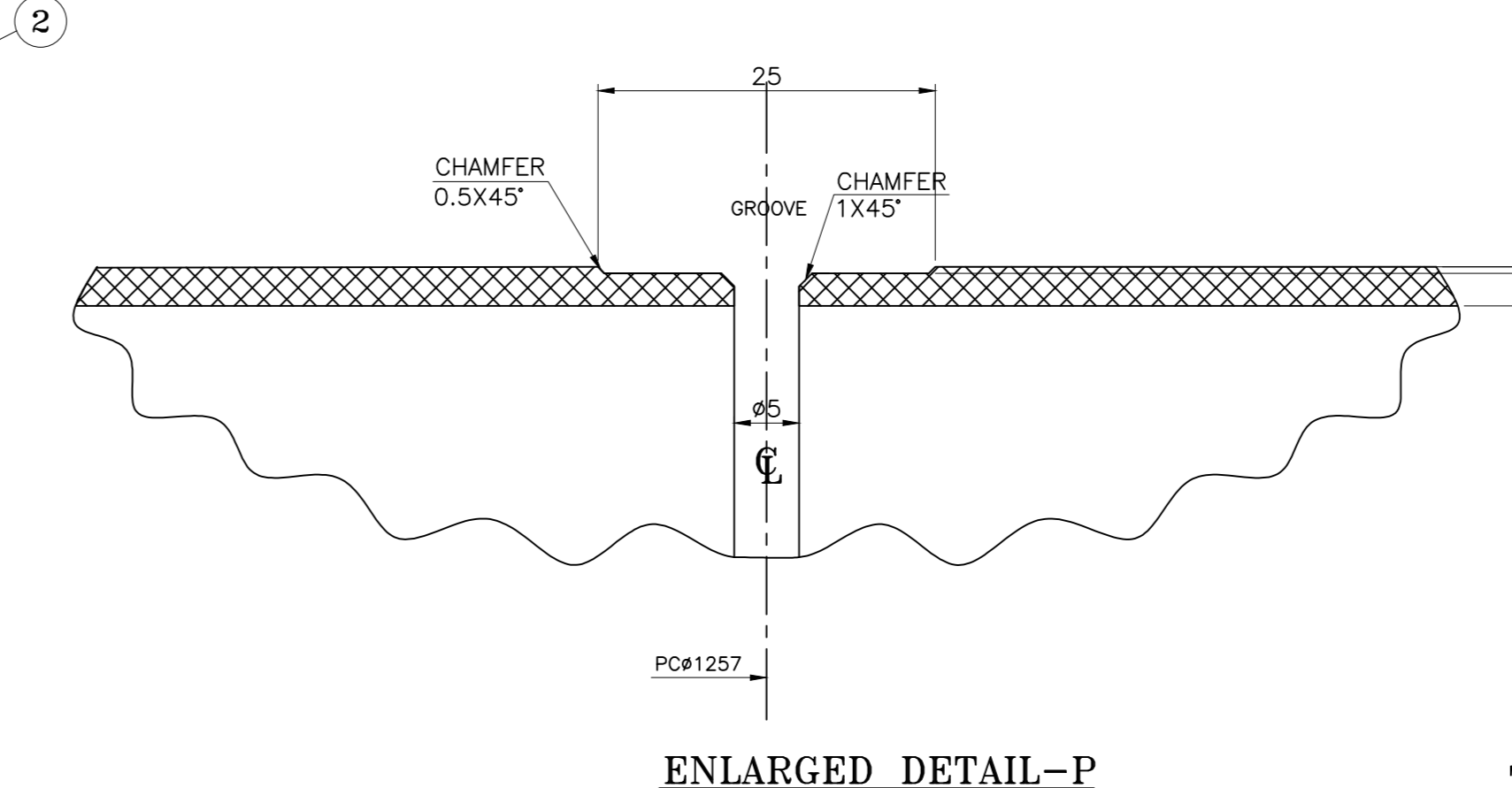
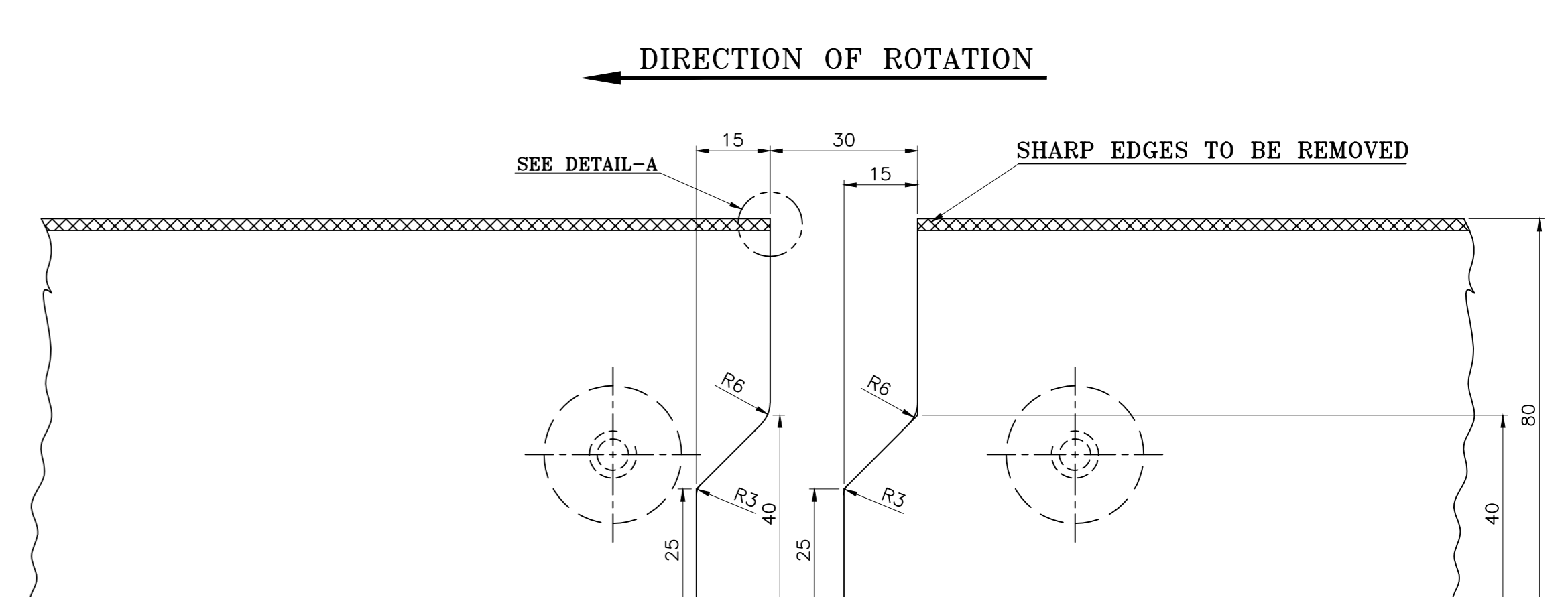
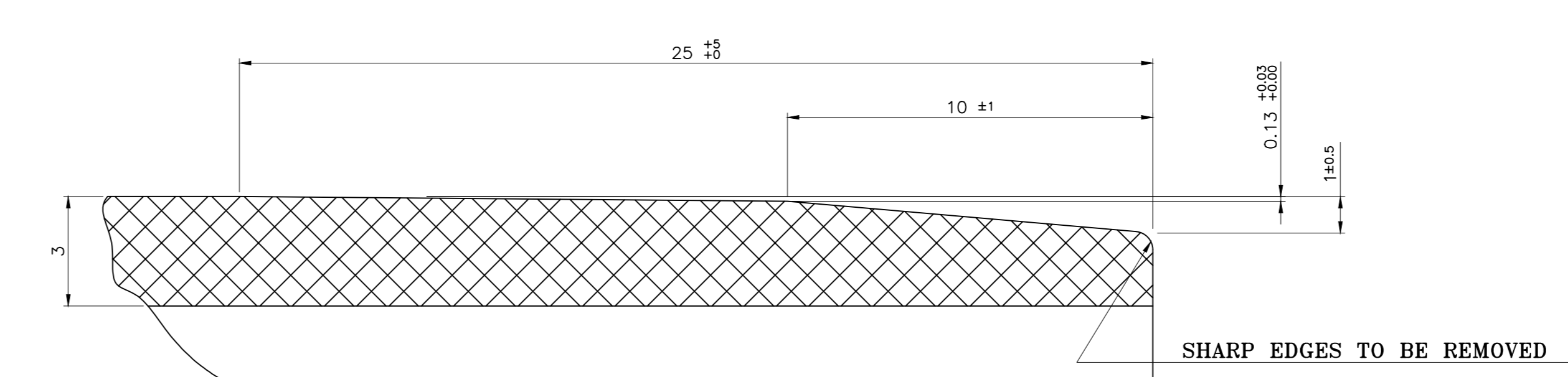
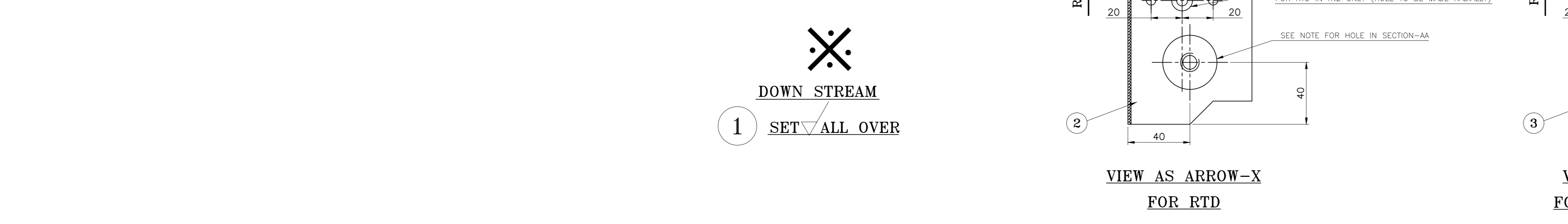
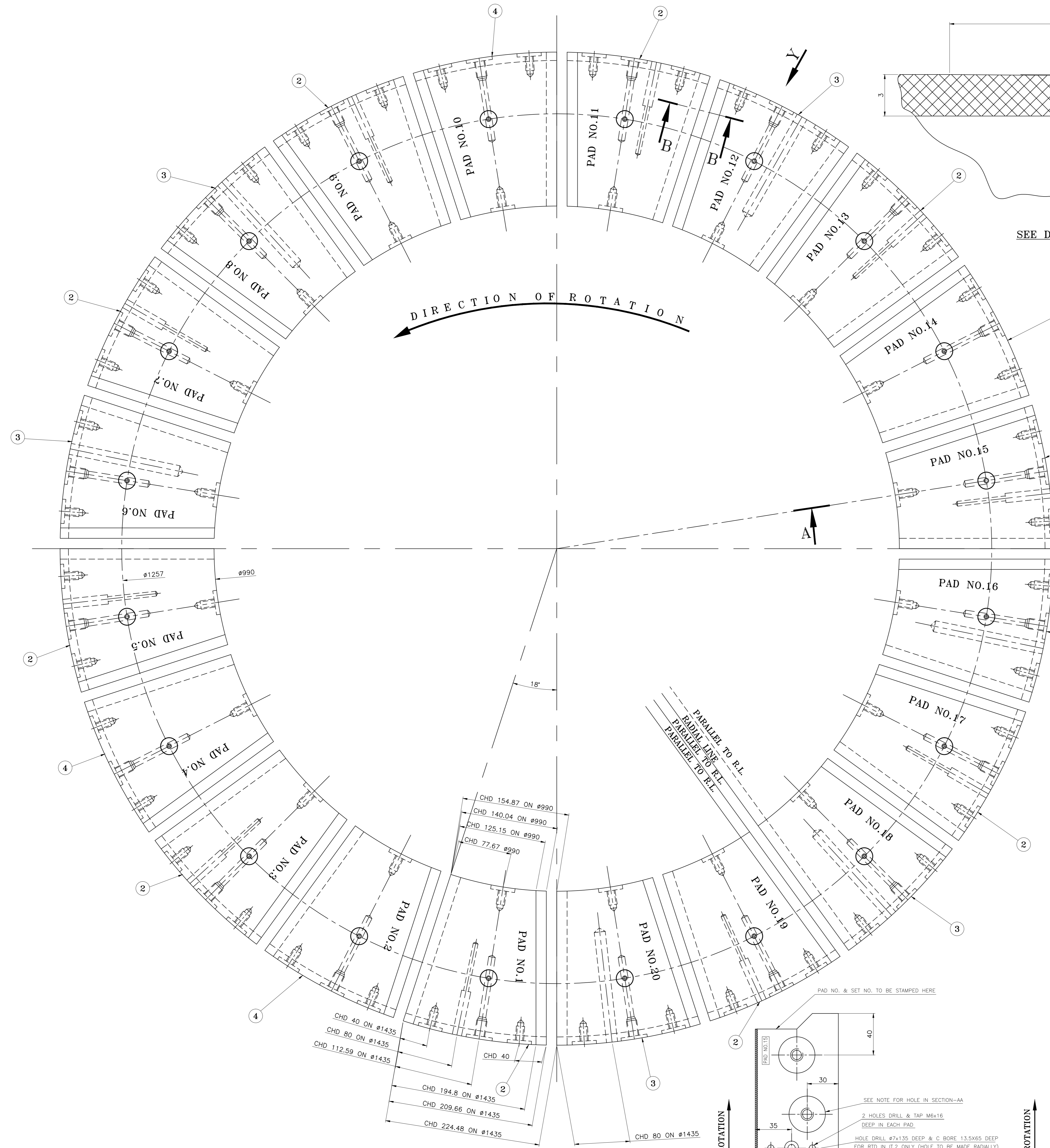


10982 10 255 01 28601



TECHNICAL REQUIREMENTS:-

1. **BASE METAL :-**
 - 1.1 THE BASE MATERIAL OF PAD SHALL BE M.S. PLATE TO DIN. EN 10025, Gr: S 275 J2G3 OR M.S. PLATE TO AA10119 (IS:2062-GR:B-FE 410 WB) CAN BE USED. IT IS TO BE HEAT TREATED FOR HYDROGEN DIFFUSION.
 - 1.2 FULL AREA OF PLATES TO BE ULTRASONICALLY TESTED FROM BOTH SURFACES AS PER CATEGORY 2 OF B.H.E.L. STANDARD AA0850118, 'ULTRASONIC TESTING, CLASSIFICATION AND ACCEPTANCE STANDARDS FOR STEEL FORGINGS, BILLETS
 - 1.3 THE SURFACE FINISH OF ALL MACHINED SURFACE SHOULD BE 3.2 MICRONS OR BETTER.
2. **FINISHED PADS :-**
 - 2.1 FOR THRUST PADS :-
 - a) STEEL AND PTFE SURFACES TO BE FLAT WITHIN 0.01mm MEASURED BY USING BS 817 GR '0' SURFACE PLATE AND THICKNESS VARIATION NOT TO EXCEED 0.02mm IN EACH PAD.
 - b) FOR INTERCHANGEABILITY, THICKNESS VARIATION FROM PAD TO PAD OF EACH SET SHOULD BE WITHIN 0.03mm.
 - 2.2 TEST THE PAD MATERIAL & PTFE MATERIAL & ITS BONDING AS PER APPROVED QA PLAN.
 - 2.3 STAMP PAD NOS. ON EACH PAD IN LOCATION INDICATED.
 - 2.4 PACKING TO BE DONE IN ACCORDANCE WITH DRG. NO.32550101400 BY SUPPLIER.
3. **DIMENSIONAL REQUIREMENTS:-**
 - 3.1 THE CHORD DIMENSIONS OF THRUST PADS SHALL BE WITHIN ± 0.5 MM.
 - 3.2 THE PITCHING OF VARIOUS HOLES SHALL BE WITHIN ± 1 MM, EXCEPT OTHERWISE STATED.
 - 3.3 ALL OTHER DIMENSIONS RELATED TO GEOMETRY AND SHAPE OF PAD SHALL BE WITHIN ± 0.25 MM.
4. **OTHER REQUIREMENTS:-**
 - 4.1 PADS FOR RTD:- PAD NO. 1,3,5,7,9,11,13,15,17 & 19 ARE FOR RTD.
 - 4.2 PADS FOR DTD:- PAD NO. 6,12,16 & 20 ARE FOR DTD.
 - 4.3 PADS FOR THERMOSTAT:- PAD NO. 8 & 18 ARE FOR THERMOSTAT.

3 HOLES DRILL & TAP M12 x 30 DEEP (2 HOLES ON O/D AND 1 HOLE ON I/D) AND C'BORE #35 x 5 DEEP IN EACH PAD (FOR LIFTING PURPOSE) THESE HOLES TO BE USED FOR PAD STOP ALSO ON O/D (HOLES TO BE MADE RADially)

1-HOLE IN EACH PAD DRILL #9.6x120 DEEP, C'BORE #15x25 DEEP AND TAP RP 3/8"x20 DEEP AND S'FACE #38 FOR H.S. CONNECTION (HOLE TO BE MADE RADially)

QTY	QTY	QTY	QTY	REMARKS	ITEM	DESCRIPTION	DRAWING NO.	MATL. CODE	UNIT	WT.	NO.
004					004	PAD SEGMENT NORMAL					23.86
006					003	PAD SEGMENT WITH DTD/THERMOSTAT					23.66
010					002	PAD SEGMENT WITH RTD					23.77
					001	SET OF PADS					475.1

ADDITIONAL INFORMATION
 W.O.NO.37030,31,32,33-P-231-55
 STATUS OF DRAWING: U

DISTRIBUTION OF PRINTS
 HSE-1 GTG(CM)-1
 PLM-4
 FBM-7 TGM-1

REVISIONS

REV.	DATE	ALTERED	CHECKED	APPROVED

PROJECT INFORMATION
 HGS-680/200-20D
 NTPC/TAPOVAN VISHNUGAD HEP

DESIGNER: HSKY
CHECKED: BK/GRP
APPROVED: BKS

DATE: 1.2.5
SCALE: 475.1

DRAWING NO.: 0 255 01 28601

INVENTORY NO. SHN. & DATE REF. DRG. NO.