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FIRST ANGLE PROJECTION

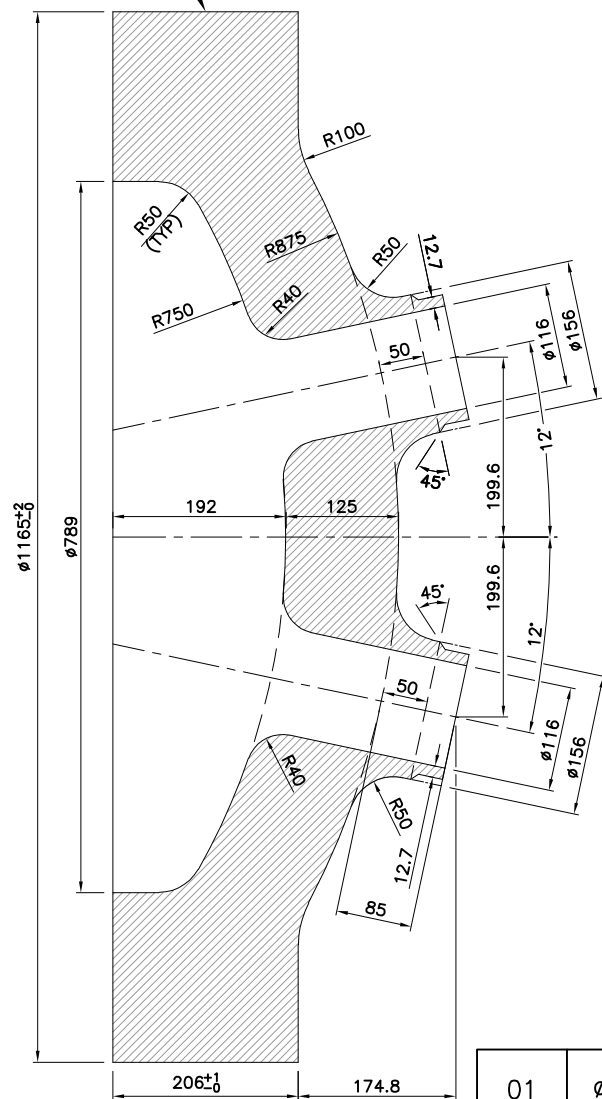
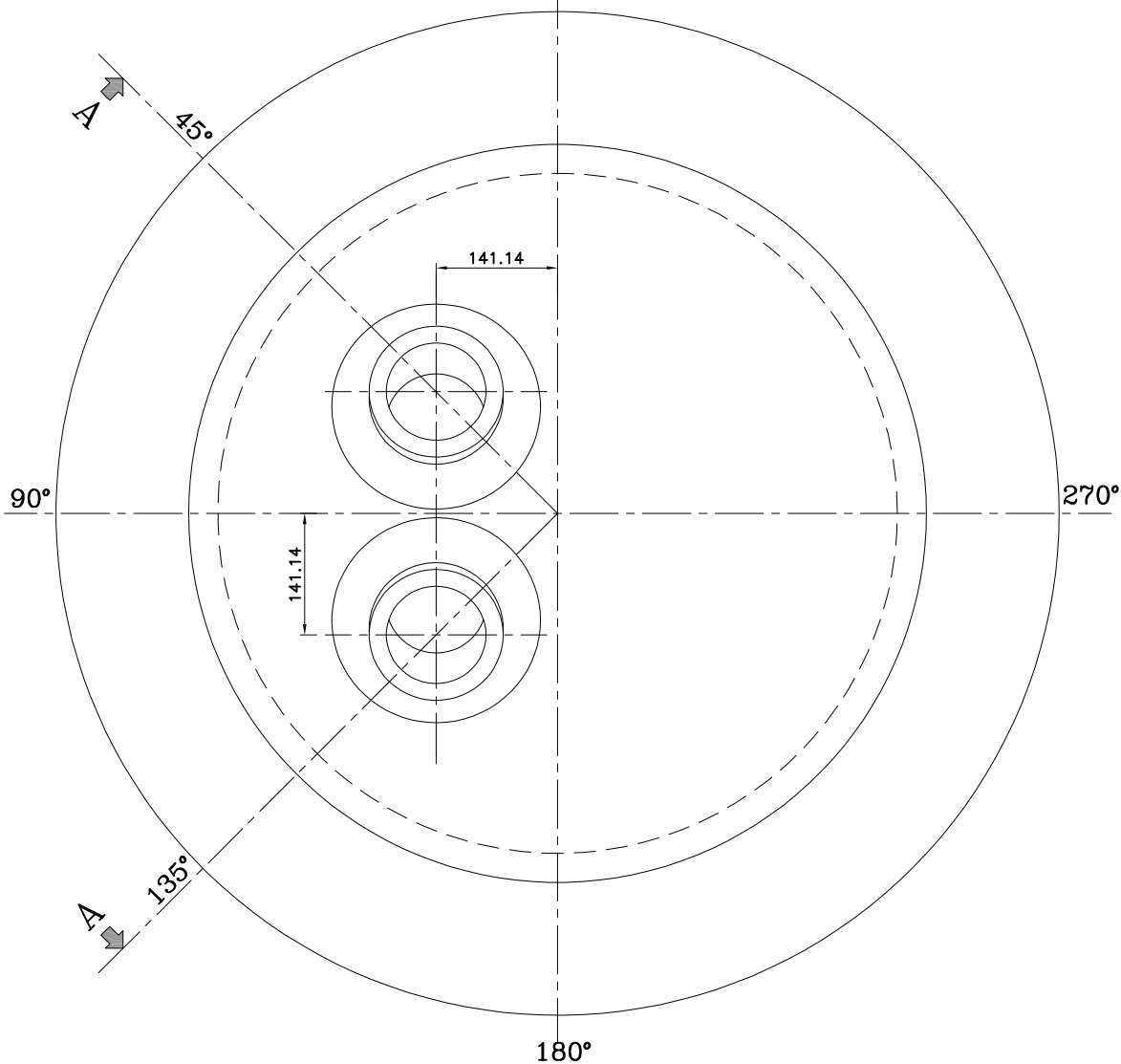
ALL DIMENSIONS ARE IN MM

3-16053-40888

DRAWING NO.

0°

IDENTIFICATION NO. TO BE
PUNCHED HERE.



SECTION-AA

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 $0.5 \times 45^\circ$.
ROUND ALL INTERNAL CORNERS AND
EDGES TO R 0.5 .
TOLERANCES ON RADII AND CHAMFERS
(IS : 2102)

REDI 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 ANGULAR DIMENSIONS : $\pm 0.5^\circ$			
TOLERANCE ON LINEAR DIMENSIONS			
SPECIFIED DIMENSIONS	TOLERANCE		
XX	± 0.40		
XX.X	± 0.40		
XX.XX	± 0.25		

01	$\phi 1165$	001	PRIMARY HEAD			B.O.		1440.0		
						SA350 LF2Cl.1	A	KG		
59	64	65	75	78	79	25	27	29	58	59
VAR00	QTY.-Nos	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	DRAWING NO.				
28 — CARD TYPE-3				28 — CARD TYPE-1				28 — CARD TYPE-2		
29	31	34	45	55	56	57	58	65	72	
IT.NO.		MATL. CODE		A	UNIT		UNIT WT.		CS	ZONE
VAR.	32	33	46	54	68		QTY.	71		



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&2/33321/2002/DD REV.00

EQUIPMENT NAME : BLEED COOLER
TAG NO : (3332-HX1)



भारत हेवी इलेक्ट्रिकल्स लिमिटेड
भोपाल
BHARAT HEAVY ELECTRICALS LTD
BHOPAL

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

REV.	DATE	ALTERED	कमलेश गामीत	REV.	DATE	ALTERED	कमलेश गामीत	REV.	DATE	ALTERED	कमलेश गामीत	विभाग	अन.टल. नाप की श्रेणी		अनुपात	भार (कि.ग्रा)	असे. ड्राइंग का संदर्भ	मद क्र.	मद संख.					
04	07/06/19	CHECKED	नागेन्द्र सिंह	03	22/05/19	CHECKED	नागेन्द्र सिंह	02	06/05/19	CHECKED	नागेन्द्र सिंह	DEPT. CDE	UNTOL. DIMS. GR.		-	1440	REF. TO ASSY. DRG.	ITEM NO.	NO. OF					
		APPROVED	ए.के.माहौर							APPROVED	ए.के.माहौर	कोड	M							411	AA0203208	ड्राइंग क्र./DRAWING NO.	पृष्ठ क्र./SHT. NO. 01	पृष्ठों की संख्या/NO. OF SHT. 01
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.			ZONE	DRAWING REVISED BASED ON NPCIL COMMENTS DTD. 15/04/2019.									PRIMARY HEAD FORGING (SEMI-FINISHED)			3-16503-40888	04