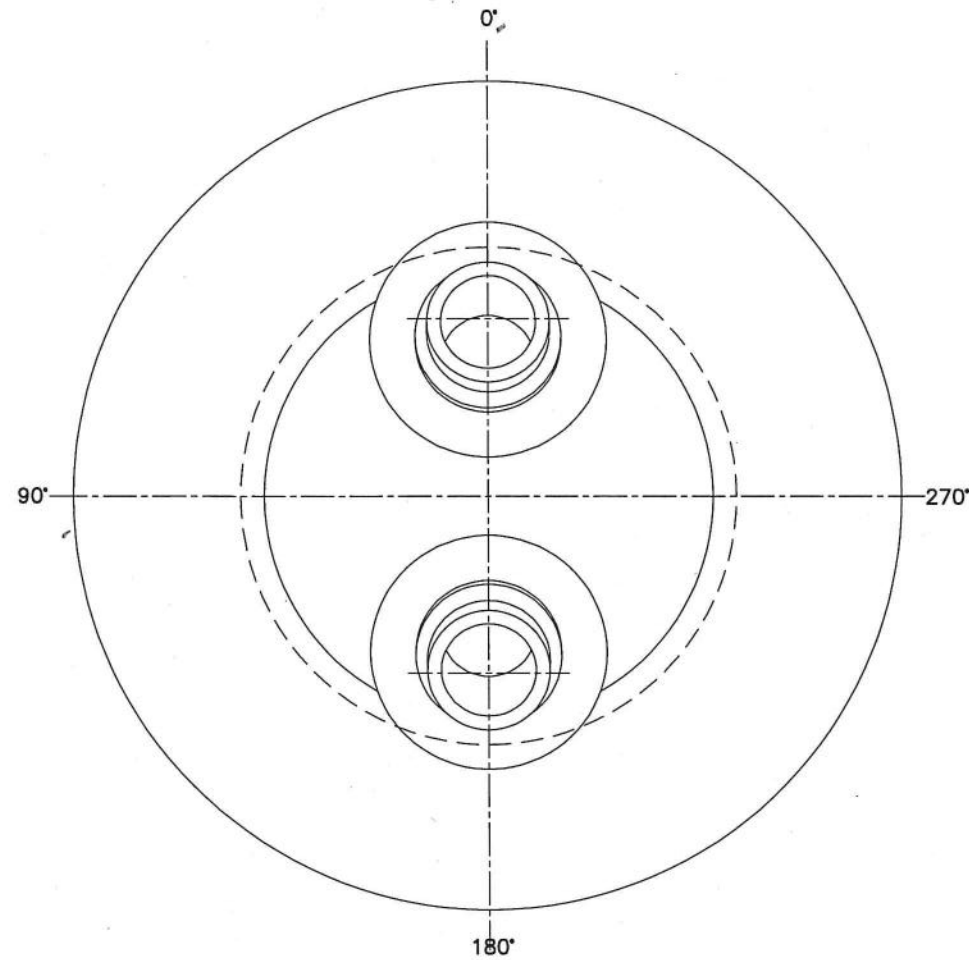
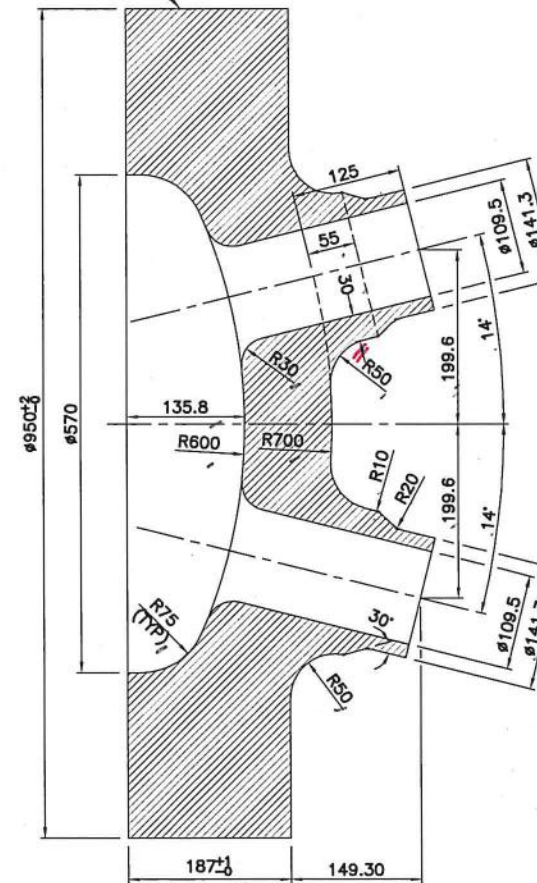


DRAWING NO. 3-16053-40879



VIEW-A

IDENTIFICATION NO. TO
BE PUNCHED HERE.

A

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 $\frac{1}{16}$ IN.
ROUND ALL INTERNAL CORNERS AND
EDGES TO R $\frac{1}{16}$ IN.
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	± 0.5
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 : 4-16503-40357

STATUS OF DRAWING

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

DISTRIBUTION OF PRINTS

CDE - 1 HCM - 4 FWM - 4

REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED
04	07/06/19	कमलेश गंगी	03	22/05/19	कमलेश गंगी	02	06/05/19	विमल कुमारा	01	05/05/19	विमल कुमारा
		CHECKED नागेन्द्र सिंह			CHECKED नागेन्द्र सिंह			CHECKED नागेन्द्र सिंह			
		APPROVED ए.के.माहौर			APPROVED ए.के.माहौर			APPROVED ए.के.माहौर			
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.				
CHANNEL HEAD FORGING (SEMI-FINISHED)											
3-16503-40879											

01	0950	001	CHANNEL HEAD	B.O.	SA350 LF2Cl.1	890.0
VAROQ	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	DRAWING NO.	UNIT WT.
QTY.-Nos						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&2/33311/2006/DD REV.00

EQUIPMENT NAME : REGENERATIVE COOLER

TAG NO : (3331-HX1)

भारत हेवी इलेक्ट्रिकल्स लिमिटेड भोपाल BHARAT HEAVY ELECTRICALS LTD BHOPAL	नाम/ NAME विजय कुमार कुशवाहा	हस्ता/ SIGN विजय कुमार	दिनांक/ DATE 08/03/2019	वे. रि. की संख्या NO. OF VAR.
विकास DEPT. CDE कोड 411	अनु. टोल. नाप की श्रेणी UNTOL. DIMS. GR. M AA0203208	अनुपात SCALE -	भार (कि.ग्रा.) WEIGHT (K.G.) 890.0	उपे. ड्राइंग का संदर्भ REF. TO ASSY. DRG. 3-16503-40871
ड्राइंग क्र./DRAWING NO. 3-16503-40879				
पृष्ठ क्र./SHT. NO. 01				