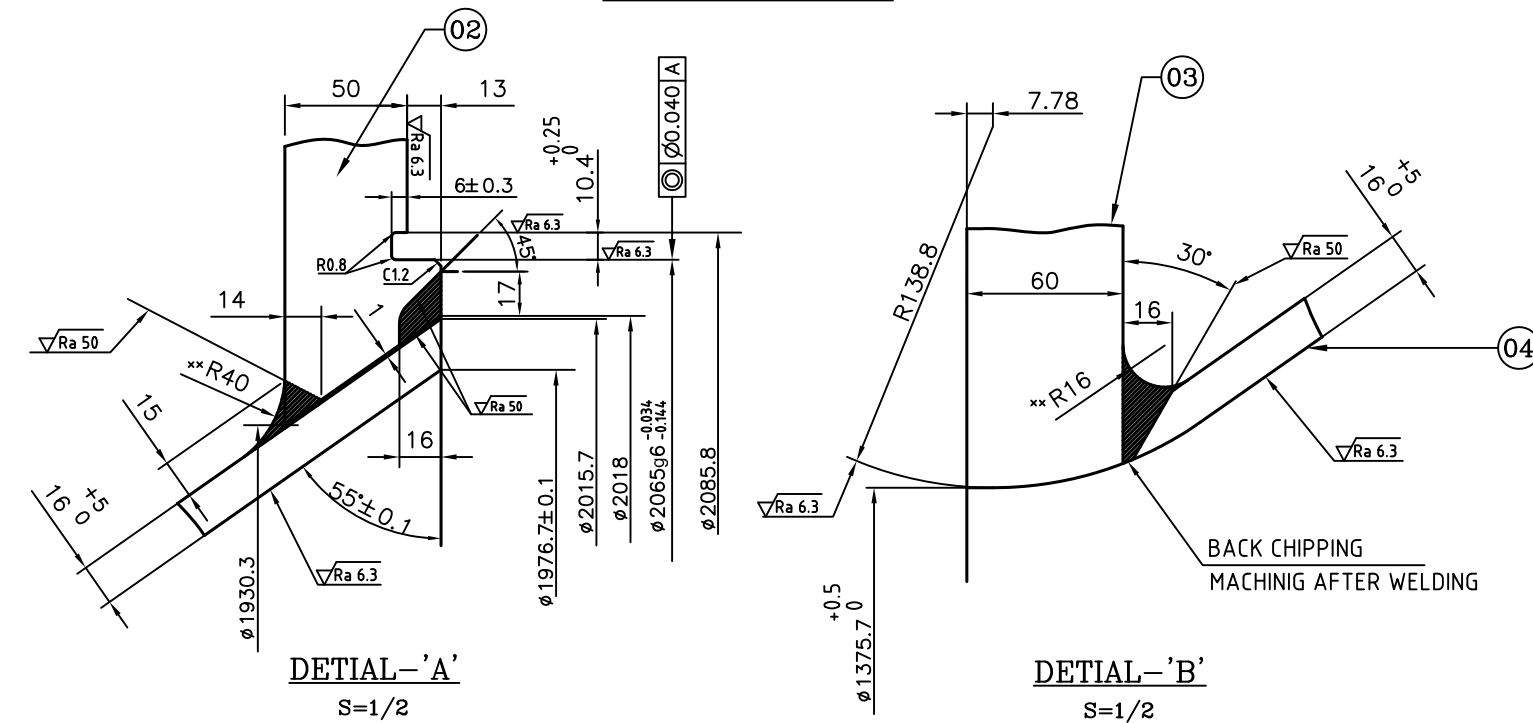




ITEM NO.4 & 5 - SS304

5) DIMENSIONS SHOWN ARE FINISH MACHINED DIMENSIONS. SUPPLIER SHALL SELECT SUITABLE MARGIN FOR RAW MATERIAL SIZES WHEREVER MACHINING IS SHOWN.

- 1) WELDING AS PER BHEL WELD PROCEDURE SPECN NO. WE-042
- 2) D.P.T SHALL BE DONE ON 100 % OF WELDS AS PER AA0850131 ACCEPTANCE AS PER AA0850129 LEVEL-IV
- 3) R.T TO BE CARRIED OUT ON 10 % OF BUTT WELDS AS PER ASME SEC VIII DIV I UW 51.
- 4) STRESS RELIEVING TO BE DONE AS PER HY0640763.
- 5) SHOT BLASTING TO BE DONE TO REMOVE SCALES, AFTER SHORT BLASTING ONE COAT OF PRIMER TO BE APPLIED WITHIN 2 HOURS.
- 6) WHEREVER NOT SPECIFIED, ALL SHARP EDGES TO BE CHAMFERED TO 2x45°
- 7) WHEREVER NOT SPECIFIED TOLERANCE ON MACHINED DIMENSIONS AS PER AA0230208 MEDIUM CLASS.

2) MACHINED SURFACES SHALL NOT BE PAINTED

1) TO BE PROPERLY PACKED AND DESPATCHED SUCH THAT NO DAMAGE IS CAUSED DURING HANDLING AND TRANSIT.

01	SUCTION LINER	21827114731			FP9714072255	985	
					ASTM A 743CF8+SS304		1
	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	MATERIAL CODE	NET WT.	GROSS WT.
					MATERIAL SPECN.	QUANTITY	

HYD

SAP

INFORMED CUSTOMER

FOLLOWING CONDITIONS APPLY

NOT OTHERWISE STATED...

1. HYDROLYSIS RESISTANCE TO UNSPECIFIED TOLERANCES.

2. CHAMFER M/CD SHARP EDGES 1.2 TO 1.0 AT 45°.

3. INTERNAL M/CD CORNER RADI 1 TO 0.7.

4. THE SURFACE ROUGHNESS WHEREVER NOT SHOWN SHALL BE TAKEN FROM THE SURFACE ROUGHNESS SHOWN OUT SIDE BACK SLASHES GIVEN AT THE TOP MOST RIGHT CORNER OF THE DRG.

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		78MN				
भी भारत हवी इलेक्ट्रिकल्स लिमिटेड భారత్ హెవీ ఎలక్ట్రికల్స్ లిమిటెడ్ భారత్ హెవీ ఎలక్ట్రికల్స్ లిమిటెడ్ HYDERABAD		NAME		SIGN.	DATE	NO.OF VAR.
		DRWL. SATISH			19.08.11	
		CHD. K.H.R.K			19.08.11	
		APPD. B.R.K			19.08.11	
DEPT.	SCALE	WEIGHT (KGS)	REF. TO ASSY DRG.		ITEM NO.	NO.OF ITEMS
CODE		1:8	985			

TITLE	DRAWING NO.	REV. 00
	21827114731	
	SHFT NO. NO OF SHEETS	