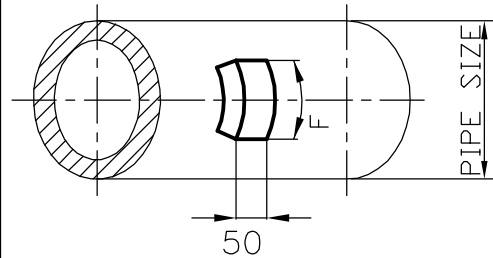
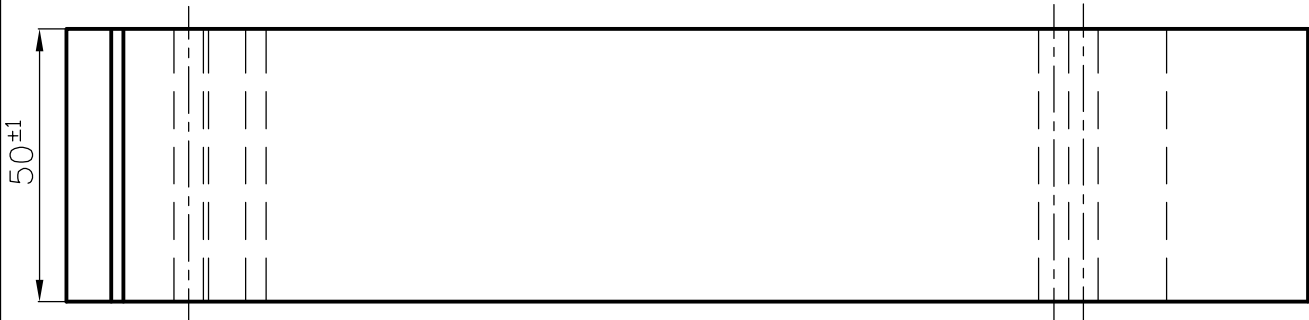
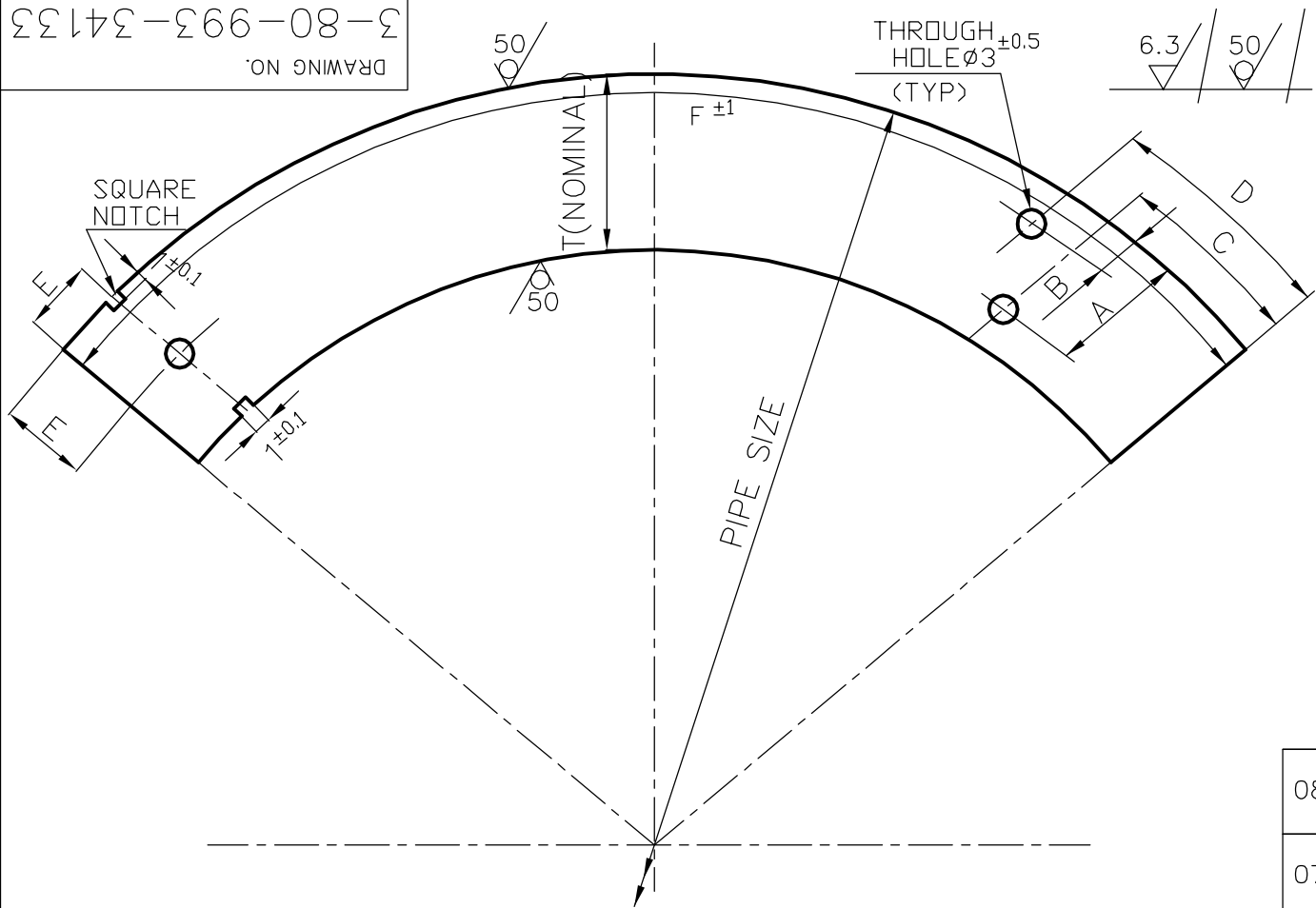


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VAR NO	PIPE SIZE	A	B	C	D	E	F	T(NOM)
01	ID240X75	56	19	75	94	38	225	75
02	ID300X104	78	26	104	130	52	312	104
03	ID360X112	84	28	112	140	56	336	112
04	ID600X46	35	12	46	58	23	203	46
05	ID440X30	23	8	30	38	15	203	30
06	OD457X112	78	26	104	130	52	312	104
07	OD219.1X51	38	13	51	64	26	203	51
08	ID460X77	58	19	77	96	39	231	77

- NOTES:
01. THE BLOCK HAS TO BE CUT FROM PIPE AS SHOWN IN THE FIGURE TO ENSURE ORIENTATION WITH RESPECT TO PIPE AXES.
 02. INNER & OUTER SURFACE OF THE PIPES SHALL NOT BE MACHINED.
 03. TOLERANCES FOR HOLE LOCATION: PLUS OR MINUS 0.8mm.
 04. CUT BITS FROM THE SHOP MAY ALSO BE UTILIZED.
 05. SUITABLE MACHINING ALLOWANCES / PRECAUTIONS ARE TO BE CONSIDERED WHILE CUTTING FROM PIPE.
 06. DEPTH OF SQUARE NOTCH HAS TO BE UNIFORMLY 1mm BOTH INSIDE AND OUTSIDE FOR THE FULL LENGTH OF 50mm.
 07. BLOCKS ARE TO BE CALIBRATED AT BHEL-TRY LABORATORY OR NABL APPROVED METROLOGY LABORATORY.
 08. AFTER CALIBRATION ALL MACHINED SURFACES ARE TO BE COATED WITH SUITABLE RUST PREVENTIVE.

08	08	PIPE ID460X77 L=70	3-80-993-34133		15 083 604 6000	C	7.777
					SA106GRC		1
07	07	PIPE OD219.1X51 L=70	3-80-993-34133		15 097 032 5000	C	3.968
					SA335P92		1
06	06	PIPE ID300X104 L=70	3-80-993-34133		15 097 040 5500	C	11.143
					SA335P92		1
05	05	PIPE ID440X30 L=70	3-80-993-34133		15 097 031 6000	C	2.241
					SA335P92		1
04	04	PIPE ID600X46 L=70	3-80-993-34133		15 097 037 5500	C	3.539
					SA335P92		1
03	03	PIPE ID360X112 L=70	3-80-993-34133		15 097 027 6500	C	15.204
					SA335P92		1
02	02	PIPE ID300X104 L=70	3-80-993-34133		15 097 040 5500	C	10.149
					SA335P92		1
01	01	PIPE ID240X75 L=70	3-80-993-34133		15 097 026 6000	C	5.337
					SA335P92		1
VAR NO.	ITEM NO.	DESCRIPTION	DRAWING NUMBER	ITEM NO	MATERIAL CODE	A	UNIT WEIGHT
				VAR NO	MATERIAL SPECN	C	QUANTITY



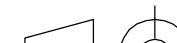
BHARAT HEAVY ELECTRICALS LTD.,
PIPING CENTRE, CHENNAI, 600 017

	NAME	SIGN	DATE
DRN	KONDAPANAIDU		15.11.2017
CHD	KONDAPANAIDU		15.11.2017
APPD	R.SESHAGIRI		15.11.2017

REV 02	DATE	ALTERED	REV 01	DATE	ALTERED RP SINGH
		APPROVED			APPROVED KONDAPA NAIDU

DRAWING REVISED AS MARKED

ALL REVISIONS ARE INDICATED AS

DEPT.	GRADE OF UN TOL DIM		SCALE	WEIGHT (Kg).	REF.TO ASSY / OLD DRG.	
CODE	C/M/F		N.T.S.	--		
TITLE				<u>CARD</u> CODE	DRAWING No.	REV
UT REFERENCE BLOCK P92 CIRCUMFERENTIAL				U 01	3-80-993-34133	01