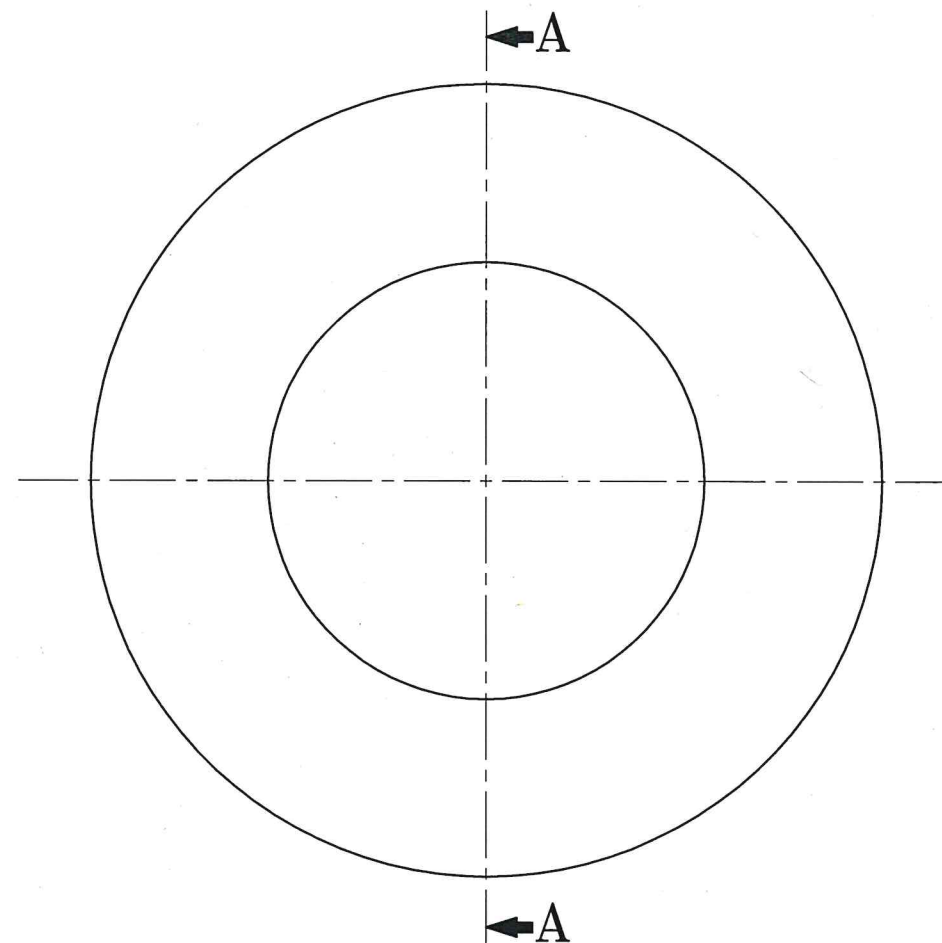
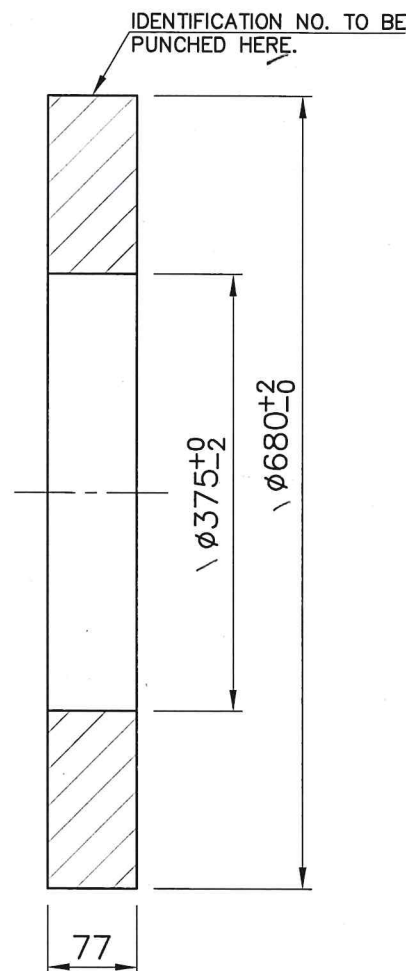


DRAWING NO. 3-16503-40890



Nuclear Power Corporation of India Limited		
☒ अनुमोदित / APPROVED		
☐ टिप्पणी के अनुसार अनुमोदित / APPROVED AS NOTED		
☐ संशोधन को आगे बढ़ाएं / रोके / PROCEED WITH/HOLD FABRICATION		
☐ अंतिम दृष्टिकोण प्रेषित करें / SEND FINAL TRANSPARENCIES & PRINTS		
☐ संशोधन करें एवं अनुमोदन के लिए पुनः प्रस्तुत करें REVISE & RESUBMIT FOR APPROVAL		
जाँचकर्ता / CHECKED BY	समीक्षाकर्ता / REVIEWED BY	अनुमोदन कर्ता / APPROVED BY
प्ररकर 15/5/19	शिवधामाधिकारी 15/5/19	15/5/19
किन्तु जानेवाले कार्य का अनुमोदन आपूर्तिकर्ता संशोधन को निवेदन के अनुसार आपूर्ति करने के उत्तरदायित्व से मुक्त नहीं करता है। This approval of the work to be done does not relieve the supplier of the responsibility of supply according to specifications.		

TECHNICAL REQUIREMENTS (TR):-

- SUPPLY CONDITION : HEAT TREATED AND PROOF 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 $\sqrt{1}$ OR BETTER.
REMOVE ALL BURRS.
REMOVE ALL EXTERNAL SHARP CORNERS
AND EDGES BY CHAMFERING TO $\frac{1}{4}$ R.
ROUND ALL INTERNAL CORNERS AND
EDGES TO R $\frac{1}{4}$.
TOLERANCES ON RADII AND CHAMFERS
(IS : 2102)
RADI AND CHAMFERS (R) 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	
10X		± 0.40	
10CX		± 0.40	
10CXX		± 0.25	
TOLERANCE ON ANGULAR DIMENSIONS : $0^\circ - 0.5^\circ$			

ADDITIONAL INFORMATION

DRG. LIST : 4-16503-40360

STATUS OF DRAWING

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

DISTRIBUTION OF PRINTS

CDE - 1 HCM - 4 FWM - 4

01	$\phi 680$	001	CHANNEL FLANGE FORGING	B.O.	154.0
VAR00	QTY.-No	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION
28	CARD TYPE-3	28	CARD TYPE-1	28	CARD TYPE-2

**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&2/33371/2009/DD REV.00

EQUIPMENT NAME : F/M RECIRCULATION & RETURN COOLER
TAG NO : (3337-HX1,2)



भारत हेवी इलेक्ट्रिकल्स लिमिटेड

भोपाल

BHARAT HEAVY ELECTRICALS LTD

BHOPAL

विभाग DEPT. CDE	उत्प. नं. नाप की त्रुटि UNTO. DIMS. GR.	उत्पात SCALE	भार (कि.ग्रा) WEIGHT (K.G.)	उत्प. इकाई का संदर्भ REF. TO ASSY. DRG.	मद क. ITEM NO.	मद संख्या NO. OF ITEM
कोड 411	AA0203208	-	154.0	3-16503-40870	001	-
शीर्षक/ TITLE				ड्राइंग क्र./DRAWING NO.	पृष्ठ क्र./SHT. NO. 01	
CHANNEL FLANGE FORGING				3-16503-40890	पृष्ठों की संख्या/NO. OF SHT. 01	