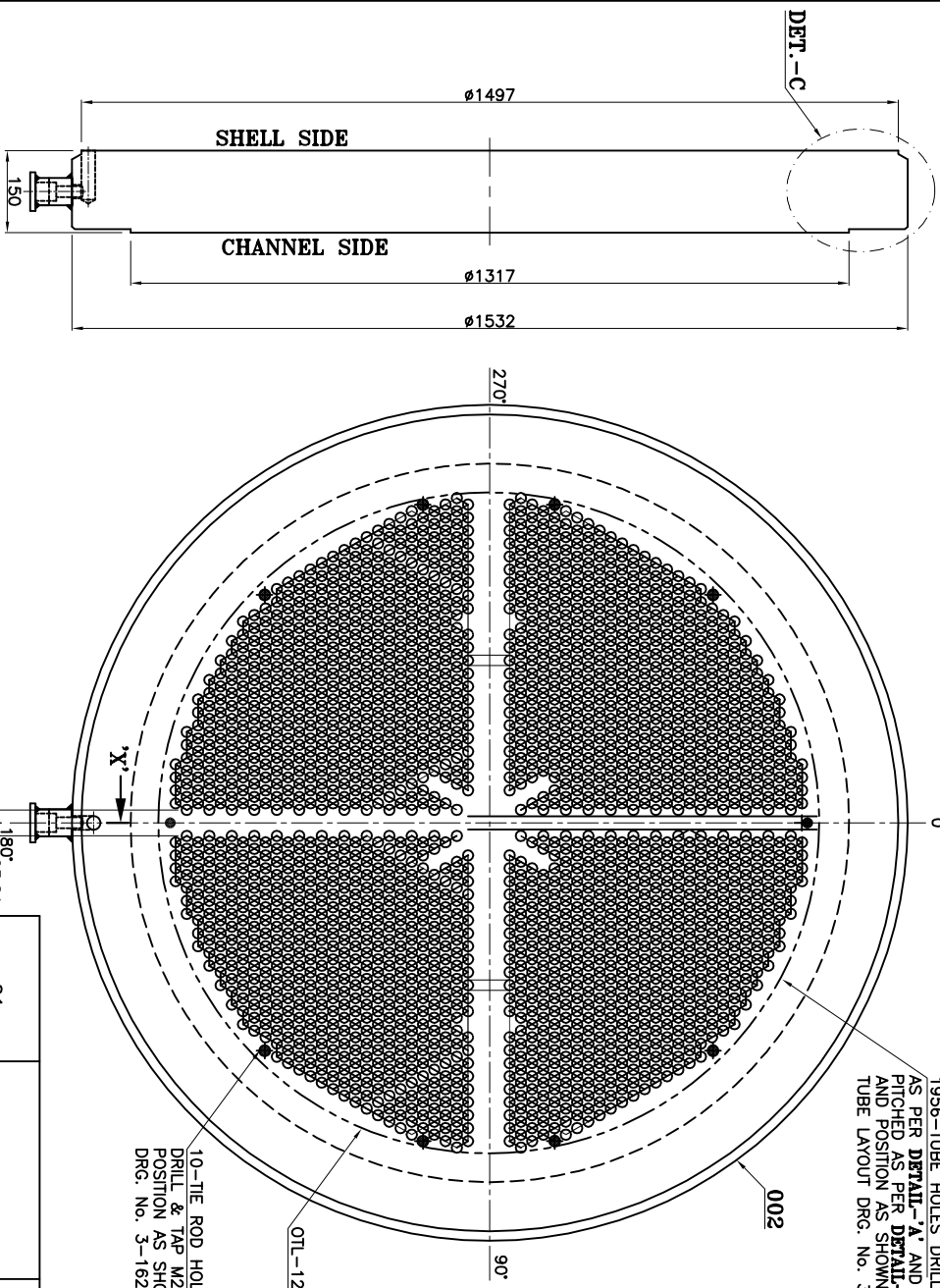
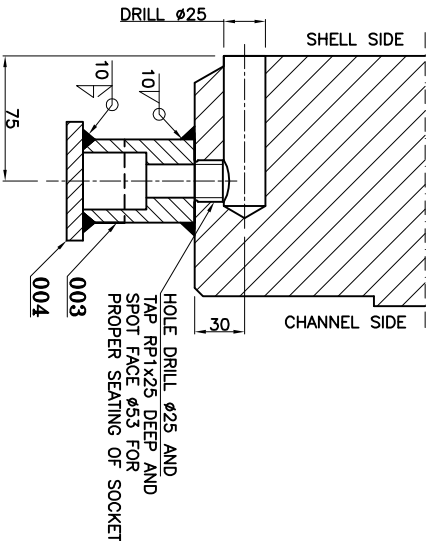


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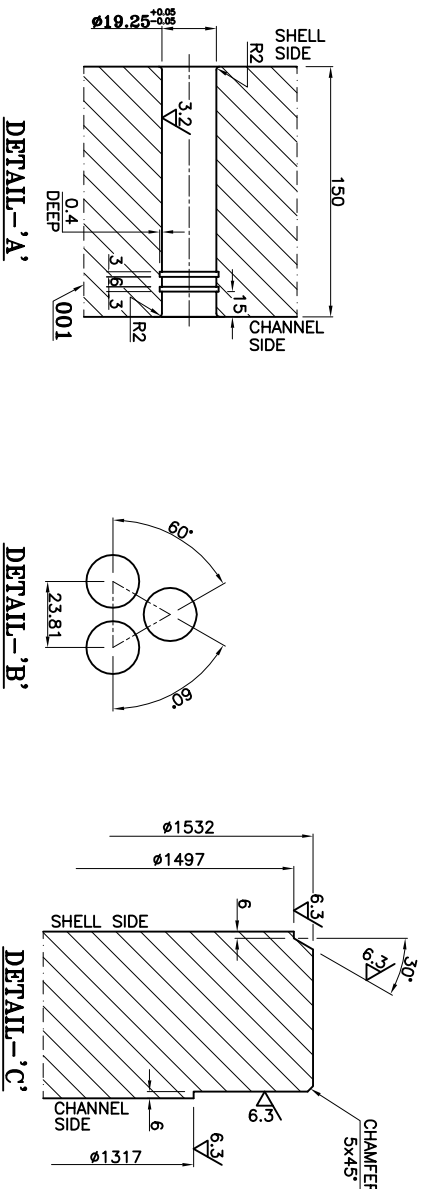
VIEW LOOKING FROM SHELL SIDE



HOLE DRILL 25 AND TAP M20x32 DEEP AND SPOT FACE 45.3 FOR PROPER SEATING OF SOCKET

1956-TUBE HOLES DRILL AS PER DETAIL-'A' AND PITCHED AS PER DETAIL-'B' AND POSITION AS SHOWN IN TUBE LAYOUT DRG. NO. 3-16222-40051.

10-TIE ROD HOLES DRILL & TAP M20x32 DEEP POSITION AS SHOWN IN TUBE LAYOUT DRG. NO. 3-16222-40051.



TECHNICAL REQUIREMENTS (TR):-

1. ALL WELDS PREPARATION TO BE MAGNETIC CRACK DETECTION TESTED AS PER AA-085133.
2. ALL PREPARATION TO BE MADE BY MACHINING MACHINE FINISH TO BE 6.3 MICRONS UNLESS OTHERWISE SPECIFIED.
3. SURFACE TO BE COATED WITH INHIBITIVE OIL AS PER TEMPORARY RUST PROTECTION.
4. FOR TUBE LAYOUT REFER DRG. NO. 3-16222-40051.
5. TUBE HOLE PITCHING TOLERANCES INDIVIDUAL: ± 0.05 (FOR 96% TUBES); +0.25/-0.05 (FOR REST OF THE TUBES).  
COMMULATIVE: ± 1.00 (BETWEEN EXTREME HOLES)
6. TOLERANCES ON OTHER DIMENSIONS, UNLESS SPECIFIED: AS PER TEMA/HE 04012.
7. COUPLING ITEM-003 TO BE WELDED ON FINAL ASSEMBLY TO FACILITATE HEATER ROLLING FOR WELDING.
8. COUPLING ITEM-003 TO BE WELDED BY QUALIFIED WELDERS ONLY & WELD TO BE CHECKED BY MAGNETIC PARTICLE EXAMINATION AS PER AA-0850133.
9. ITEM 004 IS TEMPORARY BLANK FOR HYDROSTATIC TEST.

VARNO	QTY	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	STDS	DRAWING NO.	IT. NO.	MATL. SPCN.	A No.	UNIT WT.	QTY.	ZONE
01	01			004	BLANK 12 TK.		SEE TR#9	001	AA1011808099	-	1.00		
01	01			003	COUPLING S.W. 25NB ANSI 6000#		4-16218-40174	001	B.O.	A	0.69		
01	01			002	TUBE PLATE MACHINING		3-16218-40137	001	SA105N	A	1461.0		
59	64	65	75	78	79	25	27	29					
VAR00	QTY		VAR. NO.	ITEM NO.	DESCRIPTION	STDS	DRAWING NO.	IT. NO.	MATL. SPCN.	A No.	UNIT WT.	QTY.	ZONE

28 -> CARD TYPE-3

28 -> CARD TYPE-1

28 -> CARD TYPE-2

ADDITIONAL INFORMATION  
DRG. LIST NO. 4-16200-40028  
STATUS OF DRAWING  
W.O.No. 11010/11-W-14135  
12067/68-W-14135  
DISTRIBUTION OF PRINTS  
CDE - 2 FBM - 4  
HCM - 4

NAME OF PRODUCT OR TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT  
BHARAT HEAVY ELECTRICALS LTD.  
BHO PAL

REV.	DATE	ALTERED
-	-	-
		CHECKED
		APPROVED

DEPT. CODE	UNTL. DIMS. GR.	SCALE	WEIGHT(K.G.)
411	M	-	1462.7
CODE	AA0230208		

TUBE PLATE MACHINING  
DRAWING NO. 3-16218-40155  
SHT. NO. 1 OF 1

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