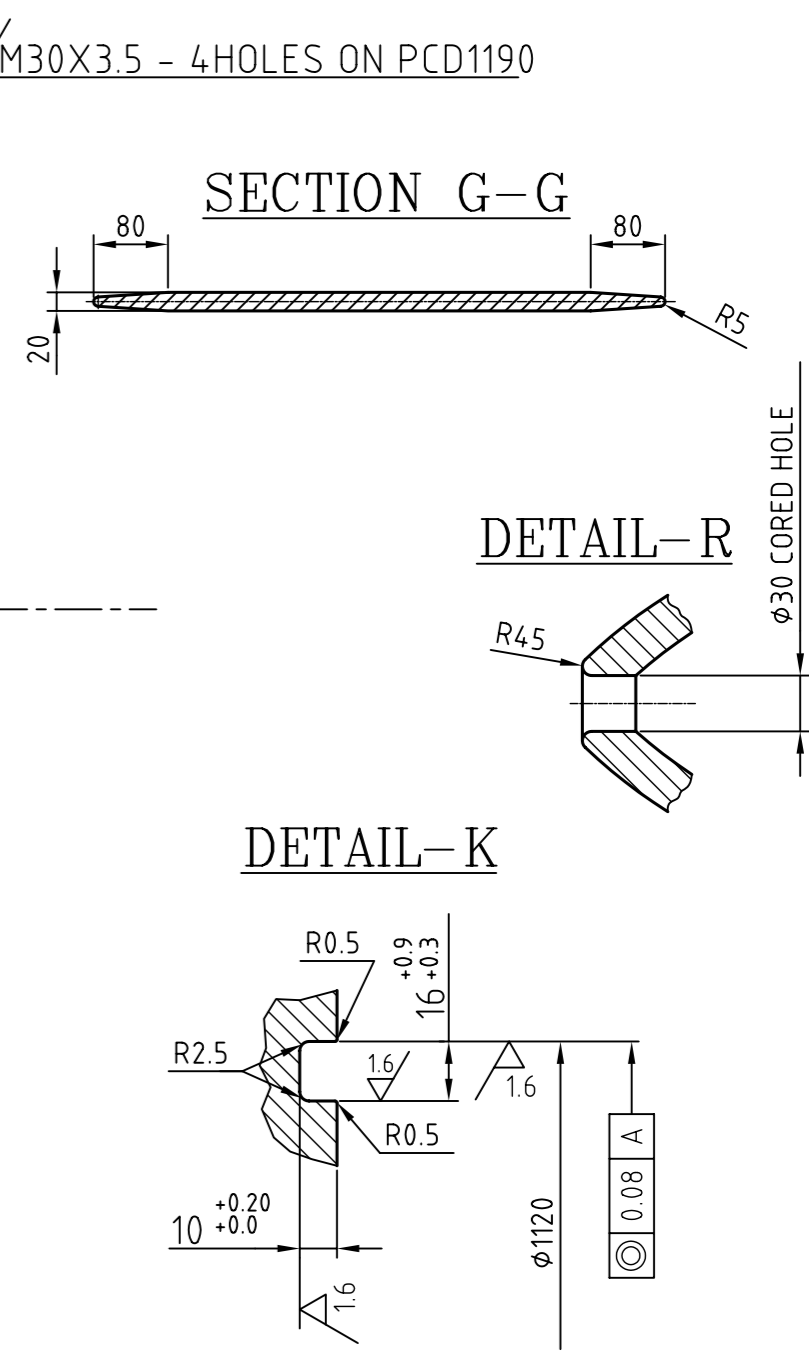
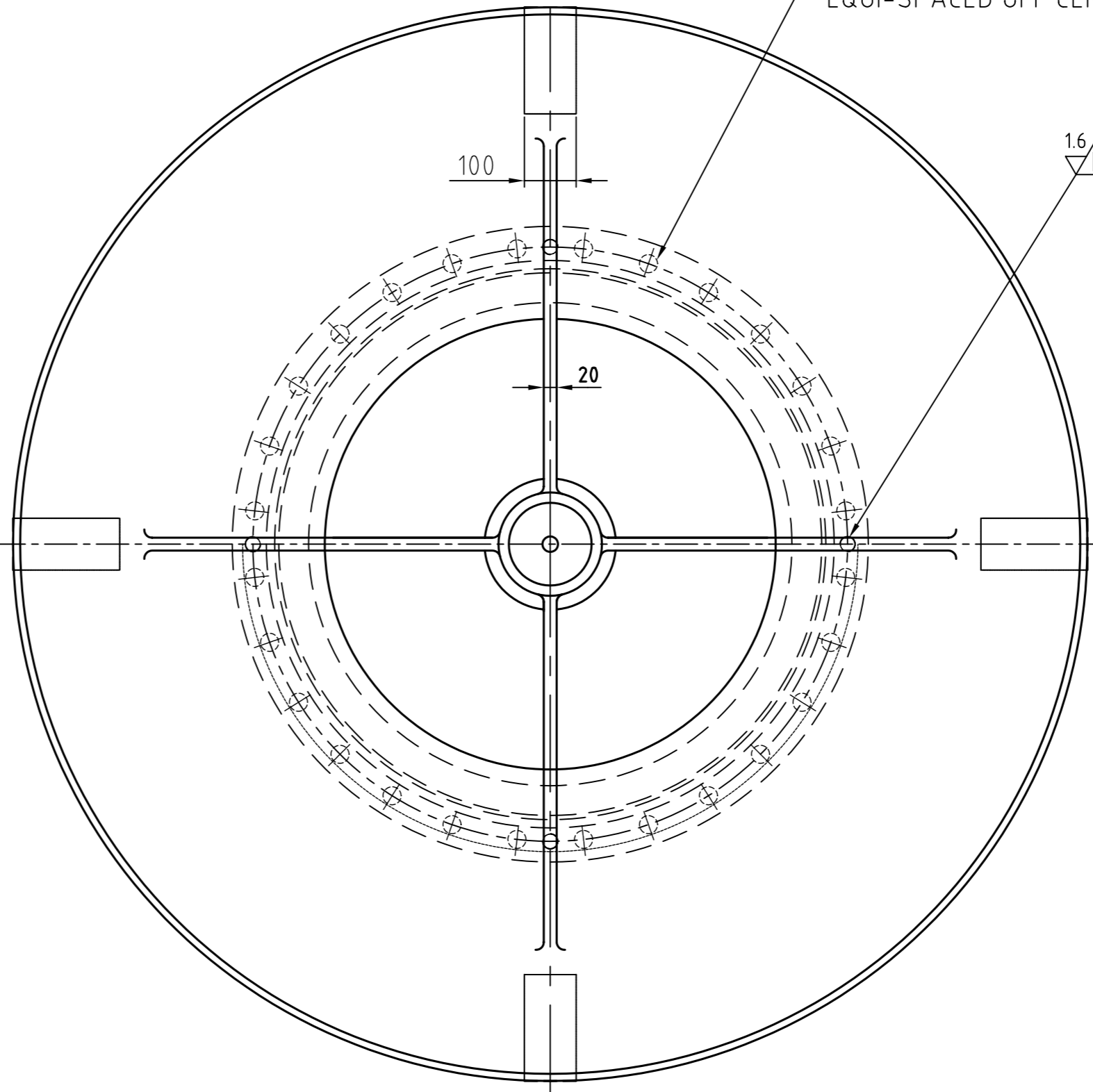
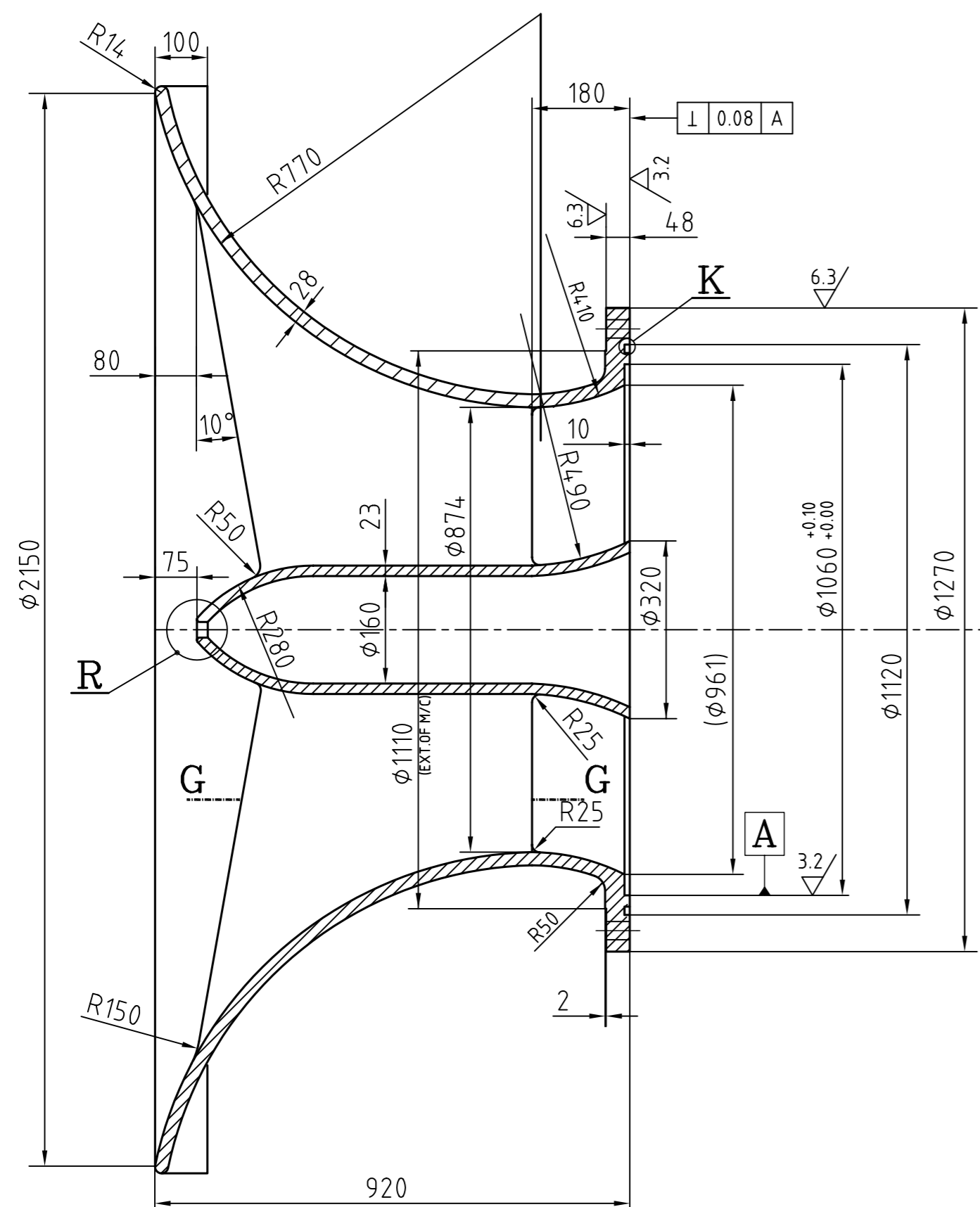


DRGNO. 2 182 36 1 5011

16/ 6.3/ 3.2/ 1.6/



THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

NOTE TO SUPPLIER

- COMPONENT SHALL BE SUPPLIED STREE RELIEVED & FINISH MACHINED AS PER DRG.DIMNS.
- VISUAL EXAMINATION AS PER MSS SP 55. 100% CHECKING TO BE DONE. (TO BE DONE AS PER PROCESS STD. NO. AA0674111)
- PRESSURE TESTING TO BE DONE AT 7.5 Kg/Sq.Cm FOR 30 MINUTES DURATION

PAINTING:-

- ALL MACHINED SURFACES SHALL BE COATED WITH SUITABLE RUST PREVENTIVE COAT AS PER CATERGORY "B" OF HY049563.
- ALL SURFACES SHALL BE PAINTED WITH 2 COATS (30 MICRON THICK) OF CHEMICAL RESISTANT EPOXIDE PRIMING PAINT AS PER AA56105.
- FINISH PAINTING SHALL BE DONE ON ALL SURFACES WITH 2 COATS (EACH 30 MICRON THICK) OF HIGH BUILD BLACK COAL TAR EPOXIDE PAINT AS PER AA56135.

TOLERANCES ON DIMENSIONS (NOT TOLERANCED IN THE DRAWING):-

AS CAST DIMENSIONS AS PER AA0230402 CLASS 3 & MACHINED DIMENSIONS AS PER AA0230208 MEDIUM CLASS CASTING SHALL NOT HAVE ANY SHARP CORNERS.

PACKING AND DESPATCH:-

TO BE PROPERLY PACKED AND DESPATCHED SUCH THAT NO DAMAGE IS CAUSED DURING HANDLING AND TRANSIT.

CERTIFICATES TO BE FURNISHED BY THE SUPPLIER:-

- MECHANICAL PROPERTIES
- PRESSURE TESTING
- DIMENSIONAL CHECK ON CASTING
- PRESSURE TESTING
- STRESS RELIEVING

FP9711072050	1510	
AA19703+2%Ni	1	
MATERIAL CODE	NET WT.	GROSS WT.
MATERIAL SPECN.	QUANTITY	

REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED
ZONE		CHECKED	ZONE		CHECKED	ZONE		CHECKED	ZONE		CHECKED
1			2			3			4		

ITEM NO	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	MATERIAL SPECN.	QUANTITY
	THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED...	TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT	CW1Q KHAPERKEDA 500MW			
	1. REF.TO HY0230261 FOR UNSPECIFIED TOLERANCES.	DRN.	NAME	SIGN	DATE	NO.OF VAR.
	2. CHAMFER M/CD SHARP EDGES 1.2 TO 1.0 AT 45°.	CHD.	A.SATISH	[Signature]	30.07.08	
	3. INTERNAL M/CD CORNER RADII 1 TO 0.7.	APPD.	K.H.R.K	[Signature]	30.07.08	
	4. THE SURFACE ROUGHNESS WHEREVER NOT SHOWN SHALL BE TAKEN FROM THE SURFACE ROUGHNESS SHOWN OUT SIDE BACK SLASHES GIVEN AT THE TOP MOST RIGHT CORNER OF THE DRG.	DEPT.	BHARAT HEAVY ELECTRICALS LTD. HYDERABAD		REF. TO ASSY DRG.	ITEM NO.
		410	[Logo]		N.A	N.A
			SCALE	WEIGHT(Kg)	DRAWING NO.	REV.
			NTS	1510	2 182 36 1 5011	00
			TITLE	SHEET NO.	NO OF SHEETS	
			SUCTION CASING			