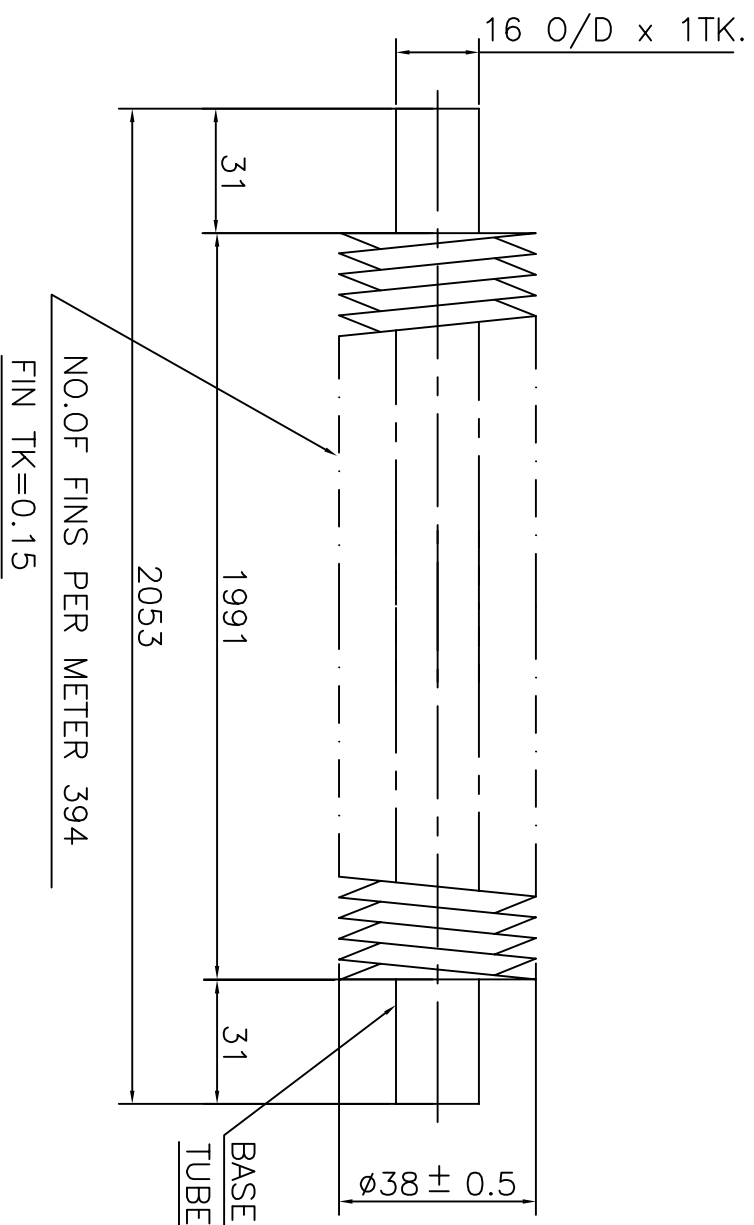


28104-90991-C.DWG



DETAIL OF ITEM 01

6. TOLERANCE
 - (a) ALL DIMENSIONS ±1 MM UNLESS OTHERWISE SPECIFIED EXCEPT IN TUBE O/D AND TK.
 - (b) TUBE O/D AND TK AS PER AA12130.
7. PACKING AND MARKING
 - (a) TUBE TO BE SUITABLY PACKED TO AVOID MOVEMENT & RUBBING.
 - (b) THE CONSIGNMENT SHOULD BE ENDORSED WITH TUBES FOR CACW COOLER.
 - (b) THE END OF TUBE TO BE CAPPED BEFORE DESPATCH.

WEIGHT OF ELEMENTS IN KG (APPROX.)		
Cu	Ni	TOTAL
2.16	0.09	2.25

NOTES :-

1. MATERIAL
 - (a) BASE TUBE TO 90-10 CU.NI TO SPECIFICATION AA12130 IN BRIGHT ANNEALED CONDITION SUITABLE FOR EXPANSION AT BOTH ENDS.
 - (b) FINNS COPPER TO IS:191 OF ELECTRICAL GRADE HAVING CONDUCTIVITY 97% MIN.
 - (c) SOLDER TO IS 193 GRADE SN 60.
2. PROCESS
 - (d) TUBE TO BE CONTINUOUSLY WOUND WITH COPPER CRIMPED FINNS. NO JOINT IN BETWEEN WILL BE ALLOWED.
 - (b) CRIMPED FINNS TO BE FIRMLY SECURED WITH TUBES TO GIVE EFFECTIVE HEAT TRANSFER AND TO WITH-STAND TRANSPORT AND OPERATIONAL HAZARDS.
 - (c) INSIDE SURFACE OF TUBES TO BE CLEAN FROM CARBONEOUS MATERIAL , DUST, OIL AND SOLDER ETC.
 - (d) ENDS OF THE TUBE TO BE SQUARE AND OUTSIDE OF THE TUBE (WITHOUT FIN) AT THE ENDS TO BE FREE FROM SOLDER FOR TUBE EXPANSION.
- (3) TESTS
 - FOLLOWING TESTS TO BE CONDUCTED ON TUBES AS PER AA12130.
 - (a) MECHANICAL TEST (b) CHEMICAL COMPOSITION TEST
 - (c) EDDY CURRENT TEST BEFORE WINDING AS PER AA12130.
 - (d) HYDRAULIC TEST AT 70 kg/cm²(g) FOR BASE TUBE AND AT 20 kg/cm² (g) AFTER FINNING.
 - (e) MERCURIUS NITRATE AND MICROSCOPIC EXAMINATION.
 - (f) FLATTENING AND DRIFT TEST.
- (4) TEST CERTIFICATES
 - 5 COPIES EACH FOR ABOVE TESTS INSPECTION
 - (a) FOR DETAIL QAP, REFER BHEL STANDARD QAP CODE-09-2706.
 - (b) TUBE TO BE INSPECTED BY BHEL I.A./ CUSTOMER AND SUPPLIER SHOULD PROVIDE PROVIDE ALL FACILITY FOR INSPECTION AT THEIR WORKS.
- (5) TOLERANCE
 - (a) ALL DIMENSIONS +1 UNLESS OTHERWISE SPECIFIED EXCEPTION TUBE OD, TUBE AND FIN TK.
 - (b) TUBE OD AND THICKNESS AS PER AA12130.

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IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN THE WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

REF. DRG. NO. SIGN. & DATE INVENTORY NO.

Sl. No.	QTY	VAR. QTY	REMARKS	VAR. IND.	IND.	DESCRIPTION	DRAWING NO.	VAR. IND.	IND.	UNIT	WT.	QTY.
59	2053					CRIMPED FIN TUBES						
64						16 O/D x 1 TK.						
65												
75												
78												
79												
25												
27												
29												
31												
34												
35												
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CRIMPED FIN CACW COOLER

ADDITIONAL INFORMATION			
STATUS OF DRAWING	28	CARD TYPE-3	
DISTRIBUTION OF PRINTS	OC - 1	HCM - 4	
ALTERED			
CHECKED			
APPROVED			
REV.	DATE	ZONE	

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		CRIMPED FIN CACW COOLER	
DEPT.CDE	AA0230208	SCALE	1:1
UNTL. DIMS. GR.	M	WEIGHT(K.G.)	1.72
CODE	411	REF. TO ASSY. DRG.	11660640
BHARAT HEAVY ELECTRICALS LTD.		BHO PAL	
S.K.B		S.K.B	
SHRIVASTAVA		SHRIVASTAVA	
AKS		AKS	
DRN.		DRN.	
SIGN.		SIGN.	
DATE		DATE	
NO. OF		NO. OF	
ITEM		ITEM	
REV.		REV.	

CRIMPED FIN TUBES

3-16606-40182 00

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