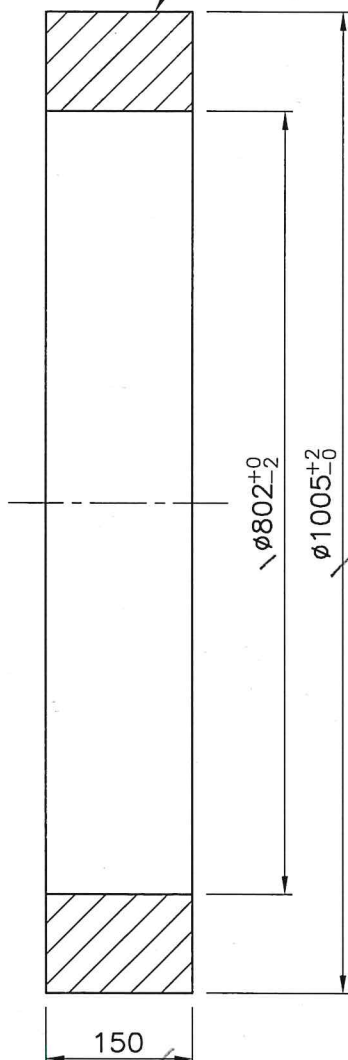
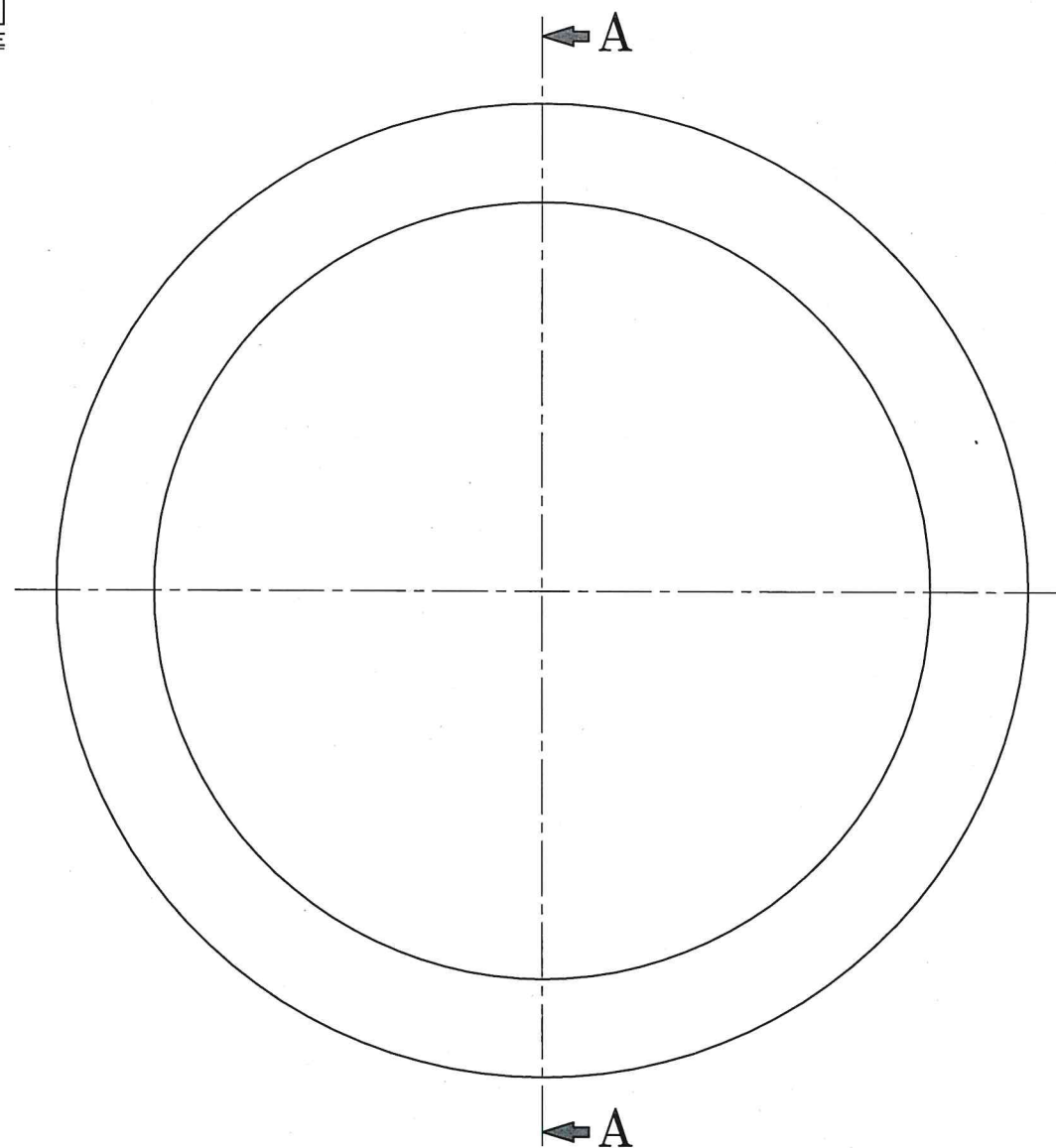


DRAWING NO. 3-16503-40906

IDENTIFICATION NO. TO BE
PUNCHED HERE.

SECTION A-A



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:
a). PURCHASE FORGING NUMBER. ✓
b). HEAT NUMBER ✓
c). BHEL PO NUMBER ✓
d). 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	CHANNEL FLANGE FORGING		B.O.	342.0	
					SA350 LF2CL.1		
VAROQ QTY.-Nos	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	DRAWING NO.	IT.N.O.	MATL. CODE
						32 33 34	MATL. SPCN.
						35 36 37	UNIT
						38 39 40	QTY.
						41 42 43	ZONE

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&2/33331/2001/DD SH. 2 OF 6

उत्पाद का प्रकार या Equipment name →
ग्राहक/परियोजना का नाम INVENTORY ADDITION AND RECOVERY SYSTEM (IARS)
TYPE OF PRODUCT OR
NAME OF CUSTOMER/PROJECT Tag no → (3333-HX1)

विकास DRN.	नाम/ NAME	हस्ता./SIGN	दिनांक/DATE	वे रि. की संख्या NO. OF VAR.
जांचा CKD.	महेन्द्र कुमार जायसवाल		14/05/2019	
अनुमोदित APPD.	नागेन्द्र सिंह	नगेन्द्र सिंह	15/05/2019	
	ए.के.माहौर		15/05/2019	

विभाग DEPT. CDE	अनु.टोल. नाप की श्रेणी UNTOL. DIMS. GR.	अनुपात SCALE	भार (कि.ग्रा) WEIGHT (K.G.)	उसे. ड्राईंग का संदर्भ REF. TO ASSY. DRG.	मद क. ITEM NO.	मद संख्या NO. OF ITEM
कोड CODE 411	M AA0203208	—	342.0	—	001	—

शीर्षक/ TITLE	ड्राईंग क्र./DRAWING NO.	पुन/ REV.
CHANNEL FLANGE FORGING	3-16503-40906	00
	पृष्ठ क्र./SHT. NO. 01	पृष्ठों की संख्या/NO. OF SHT. 01

DO NOT SCALE THE DRAWING.
UNLESS OTHERWISE STATED:-
ALL DIMENSIONS ARE IN mm.
MACHINE ALL OVER.
SURFACE FINISH TO BE $\sqrt{32}$ OR BETTER.
REMOVE ALL BURRS.
REMOVE ALL EXTERNAL SHARP CORNERS
AND EDGES BY CHAMFERING TO $0.5 \times R$.
ROUND ALL INTERNAL CORNERS AND
EDGES TO $R 0.5$.
TOLERANCES ON RADI AND CHAMFERS
(IS : 2102)

TOLERANCE ON LINEAR DIMENSIONS (IS:2102)	
DIMENSIONS	TOL.
UP TO 6	± 0.1
6 - 30	± 0.2
30 - 120	± 0.3
120 - 315	± 0.5
315 - 1000	± 0.8
1000 - 2000	± 1.2
2000 - 4000	± 2.0
4000 - 8000	± 3.0

TOLERANCE ON ANGULAR DIMENSIONS (IS:2102)	
SPECIFIED DIMENSIONS	TOLERANCE
XX	± 0.40
XX/XX	± 0.40
XX/XX	± 0.25

TOLERANCE ON ANGULAR DIMENSIONS : $0^\circ - 0.5^\circ$

ADDITIONAL INFORMATION

DRG. LIST : 4-16503-40362

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

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

☒ अनुमोदित / APPROVED with minor comments
☐ टिप्पणी के अनुसार अनुमोदित / APPROVED AS NOTED
☐ संशोधन को आगे बढ़ाएं / रोके /
PROCEED WITH/HOLD FABRICATION
☐ अंतिम दृष्टिकोण से एवं प्रतिकॉपी भेजें /
SEND FINAL TRANSPARENCIES & PRINTS
☐ संशोधन करें एवं अनुमोदन के लिए पुनः प्रस्तुत करें
REVISE & RESUBMIT FOR APPROVAL

जांचकर्ता / CHECKED BY	समीक्षकर्ता / REVIEWED BY	अनुमोदन कर्ता / APPROVED BY
प्रखर 16/5/19	विश्वनाथिकर 16/5/19	र.अ. 12/5/19

किए जाने वाले कार्य का अनुमोदन अनुमोदित संविदाकार को विनिर्देशनों के
अनुसार पूर्ण 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.

REF. DRG. NO.

SIGN. & DATE

INVENTORY NO.