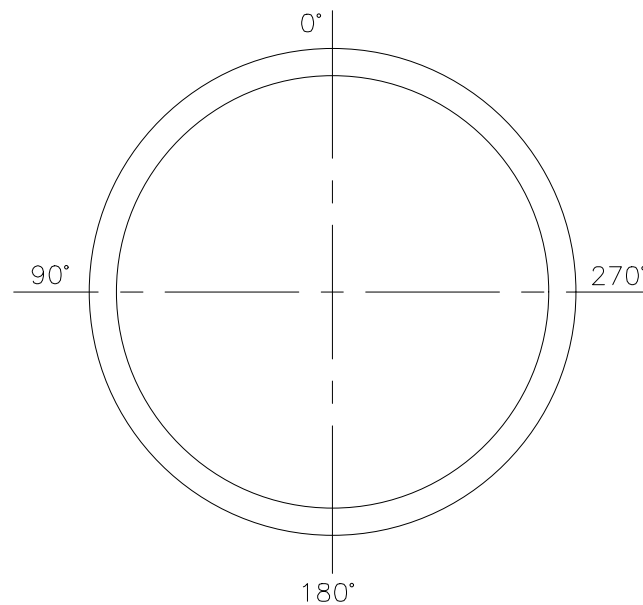
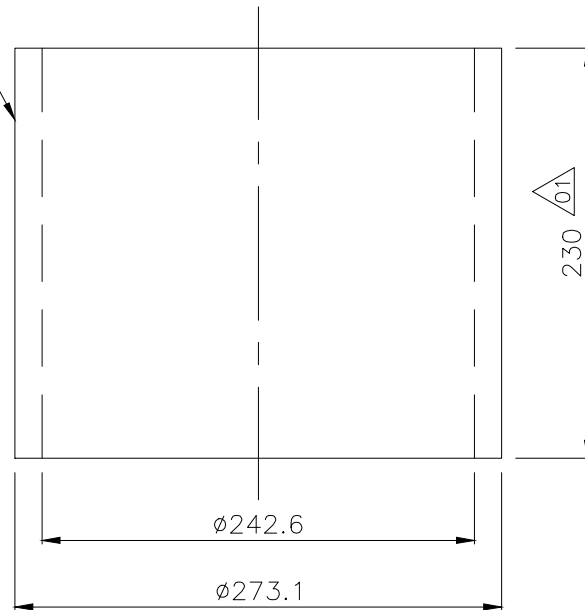


DRAWING NO.

IDENTIFICATION
TO BE STAMPED
HERE



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 SURFACE 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 $\sqrt{}$ OR BETTER.
REMOVE ALL BURRS.
REMOVE ALL EXTERNAL SHARP CORNERS
AND EDGES BY CHAMFERING TO $0.15 \pm 0.05 \times 45^\circ$.
ROUND ALL INTERNAL CORNERS AND
EDGES TO $R \ 0.40$.
TOLERANCES ON RADI AND CHAMFERS
(IS : 2102)

REDI AND CHAMFERS	0.5-3	3-6	6-30
TOLERANCES	± 0.2	± 0.1	± 0.1

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

02						001			NOZZLE FORGING N1,N2									B.O.			A			KG			22.0					
																		SA350 LF2C1.														
59	64	65	75	78	79	25	27	29	58	59	60	77	29	31	34	45	58	59	68	75	76	77	78	79	80	81	82	83	84	85		
VAROO QTY.-Nos			REMARKS			VAR. NO.			ITEM NO.			DESCRIPTION			DRAWING NO.			MATL. CODE			UNIT WT.			QTY.			ZONE					
28 → CARD TYPE-3						28 → CARD TYPE-1						28 → CARD TYPE-2																				



एनपीसीआईएल
NPCIL

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&2/33411/2011/DD REV.00

CDE - 1 HCM - 4 FWM - 4

EQUIPMENT NAME: INVENTORY ADDITION AND
RECOVERY SYSTEM (IARS) 3333 (HX-1)



बी एच ई एल
BHEL

भारत हेवी इलेक्ट्रिकल्स लिमिटेड
भोपाल
BHARAT HEAVY ELECTRICALS LTD
BHOPAL

	नाम/ NAME	हस्ता./SIGN	दिनांक/DATE	वे. र. की संख्या NO. OF VAR.
खनाया DRN.	महेन्द्र कुमार जायसवाल		25/06/2019	
जौंचा CKD.	नागेन्द्र सिंह	नगेन्द्र सिंह	27/06/2019	
जनुमोहित	ए.के. माहौर		28/06/2019	

REV.	DATE	ALTERED	महेन्द्र कुमार जायसवाल	
01	13.09.19	CHECKED	नागेन्द्र सिंह	
		APPROVED	ए.के. माहौर	

विभाग DEPT. CDE	अन.टल. नाप की श्रेणी UNTOL. DIMS. GR.
कोड CODE 411	



अनुपात SCALE	भार (किग्रा) WEIGHT (K)
1:100	22.0

असे. डाईंग का संदर्भ	
REF. TO ASSY. DRG.	
1-16503-40868	

मद क्र. ITEM NO.	मद संख्या NO. OF ITEM
—	—

ZONE	-DIM 230 WAS 166. -WEIGHT 22 WAS 16 kg -TR#11 DELETED.
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शीर्षक/ TITLE

NOZZLE FORGING – N1, N2

डाइंग क्र./DRAWING NO.

3-16503-40909

पुन./ REV.
02

पृष्ठ क्र./SHT. NO. 01

पृष्ठों की संख्या/NO. OF SHT. 01