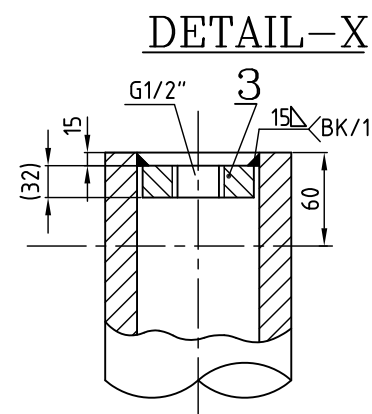


INVENTORY NO
SIGN. AND DATE
REF. DRG. NO.
COMPUTER FILE NAME
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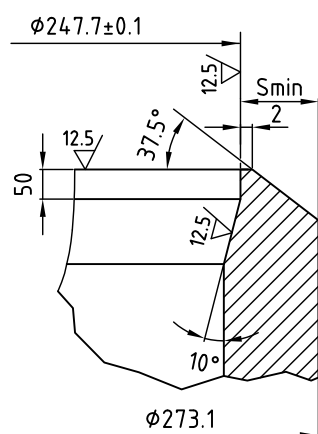
GENERAL DIMENSIONAL LIMITS, FITS & TOLERANCES AS PER HY0230261

DRG. NO. 3-308-59-00079

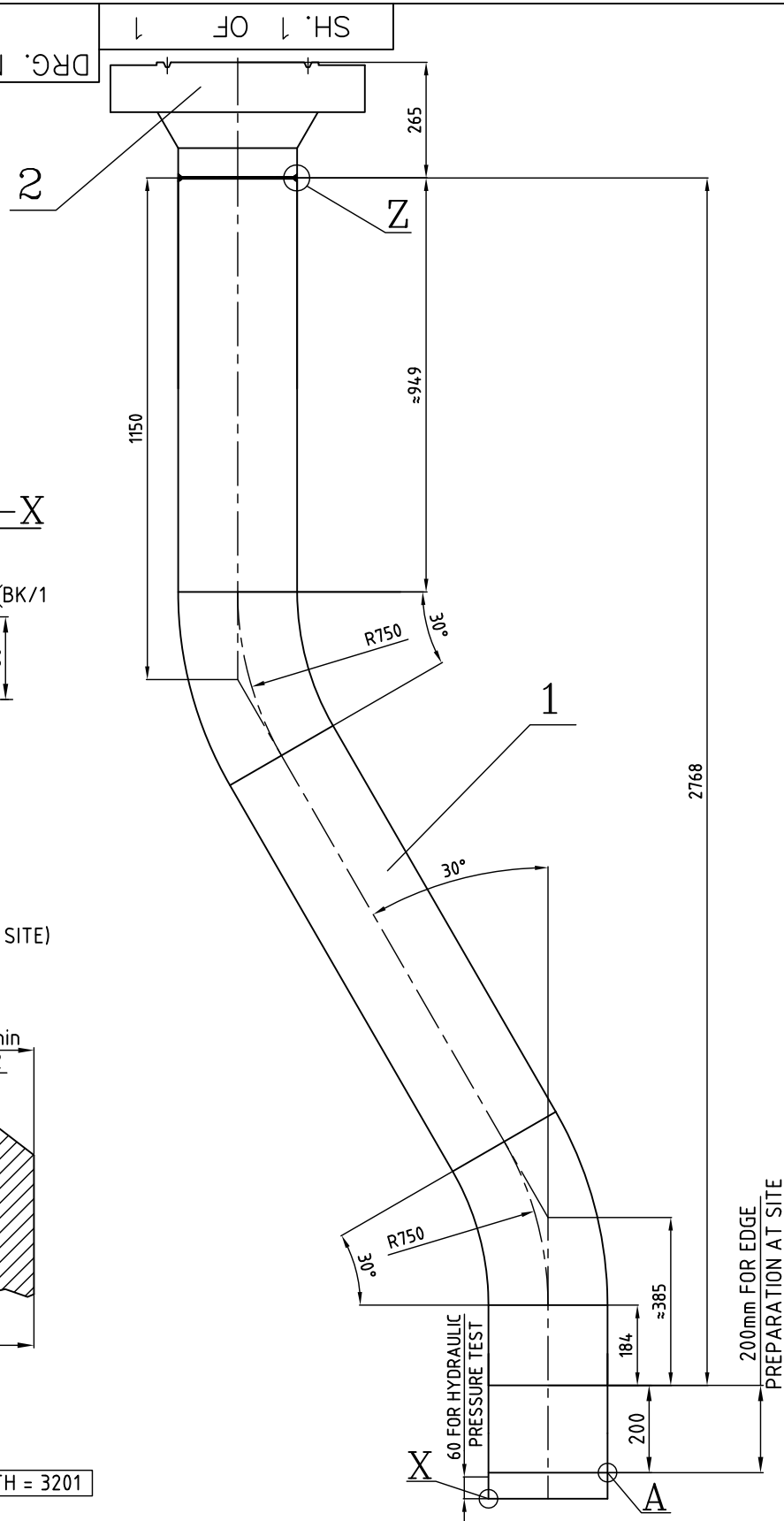
SH. 1 OF 1



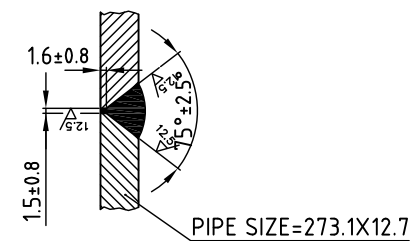
DETAIL-A
(FOR EDGE PREPARATION AT SITE)



PIPE DEVELOPED LENGTH = 3201



DETAIL-Z



NOTES:

- DESIGN PARAMETERS AS PER VARIANT TABLE.
- FLOW MEDIUM : STEAM
- HOT/COLD BENDING TEMP CONTROL SHALL BE AS PLANT STD: HY0640761
- PIPE THICKNESS OF Smin MENTIONED IN VARIANT TABLE TO BE MAINTAINED.
ULTRA SONIC TEST TO BE CONDUCTED AT BENT PORTION.
- HEAT TREATMENT OF BENDS AS PER PLANT STD: HY0640761.
- FUSION FACES (EDGE PREPARATION) AS PER PLANT STD: HY0620599
- 100% DP TEST TO BE CARRIED OUT FOR ALL FILLET WELDS ,
- GEN. QUALITY REQUIREMENTS FOR PIPING AS PRODUCT STD: TC 76001
- MPI TEST AS PER PLANT STD: HY0850197.
- CLEANING AND PAINTING OF PIPES SHELL BE AS PER PLANT STD: HY0674162,
PAINTING SCHEME 2V4(ALUMINIUM)
- TO BE HYDRAULICALLY PRESSURE TESTED AS MENTIONED IN VARIANT TABLE.
- PIPE MATERIAL:SA 335 GrP91,MATL.SPECIFICATION:AA10634.
- FOR WELDING DETALS REFER DRG.NO:3-31300-00484(2 SH.)
- MANUFACTURING TOLERANCES :-
ON BENDING ANGLE : ± 0.5°
ON DIMENSIONS : ± 10mm

50 ata./540°C	75 ata	12.7	00
DESIGN PARAMETERS.	HYDRAULIC TEST PRESSURE	Smin	VAR

TYPE OF PRODUCT OR
NAME OF CUSTOMER/PROJECT

 BHARAT HEAVY ELECTRICALS LTD. HYDERABAD		NAME	SIGN.	DATE	NO.OF VAR.
		DRN.	MEERAVALI	28.04.16	
		CHD.	PATIL	28.04.16	-N.A.-
DEPT. I.T.D.		APPD.	ASHOK	28.04.16	
CODE 415	UNTOL. DIMS. GR. -G/M/F-	SCALE N.T.S	WEIGHT (KG) 477.8	REF. TO ASSY. DRG. -N.A.-	ITEM NO. -N.A.-
TITLE PIPE BEND (10") LEFT-S		CARD CODE N.A.	DRAWING NO. 3-308-59-00079		REV. 00
		SHT. No 1		NO. OF SHT. 1	