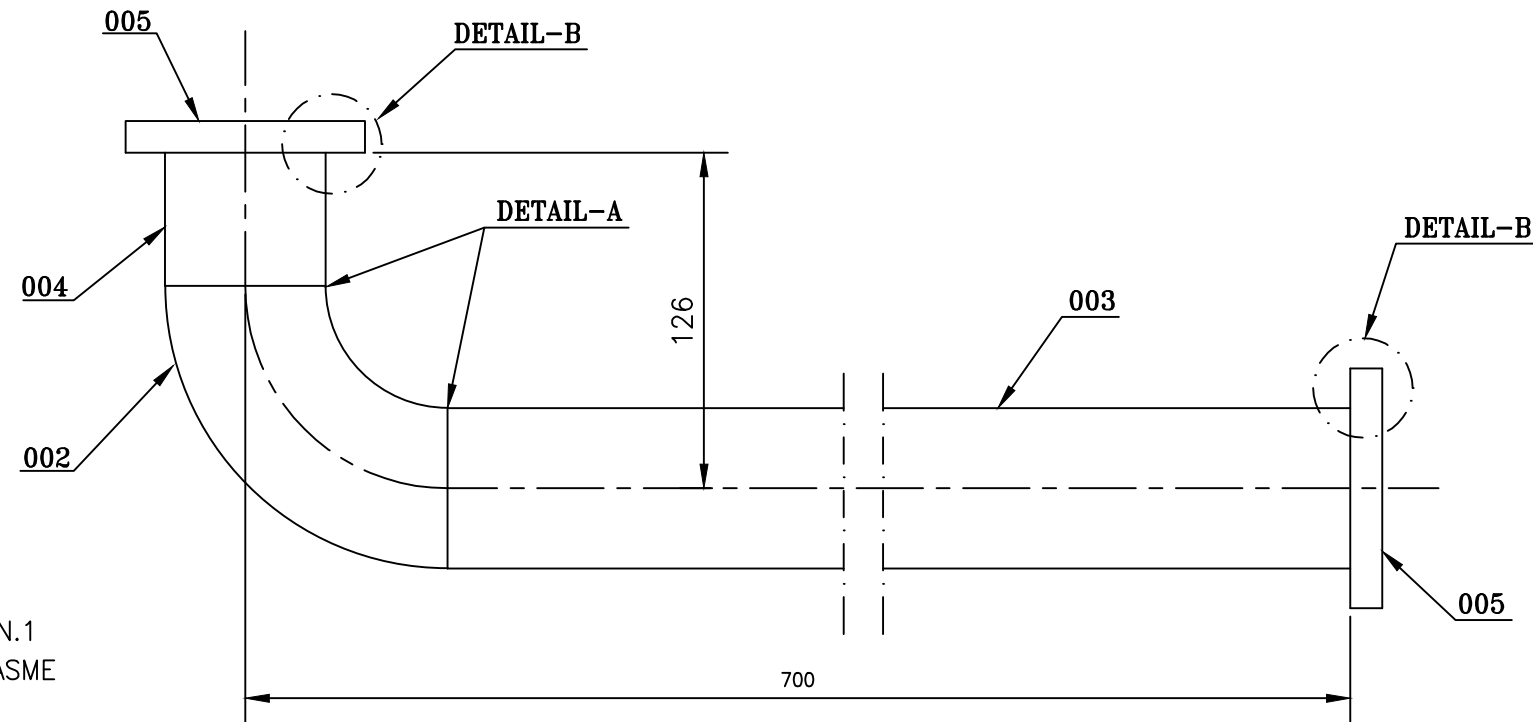
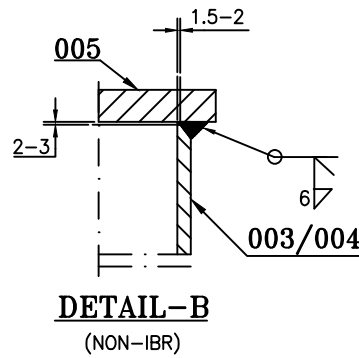
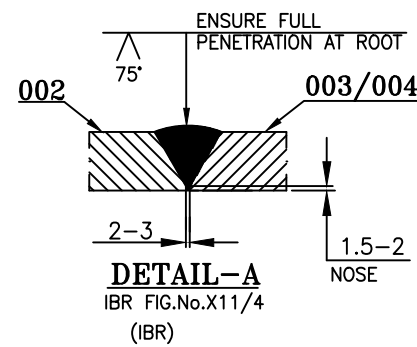


FIRST ANGLE PROJECTION

DRG. NO. 3-17505-40460



ASSLY.OF ITEM 001,VAR.00

TECHNICAL REQUIREMENTS(TR)

1. FABRICATION TO IN LINE WITH IBR-1950 CLASS 1.
2. FABRICATION TO BE DONE USING IBR QUALIFIED WELDERS ONLY.
3. ALL BUTT WELDS & CORNOR WELDS TO BE CHECKED BY DYE PENETRATION EXAMINATION AS PER APPEDIX-8 OF ASME SEC.VIII DIVN.1
4. ALL BUTT WELDS TO BE FULLY RADIOGRAPHED AS PER UW-51 OF ASME ASME SEC.VIII DIVN.1;2004.
5. DRILL & TAP HOLES IN BLANK (ITEM 005) AS REQUIRED IN SHOP, FOR HYDROSTATIC TESTING OF ASSY.
6. FABRICATION ASSY. TO BE CLEANED BY SHOT BLASTING TO Sa 2 1/2 FINISH AS PER SIS-055900.
7. FABRICATION ASSY. TO BE CHECKED BY HYDROSTATIC TESTING FOR 30 MINUTES, MINIMUM.
8. PAINTING AFTER SHOT BLASTING
  - 8.1 INSIDE SURFACE: NIL
  - 8.2 OUTSIDE SURFACE: TWO COATS OF HEAT RESISTANT AIR DRYING ALUMINUM PAINT AS PER AA-56134

QTY.	ITEM NO.	DESCRIPTION	UNIT	WT.	ZONE
02	005	BLANK-50NB 12TK.	KG	060	
01	004	PIPE-50NB 60.3 ODx8.74TK.	MR	0.56	
01	003	PIPE-50NB 60.3 ODx8.74TK.	MR	6.93	
01	002	ELBOW - LR 50NB SCH.160	NO	2.65	
1	001	CONNECTING PIPE ASSLY.	NO	11.40	

DESIGN DATA	
DESIGN PRESSURE	50.0 Kg/cm <sup>2</sup> g
DESIGN TEMP.	285°C
HYDROSTATIC TEST PRESSURE	75.0 Kg/cm <sup>2</sup> g

ISSUED BY \_\_\_\_\_ CHECKED BY \_\_\_\_\_ APPROVED BY \_\_\_\_\_

**I.B.R.**  
 ADDITIONAL INFORMATION  
 DRG. LIST No.4-17500-40040  
 STATUS OF DRAWING  
 DISTRIBUTION OF PRINTS  
 CDE-1 HCM-4

**H.P.HEATERS STANDARD**  
 भारत हेवी इलेक्ट्रिकल्स लिमिटेड भोपाल  
**BHARAT HEAVY ELECTRICALS LTD. BHOPAL**  
 नाम / NAME: NEETU ARYA  
 हस्ता / SIGN.:  
 दि. / DATE: 23.02.07  
 चे. की संख्या / NO. OF VAR.: 001

REV.	DATE	ALTERED THAWANI
01	20.02.08	CHECKED SAXENA S. APPROVED TAURANI M.L.
ZONE		DESIGN TEMP. ADDED.

भाग / DEPT. CODE: 411  
 उन्तोल. दिस. ग. / UNTOL. DIMS. GR.: M  
 कोड / CODE: AA 0230208  
 भा. कि.ग. / WEIGHT(K.G.): 11.40  
 उतुपत / SCALE: 1:2.5

उत्पाद का प्रकार या गृहक / परिचयना का नाम  
 TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT  
 उतुपत / SCALE: 1:2.5  
 भा. कि.ग. / WEIGHT(K.G.): 11.40  
 उतु. ड्राईंग का संदर्भ / REF. TO ASSY. DRG.:  
 मद्र. क. / ITEM NO.: 006  
 मद्र. संख्या / NO. OF ITEM: 005  
 ड्राईंग क. / DRAWING NO.: 3-17505-40460  
 पृष्ठ क. / SHT. NO.: 1 पृष्ठों की सं. / NO. OF SHT.: 1

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REF. DRG. NO.

SIGN. & DATE

INVENTORY NO.