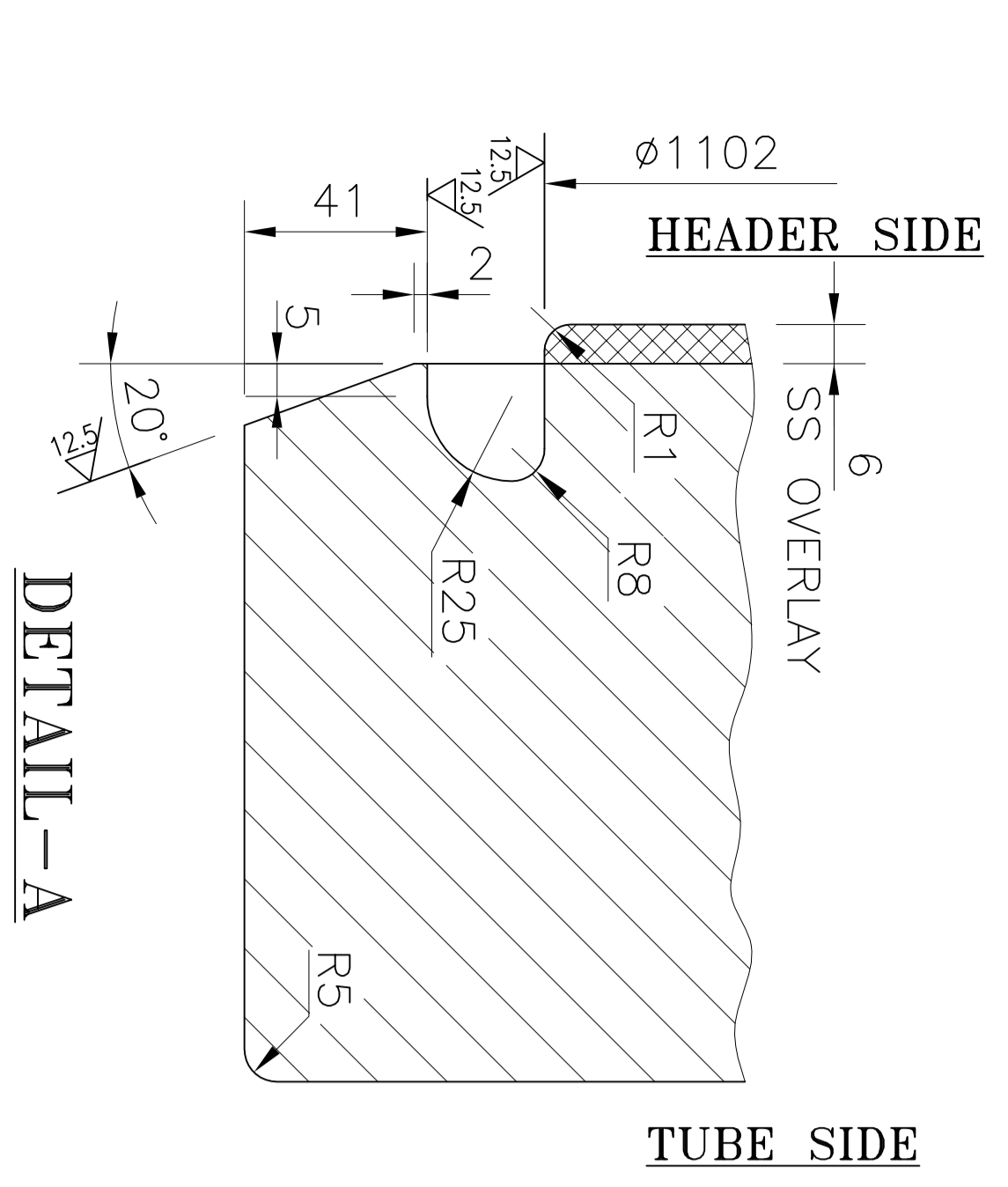
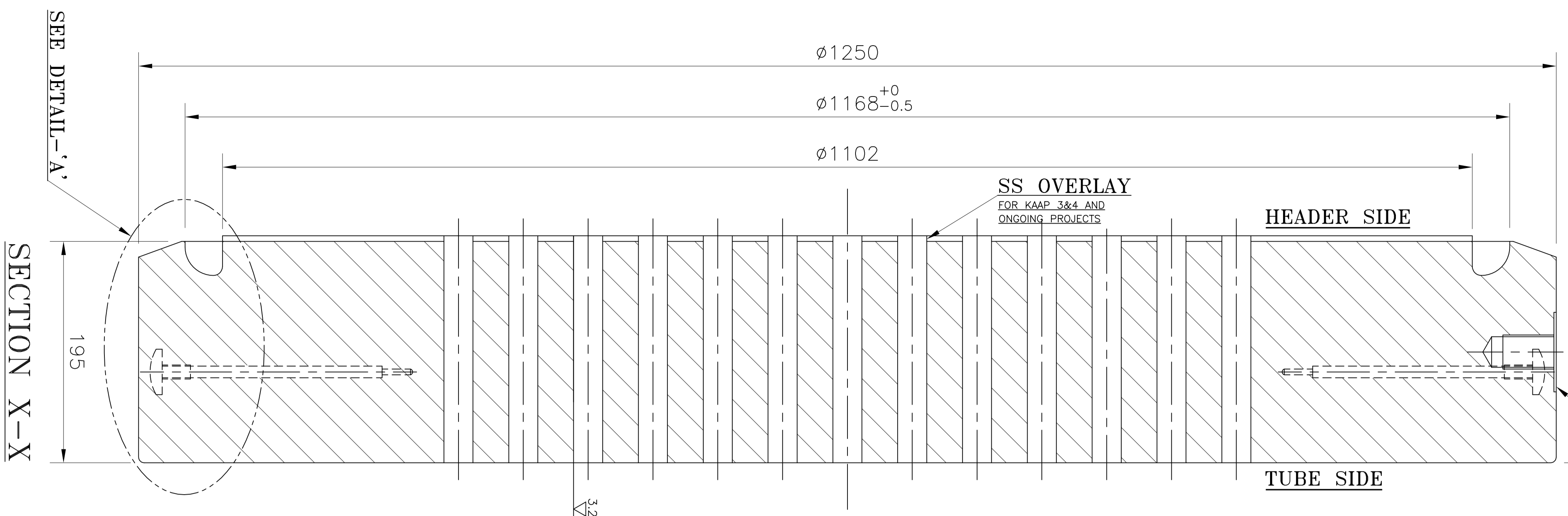


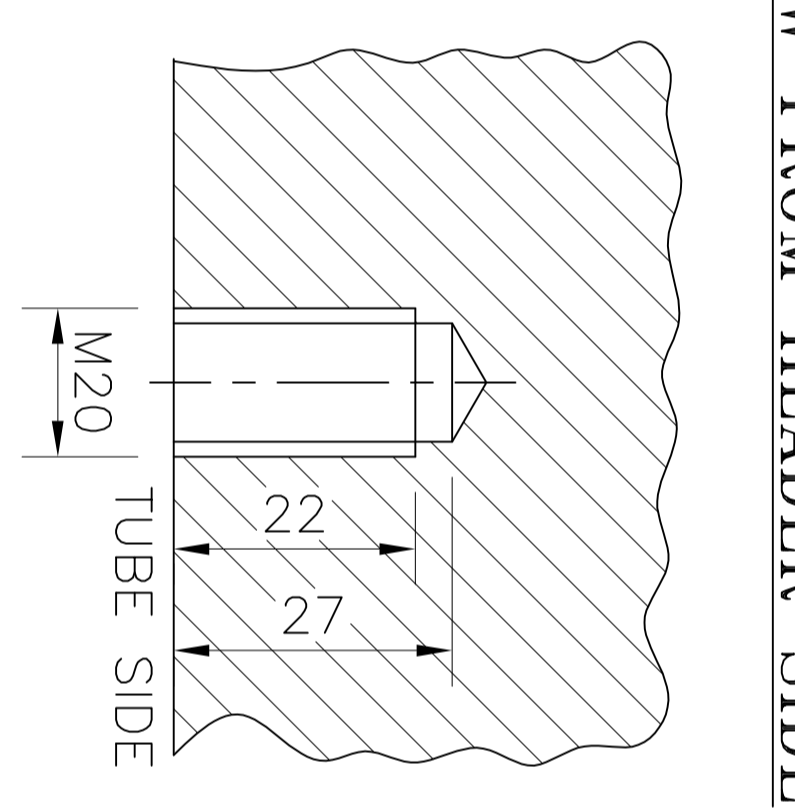
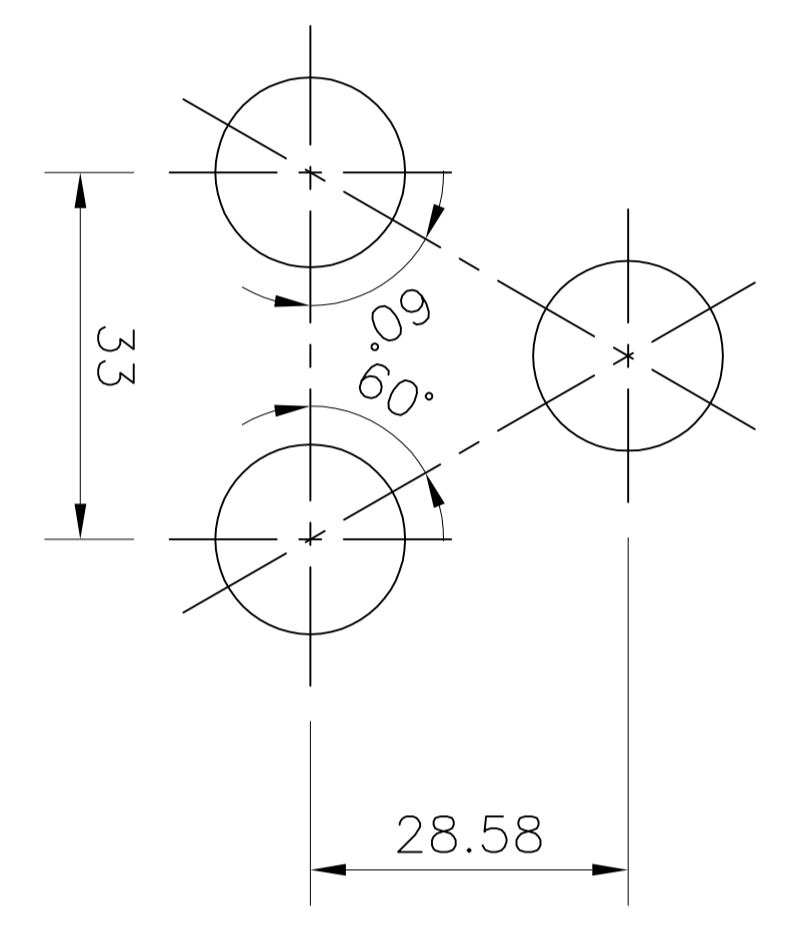
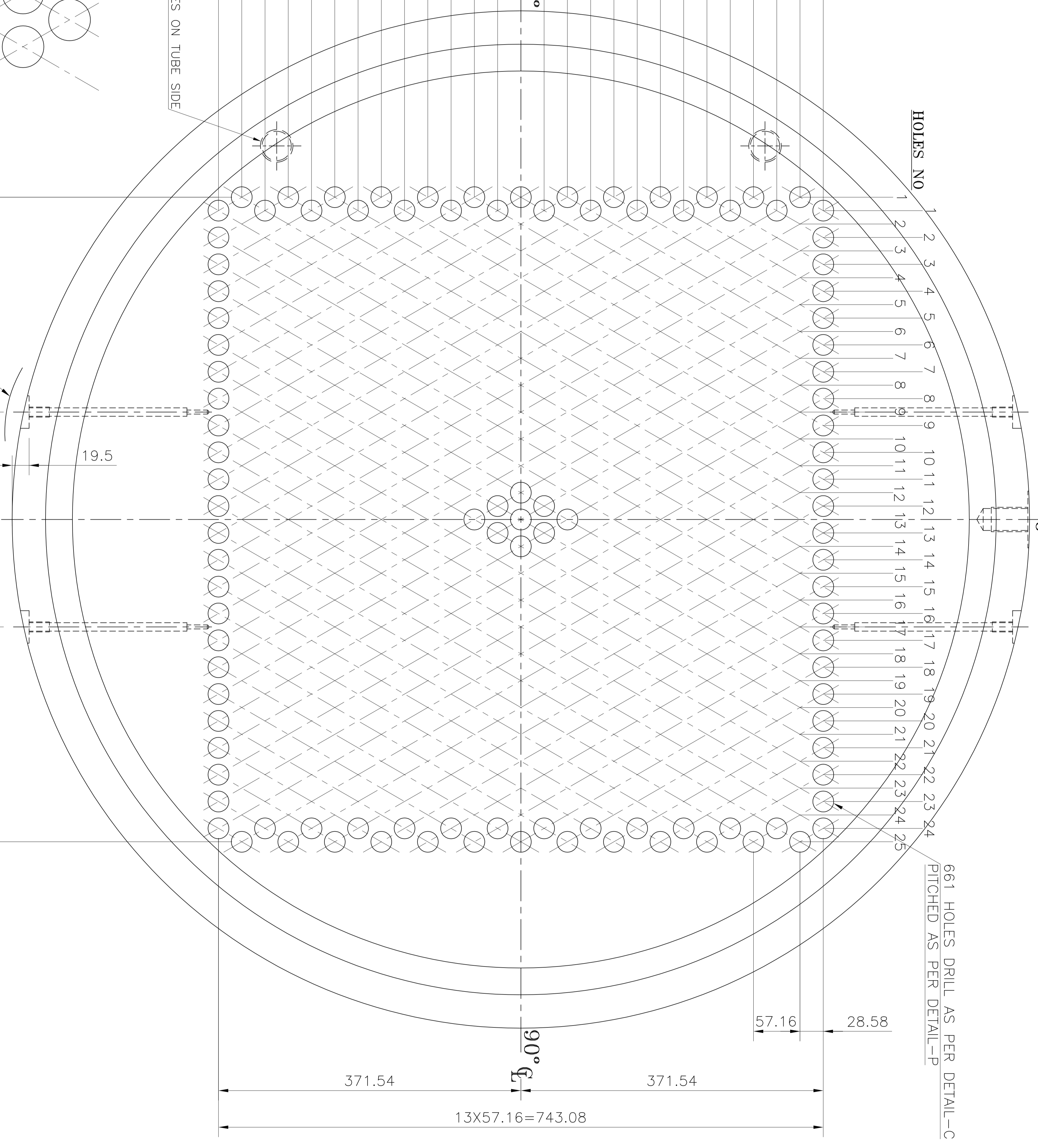
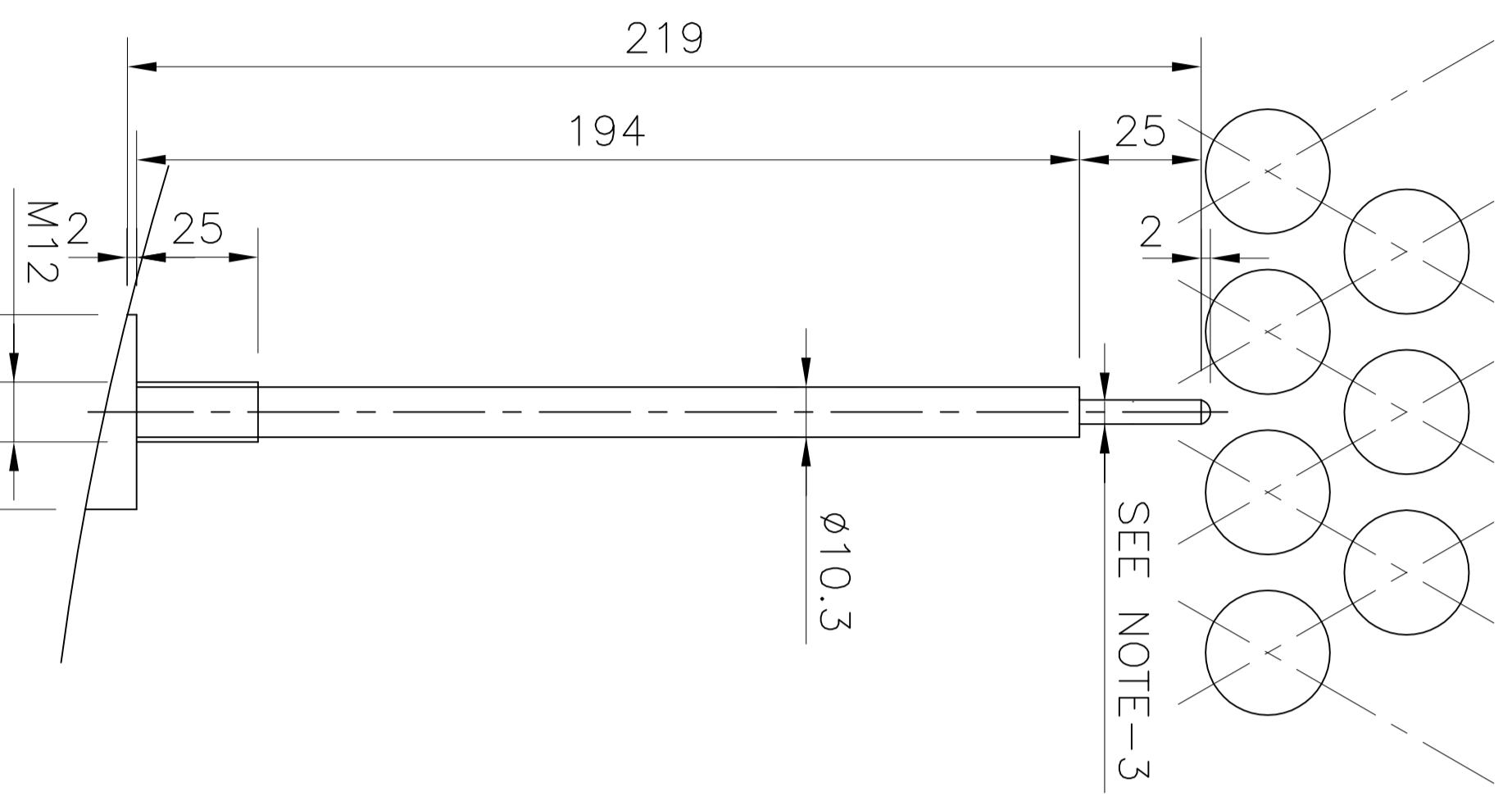
1 HOLE DRILL  $\phi 27 \times 57$  DEEP & TAP  $M30 \times 47$  DEEP & SPOT FACE  $\phi 70 \times 2$  DEEP FOR LIFTING TUBE PLATE (IF REQUIRED)



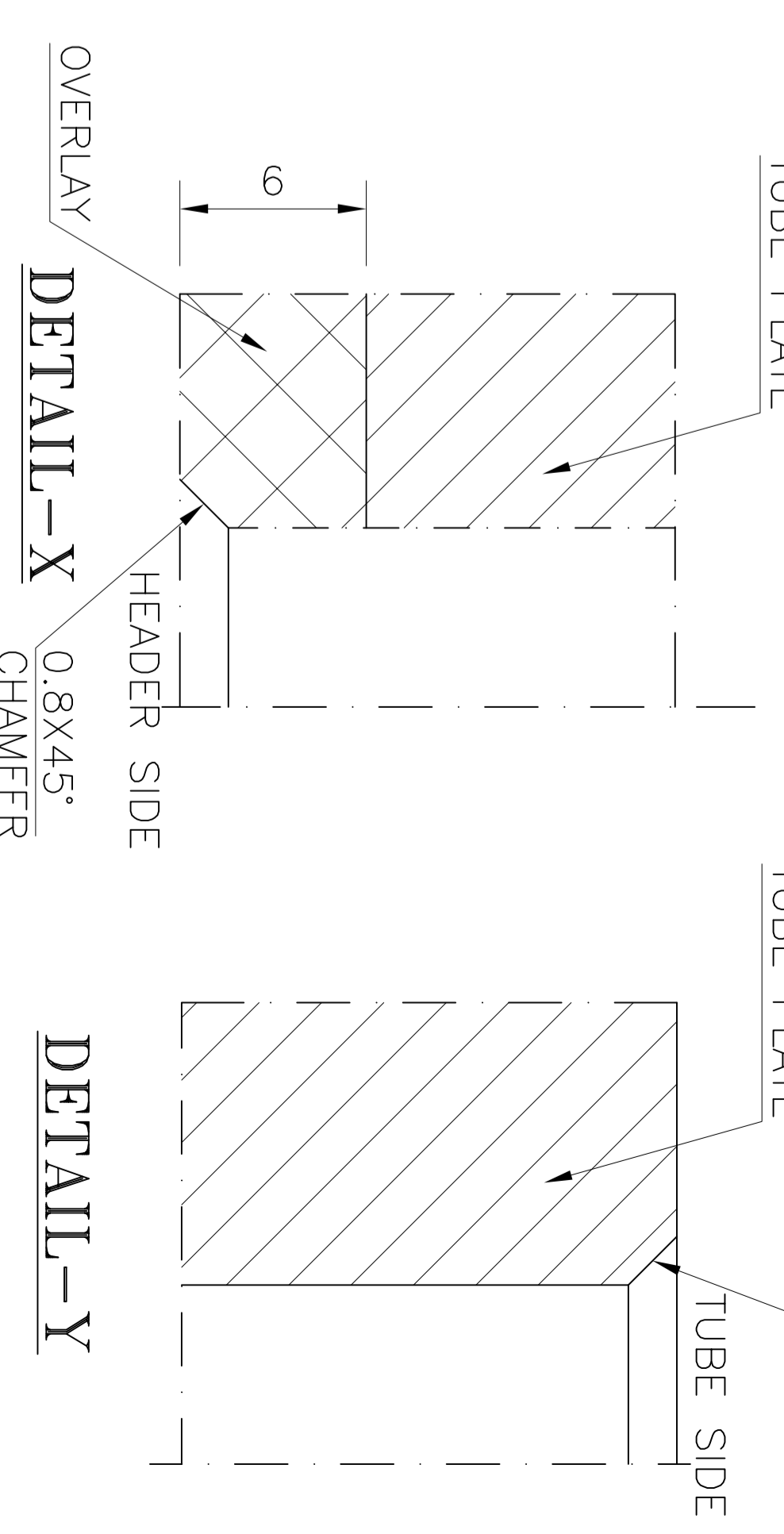
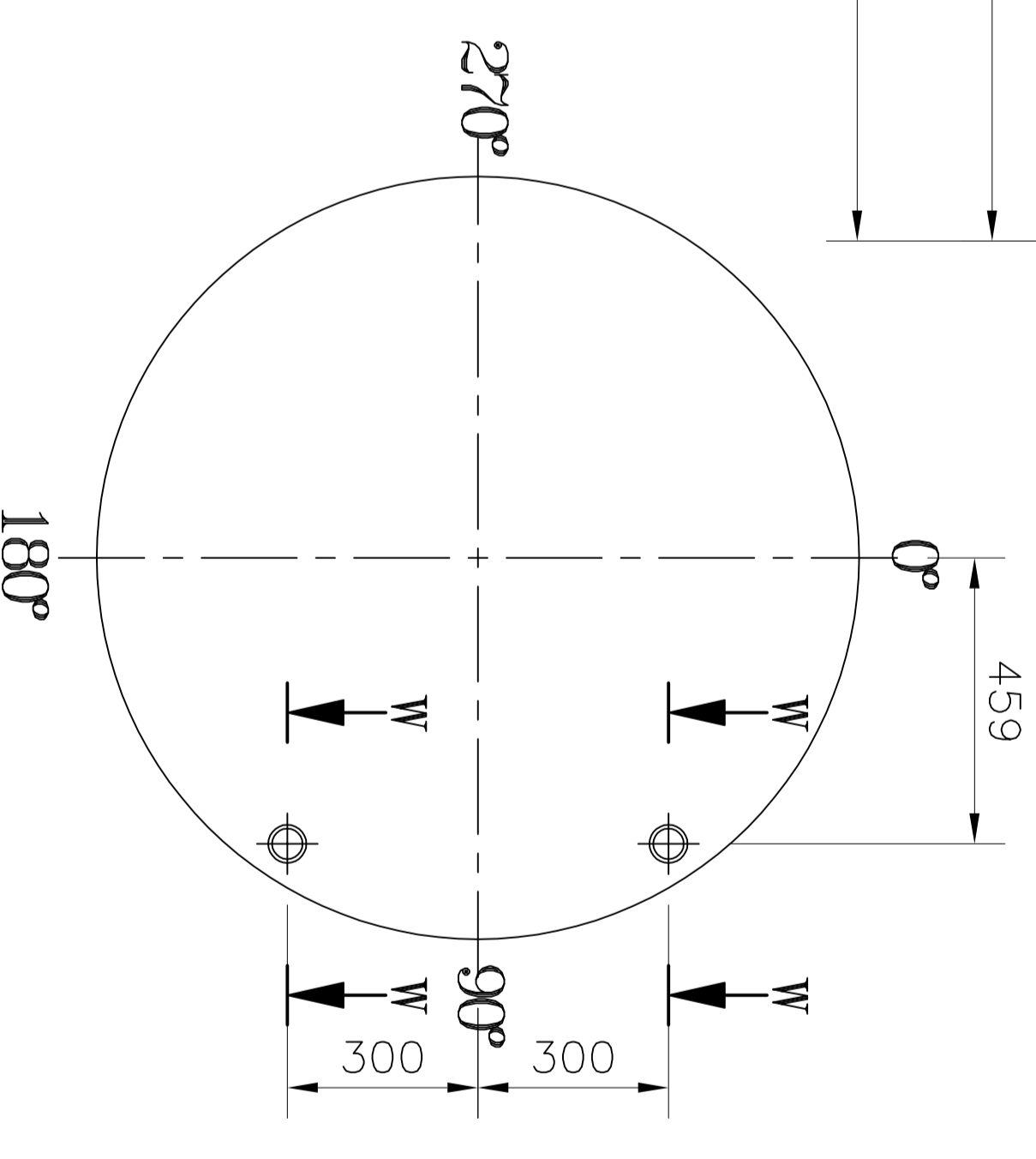
NO. OF HOLES

ROW NO.

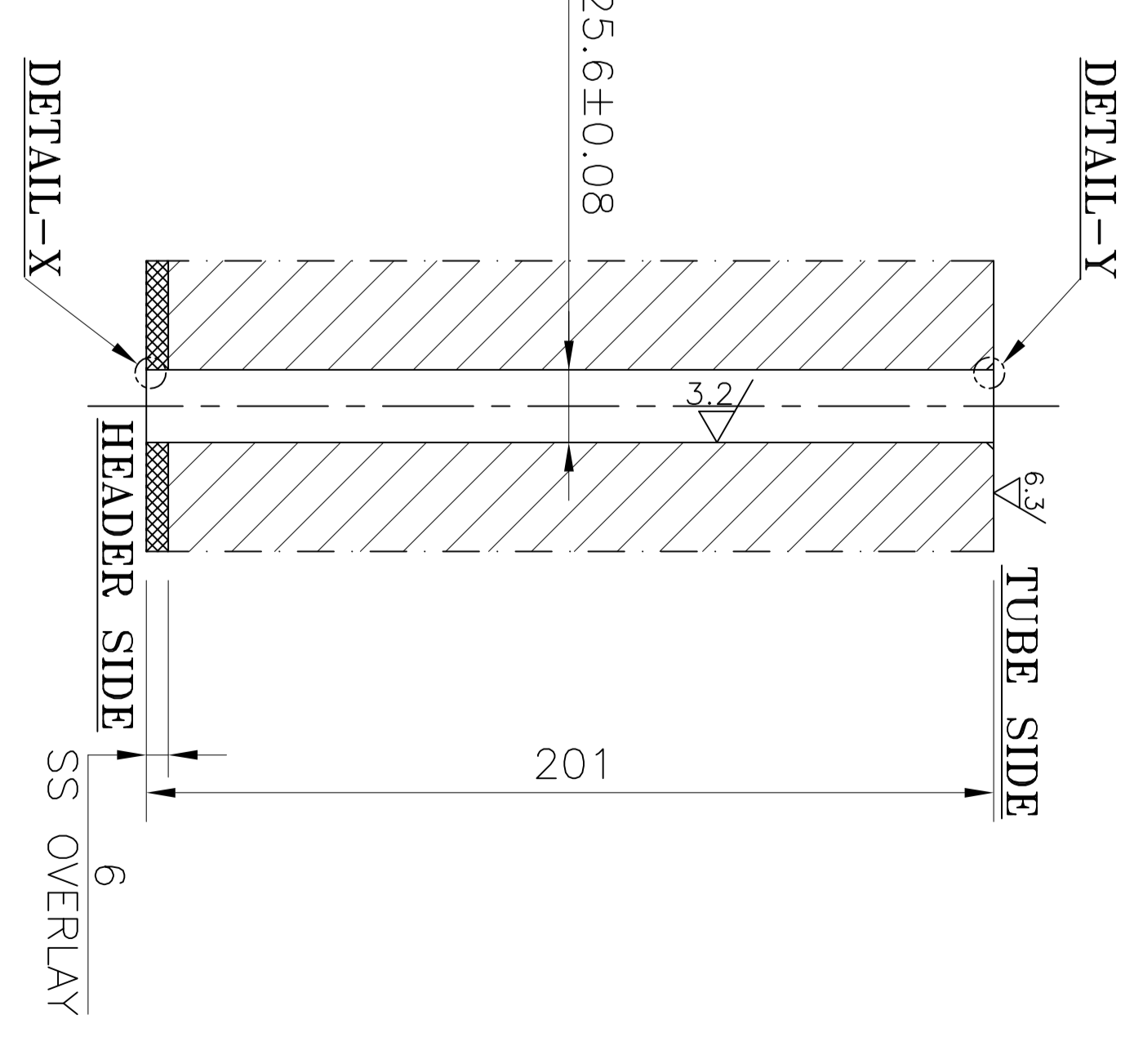
2 TAP HOLES ON TUBE SIDE



DETAIL OF IT. NO. 01  
VIEW FROM HEADER SIDE



DETAIL OF TUBE HOLE DRILLING



ITEM NO.	TOOL NO.	DESCRIPTION
001	1421636	PLAIN PLUG GAUGE FOR $\phi 25.6 \pm 0.08$
001	1421604	FORM TOOL FOR RADIUS 25
001	1421605	FORM TOOL FOR RADIUS 8
001	1421599	GUN DRILL DIA 25.58
001	1421600	GUN DRILL BUSH DIA 25.58
001	1421602	GUN DRILL DIA 10.3
001	1421601	SPECIAL DRILL SIZE 5.0 DIA 45MM WORKING LENGTH SHANK PORTION-10 DIA-315 LONG & 6 DIA. 50 LONG FOR HOLDING THE CHUCK
001	1421603	GUN DRILL BUSH DIA 10.3
001	1421684	PITCH PLATE FOR GUN DRILLING MACHINE(33X60)
001	1421685	ROUGHING REAMER FOR $\phi 25.6$
001	1421686	LIGAMENT GAUGE 33MM PITCH.
001	1421687	RADIUS TOOL R5(L.H.)
001	1421688	UPPER LIMIT OF THE HOLE 25.85 DIA FOR PROCURING TOOL FOR RECTIFICATION
001	1421689	FORM TOOL FOR RADIUS 20° X 36 LONG
001	1421690	TAPER SHANK END MILL $\phi 40$
001	1581032	COPING TEMPLATE FOR 20° CHAMFER
001	1581747	CHECKING TEMPLATE FOR RADIUS 25 GROOVE.

NOTES:-

- FOR TUBE PLATE OVERLAY, REFER DRAWING NO. 3-16816-40047 FOR KAPP-3&4 AND ONGOING PROJECTS.
- FOR TUBE PLATE FORGING REFER DRG. NO. 2-16816-40037 FOR TAPP-3&4 ONLY.
- SPECIAL CARE REQUIRED FOR DRILLING OF DIA-10.3 HOLE TO AVOID BREAKING INTO TUBE HOLES.
- DI-A-5 FOR TAPPUR-3&4, DI-A-6.5 FOR REST OF THE PROJECTS.

REV	DATE	ALTERED BY	DATE	APPROVED BY	REV	DATE	ALTERED BY	DATE	APPROVED BY
12	15.05.11	APPROVED	SSB	SSB	11	15.05.11	APPROVED	SSB	SSB
11	15.05.11	APPROVED	SSB	SSB	10	15.05.11	APPROVED	SSB	SSB
10	15.05.11	APPROVED	SSB	SSB	09	15.05.11	APPROVED	SSB	SSB
09	15.05.11	APPROVED	SSB	SSB	08	15.05.11	APPROVED	SSB	SSB
08	15.05.11	APPROVED	SSB	SSB	07	15.05.11	APPROVED	SSB	SSB
07	15.05.11	APPROVED	SSB	SSB	06	15.05.11	APPROVED	SSB	SSB
06	15.05.11	APPROVED	SSB	SSB	05	15.05.11	APPROVED	SSB	SSB
05	15.05.11	APPROVED	SSB	SSB	04	15.05.11	APPROVED	SSB	SSB
04	15.05.11	APPROVED	SSB	SSB	03	15.05.11	APPROVED	SSB	SSB
03	15.05.11	APPROVED	SSB	SSB	02	15.05.11	APPROVED	SSB	SSB
02	15.05.11	APPROVED	SSB	SSB	01	15.05.11	APPROVED	SSB	SSB

MSR FOR 500/700MM

0-16816-4003.12

FOR II-STAGE REHEATER (LOWER)