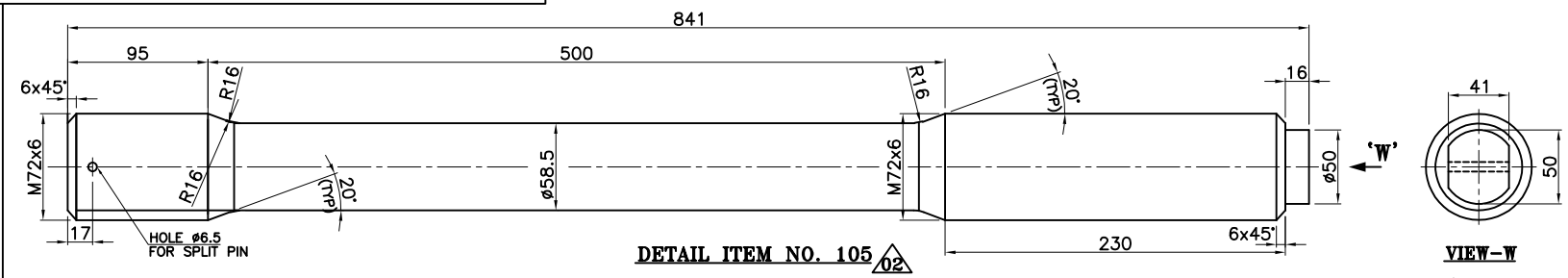
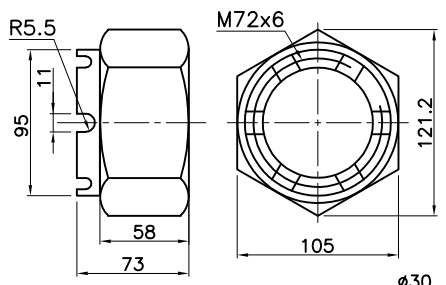
FIRST ANGLE PRJECTION | Fold-1 | ALL DIMENSIONS ARE IN MM

DRAWING NO. 3-16503-40903

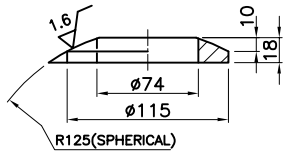


DETAIL ITEM NO. 105 02

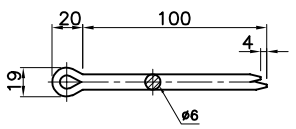
VIEW-W



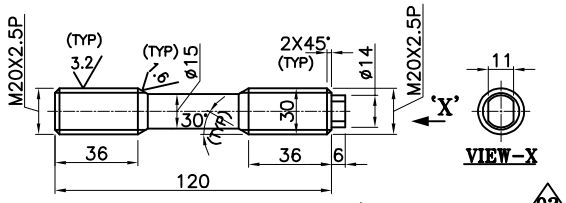
DETAIL ITEM NO. 106



DETAIL ITEM NO. 107

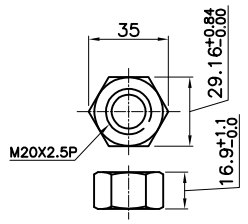


DETAIL ITEM NO. 108



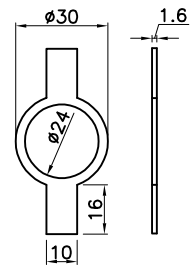
DETAIL ITEM NO. 109 02

VIEW-X

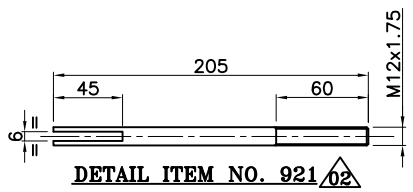


DETAIL ITEM NO. 110

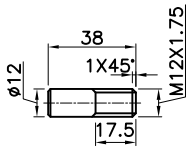
02



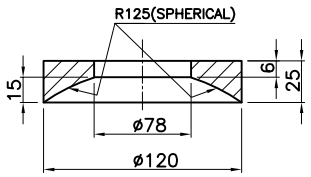
DETAIL ITEM NO. 111



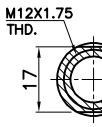
DETAIL ITEM NO. 921 02



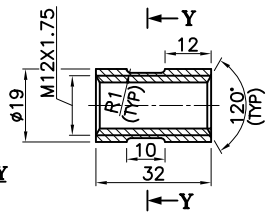
DETAIL ITEM NO. 112



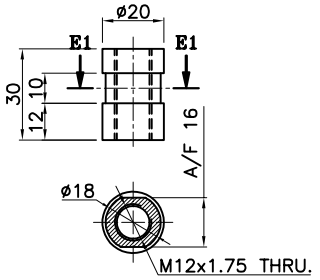
DETAIL ITEM NO. 123



SECTION:Y-Y



DETAIL ITEM NO. 314



SECTION E1-E1

DETAIL OF I.No. 922 02

02 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 NDE & MACHINING.
4. THREADING SHALL BE AS PER ISO@ ANSI B1.1
5. ALL SHARP CORNERS SHALL BE ROUNDED OFF TO SMOOTH RADIUS.
6. THREADS OF ALL STUDS/NUTS SHALL BE APPLIED WITH MOLYBDENUM DISULFIDE.

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

	VAR00 QTY.NOS	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.NO. / VAR.	MATL. CODE / MATL. SPCN.	A-C	UNIT	UNIT WT. / QTY.	GS	ZONE
02	08	–		922	NUT M12 X 1.75		–		– / SA 479 Gr.304L	A	KG	0.07		
02	08	205 LONG		921	FIXING ROD M12		–		– / SA 479 Gr.304L	A	KG	0.18		
	14	–		314	NUT M12 X 1.75		–		– / SA 479 Gr.304L	A	KG	0.02		
	24	–		123	SPHERICAL WASHER		–		– / 34CrNi MO6	A	KG	0.25		
	01	–		112	DOWEL PIN M12 X 1.75		–		– / SA 350 LF2/SA 193 Gr.B7	A	KG	0.03		
	16	–		111	LOCK WASHER–20		–		– / IS:1079	A	KG	0.01		
02	16	–		110	NUT M20 X 2.5		–		– / SA 194 Gr.7	A	KG	0.65		
02	8	126 Lg		109	STUD M20 X 2.5		–		– / SA 193 Gr.B7	A	KG	0.38		
	48	–		108	SPLIT PIN ø6		–		– / IS 549	A	KG	0.03		
	24	–		107	SPHERICAL WASHER		–		– / 34CrNi MO6	A	KG	0.25		
	48	–		106	CASTELLATED NUT M72		–		– / 34CrNi MO6	A	KG	3.47		
	24	841 Lg.		105	STUD M72X6P		–		– / 20NiCr MO14.5	A	KG	26.9		

28 —— CARD TYPE-3 | 28 —— CARD TYPE-1 | 28 —— CARD TYPE-2

SUBMITTED FOR NPCIL APPROVAL

DO NOT SCALE THE DRAWING.

UNLESS OTHERWISE STATED:–

ALL DIMENSIONS ARE IN mm.
MACHINE ALL OVER.
SURFACE FINISH TO BE 3.2 OR BETTER.
REMOVE ALL BURRS.
REMOVE ALL EXTERNAL SHARP CORNERS AND EDGES BY CHAMFERING TO 0.15/0.40 x 45°.
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

TOLERANCE ON LINEAR DIMENSIONS (IS:2102)

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

TOLERANCE ON ANGULAR DIMENSIONS : 0°–0.5°

NPCIL PURCHASE ORDER NO. : CMM/FTP/10-33-1-1149/e-PO/30599 Dtd. 25/01/2019

ADDITIONAL INFORMATION
DRG. LIST : 4–16503–40359

STATUS OF DRAWING
W/O. NO. : 18085/86–W–04801

DISTRIBUTION OF PRINTS
CDE – 1 HCM – 4 FWM – 4

NUCLEAR POWER CORPORATION OF INDIA LIMITED
(A GOVERNMENT OF INDIA ENTERPRISE)
PROJECT : GORAKHPUR HARYANA ANU VIDHYUT PARIYOJANA 1&2 (700 MWe)
NPCIL PURCHASE ORDER NO. : CMM/FTP/10–33–1–1149/e–PO/30599, DATED 25.01.2019

उत्पाद का प्रकार ~~या ग्राहक/परियोजना का नाम~~
TYPE OF PRODUCT ~~OR NAME OF CUSTOMER/PROJECT~~

SHUT DOWN HEAT EXCHANGER (HX1,HX2,HX3,HX4)

भारत हेवी इलेक्ट्रिकल्स लिमिटेड भोपाल
BHARAT HEAVY ELECTRICALS LTD. BHOPAL

	नाम/ NAME	हस्ता./SIGN	दिनांक/DATE
बनाया DRN.	विजय कुमार कुशवाहा		29/05/2019
जाँचा CKD.	नागेन्द्र सिंह		30/05/2019
अनुमोदित APPD.	ए.के.माहौर		31/05/2019

वे रि. की संख्या NO. OF VAR.

REV.	DATE		
02	21/02/2020	ALTERED महेन्द्र कुमार जायसवाल	
		CHECKED नागेन्द्र सिंह	
		APPROVED ए.के.माहौर	

ZONE: DRAWING REVISED TO INCLUDE # 921 & 922 AND TO INCORPORATE NPCIL'S COMMENTS AS MARKED 02
TR ADDED

REV.	DATE		
01	08/01/2020	ALTERED विजय कुमार कुशवाहा	
		CHECKED नागेन्द्र सिंह	
		APPROVED ए.के.माहौर	

ZONE: DRAWING REVISED & REDRAWN BASED ON LATEST DRAWING SUBMITTED FOR SDC AND BASED ON MOM Dtd.03/01/2020.

विभाग DEPT.	कोड CODE	उन.टाल. नाप की श्रेणी UNTOL. DIMS. GR.	अनुपात SCALE	भार (कि.ग्रा.) WEIGHT (K.G.)
CDE	411	AA0230208 M	-	-

शीर्षक/ TITLE: FASTENERS

उसे. ड्राइंग का संदर्भ REF. TO ASSY. DRG.: 1–16503–40853,862,875,876,896

मद क्र. ITEM NO.: –

मद संख्या NO. OF ITEM: –

ड्राइंग क्र./DRAWING NO.: 3–16503–40903

पुन./ REV.: 02

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

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it must not be used directly or indirectly in any way determental to the interest of the company.

REF. DRG. NO. | SIGN. & DATE | INVENTORY NO.

Fold-1 | FORMAT SIZE A3