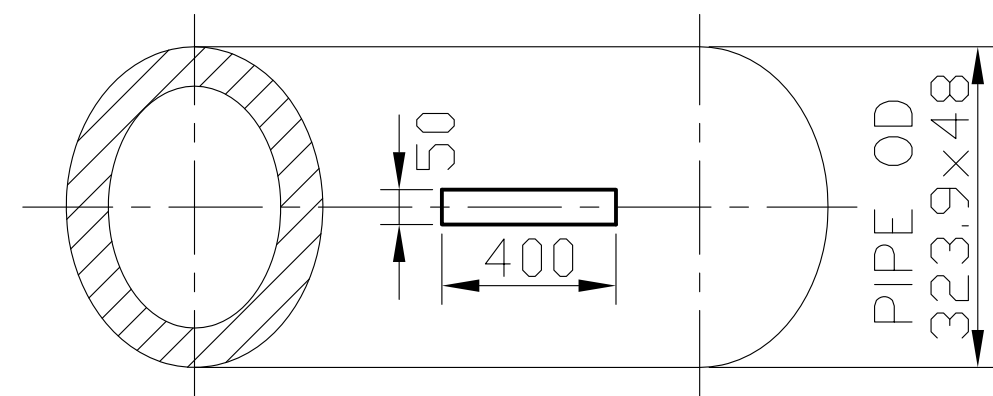
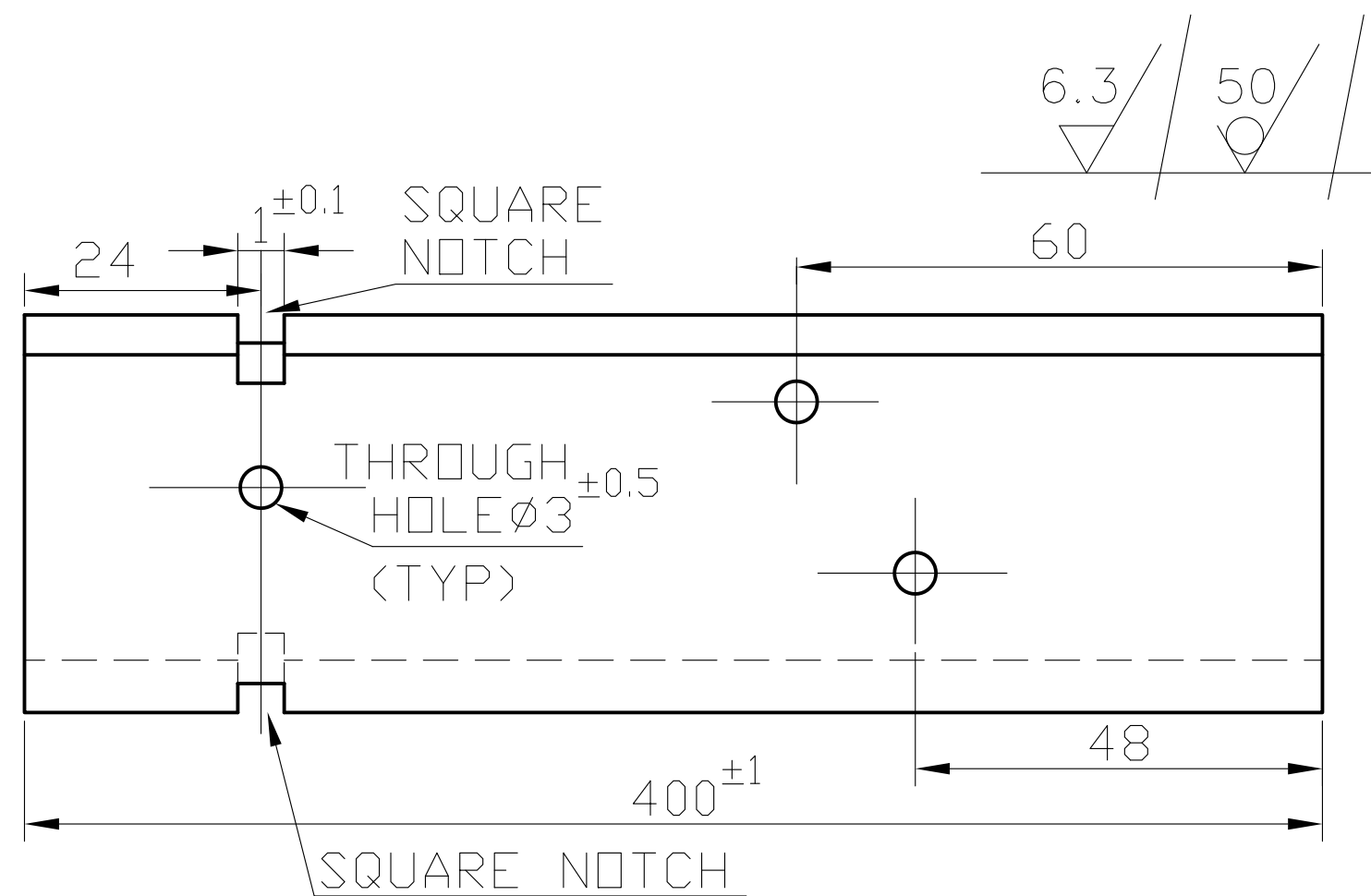
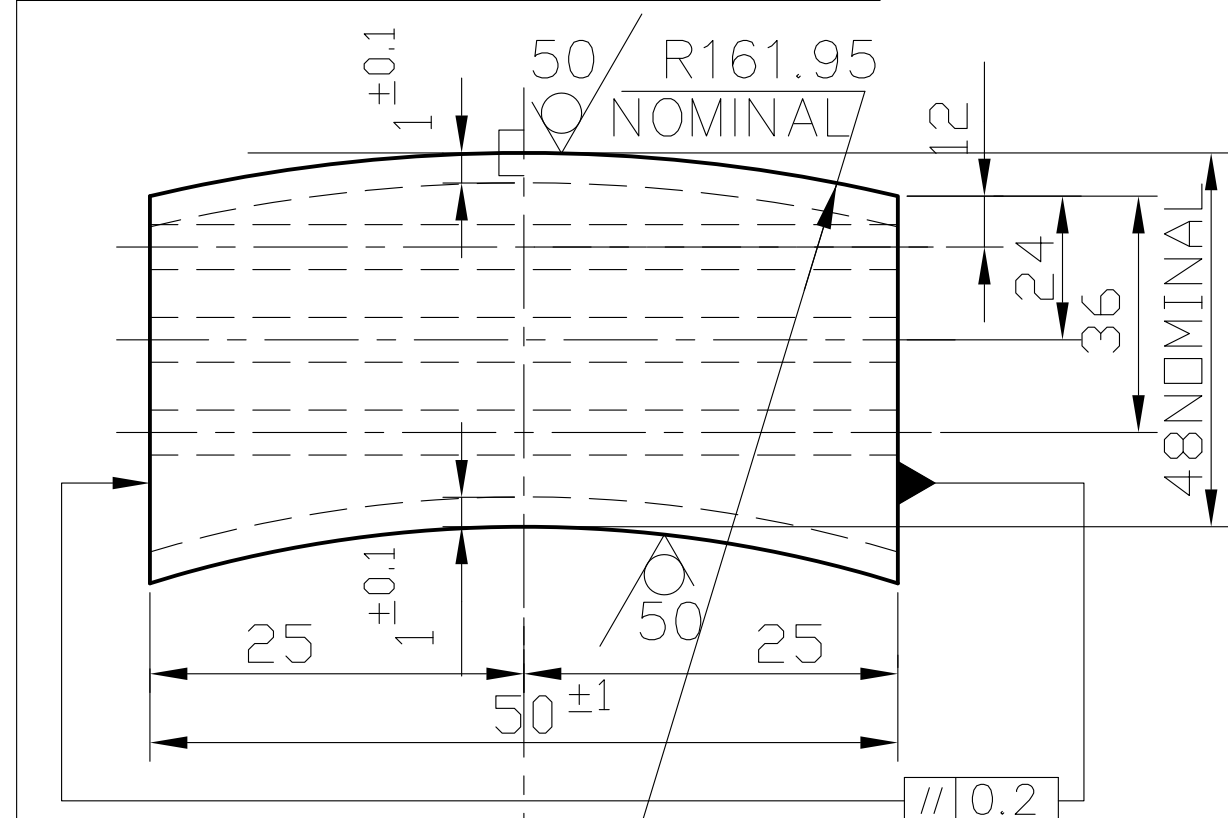


DRAWING NO.



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. FOR CIRCUMFERENTIAL BLOCK RFEER STD DRG 3-80-999-97834.
08. FOR HARDNESS REFERENCE BLOCK RFEER STD DRG 3-80-999-97721.
09. FINISHED AXIAL BLOCK CODE No.
10. BLOCKS ARE TO BE CALIBRATED AT NABL APPROVED METROLOGY LABORATORY.
11. AFTER CALIBRATION ALL MACHINED SURFACES ARE TO BE COATED WITH SUITABLE RUST PREVENTIVE.

STANDARD

		PIPE OD323.9x48 L=420	3-80-999-97833		15 958 162 6000	P	7.912
					SA335P91		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	LALIT		01.06.2011
		CHD	G.PANNER SELVAM		01.06.2011
		APPD	A.P.MADHAVAN KUTTY		01.06.2011

	REV 01	DATE	ALTERED	DEPT.	GRADE OF UN TOL. DIM		SCALE	WEIGHT (Kg).	REF.TO ASSY / OLD DRG.	
			APPROVED	CODE	C/M/F		N.T.S.	7.912		
					TITLE UT REFERENCE BLOCK P91 AXIAL (323.9x48)				CARD CODE U 01	DRAWING No. 3-80-999-97833