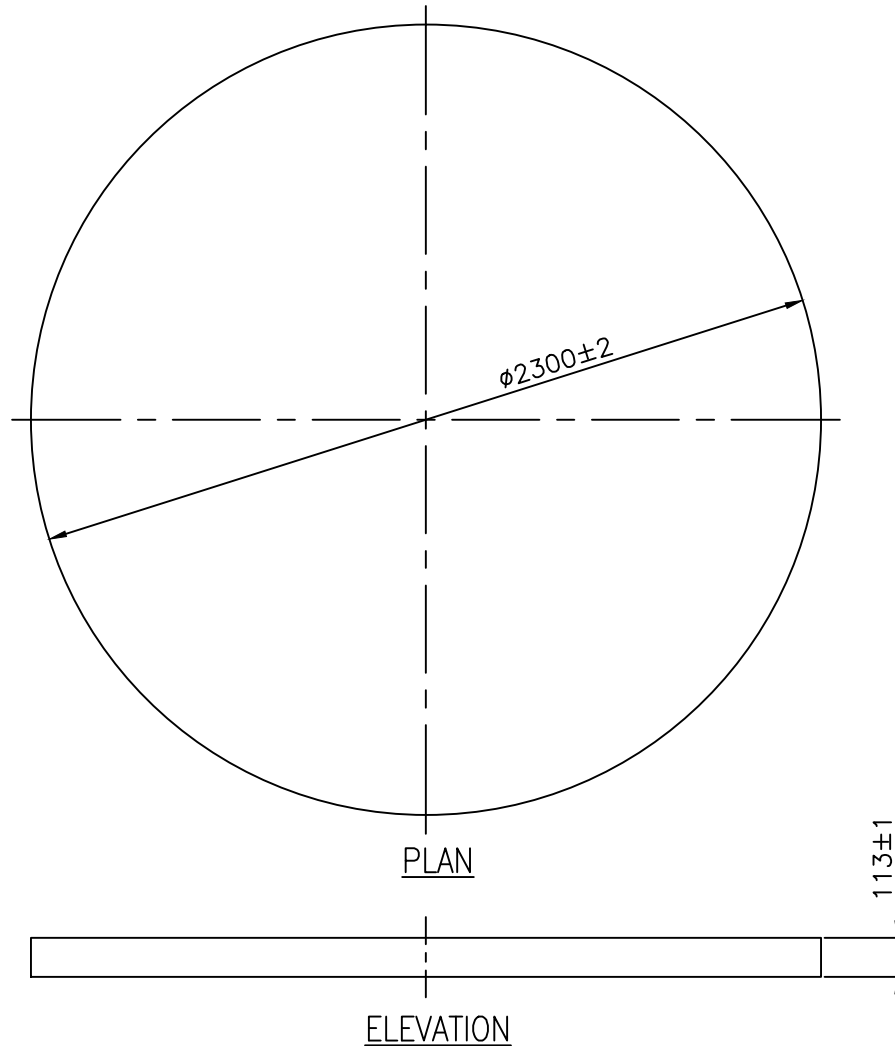


| | |
|--------------------------|------------------------|
| MATERIAL-AL ALLOY 5154-0 | |
| CONDITION-ANNEALED | BLANK WEIGHT ~ 1270 Kg |

Note:-

1. All dimensions are in mm. Only written dimension shall be followed. Scaling of dimension is not allowed.
2. Tensile test specimen's type and it's locations in the forging shall be as per ASTM-B557.
3. 100% UT with 10% overlap shall be conducted before and after annealing, other tests shall be carried out as per technical specification.
4. Surface finish shall be 6.3micron or better (all over.)
5. All edges shall be Chamfer to 1X45°.
6. Chemical composition shall be as per technical specification.
7. The dimensions shown are finished dimensions in proof machined condition, extra material required for forging shall be considered by the fabricator. The extra material kept during rough machining shall be decided mutually by vendor and purchaser.



TITLE :

TOP ENCLOSURE BLANK

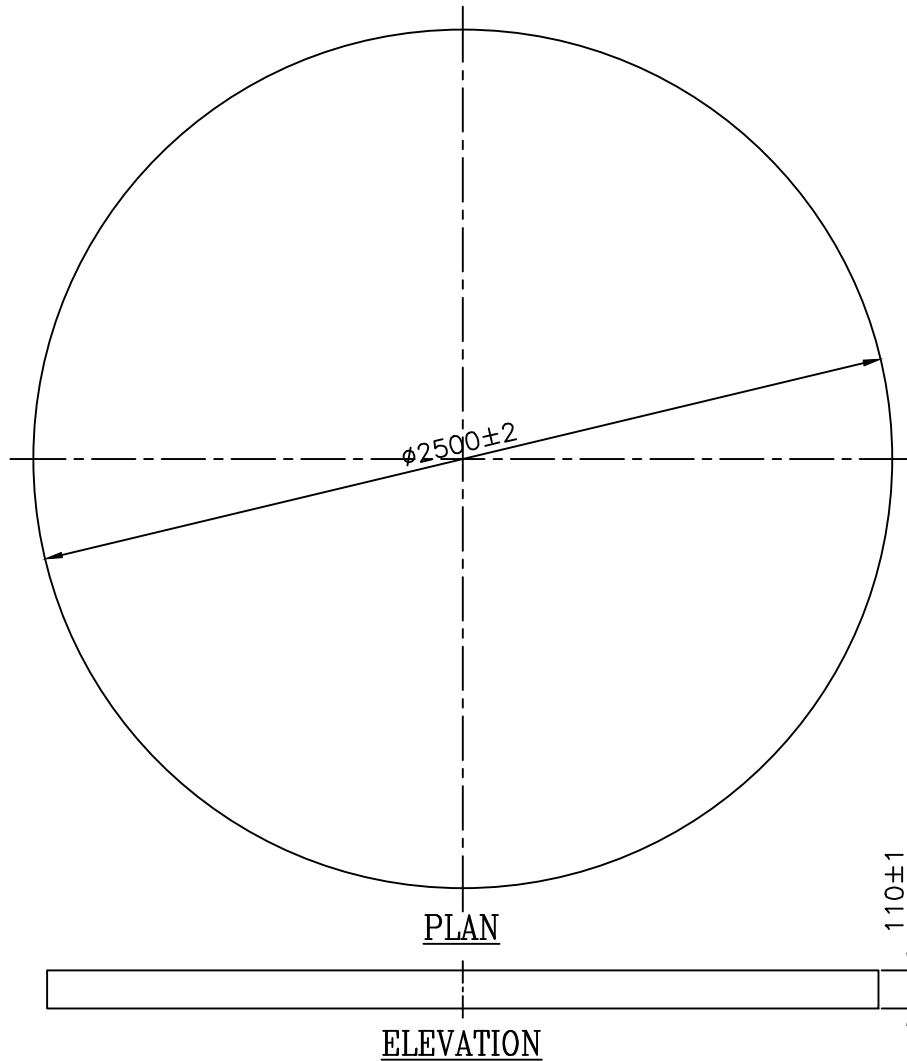
TENDER DRAWING

| | |
|-----------------------------------|--------|
| APP'D. | DATE: |
| PROJECTION: | |
| SCALE:- | NTS |
| FILE NAME: HFRR-31140-3005-DD.drg | |
| DRG. NO. A4/HFRR/31140/3005/DD | |
| SHEET | 1 OF 8 |
| REV. R0 | |

| | |
|--------------------------|------------------------|
| MATERIAL-AL ALLOY 5154-0 | |
| CONDITION-ANNEALED | BLANK WEIGHT ~ 1460 Kg |

Note:-

1. All dimensions are in mm. Only written dimension shall be followed. Scaling of dimension is not allowed.
2. Tensile test specimen's type and it's locations in the forging shall be as per ASTM-B557.
3. 100% UT with 10% overlap shall be conducted before and after annealing, other tests shall be carried out as per technical specification.
4. Surface finish shall be 6.3micron or better (all over.)
5. All edges shall be Chamfer to 1X45°.
6. Chemical composition shall be as per technical specification.
7. The dimensions shown are finished dimensions in proof machined condition, extra material required for forging shall be considered by the fabricator. The extra material kept during rough machining shall be decided mutually by vendor and purchaser.



TITLE : **BOTTOM ENCLOSURE BLANK**

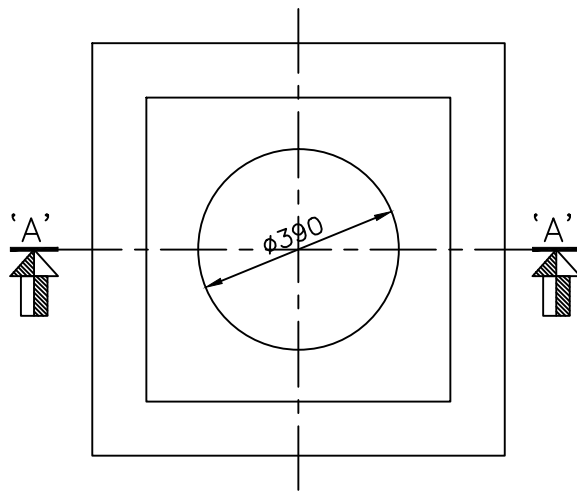
TENDER DRAWING

| | |
|-----------------------------------|--------|
| APP'D. | DATE: |
| PROJECTION: | |
| SCALE:- | NTS |
| FILE NAME: HFRR-31140-3005-DD.drg | |
| DRG. NO. A4/HFRR/31140/3005/DD | |
| SHEET | 2 OF 8 |
| REV. R0 | |

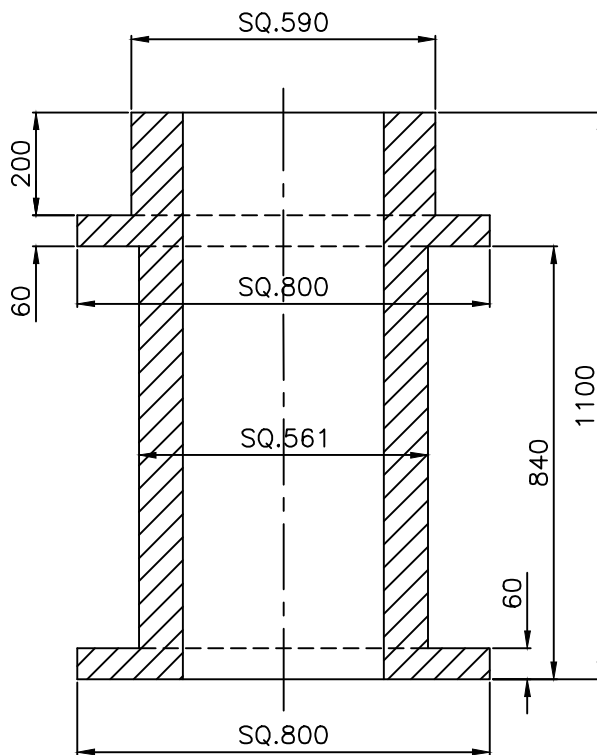
MATERIAL-AL ALLOY 5052-0

CONDITION-ANNEALED

BLANK WEIGHT ~735 Kg



PLAN



SECTION A-A

Note:-

1. All dimensions are in mm. Only written dimension shall be followed. Scaling of dimension is not allowed.
2. Tensile test specimen's type and it's locations in the forging shall be as per ASTM-B557.
3. 100% UT with 10% overlap shall be conducted before and after annealing, other tests shall be carried out as per technical specification.
4. Surface finish shall be 6.3micron or better (all over.)
5. All edges shall be Chamfer to 1X45°.
6. Chemical composition shall be as per technical specification.
7. The dimensions shown are finished dimensions in proof machined condition, extra material required for forging shall be considered by the fabricator. The extra material kept during rough machining shall be decided mutually by vendor and purchaser.

TITLE :

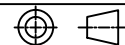
INNER SHELL FORGING

TENDER DRAWING

APP'D.

DATE:

PROJECTION:



SCALE:- NTS

FILE NAME: HFRR-31140-3005-DD.drg

DRG. NO.

A4/HFRR/31140/3005/DD

SHEET

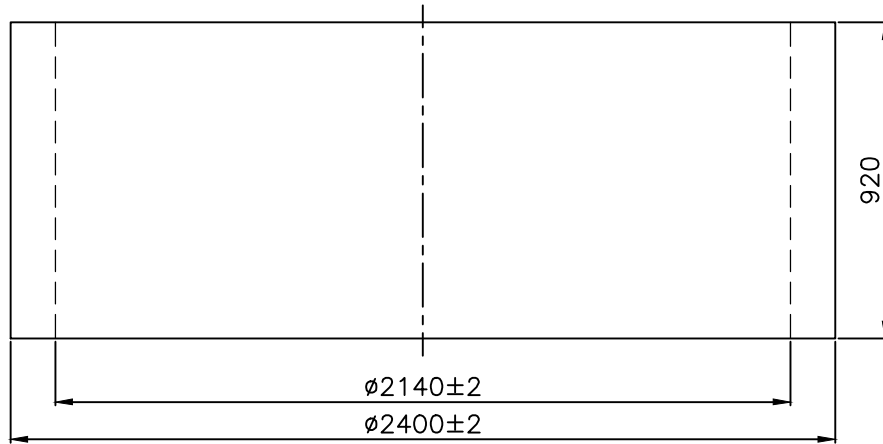
3 OF 8

REV. R0

| | |
|--------------------------|----------------------|
| MATERIAL-AL ALLOY 5154-0 | |
| CONDITION-ANNEALED | BLANK WEIGHT 2300 Kg |

Note:-

1. All dimensions are in mm. Only written dimension shall be followed. Scaling of dimension is not allowed.
2. Tensile test specimen's type and it's locations in the forging shall be as per ASTM-B557.
3. 100% UT with 10% overlap shall be conducted before and after annealing, other tests shall be carried out as per technical specification.
4. Surface finish shall be 6.3micron or better (all over.)
5. All edges shall be Chamfer to 1X45°.
6. Chemical composition shall be as per technical specification.
7. The dimensions shown are finished dimensions in proof machined condition, extra material required for forging shall be considered by the fabricator. The extra material kept during rough machining shall be decided mutually by vendor and purchaser.



TITLE :

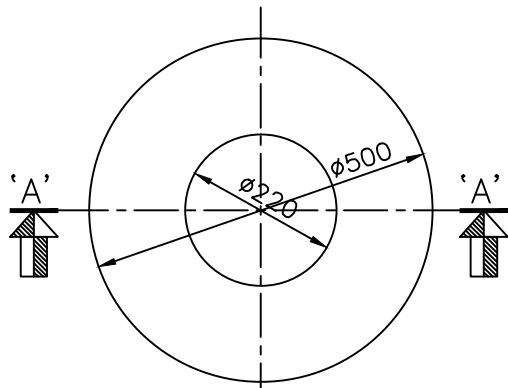
OUTER SHELL RING FORGING

TENDER DRAWING

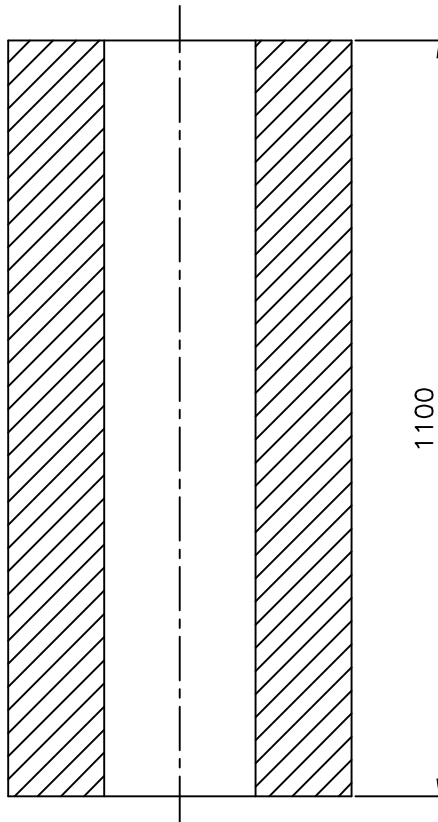
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|-----------------------------------|---------|
| APP'D. | DATE: |
| PROJECTION: | |
| SCALE:- NTS | |
| FILE NAME: HFRR-31140-3005-DD.drg | |
| DRG. NO. A4/HFRR/31140/3005/DD | |
| SHEET | REV. R0 |

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| |
|--------------------------|
| MATERIAL-AL ALLOY 5154-0 |
| CONDITION-ANNEALED |
| BLANK WEIGHT 470 Kg |



PLAN



SECTION A-A

Note:-

1. All dimensions are in mm. Only written dimension shall be followed. Scaling of dimension is not allowed.
2. Tensile test specimen's type and it's locations in the forging shall be as per ASTM-B557.
3. 100% UT with 10% overlap shall be conducted before and after annealing, other tests shall be carried out as per technical specification.
4. Surface finish shall be 6.3micron or better (all over.)
5. All edges shall be Chamfer to 1X45°.
6. Chemical composition shall be as per technical specification.
7. The dimensions shown are finished dimensions in proof machined condition, extra material required for forging shall be considered by the fabricator. The extra material kept during rough machining shall be decided mutually by vendor and purchaser.

TITLE :

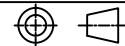
OBROUND PIECE FORGING

TENDER DRAWING

APP'D.

DATE:

PROJECTION:



SCALE:- NTS

FILE NAME: HFRR-31140-3005-DD.drg

DRG. NO.

A4/HFRR/31140/3005/DD

SHEET

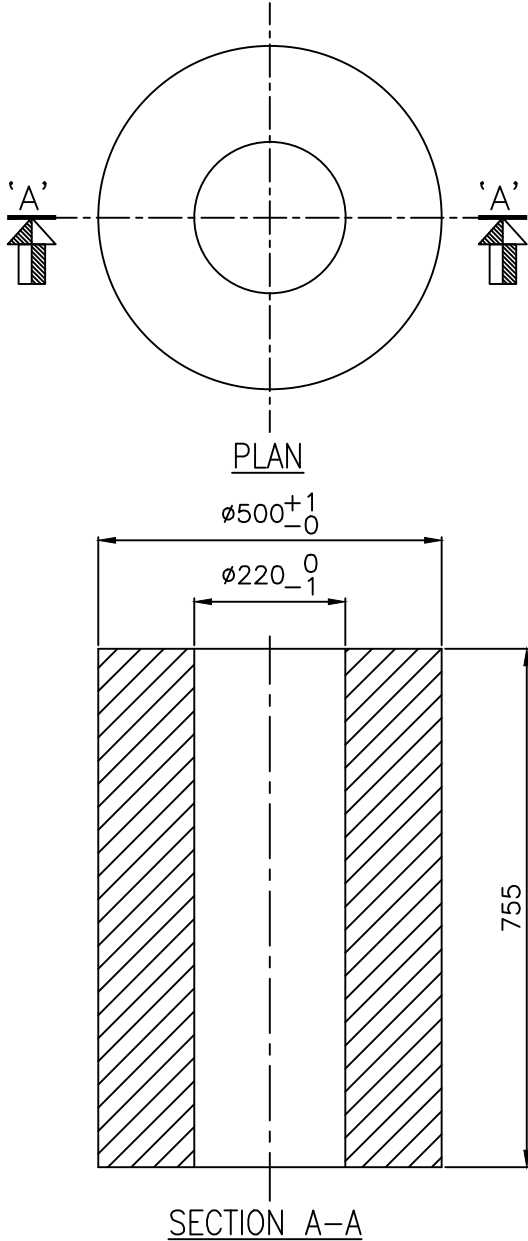
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REV. R0

| |
|--------------------------|
| MATERIAL-AL ALLOY 5154-0 |
| CONDITION-ANNEALED |
| BLANK WEIGHT 340 Kg |

Note:-

1. All dimensions are in mm. Only written dimension shall be followed. Scaling of dimension is not allowed.
2. Tensile test specimen's type and it's locations in the forging shall be as per ASTM-B557.
3. 100% UT with 10% overlap shall be conducted before and after annealing, other tests shall be carried out as per technical specification.
4. Surface finish shall be 6.3micron or better (all over.)
5. All edges shall be Chamfer to 1X45°.
6. Chemical composition shall be as per technical specification.
7. The dimensions shown are finished dimensions in proof machined condition, extra material required for forging shall be considered by the fabricator. The extra material kept during rough machining shall be decided mutually by vendor and purchaser.



TITLE :

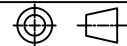
TRANSITION PIECE FORGING

TENDER DRAWING

APP'D.

DATE:

PROJECTION:



SCALE:- NTS

FILE NAME: HFRR-31140-3005-DD.drg

DRG. NO.

A4/HFRR/31140/3005/DD

SHEET

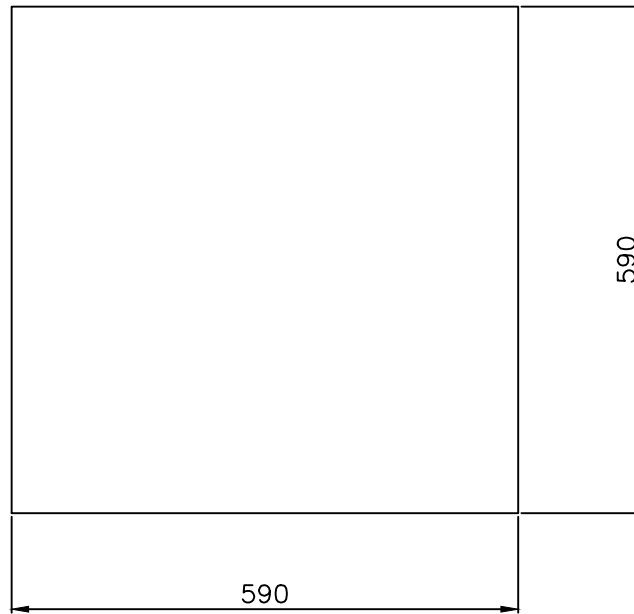
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REV. R0

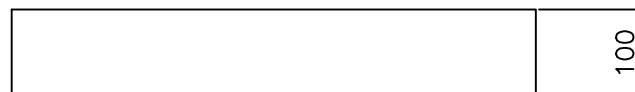
| | |
|--------------------------|--------------------|
| MATERIAL-AL ALLOY 5154-0 | |
| CONDITION-ANNEALED | BLANK WEIGHT 95 Kg |

Note:-

1. All dimensions are in mm. Only written dimension shall be followed. Scaling of dimension is not allowed.
2. Tensile test specimen's type and it's locations in the forging shall be as per ASTM-B557.
3. 100% UT with 10% overlap shall be conducted before and after annealing, other tests shall be carried out as per technical specification.
4. Surface finish shall be 6.3micron or better (all over.)
5. All edges shall be Chamfer to 1X45°.
6. Chemical composition shall be as per technical specification.
7. The dimensions shown are finished dimensions in proof machined condition, extra material required for forging shall be considered by the fabricator. The extra material kept during rough machining shall be decided mutually by vendor and purchaser.



PLAN



ELEVATION

TITLE :

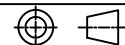
CHIMNEY FLANGE BLANK

TENDER DRAWING

APP'D.

DATE:

PROJECTION:



SCALE:- NTS

FILE NAME: HFRR-31140-3005-DD.dwg

DRG. NO.

A4/HFRR/31140/3005/DD

SHEET

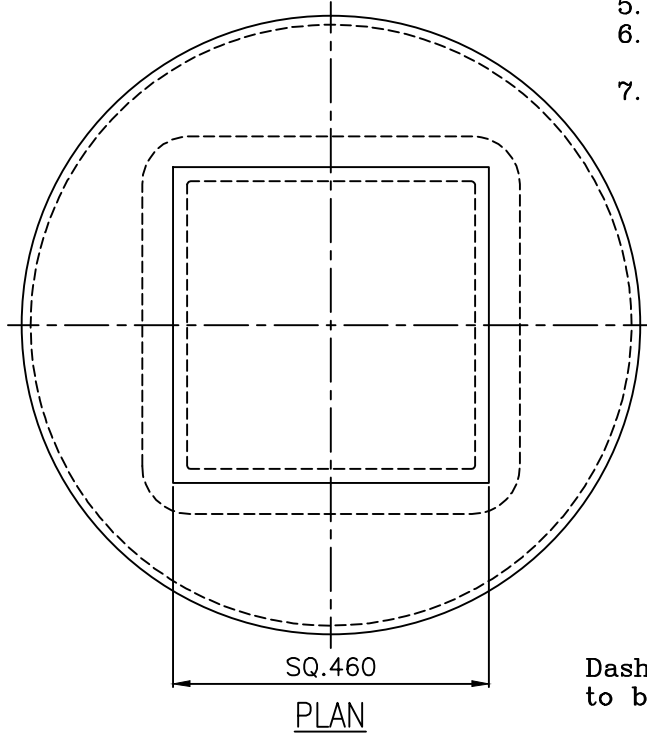
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REV. R0

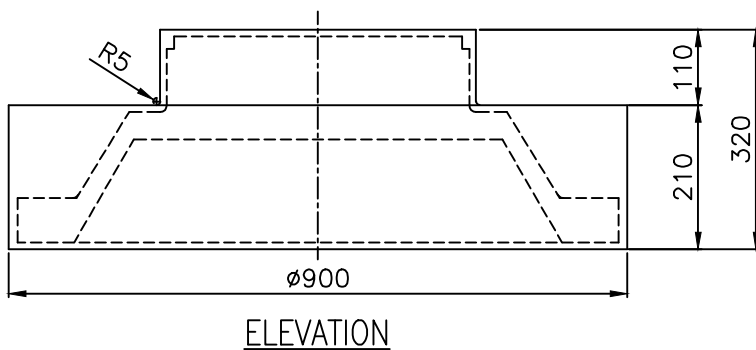
| |
|--------------------------|
| MATERIAL-AL ALLOY 6061T6 |
| CONDITION-ANNEALED |
| BLANK WEIGHT ~425 Kg |

Note:-

1. All dimensions are in mm. Only written dimension shall be followed. Scaling of dimension is not allowed.
2. Tensile test specimen's type and it's locations in the forging shall be as per ASTM-B557.
3. 100% UT with 10% overlap shall be conducted before and after annealing, other tests shall be carried out as per technical specification.
4. Surface finish shall be 6.3micron or better (all over.)
5. All edges shall be Chamfer to 1X45°.
6. Chemical composition shall be as per technical specification.
7. The dimensions shown are finished dimensions in proof machined condition, extra material required for forging shall be considered by the fabricator. The extra material kept during rough machining shall be decided mutually by vendor and purchaser.



Dashed lines shows finished component to be fabricated from blank.



TITLE :

GRID PLATE

TENDER DRAWING

APP'D. DATE:

PROJECTION:

SCALE:- NTS

FILE NAME: HFRR-31140-3005-DD.drg

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