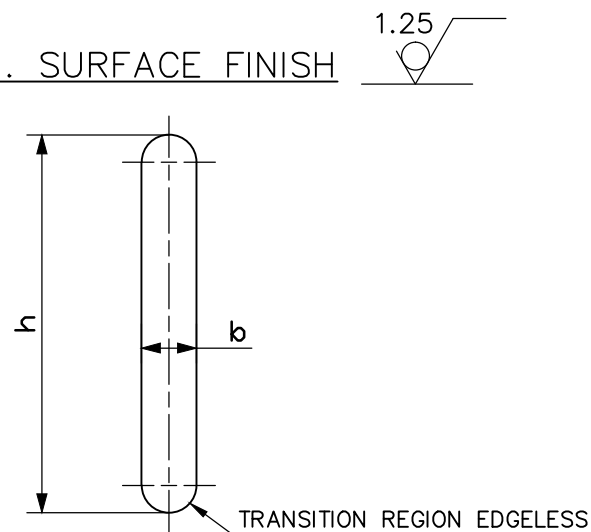


APPLICABLE SPECIFICATION : PC-M-963

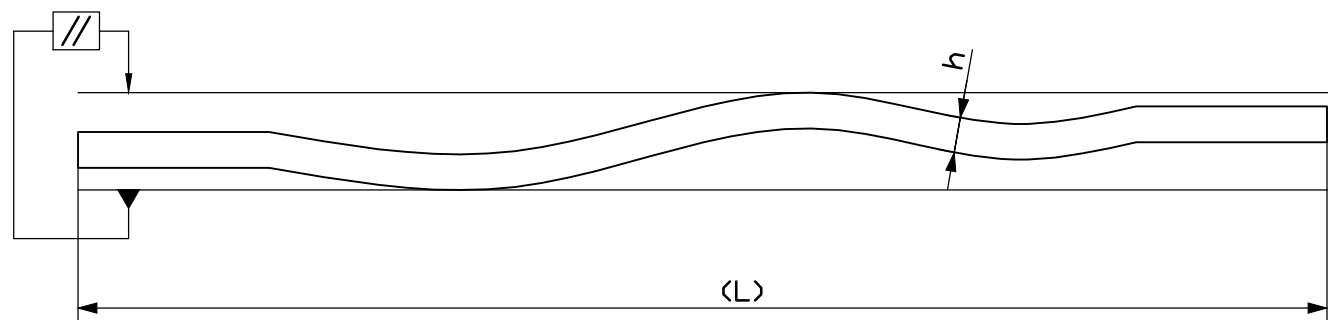
SHAPE AND SURFACE FINISH OF FLATS

1. SURFACE FINISH



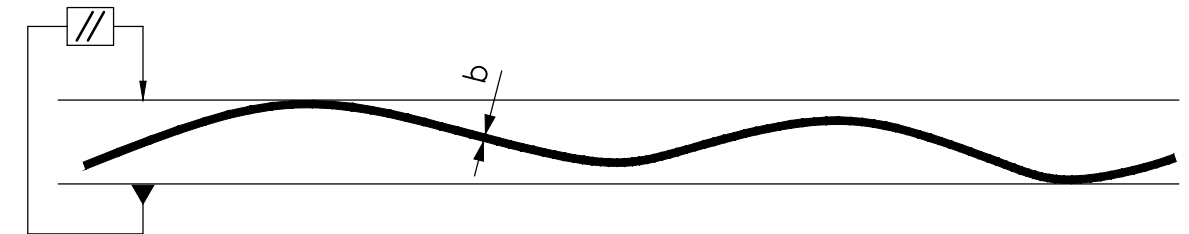
h	b
$60^{+0.2}_{-0.0}$	$2.9^{+0.0}_{-0.1}$
$20^{+0.2}_{-0.0}$	$2.9^{+0.0}_{-0.1}$

2. STRAIGHTNESS



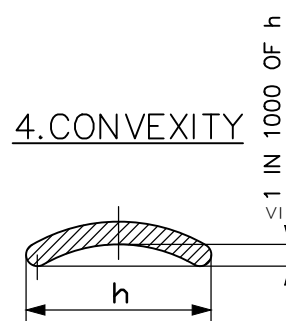
1. STRAIGHTNESS RELATED TO ANY MEASURED LENGTH ≥ 250 : MAX 1 IN 1000 OF MEASURED LENGTH.
2. FOR FLATS < 250 : MAX 0.25

3. WAVINESS AND ANGULAR DEFLECTION



1. WAVINESS RELATED TO ANY MEASURED LENGTH ≥ 250 : MAX 1 IN 1000 OF MEASURED LENGTH.
2. FOR FLATS < 250 : MAX 0.25
3. ANGULAR DEVIATION RELATED TO ANY MEASURED LENGTH ≥ 250 : MAX 0.3 IN 1000 OF MEASURED LENGTH.
4. FOR FLATS < 250 : MAX 0.075

4. CONVEXITY



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TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT

700MWe/GHAVP-1&2



Bharat Heavy Electricals Ltd
UNIT: HIGH PRESSURE BOILER PLANT
TIRUCHIRAPALLI - 620014

DRN
CHD
APPD

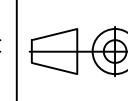
NAME
N.K
NKK/SM
AS

SIGNATURE
DATE
120814
120814
120814

NO. OF
VAR

DEPT
NC
CODE
150

GRADE OF
UNTOL. DIM
C/M/F



SCALE
NTS

WEIGHT (Kg)
--

REF TO ASSY / OLD DWG

ITEM
NO

No OF
ITEMS

TITLE
MANUFACTURING
FORM TOLERANCES FOR
PROFILE OF GRID FLATS

CARD
CODE
U 01

DRAWING NO :
3-93-170-05304

REV
00

REV	DATE	ALTERED :
		CHD&APPD :