

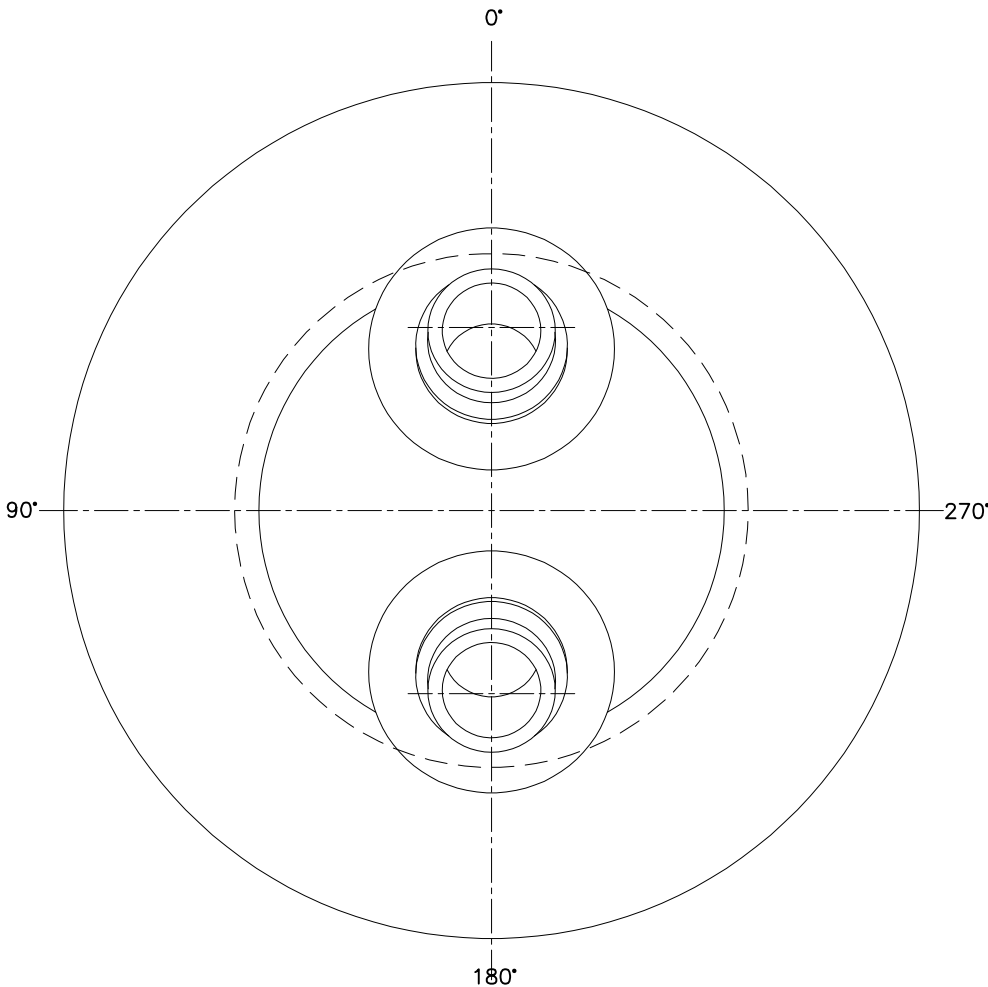
COPY RIGHT AND CONFIDENTIAL
The information on this document is the property of BHARAT HEAVY ELECTRICALS LIMITED
it must not be used directly or indirectly in any way detrimental to the interest of the company.

FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN MM

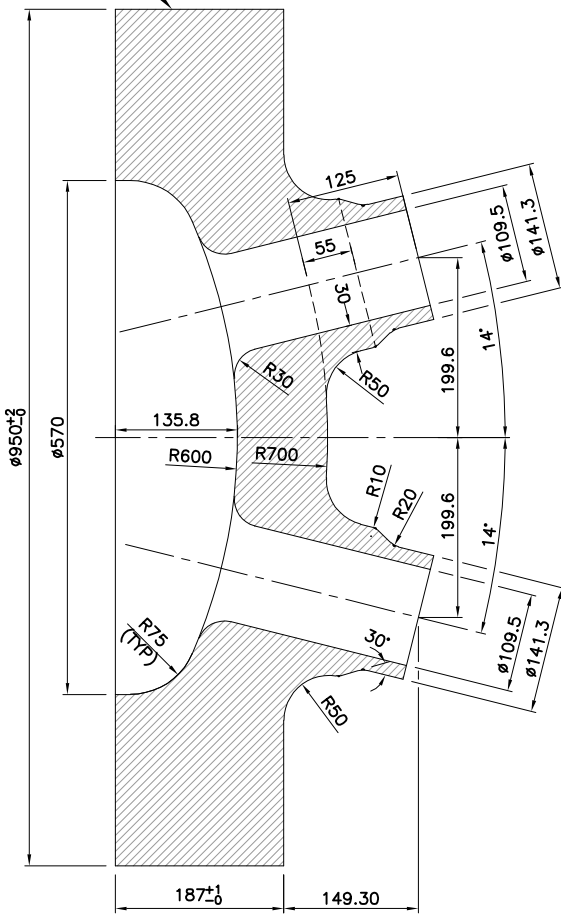
3-16053-40879

DRAWING NO.



VIEW-A

IDENTIFICATION NO. TO
BE PUNCHED HERE.



A

TECHNICAL REQUIREMENTS (TR):-

- SUPPLY CONDITION : HEAT TREATED AND FINISH MACHINED ALL OVER.
- ALL TECHNICAL AND TESTING REQUIREMENTS SHALL BE AS PER NPCIL APPROVED SPECIFICATION No.- BHEL/NPCIL/30599/CS-FORGINGS/CDE-19-3411.
- NO REPAIRS/WELDING SHALL BE PERMITTED WITHOUT PRIOR APPROVAL OF NPCIL.
- TEST COUPON FOR TESTING SHALL BE FORMED AS PER SPECIFICATION NO.- BHEL/NPCIL/30599/CS-FORGINGS/CDE-19-3411.
- IDENTIFICATION TO BE STAMPED AT LOCATION SHOWN WITH FOLLOWING INFORMATION:
 - PURCHASE FORGING NUMBER.
 - HEAT NUMBER
 - BHEL PO NUMBER
 - MATERIAL DESIGNATION.
- MATERIAL OF CONSTRUCTION : SA 350 LF2 CLASS-1.
- TEMPORARY OIL BASED RUST PREVENTIVE TO BE APPLIED AFTER MACHINING ON ALL SURFACES.
- ALL DIMENSIONS INDICATED ARE IN mm.
- UNLESS OTHERWISE MENTIONED THE TOLERANCE ON LINEAR AND ANGULAR DIMENSIONS SHALL BE AS PER IS:2102.
- THE SURFACE FINISH OF FORGINGS SHALL BE 3.2 OR BETTER.
- ALL MACHINED SURFACES SHALL BE SUBJECTED TO MT/PT.

**DO NOT SCALE THE DRAWING.
UNLESS OTHERWISE STATED:-**
ALL DIMENSIONS ARE IN mm.
MACHINE ALL OVER.
SURFACE FINISH TO BE $\sqrt{3.2}$ OR BETTER.
REMOVE ALL BURRS.
REMOVE ALL EXTERNAL SHARP CORNERS
AND EDGES BY CHAMFERING TO $0.15 \times 45^\circ$.
ROUND ALL INTERNAL CORNERS AND
EDGES TO R 0.15
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 : $0^\circ - 0.5^\circ$

ADDITIONAL INFORMATION

DRG. LIST : 4-16503-40357

STATUS OF DRAWING

W/O. NO. : 18085/86-W-04801

DISTRIBUTION OF PRINTS

CDE - 1 HCM - 4 FWM - 4

REV.	DATE	ALTERED	REV.	DATE	ALTERED
04	07/06/19	CHECKED नागेन्द्र सिंह APPROVED ए.के.माहौर	03	22/05/19	CHECKED नागेन्द्र सिंह APPROVED ए.के.माहौर
ZONE	DRAWING REVISED BASED ON NPCIL COMMENTS DTD. 03/06/2019.		ZONE	DRAWING REVISED BASED ON NPCIL COMMENTS DTD. 20/05/2019. PROFILE DIMENSIONS INCORPORATED TO PROCURE FORGING IN FINISH CONDITION.	

REV.	DATE	ALTERED
02	06/05/19	CHECKED नागेन्द्र सिंह APPROVED ए.के.माहौर
ZONE	DRAWING REVISED BASED ON NPCIL COMMENTS DTD. 15/04/2019.	

01	0950	001	CHANNEL HEAD	B.O.	890.0
VAR00	QTY.-Nos	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION
28	CARD TYPE-3		28	CARD TYPE-1	



NUCLEAR POWER CORPORATION OF INDIA LIMITED
(A GOVERNMENT OF INDIA ENTERPRISE)

PROJECT : GORAKHPUR HARIYANA ANU VIDHYUT PARIYOJANA 1&2 (700 MWe)

NPCIL PURCHASE ORDER NO. : CMM/FTP/10-33-1-1149/e-PO/30599, DATED 25.01.2019

NPCIL DRAWING NO : GHAVP-1&2/33311/2006/DD REV.00

EQUIPMENT NAME : REGENERATIVE COOLER
TAG NO : (3331-HX1)



भारत हेवी इलेक्ट्रिकल्स लिमिटेड
भोपाल
BHARAT HEAVY ELECTRICALS LTD
BHOPAL

नाम/ NAME	हस्ता./SIGN	दिनांक/DATE	वे.रि. की संख्या NO. OF VAR.
विजय कुमार कुशवाहा	विजय	08/03/2019	
नागेन्द्र सिंह	नागेन्द्र	08/03/2019	
अरुण कुमार सिंह	अरुण	08/03/2019	

विभाग DEPT.	अन.टोल. नाप की त्रुटि UN.TOL. DIMS. GR.	अनुपात SCALE	भार (कि.ग्रा) WEIGHT (K.G.)	उसे. ड्राइंग का संदर्भ REF. TO ASSY. DRG.	मद क. ITEM NO.	मद संख्या NO. OF ITEM
CDE 411	M AA0203208	-	890.0	3-16503-40871	001	-
शीर्षक/ TITLE				ड्राइंग क./DRAWING NO.		
CHANNEL HEAD FORGING (SEMI-FINISHED)				3-16503-40879		
				पृष्ठ क./SHT. NO. 01		
				पृष्ठों की संख्या/NO. OF SHT. 01		