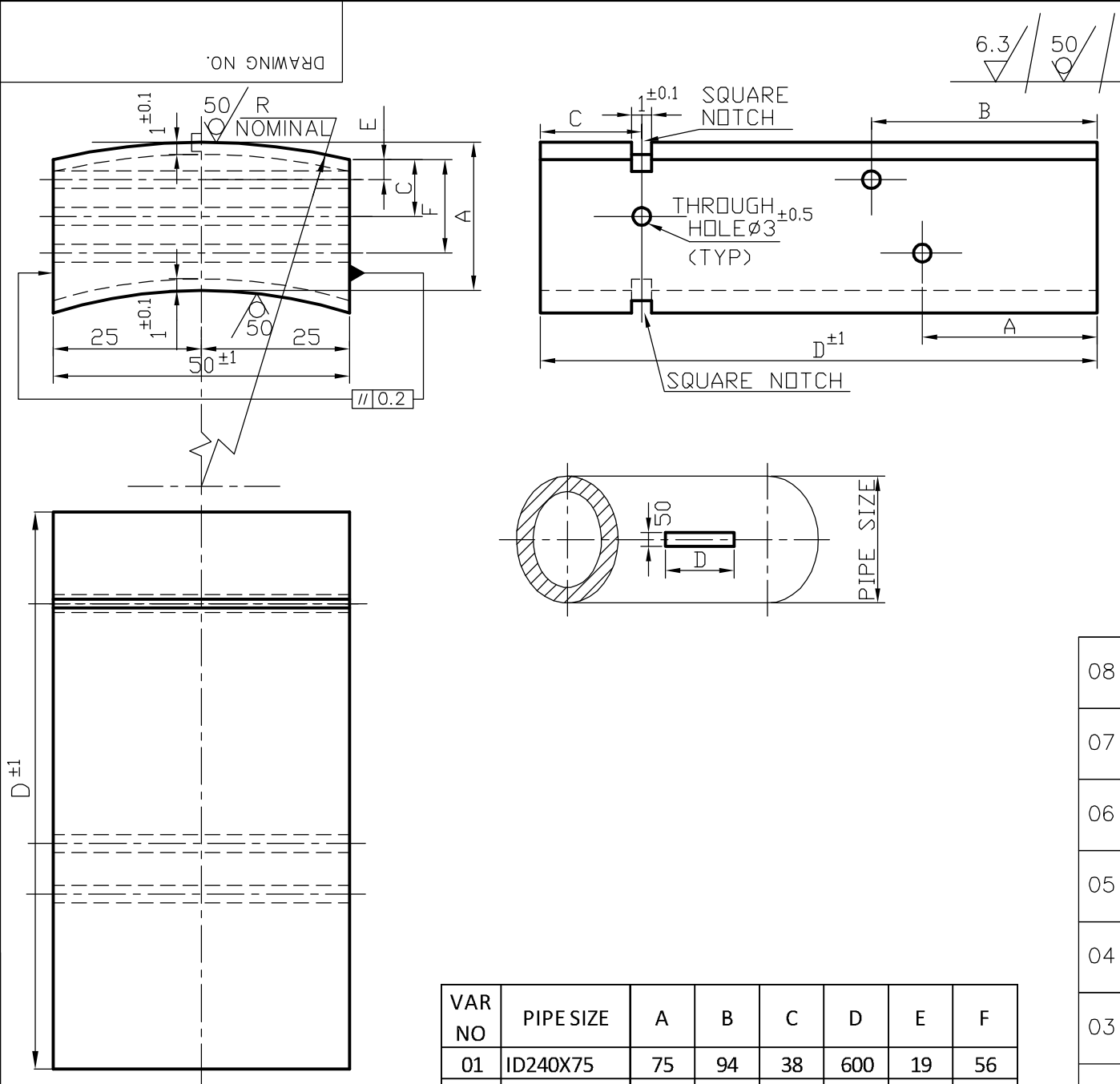


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CAUTION



VAR NO	PIPE SIZE	A	B	C	D	E	F
01	ID240X75	75	94	38	600	19	56
02	ID300X104	104	130	52	832	26	78
03	ID360X112	112	140	56	896	28	84
04	ID600X46	46	58	23	368	12	35
05	ID440X30	30	38	15	240	8	23
06	OD457X112	104	130	52	832	26	78
07	OD219.1X51	51	64	26	408	13	38
08	ID460X77	77	96	39	616	19	58

01

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 NABL APPROVED METROLOGY LABORATORY.
08. AFTER CALIBRATION ALL MACHINED SURFACES ARE TO BE COATED WITH SUITABLE RUST PREVENTIVE.

08	08	PIPE ID460X77 L=616	3-80-993-34137	15 083 604 6000	C	18.167
				SA106GRC		1
07	07	PIPE OD219.1X51 L=408	3-80-993-34137	15 097 032 5000	C	8.167
				SA335P92		1
06	06	PIPE ID300X104 L=832	3-80-993-34137	15 097 040 5500	C	39.388
				SA335P92		1
05	05	PIPE ID440X30 L=240	3-80-993-34137	15 097 031 6000	C	2.826
				SA335P92		1
04	04	PIPE ID600X46 L=368	3-80-993-34137	15 097 037 5500	C	6.644
				SA335P92		1
03	03	PIPE ID360X112 L=896	3-80-993-34137	15 097 027 6500	C	39.388
				SA335P92		1
02	02	PIPE ID300X104 L=832	3-80-993-34137	15 097 040 5500	C	33.962
				SA335P92		1
01	01	PIPE ID240X75 L=600	3-80-993-34137	15 097 026 6000	C	17.662
				SA335P92		1
VAR NO.	ITEM NO.	DESCRIPTION	DRAWING NUMBER	ITEM NO	MATERIAL CODE	UNIT WEIGHT
				VAR NO	MATERIAL SPECN	QUANTITY



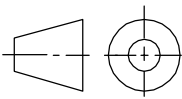
BHARAT HEAVY ELECTRICALS LTD.,
PIPING CENTRE, CHENNAI, 600 017

NAME	SIGN	DATE
DRN KONDAPANAU		16.11.17
CHD KONDAPANAU		16.11.17
APPD R.SESHAGIRI		16.11.17

REV 01	DATE 22.06.19	ALTERED RP SINGH APPROVED KONDAPA NAIDU
		DRAWING REVISED AS MARKED

DEPT.

GRADE OF
UN TOL. DIM
C/M/F



SCALE

N.T.S.

WEIGHT (Kg).

--

REF.TO ASSY / OLD DRG.

TITLE

CARD
CODE

DRAWING No.

REV

U 01

ALL REVISIONS ARE INDICATED AS

01