

39880-199-90-8

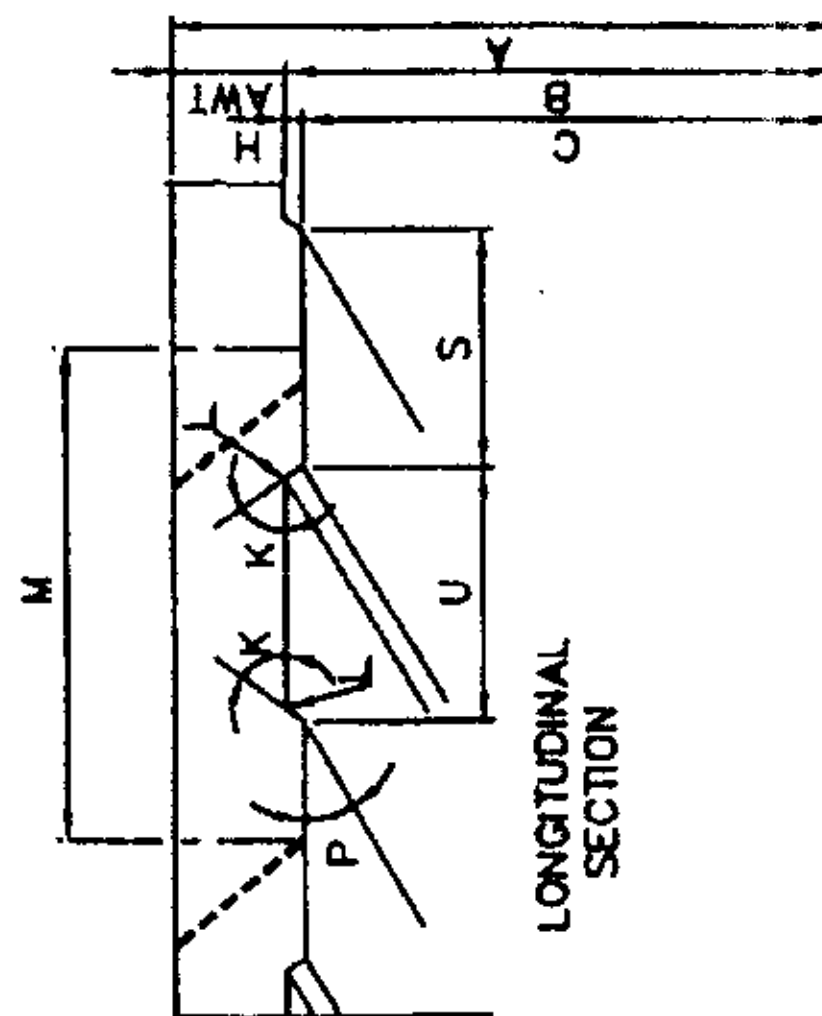
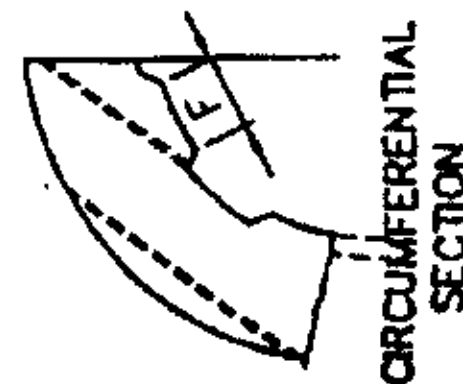
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DIMENSIONAL SPECIFICATION FOR MULTI-RIFFLED TUBING

FOR TOLERANCES OF UNTOLERANCED
DIMENSIONS DURING MANUFACTURE
REFER PLANT STANDARD TP 023 0299

MATERIAL SPECIFICATION : SA 210 GrC

↓ PARAMETERS	TUBE SIZE →	TUBE #51x5.6	TUBE #51x6.0	TUBE #51x7.1	TUBE #63.5x7.1	TUBE #63.5x11	TUBE #63.5x12
A	TUBE OUTSIDE DIAMETER	51.00 ±0.25	51.00 ±0.25	51.00 ±0.25	63.50 ±0.30	63.50 ±0.30	63.50 ±0.30
B	MAJOR INSIDE DIAMETER	38.57 ±0.25	37.68 ±0.25	35.24 ±0.25	47.74 ±0.30	39.08 ±0.30	36.86 ±0.30
C	MINIMUM INSIDE DIAMETER	35.57	34.71	32.30	44.53	36.03	33.85
D	MINIMUM WALL THICKNESS	5.6	6.0	7.1	7.1	11	12
E	NUMBER OF RIBS	8	8	8	8	8	8
F	RIP WIDTH AT TOP (NOMINAL) (CIRCUMFERENTIAL)	4.78	4.78	4.78	4.78	4.78	4.78
H	RIB HEIGHT	1.07 ±0.30	1.06 ±0.30	1.04 ±0.30	1.15 ±0.30	1.07 ±0.30	1.05 ±0.30
K	RIB-SIDE ANGLE	55° ±15°	55° ±15°	55° ±15°	55° ±15°	55° ±15°	55° ±15°
L	RIB RADIUS	0.13-1.27	0.13-1.27	0.13-1.27	0.13-1.27	0.13-1.27	0.13-1.27
M	RIB PITCH	26.23 ±3.18	25.62 ±3.18	23.97 ±3.18	32.46 ±3.18	26.57 ±3.18	25.06 ±3.18
N	LEAD LENGTH (360°)	209.8 ±25.4	205.0 ±25.4	191.8 ±25.4	259.7 ±25.4	212.6 ±25.4	200.5 ±25.4
P	LEAD ANGLE (NOMINAL)	30°	30°	30°	30°	30°	30°
S	RIB WIDTH AT TOP (LONGITUDINAL)	8.28 ±1.27	8.28 ±1.27	8.28 ±1.27	8.28 ±1.27	8.28 ±1.27	8.28 ±1.27
U	GROOVE WIDTH AT TOP (LONGITUDINAL)	17.95 ±1.90	17.34 ±1.90	15.69 ±1.90	24.18 ±1.90	18.29 ±1.90	16.78 ±1.90



ITEM	DESCRIPTION	DRAWING NUMBER	MATERIAL CODE	UNIT WEIGHT
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TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT



Bharat Heavy Electricals Ltd
UNIT: HIGH PRESSURE BOILER PLANT
TIRUCHIRAPALLI - 620014

305-005
121
NTS

PROJECTION SCALE
WEIGHT (Kg)
REF TO ASBY / OLD DWS

DATE
12.9.91
10.2.99
12.2.99

REVISION
R.MORALI
M.SOMU
P.S.GURU

DRAWING NO :
3-06-651-03853

TITLE
DIM. SPEC. FOR
MULTI-RIFFLED TUBING

REV

REV
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ALTERED :
CHD & APPD:

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