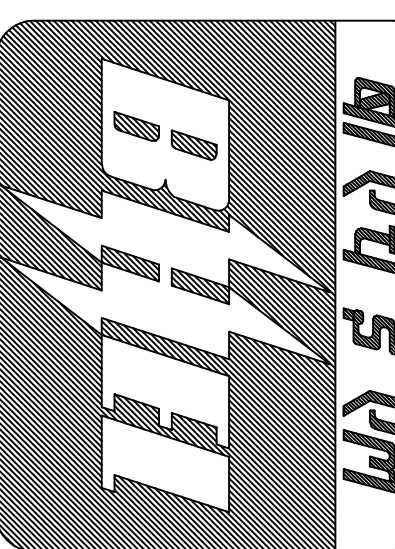
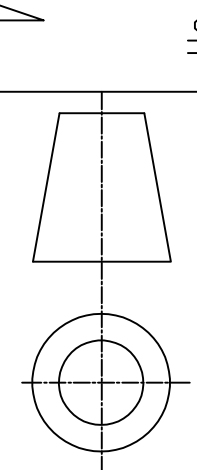
TOLERANCE ON LINEAR DIMENSIONS (IS.2102)			
DIMENSIONS	TOL.	DIMENSIONS	TOL.
Up to 6	0.1	315 - 1000	± 0.2
6 - 30	± 0.2	1000-2000	± 0.8
30 - 120	± 0.5	2000-4000	± 2.0
120 - 315	± 0.5	4000-8000	± 3.0

TOLERANCE ON ANGULAR DIMENSIONS : $0^\circ - 0.25^\circ$			
TOLERANCE ON LINEAR DIMENSIONS			
SPECIFIED DIMENSIONS	TOLERANCE		
XX	± 0	± 40	
XX.X	± 0	± 40	
XX.XX	± 0	± 40	
	± 0	± 0.25	

REV.	DATE	ALTERED CHECKED APPROVED	REV.	DATE	ALTERED CHECKED APPROVED
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ZONE		ZONE	

NPCL PURCHASE ORDER NO. : CMM/FTP/10-33-1-1149/e-PO/30599 Dtd. 25/01/2019		
ADDITIONAL INFORMATION DRG. LIST : 4-16503-40358		
STATUS OF DRAWING W/O. NO. : 18085/86-W-04801		
DISTRIBUTION OF PRINTS CDE - 2 FWM - 4 HCM - 4		
REV.	DATE	ALTERED
01	18.03.20	चेक करी नवीन सिंह ए.के. मोदी
ZONE	DRAWING REVISED TO INCORPORATE ALL FASTENERS AS PER LATEST DRGS. OF BCL.	

 NUCLEAR POWER CORPORATION OF INDIA LIMITED (A GOVERNMENT OF INDIA ENTERPRISE)									
उत्पाद का प्रकार या ग्राहक/परियोजना का नाम TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT BLEED COOLER गोराकपुर हारियाना अनु विद्युत GORAKHPUR HARYANA ANU VIDYUT PARIYOJANA									
भारत हेवी इलेक्ट्रिकल्स लिमिटेड भोपाल BHARAT HEAVY ELECTRICALS LTD BHOVAL  बनारस DRN.									
विभाग DEPT. CDE कोड 411 उत्प. टोल. ताय की श्रेणी UNTOOL. DIMS. GR. AA0230208 M 									
उत्पाद SCALE भार (कि.ग.) WEIGHT (K.G.) उत्पाद SCALE									
गोराकपुर हारियाना अनु विद्युत GORAKHPUR HARYANA ANU VIDYUT PARIYOJANA उत्पाद SCALE भार (कि.ग.) WEIGHT (K.G.)									
गोराकपुर हारियाना अनु विद्युत GORAKHPUR HARYANA ANU VIDYUT PARIYOJANA उत्पाद SCALE भार (कि.ग.) WEIGHT (K.G.)									
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गोराकपुर हारियाना अनु विद्युत GORAKHPUR HARYANA ANU VIDYUT PARIYOJANA उत्पाद SCALE भार (कि.ग.) WEIGHT (K.G.)									

D	8		902	NUT M12 X 1.75P X 30Lg			-	SA479TP304L	KG	-	0.04	
	8	191.8 LONG	901	ROD 12 DIA			-	SA479TP304L	KG	-	0.17	
	8		817	NUT M24 X 3P			-	SA194 Gr.7	KG	-	0.25	
	4		816	STRUCTURE STUD M24 X 3P X 150 Lg.			-	SA193 Gr.B7	KG	-	1.25	
	16		815	NUT M42 X 4.5P			-	SA194 Gr.7	KG	-	0.7	
	8		814	STRUCTURE STUD M42 X 4.5P X 740 Lg.			-	SA193 Gr.B7	KG	-	8.0	
	04		341	HEX. NUT M12 x 1.75			-	SA479 GR.304L	KG	-	0.02	
	02		340	TIE ROD (THREADED) Ø12 x 378 LG.			-	SA479 GR.304L	KG	-	0.4	
	02		339	TIE ROD (THREADED) Ø12 x 318 LG.			-	SA479 GR.304L	KG	-	0.3	
	18	30 LG.	336	NUT M12 x 1.75 P			-	SA479 GR.304L	KG	-	0.02	
C	24		119	STUD CAP - M64			-	IS-9550	KG	-	0.8	
	24		118	HEX. NUT M64 x 6			-	34 Cr Ni Mo 6	KG	-	1.54	
	24		117	SPLIT PIN Ø6 x 120 LG.			-	IS-549	KG	-	0.02	
	32		115	HEX. NUT M12 x 1.75			-	SA194 Gr.2H	KG	-	0.01	
	16		114	STUD M12 x 1.75 x 110 LG.			-	SA320 L43	KG	-	0.08	
	16		110	HEX. NUT M20x2.5			-	SA194 Gr.2H	KG	-	0.2	
	08		109	STUD M20 x 2.5 x 110 LG.			-	SA320 L43	KG	-	0.30	
	01		107	DOWEL PIN			-	SA330 LP2SA193Gr.B7	KG	-	0.1	
	24		106	SPLIT PIN Ø9.5 x 120 LG.			-	IS-549	KG	-	0.1	
	24		105	SPHERICAL WASHER			-	34 Cr Ni Mo 6	KG	-	0.7	
B	24		104	CASTELATED M64 x 6			-	34 Cr Ni Mo 6	KG	-	2.0	
	24		103	STUD M64x6x700			-	20 Ni Cr Mo 14.5	KG	-	18	
	QTY VAR00	REMARKS	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT NO VAR.	MAT'L CODE MAT'L SPCL.	UNIT WT. QTY.	5	12	END
CARD TYPE-3				CARD TYPE-1				CARD TYPE-2				
28				28				28				