

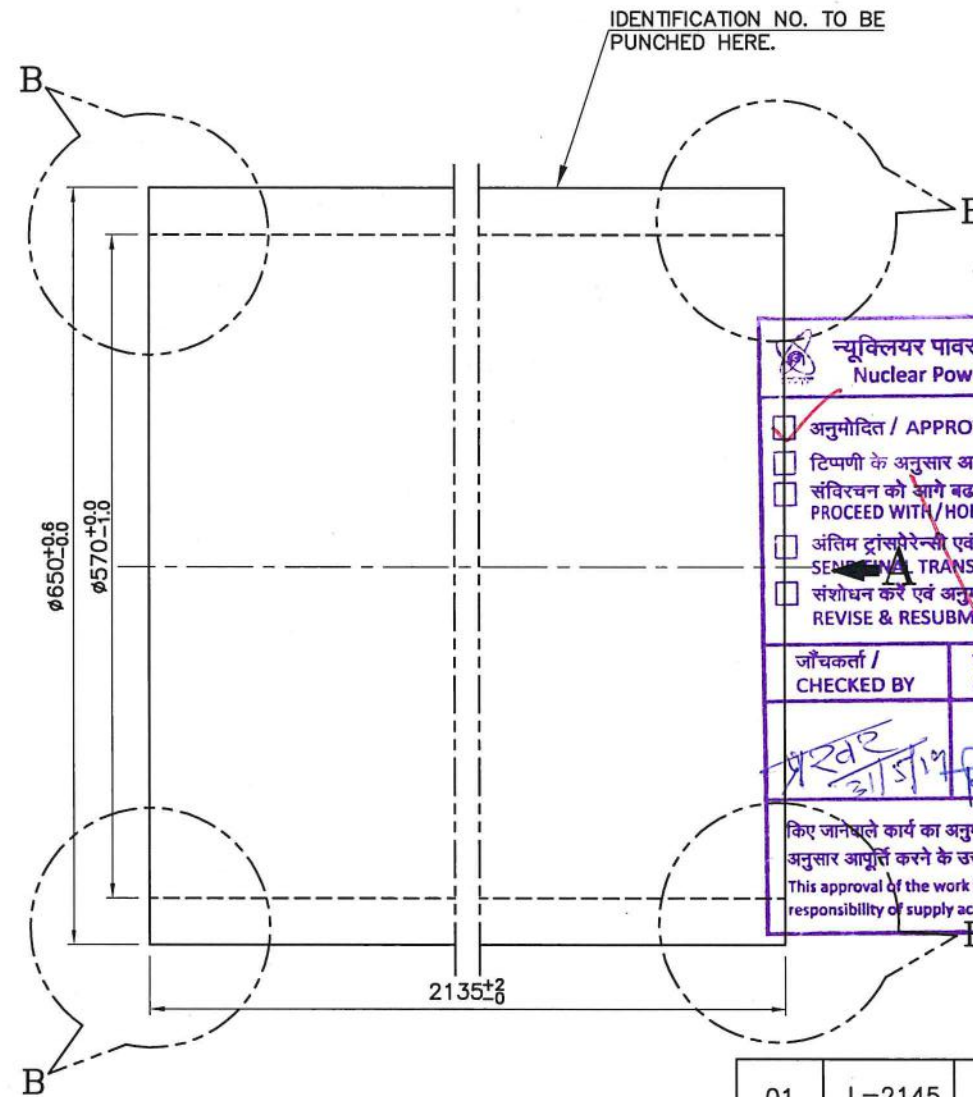
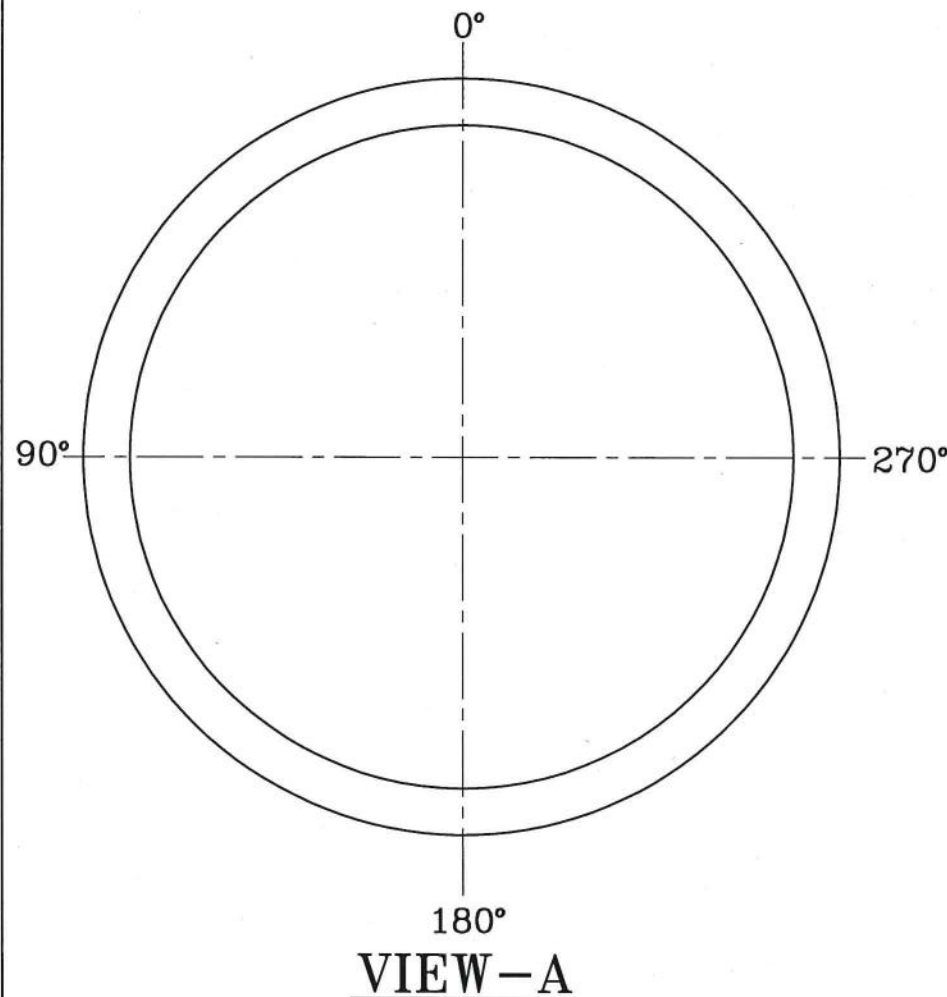
16804-89091-3

DRAWING NO.

FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN MM

Soft Copy rec on 31/5/19

IDENTIFICATION NO. TO BE
PUNCHED 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 / रोके / PROCEED WITH/HOLD FABRICATION		
☐ अंतिम दस्तावेजों एवं प्रतियों भेजें / SEND FINAL TRANSPARENCIES & PRINTS		
☐ संशोधन करें एवं अनुमोदन के लिए पुनः प्रस्तुत करें REVISE & RESUBMIT FOR APPROVAL		
जाँचकर्ता / CHECKED BY	समीक्षकर्ता / REVIEWED BY	अनुमोदन कर्ता / APPROVED BY
किए जानेवाले कार्य का अनुमोदन अपूर्णता संविदाकार को विनिर्देशनों के अनुसार अपूर्ण 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.		

EDGE PREPARATION
DETAIL - B

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 WELD EDGE & MACHINED SURFACES SHALL BE SUBJECTED TO MT/PT.
- FORGING SHALL BE AS CLOSED AS PRACTICABLE TO FINISHED FORGING SHAPE.

DO NOT SCALE THE DRAWING.
UNLESS OTHERWISE STATED:-
ALL DIMENSIONS ARE IN mm.
MACHINE ALL OVER.
SURFACE FINISH TO BE 3.2 OR BETTER.
REMOVE ALL BURRS.
REMOVE ALL EXTERNAL SHARP CORNERS
AND EDGES BY CHAMFERING TO 1.5 x 45°.
ROUND ALL INTERNAL CORNERS AND
EDGES TO R 1.5.
TOLERANCES ON RADI AND CHAMFERS
(IS : 2102)
TOLERANCES ON LINEAR DIMENSIONS (IS:2102)
TOLERANCES ON ANGULAR DIMENSIONS : 0°-0.5°

DIMENSIONS	TOL.	DIMENSIONS	TOL.
UP TO 3	±0.1	318 - 1000	±0.5
3 - 30	±0.2	1000 - 2000	±1.2
30 - 120	±0.3	2000 - 4000	±2.0
120 - 315	±0.5	4000 - 8000	±3.0

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	कमलेश गामीत	REV.	DATE	ALTERED	कमलेश गामीत
03	22/05/19	CHECKED	नागेन्द्र सिंह	02	06/05/19	CHECKED	नागेन्द्र सिंह
		APPROVED	ए.के.माहौर			APPROVED	ए.के.माहौर
ZONE	DRAWING REVISED BASED ON NPCIL COMMENTS DTD. 16/05/2019.			ZONE	DRAWING REVISED BASED ON NPCIL COMMENTS DTD. 16/04/2019.		

REV.	DATE	ALTERED	कमलेश गामीत	REV.	DATE	ALTERED	कमलेश गामीत
01	25/03/19	CHECKED	नागेन्द्र सिंह			CHECKED	नागेन्द्र सिंह
		APPROVED	ए.के.माहौर			APPROVED	ए.के.माहौर
ZONE	DRAWING REVISED BASED ON NPCIL COMMENTS DTD. 19/03/2019. TOLERANCE TABLE ADDED. DETAIL 'A' ADDED.						



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&2/33311/2002/DD REV.00

EQUIPMENT : REGENERATIVE COOLER
TAG NO : (3331-HX1)

विभाग DEPT. CDE	उत्प. टोल. नाप की त्रुटि UNTOL. DIMS. GR.	उत्पात 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	AA0203208	-	1288.0	3-16503-40874	001	-
शीर्षक/ TITLE				ड्राइंग क्र./DRAWING NO.	पृष्ठ क्र./SHT. NO. 01	पृष्ठों की संख्या/NO. OF SHT. 01
SHELL FORGING				3-16503-40891		03