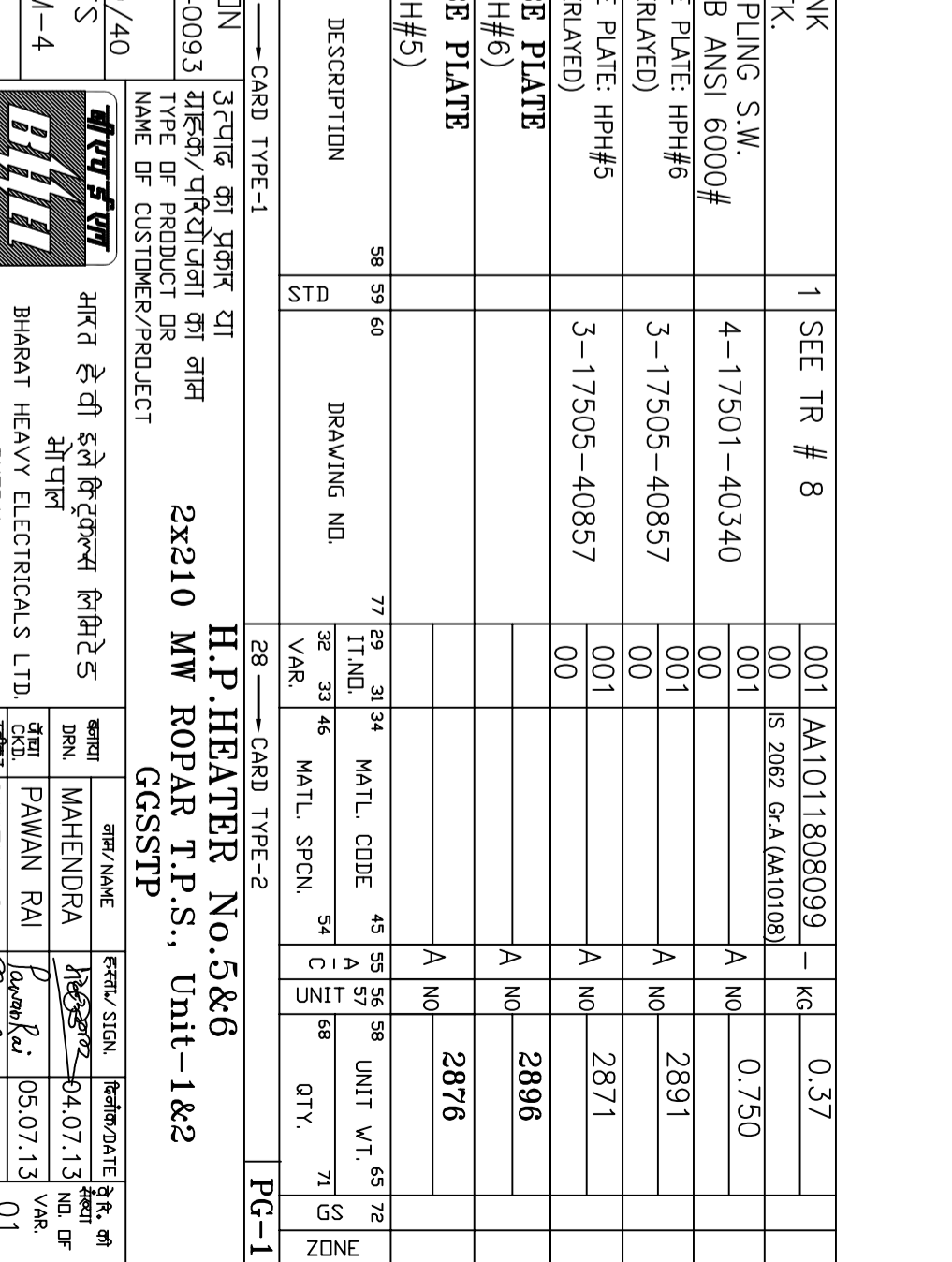
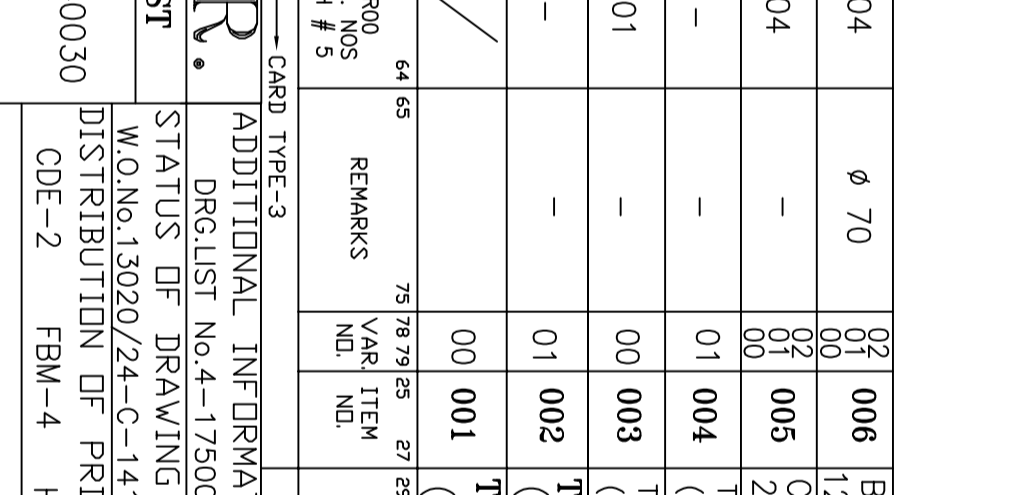
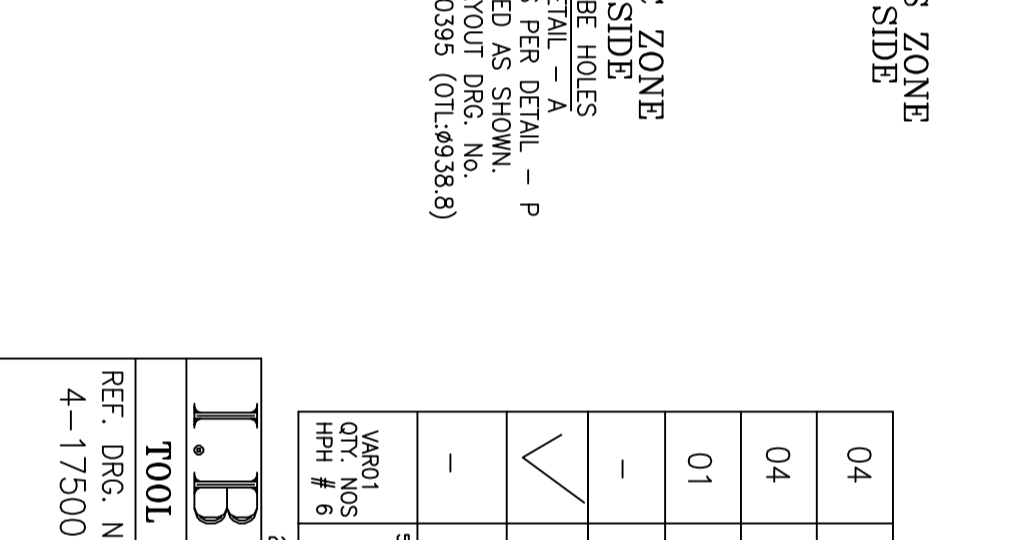
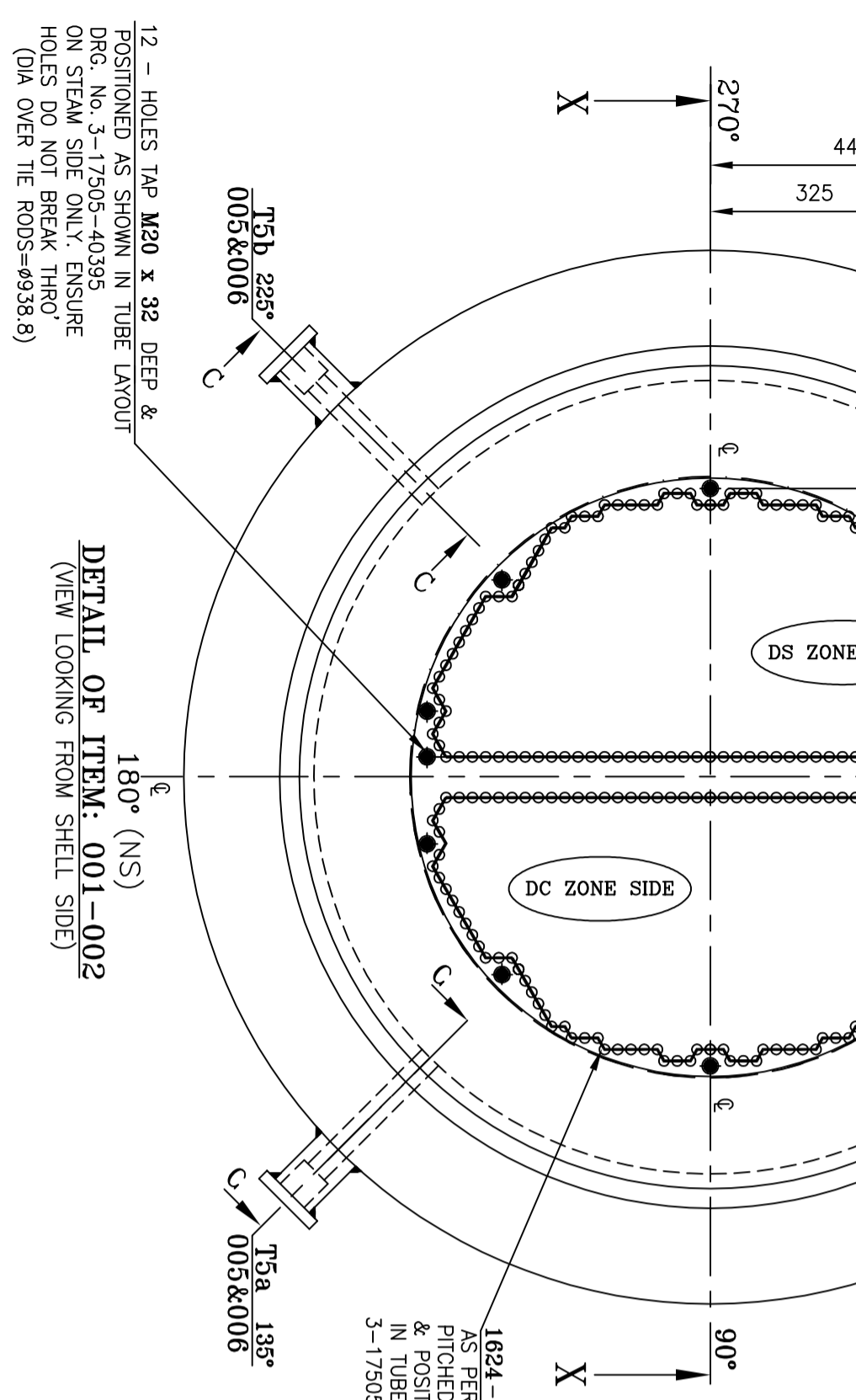
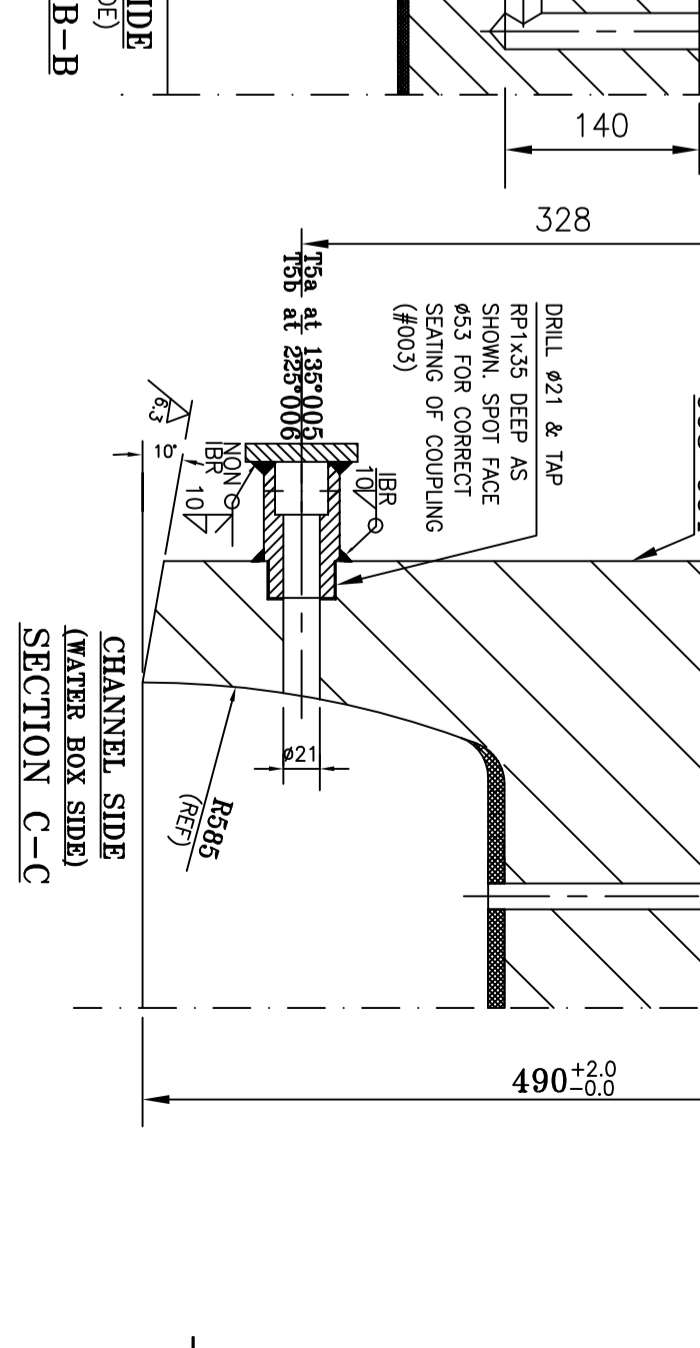
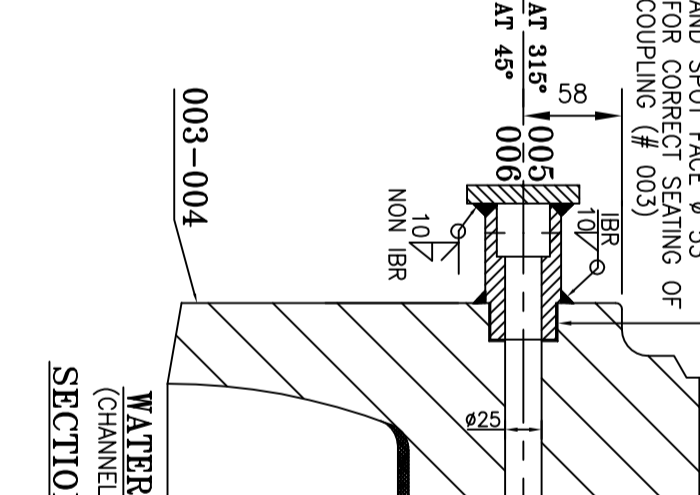
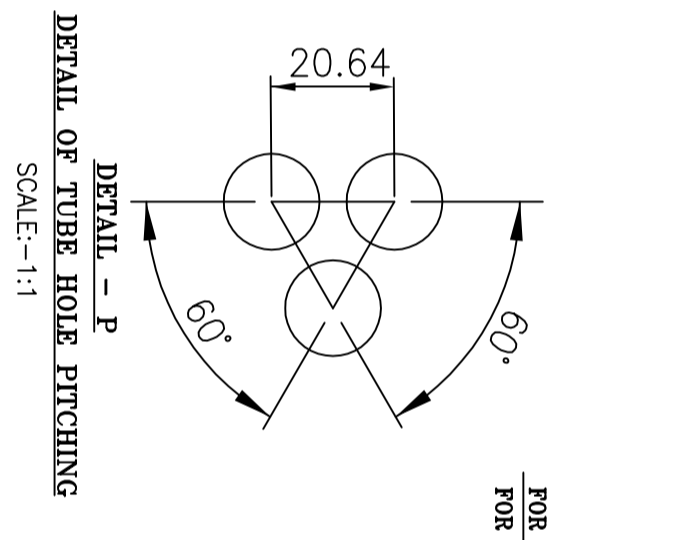
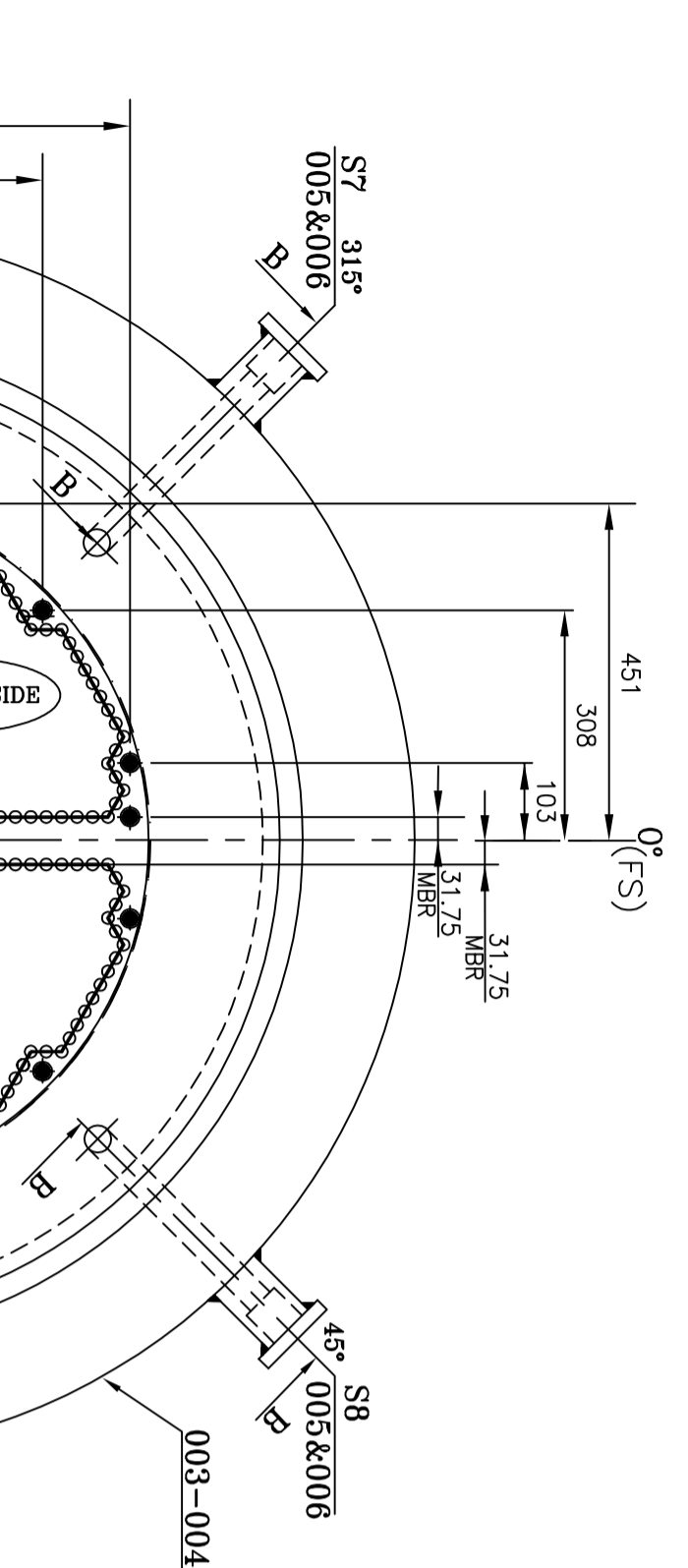
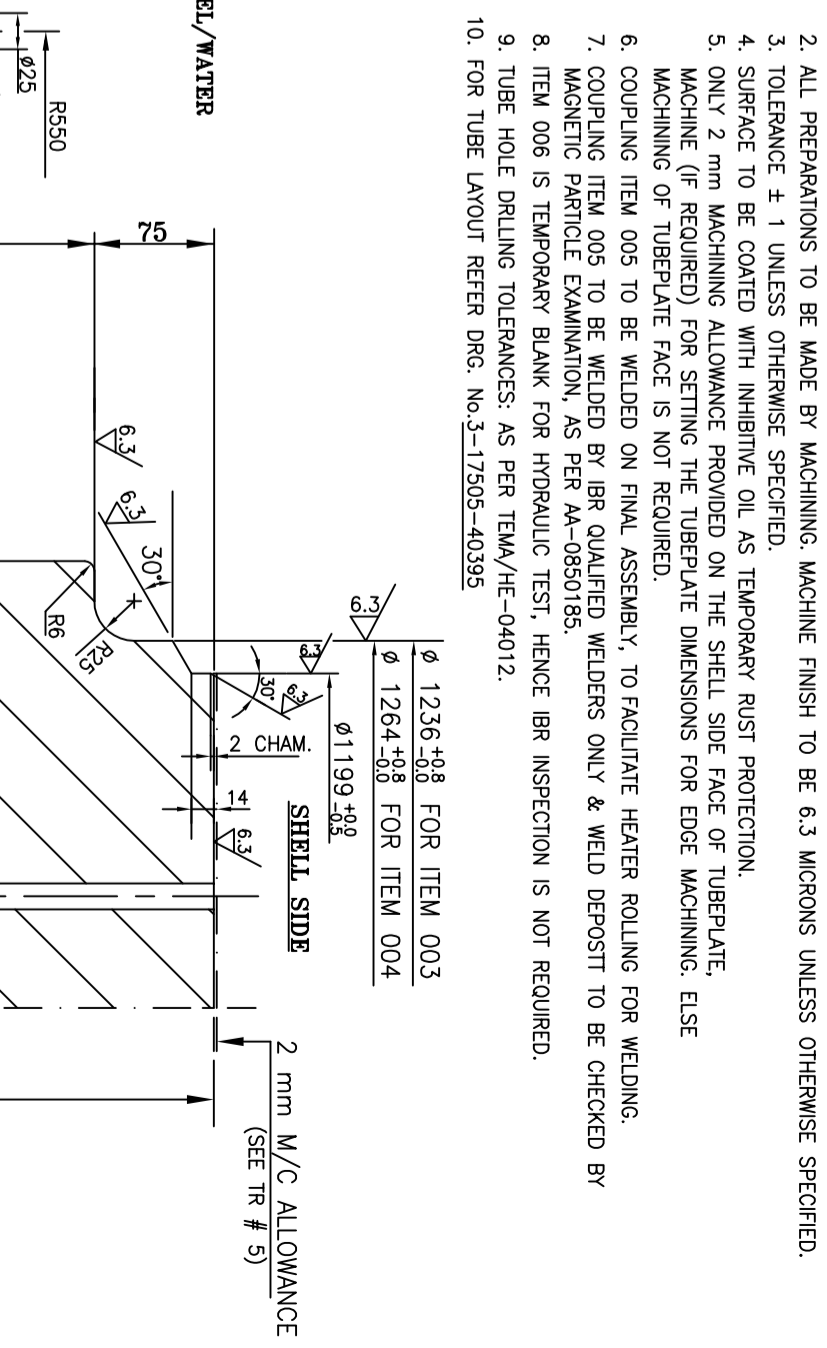
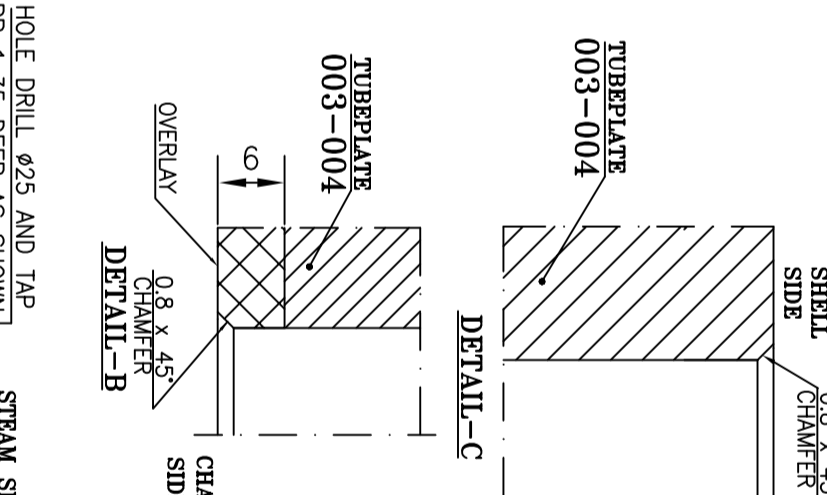
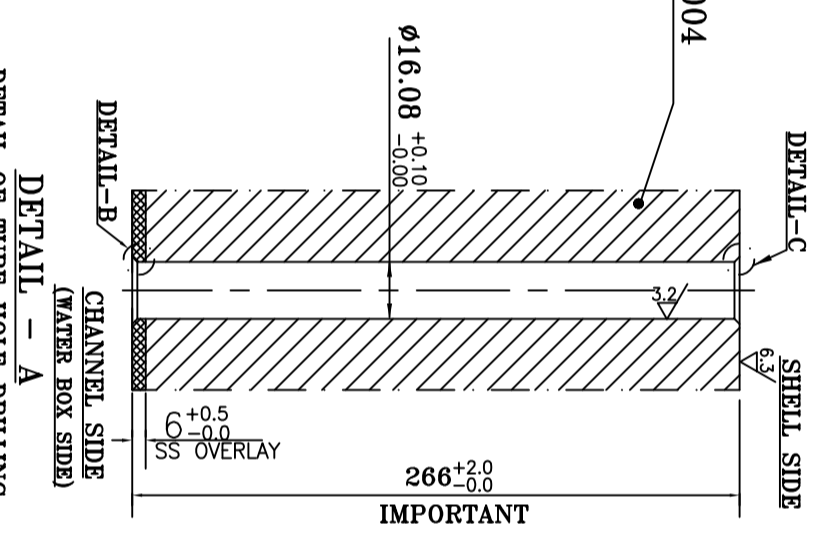
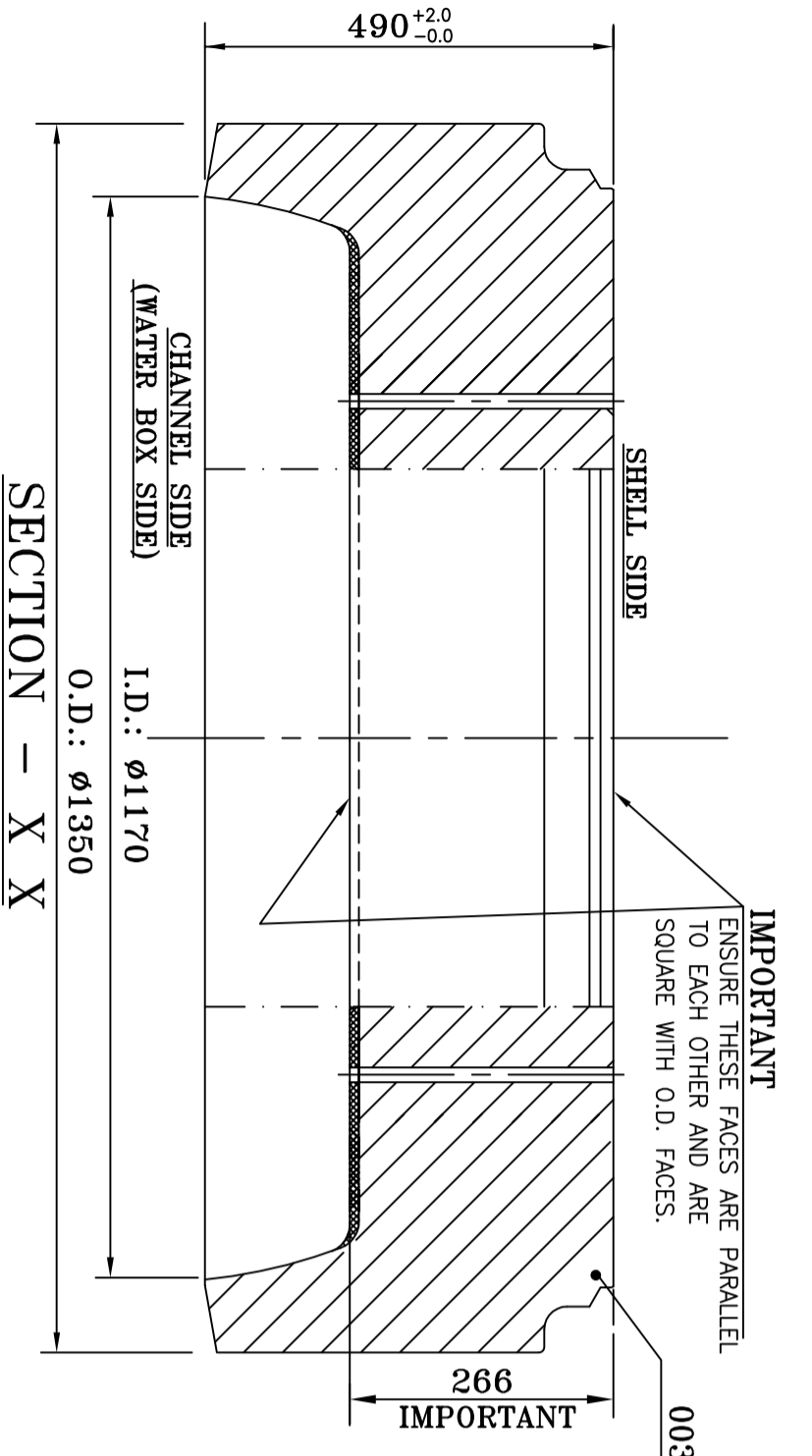


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INVENTORY NO. 21.09.07 SIGN AND DATE 2-17505-40325 REF. DRG. NO.



- TECHNICAL REQUIREMENTS (TR)**
1. ALL WELD PREPARATIONS TO BE MAGNETIC CRACK DETECTION TESTED AS PER AA-0850185.
 2. ALL PREPARATIONS TO BE MADE BY MACHINING. MACHINE FINISH TO BE 6.3 MICRONS UNLESS OTHERWISE SPECIFIED.
 3. TOLERANCE ± 1 UNLESS OTHERWISE SPECIFIED.
 4. SURFACE TO BE COATED WITH INHIBITIVE OIL AS TEMPORARY RUST PROTECTION.
 5. ONLY 2 mm MACHINING ALLOWANCE PROVIDED ON THE SHELL SIDE FACE OF TUBEPLATE MACHINE. (IF REQUIRED) FOR SETTING THE TUBEPLATE DIMENSIONS FOR EDGE MACHINING. ELSE MACHINING OF TUBEPLATE FACE IS NOT REQUIRED.
 6. COUPLING ITEM 005 TO BE WELDED ON FINAL ASSEMBLY, TO FACILITATE HEATER ROLLING FOR WELDING.
 7. COUPLING ITEM 005 TO BE WELDED BY IPR QUALIFIED WELDERS ONLY & WELD DEPOSIT TO BE CHECKED BY MAGNETIC PARTICLE EXAMINATION, AS PER AA-0850185.
 8. ITEM 006 IS TEMPORARY BLANK FOR HYDRAULIC TEST. HENCE IPR INSPECTION IS NOT REQUIRED.
 9. TUBE HOLE DRILLING TOLERANCES: AS PER TEMA/HE-04012.
 10. FOR TUBE LAYOUT REFER DRG. No. 3-17505-40395

VAR#	QTY	ITEM	DESCRIPTION	UNIT	W.T.
04	04	07	BLANK	KG	0.37
04	04	02	12 TK.		
04	04	05	COUPLING S.W.	0.01	0.750
			25NB ANSI 6000#		
01	-	04	TUBE PLATE: HPH#6 (OVERLAYED)	0.01	2891
			(OVERLAYED)		
-	01	03	TUBE PLATE: HPH#5 (OVERLAYED)	0.01	2871
			(OVERLAYED)		
✓	-	01	TUBE PLATE (HPH#6)	A	2896
✓	-	01	TUBE PLATE (HPH#5)	A	2876

VAR#	QTY	ITEM	DESCRIPTION	UNIT	W.T.
59	64	65	REMARKS		
75	78	79	VAR		
81	82	83	ITEM		
84	85	86	DESCRIPTION		
87	88	89	DRAWING NO.		
90	91	92	VAR.		
93	94	95	MATL. SPGN.		
96	97	98	QTY.		
99	100	101	UNIT		
102	103	104	W.T.		
105	106	107	QTY.		
108	109	110	UNIT		
111	112	113	W.T.		
114	115	116	QTY.		
117	118	119	UNIT		
120	121	122	W.T.		
123	124	125	QTY.		
126	127	128	UNIT		
129	130	131	W.T.		
132	133	134	QTY.		
135	136	137	UNIT		
138	139	140	W.T.		
141	142	143	QTY.		
144	145	146	UNIT		
147	148	149	W.T.		
150	151	152	QTY.		
153	154	155	UNIT		
156	157	158	W.T.		
159	160	161	QTY.		
162	163	164	UNIT		
165	166	167	W.T.		
168	169	170	QTY.		
171	172	173	UNIT		
174	175	176	W.T.		
177	178	179	QTY.		
180	181	182	UNIT		
183	184	185	W.T.		
186	187	188	QTY.		
189	190	191	UNIT		
192	193	194	W.T.		
195	196	197	QTY.		
198	199	200	UNIT		
201	202	203	W.T.		
204	205	206	QTY.		
207	208	209	UNIT		
210	211	212	W.T.		
213	214	215	QTY.		
216	217	218	UNIT		
219	220	221	W.T.		
222	223	224	QTY.		
225	226	227	UNIT		
228	229	230	W.T.		
231	232	233	QTY.		
234	235	236	UNIT		
237	238	239	W.T.		
240	241	242	QTY.		
243	244	245	UNIT		
246	247	248	W.T.		
249	250	251	QTY.		
252	253	254	UNIT		
255	256	257	W.T.		
258	259	260	QTY.		
261	262	263	UNIT		
264	265	266	W.T.		
267	268	269	QTY.		
270	271	272	UNIT		
273	274	275	W.T.		
276	277	278	QTY.		
279	280	281	UNIT		
282	283	284	W.T.		
285	286	287	QTY.		
288	289	290	UNIT		
291	292	293	W.T.		
294	295	296	QTY.		
297	298	299	UNIT		
300	301	302	W.T.		
303	304	305	QTY.		
306	307	308	UNIT		
309	310	311	W.T.		
312	313	314	QTY.		
315	316	317	UNIT		
318	319	320	W.T.		
321	322	323	QTY.		
324	325	326	UNIT		
327	328	329	W.T.		
330	331	332	QTY.		
333	334	335	UNIT		
336	337	338	W.T.		
339	340	341	QTY.		
342	343	344	UNIT		
345	346	347	W.T.		
348	349	350	QTY.		
351	352	353	UNIT		
354	355	356	W.T.		
357	358	359	QTY.		
360	361	362	UNIT		
363	364	365	W.T.		
366	367	368	QTY.		
369	370	371	UNIT		
372	373	374	W.T.		
375	376	377	QTY.		
378	379	380	UNIT		
381	382	383	W.T.		
384	385	386	QTY.		
387	388	389	UNIT		
390	391	392	W.T.		
393	394	395	QTY.		
396	397	398	UNIT		
399	400	401	W.T.		
402	403	404	QTY.		
405	406	407	UNIT		
408	409	410	W.T.		
411	412	413	QTY.		
414	415	416	UNIT		
417	418	419	W.T.		
420	421	422	QTY.		
423	424	425	UNIT		
426	427	428	W.T.		
429	430	431	QTY.		
432	433	434	UNIT		
435	436	437	W.T.		
438	439	440	QTY.		
441	442	443	UNIT		
444	445	446	W.T.		
447	448	449	QTY.		
450	451	452	UNIT		
453	454	455	W.T.		
456	457	458	QTY.		
459	460	461	UNIT		
462	463	464	W.T.		
465	466	467	QTY.		
468	469	470	UNIT		
471	472	473	W.T.		
474	475	476	QTY.		
477	478	479	UNIT		
480	481	482	W.T.		
483	484	485	QTY.		
486	487	488	UNIT		
489	490	491	W.T.		
492	493	494	QTY.		
495	496	497	UNIT		
498	499	500	W.T.		
501	502	503	QTY.		
504	505	506	UNIT		
507	508	509	W.T.		
510	511	512	QTY.		
513	514	515	UNIT		
516	517	518	W.T.		
519	520	521	QTY.		
522	523	524	UNIT		
525	526	527	W.T.		
528	529	530	QTY.		
531	532	533	UNIT		
534	535	536	W.T.		
537	538	539	QTY.		
540	541	542	UNIT		
543	544	545	W.T.		
546	547	548	QTY.		
549	550	551	UNIT		
552	553	554	W.T.		
555	556	557	QTY.		
558	559	560	UNIT		
561	562	563	W.T.		
564	565	566	QTY.		
567	568	569	UNIT		
570	571	572	W.T.		
573	574	575	QTY.		
576	577	578	UNIT		
579	580	581	W.T.		
582	583	584	QTY.		
585	586	587	UNIT		
588	589	590	W.T.		
591	592	593	QTY.		
594	595	596	UNIT		
597	598	599	W.T.		
600	601	602	QTY.		
603	604	605	UNIT		
606	607	608	W.T.		
609	610	611	QTY.		
612	613	614	UNIT		
615	616	617	W.T.		
618	619	620	QTY.		
621	622	623	UNIT		
624	625	626	W.T.		
627	628	629	QTY.		
630	631	632	UNIT		
633	634	635	W.T.		
636	637	6			