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REF. DRG. NO.

SIGN. & DATE

INVENTORY NO.

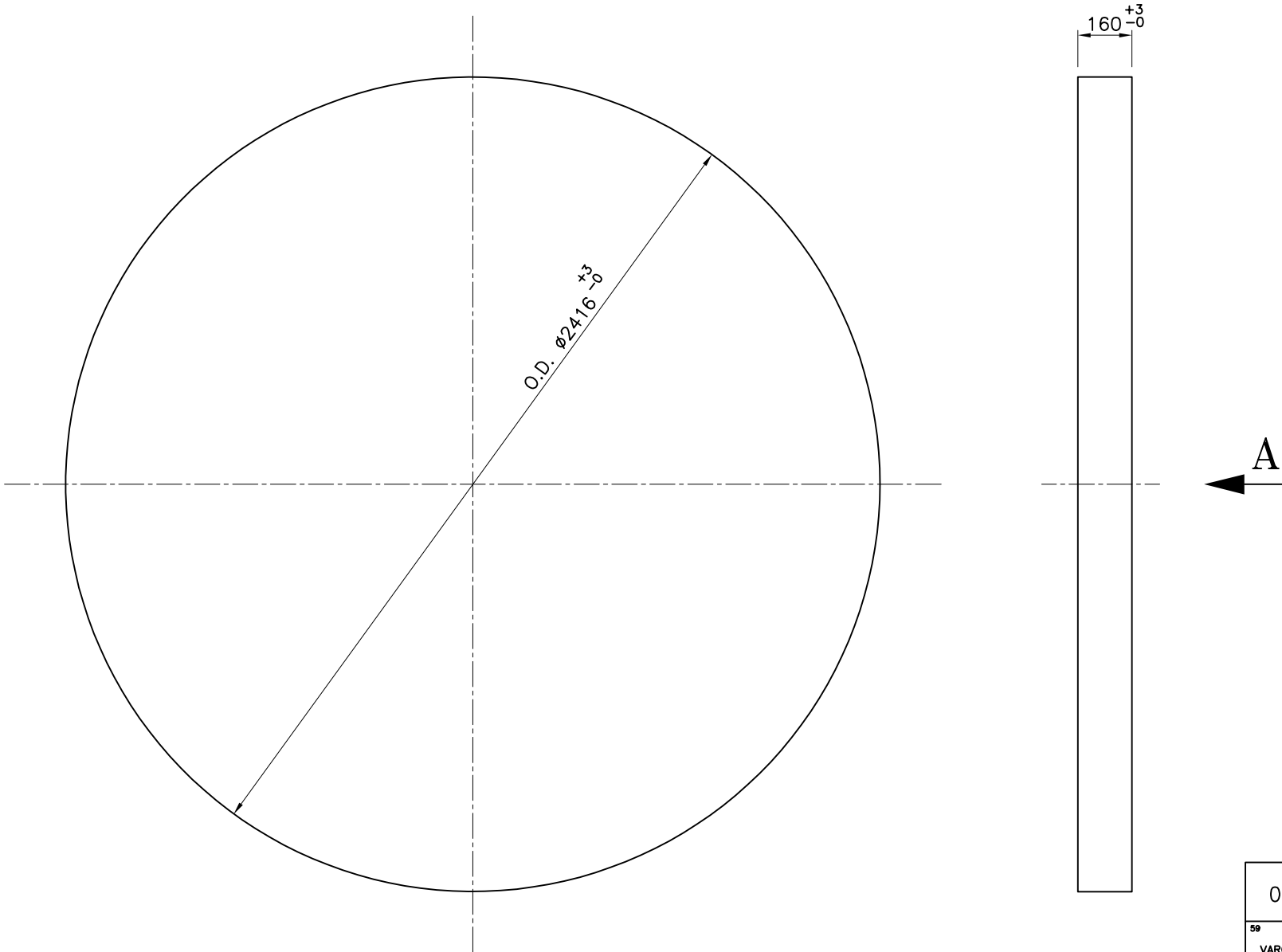
FIRST ANGLE PROJECTION

Fig-1

ALL DIMENSIONS ARE IN MM

3-16503-40910

DRAWING NO.



VIEW-A

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 $0.15 \times 45^\circ$
ROUND ALL INTERNAL CORNERS AND
EDGES TO R 0.15
 0.40
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°–0.5°			

ADDITIONAL INFORMATION

DRG. LIST : 4-16503-40363

STATUS OF DRAWING

W/O. NO. : 18083/84-W-04701

DISTRIBUTION OF PRINTS

CDE - 1 HCM - 4 FWM - 4

REV.	DATE	ALTERED	BY
01	06/04/19	CHECKED	मो. वहाब रफीक
		APPROVED	ए.के.माहौर
ZONE	OD REVISED TO $\phi 2416$		



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/10-32-1-1152/e-P0/30447, DATED 24.01.2019

NPCIL DRAWING NO : GHAVP-1&2/32111/2008/DD SH. 2 of 2 REV.00

उत्पाद का प्रकार या
ग्राहक/परियोजना का नाम
TYPE OF PRODUCT OR
NAME OF CUSTOMER/PROJECT

MODERATOR HEAT EXCHANGER

GORAKHPUR HARYANA ANU VIDYUT PARIYOJANA - 1&2 (700 MWe)



भारत हेवी इलेक्ट्रिकल्स लिमिटेड
मो पाल
BHARAT HEAVY ELECTRICALS LTD
BHOPAL

वनाया DRN.	नाम/ NAME	हस्ता./SIGN	दिनांक/DATE	वे रि. की संख्या NO. OF VAR.
मो. वहाब रफीक	महेन्द्र कुमार जायसवाल		30/06/2019	
ए.के.माहौर	मो. वहाब रफीक		30/06/2019	
	ए.के.माहौर		30/06/2019	

विभाग DEPT. CDE	अन.टोल. नाप की त्रैणी UNTOL. DIMS. GR.	अनुपात SCALE	भार (कि.ग्रा) WEIGHT (K.G.)	असे. ड्राईंग का संदर्भ REF. TO ASSY. DRG.	मद क. ITEM NO.	मद संख्या NO. OF ITEM
कोड 411 CODE		1:100	5758	3-16503-40871	-	-
शीर्षक/ TITLE				ड्राईंग क./DRAWING NO.	पुन./ REV.	
CHANNEL COVER FORGING (SEMI-FINISHED)				3-16503-40910	01	
				पृष्ठ क./SHT. NO. 01	पृष्ठों की संख्या/NO. OF SHT. 01	

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.

01	$\phi 2416$	001	CHANNEL COVER	B.O.	5758
				SA350 LF2Cl.1	
VAROQ QTY.-Nos	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	DRAWING NO.
28	CARD TYPE-3	28	CARD TYPE-1	28	CARD TYPE-2