

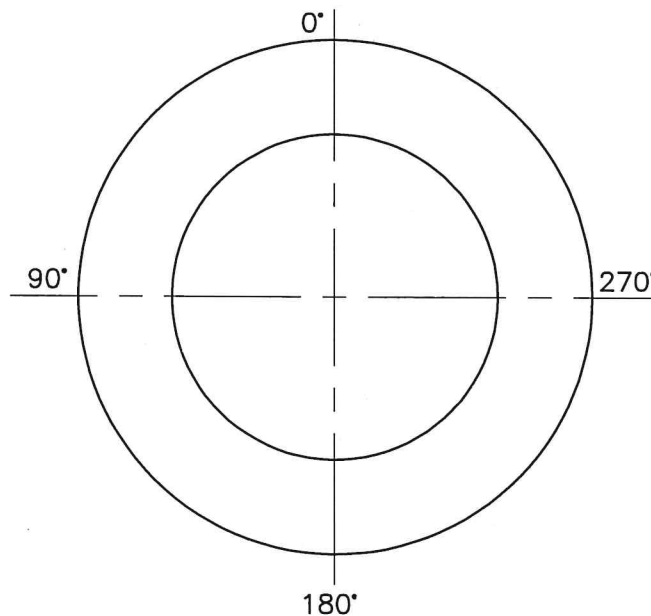
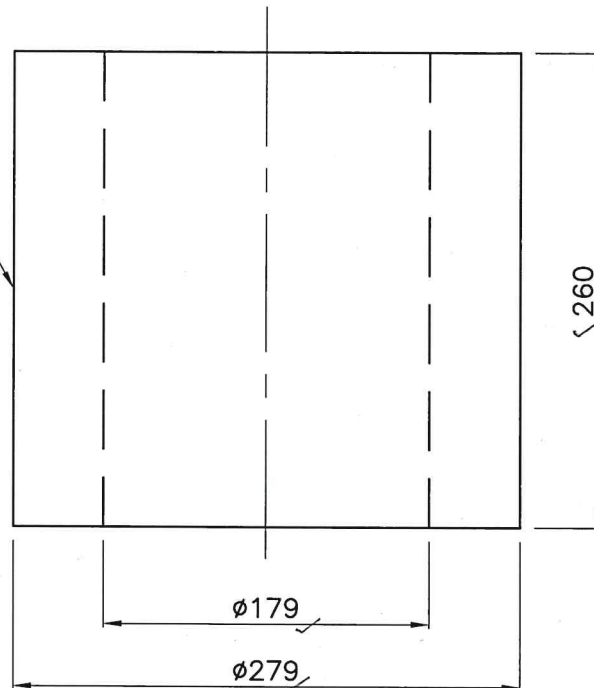
96807-80991-3

DRAWING NO.

FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN MM

Soft copy rec on 15/5/19

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TO BE STAMPED
HERE

न्यूक्लियर पावर कॉर्पोरेशन ऑफ इंडिया लिमिटेड
Nuclear Power Corporation of India Limited

☒ अनुमोदित / APPROVED
☐ टिप्पणी के अनुसार अनुमोदित / APPROVED AS NOTED
☐ संशोधन को आगे बढ़ाएं / प्रोceed WITH/HOLD FABRICATION
☐ अंतिम दृश्यप्रेषणी एवं प्रतियां भेजें / SEND FINAL TRANSPARENCIES & PRINTS
☐ संशोधन करें एवं अनुमोदन के लिए पुनः प्रस्तुत करें REVISE & RESUBMIT FOR APPROVAL

जांचकर्ता / CHECKED BY: प्ररव 16/5/19
 समीक्षकर्ता / REVIEWED BY: शिवाजी 16/5/19
 अनुमोदन कर्ता / APPROVED BY: 16/5/19

किए जानेवाले कार्य का अनुमोदन आपूर्तिकर्ता संविदाकार को विनिर्देशनों 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.

DO NOT SCALE THE DRAWING.
UNLESS OTHERWISE STATED:-
 ALL DIMENSIONS ARE IN mm.
 MACHINE ALL OVER.
 SURFACE FINISH TO BE $\sqrt{10}$ OR BETTER.
 REMOVE ALL BURRS.
 REMOVE ALL EXTERNAL SHARP CORNERS
 AND EDGES BY CHAMFERING TO $R_{\min}$ & $R_{\max}$.
 ROUND ALL INTERNAL CORNERS AND
 EDGES TO $R_{\min}$.
 TOLERANCES ON RADII AND CHAMFERS
 (IS : 2102)
 RADII AND CHAMFERS: 0.5-3 3-9 9-30
 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 : 0'-0.5'

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

REV. DATE ALTERED
 CHECKED
 APPROVED

ZONE

REV. DATE ALTERED
 CHECKED
 APPROVED

DRAWING REVISED BASED ON NPCIL COMMENTS DTD. 16/04/2019.

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 WELD EDGE & MACHINED SURFACES SHALL BE SUBJECTED TO MT/PT.

01		001	REDUCER FORGING		B.O.	73.0			
					SA350 LF2Cl.1				
VAR. NO.	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	DRAWING NO.	IT. NO.	MATL. CODE	UNIT WT.	QTY.

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&2/33411/2011/DD REV.00

EQUIPMENT NAME : SHUT DOWN COOLER -
 TAG NO : (3341-HX1,2,3,4) -

नाम/ NAME	हस्ता./SIGN	दिनांक/DATE	वे. री. की संख्या NO. OF VAR.
कमलेश गामीत		26/03/2019	
नागेन्द्र सिंह		26/03/2019	
ए.के.माहौर		26/03/2019	

विभाग DEPT. CDE	उत्प. टोल. नाप की त्रुटि UNTO. DIMS. GR.	अनुपात SCALE	भार (कि.ग्रा) WEIGHT (K.G.)	उत्प. ड्राइंग का संदर्भ REF. TO ASSY. DRG.	मद क. ITEM NO.	मद संख्या NO. OF ITEM
कोड 411		1:100	73.0	3-16503-40897	-	-

शीर्षक/ TITLE	ड्राइंग क्र./DRAWING NO.	पृष्ठ क्र./SHT. NO. 01	पृष्ठों की संख्या/NO. OF SHT. 01
REDUCER FORGING	3-16503-40896		