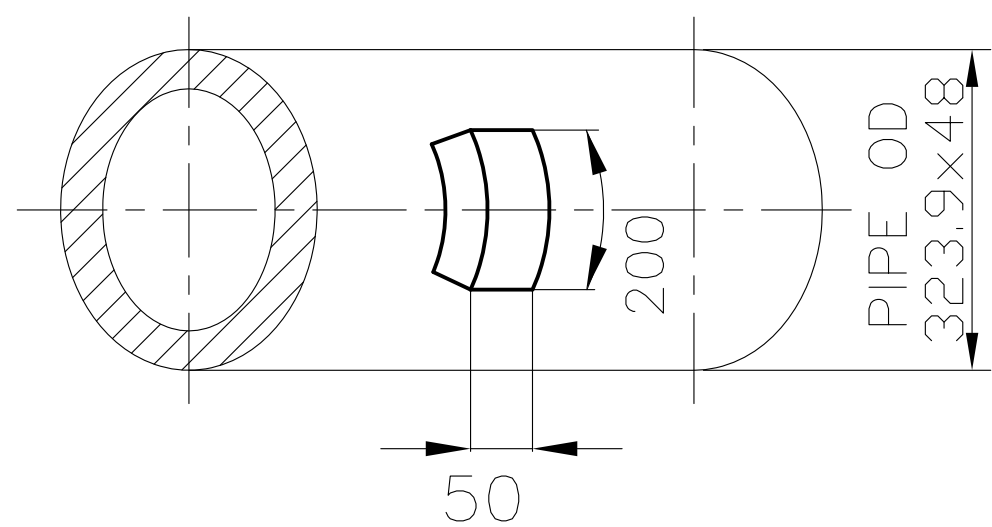
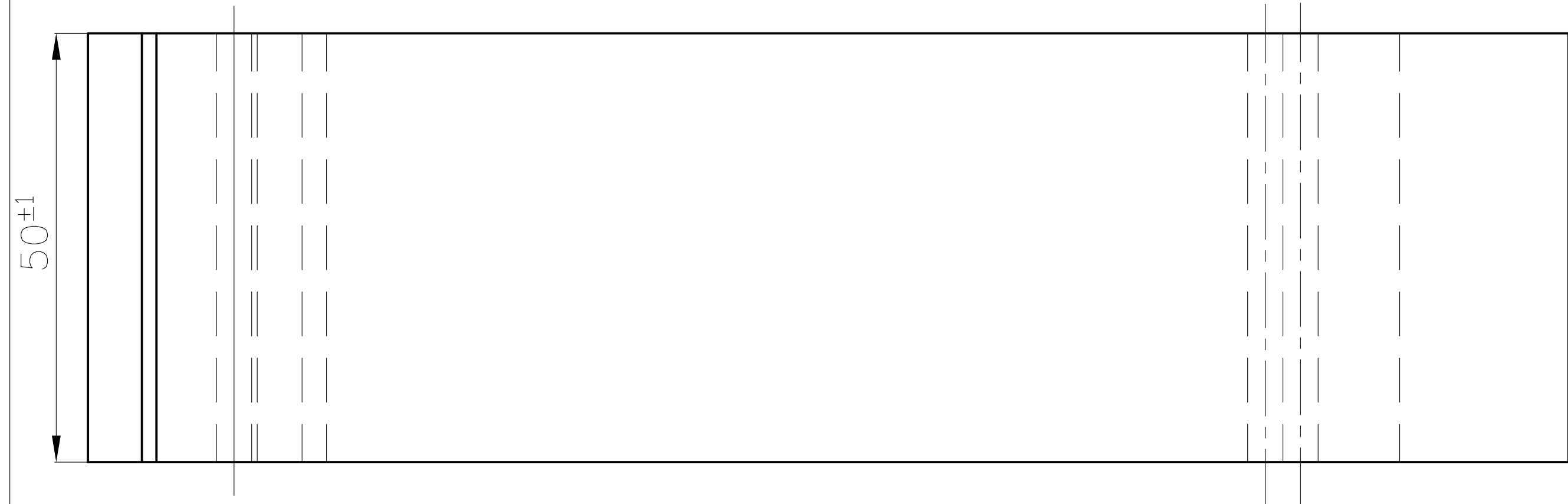
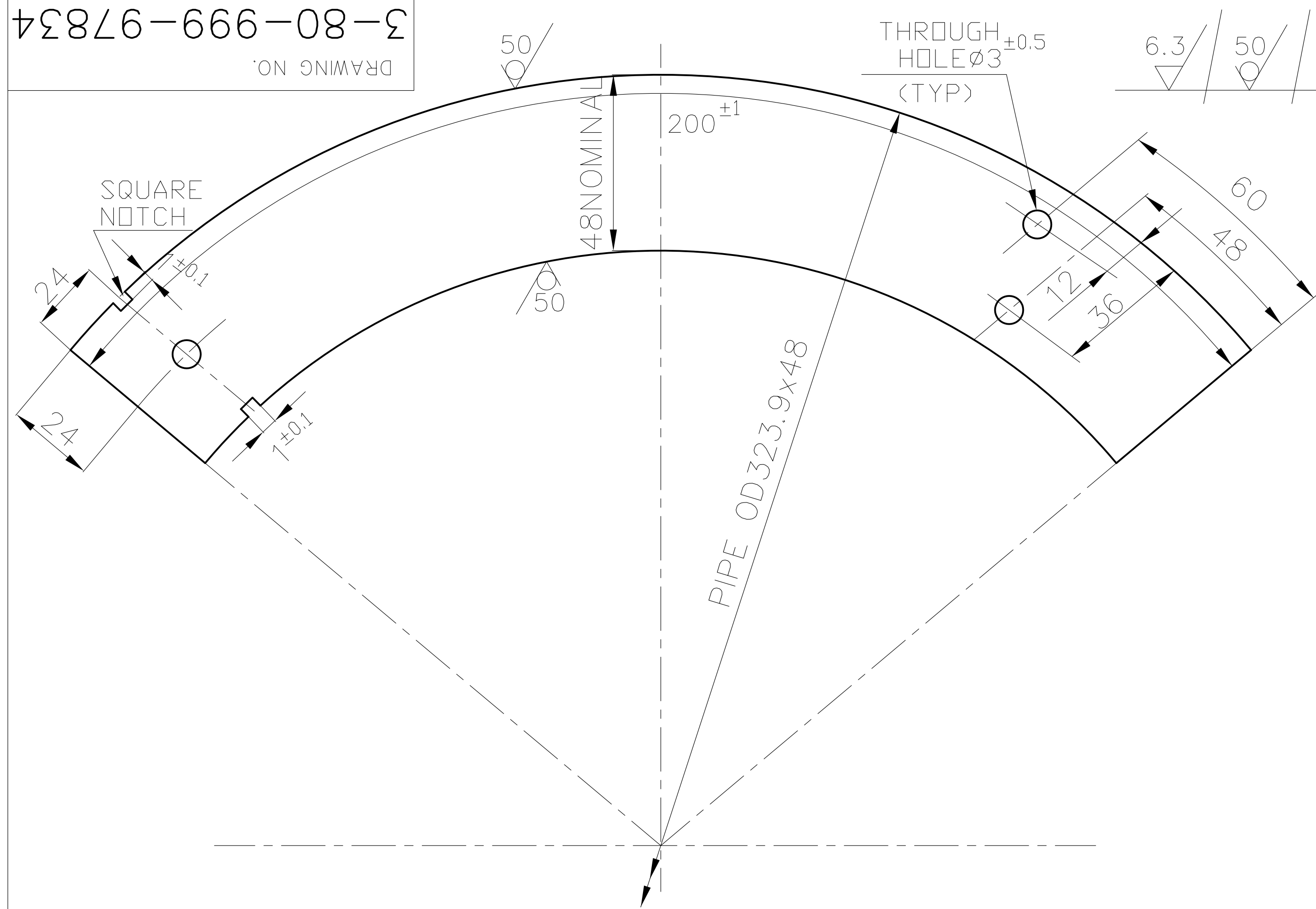


CAUTION

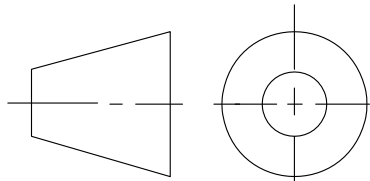
DRAWING NO.



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 AUXIAL BLOCK RFEER STD DRG 3-80-999-97833.
08. FOR HARDNESS REFERENCE BLOCK RFEER STD DRG 3-80-999-97721.
09. FINISHED CIRCUMFERENTIAL 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=200	3-80-999-97834		15 958 162 6000	P	3.768
					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.,		NAME		SIGN		DATE	
		PIPING CENTRE, CHENNAI, 600 017		DRN	LALIT			01.06.2011	
				CHD	G.PANNER SELVAM			01.06.2011	
				APPD	A.P.MADHAVAN KUTTY			01.06.2011	
DEPT.	GRADE OF UN TOL. DIM		SCALE	WEIGHT (Kg).	REF.TO ASSY / OLD DRG.				
CODE	C/M/F		N.T.S.	3.768					
TITLE				CARD CODE	DRAWING No.				REV
UT REFERENCE BLOCK P91 CIRCUMFERENTIAL (323.9x48)				U 01	3-80-999-97834				00