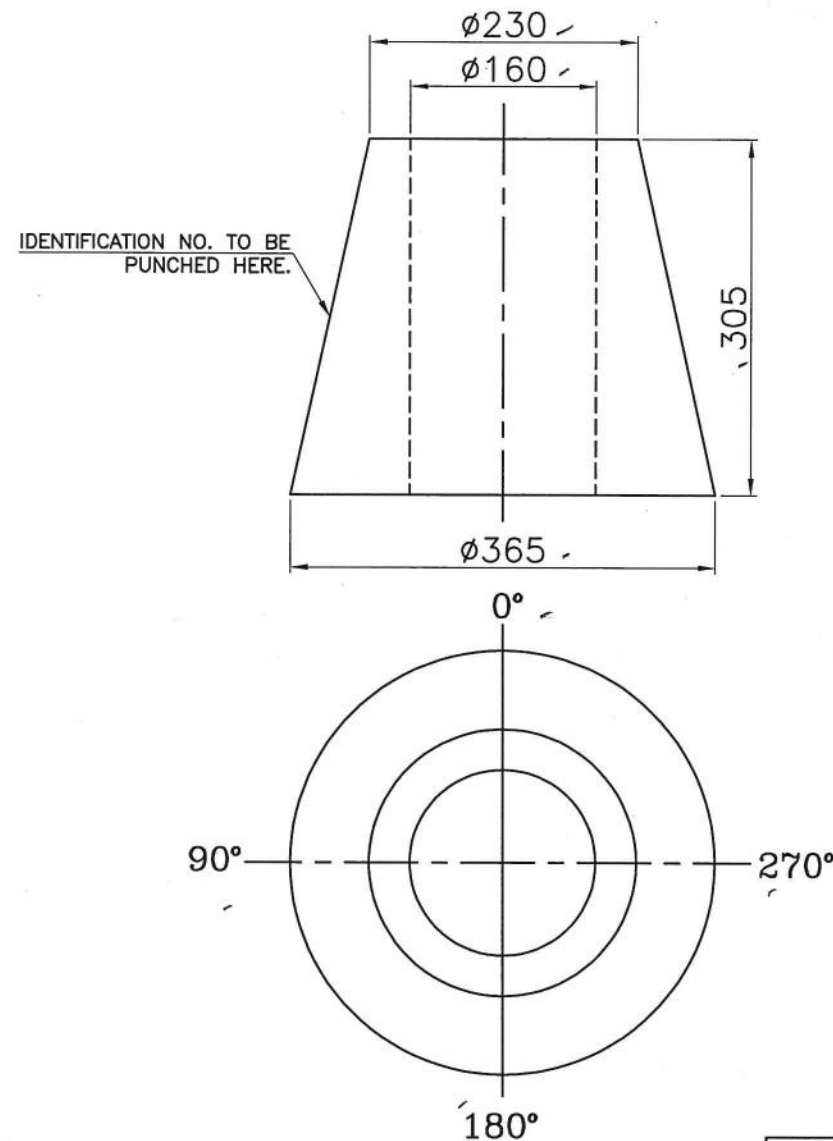


DRAWING NO. 3-16053-40893

Soft copy recd on 15/5/19



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 ट्रांसपैरेन्सी एवं प्रिंटिंग भेजें / SEND FINAL TRANSPARENCIES & PRINTS		
☐ संशोधन करें एवं अनुमोदन के लिए पुनः प्रस्तुत करें REVISE & RESUBMIT FOR APPROVAL		
जाँचकर्ता / CHECKED BY	समीक्षाकर्ता / REVIEWED BY	अनुमोदन कर्ता / APPROVED BY
प्रश्वर 16/5/19	प्रियदर्शन 16/5/19	अ.के.माहोर 16/5/19
किए जानेवाले कार्य का अनुमोदन आपूर्तिकर्ता संविदाकार को बिनिर्देशनों के अनुसार आपूर्ति 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.		

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 WELD EDGE & 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 $1.5 \times r$.
ROUND ALL INTERNAL CORNERS AND
EDGES TO R $\frac{1}{16}$.
TOLERANCES ON RADI AND CHAMFERS
(IS : 2102)
TOLERANCES ON RADI AND CHAMFERS
(IS : 2102)
TOLERANCES ON RADI AND CHAMFERS
(IS : 2102)

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 : 0°-0.5°			
ANGULAR DIMENSIONS	TOLERANCE	ANGULAR DIMENSIONS	TOLERANCE
0° - 30°	± 0.40	30° - 90°	± 0.40
90° - 120°	± 0.40	120° - 180°	± 0.40

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

01		001	NOZZLE FORGING		B.O.	121.0	
					SA350 LF2CL1		
VARO QTY.-No	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	DRAWING NO.	IT.NO. VAR.	MATL. CODE MATERIAL SPEC.
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&2/33311/2002/DD REV.00

EQUIPMENT NAME : REGENERATIVE COOLER

TAG NO : (3331-HX1)

विकास DRN.	कमलेश गामीत	हस्ता./SIGN	दिनांक/DATE	चे.रि. की संख्या NO. OF VAR.
जांचा CKD.	नागेन्द्र सिंह अरुण कुमार सिंह	नागेन्द्र सिंह अरुण कुमार सिंह	08/03/2019 08/03/2019	
अनुमोदित APPD.	ए.के.माहोर	ए.के.माहोर	08/03/2019	
विभाग DEPT. CDE	उत्त.तल. नाप की श्रेणी UNTOL. DIMS. GR.	अनुपात SCALE	भार (कि.ग्रा.) WEIGHT (K.G.)	उत्त. इकाई का संदर्भ REF. TO ASSY. DRG.
कोड CODE 411	AA0203208	-	121.0	3-16503-40874
शीर्षक/ TITLE	NOZZLE FORGING			
इकाई का संदर्भ DRAWING NO.				मद संख्या NO. OF ITEM
3-16503-40893				02
पृष्ठ क्र./ SHT. NO. 01		पृष्ठों की संख्या/ NO. OF SHT. 01		