

DRAWING NO.



1. SUPPLY CONDITION : HEAT TREATED AND FINISH MACHINED ALL OVER.
2. ALL TECHNICAL AND TESTING REQUIREMENTS SHALL BE AS PER NPCIL APPROVED SPECIFICATION No.- BHEL/NPCIL/30599/CS-FORGINGS/CDE-19-3411.
3. NO REPAIRS/WELDING SHALL BE PERMITTED WITHOUT PRIOR APPROVAL OF NPCIL.
4. TEST COUPON FOR TESTING SHALL BE FORMED AS PER SPECIFICATION NO.- BHEL/NPCIL/30599/CS-FORGINGS/CDE-19-3411.
5. IDENTIFICATION TO BE STAMPED AT LOCATION SHOWN WITH FOLLOWING INFORMATION:
 - a). PURCHASE FORGING NUMBER.
 - b). HEAT NUMBER
 - c). BHEL PO NUMBER
 - d). MATERIAL DESIGNATION.
6. MATERIAL OF CONSTRUCTION : SA 350 LF2 CLASS-1.
7. TEMPORARY OIL BASED RUST PREVENTIVE TO BE APPLIED AFTER MACHINING ON ALL SURFACES.
8. ALL DIMENSIONS INDICATED ARE IN mm.
9. UNLESS OTHERWISE MENTIONED THE TOLERANCE ON LINEAR AND ANGULAR DIMENSIONS SHALL BE AS PER IS:2102.
10. THE SURFACE FINISH OF FORGINGS SHALL BE 3.2 OR BETTER.
11. ALL MACHINED SURFACES SHALL BE SUBJECTED TO MT/PT.

ZONE	DRAWING REVISED BASED ON NPCIL COMMENTS DTD. 11/06/2019.	ZONE	DRAWING REVISED BASED ON NPCIL COMMENTS DTD. 03/06/2019.
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DO NOT SCALE THE DRAWING.
UNLESS OTHERWISE STATED:-
ALL DIMENSIONS ARE IN mm.
MACHINE ALL OVER.
SURFACE FINISH TO BE $\sqrt{}$ OR BETTER.
REMOVE ALL BURRS.
REMOVE ALL EXTERNAL SHARP CORNERS
AND EDGES BY CHAMFERING TO $\frac{0.5}{\sqrt{2}} \pm 0.05$ mm.
ROUND ALL INTERNAL CORNERS AND
EDGES TO R $\frac{0.5}{\sqrt{2}} \pm 0.05$ mm.
TOLERANCES ON RADE AND CHAMFERS
(IS : 2102)

FEEDS AND CHAMFERS	0.5-3	3-8	8-30
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	
SPECIFIED DIMENSIONS	TOLERANCE
XX	± 0.40
XX.X	± 0.40
XX.XX	± 0.25

CDE - 1 HCM - 4 FWM - 4

ZONE	DRAWING REVISED BASED ON NPCIL COMMENTS DTD. 20/05/2019.
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01		Ø1410		001		PRIMARY HEAD						B.O.		A		2605.0			
												SA350 LF2Cl.1		KG					
VARO QTY.—Nos		REMARKS		VAR. NO.		ITEM NO.		DESCRIPTION		STD		DRAWING NO.		IT.NO.		MATL. CODE		UNIT WT.	
28 ——— CARD TYPE—3								28 ——— CARD TYPE—1						28 ——— CARD TYPE—2				QTY.	



एनपीसीआईएल
NPCIL

NPCIL DRAWING NO : GHAVP-1&2/33311/2010/11/DD REV.00

TAG NO : (3341-HX1,2,3,4)

CODE	AA0203208	-	2605.0	3-16503-40873	001	-
शीट क./TITLE				ड्राइंग नं./DRAWING NO.		पृष्ठ/REV

ड्रिंग नं./DRAWING NO.	पुन./REV
3-16503-40889	05

पृष्ठ क्र./SHT. NO. 01	पृष्ठों की संख्या/NO. OF SHT. 01
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