

		TECHNOLOGICAL PROCESS NOT FOR PROCESS SHEET PRINT			Production Order	Date	
Plant: P006	Equipment No: HEH2321			101588746	06.05.2015		
Type	WBS Element	Customer			Part No		
	P-1032236100-17505	GSECL			17505003		
Drawing No.-Var	E.Rev.	T.Rev	Material No.	Name Of The Part			
31750102328	01		31750102328-01	TUBE SHEET FOR HPH-6A/6B			
Pos.No	BOM Qty	Ord Qty	MU	St.	Nt.Wt.	Remarks	MDCC
0001	1.000	1.000	EA	IS06	9,876.200		NO

BOM Details

Pos.No	IC	Material Code	P.No	Remarks					
Matl.Spec	SPK	Qty	MU	Size 1	Size 2	Size 3	Formula Key	MPcs	St.
0001	L	HE9717194220	17505004	MA BY QC,CIB AND LLOYDS.					
HE51155-NA		1.000	EA	0.000	0.000	0.000		0.000	ST06
Material Description : TUBESHEET FORGING				Reservation :	Item : 0001	Picklist:			
				0009266905					

Operation Details

Opr No	W.C.	Plant	Ctl. ky	Prep Time	Time/ PC(M)	Time/ PC(L)	Total Time	QC Signature
PRT Cat	PRT No.			PRT Description				
Sub Operation Text								
0011	DA9995	P006	ZP99	0.000	0.000	0.000	0.000	

SCOPE OF WORK

Note:- This scope of work is valid for Tube sheet drilling of Wanakbori
1 x 800 MW

H.P.Heaters 6A,6B,7A,7B,8A and 8B.

Tube layout drg.no. :,3-17501-02329 Rev.00 Common drg. for all HP
Heaters of Wankbori.


Tube sheet drg.no. :,3-17501-02328 Rev.01 -- HP Heater - 6A and 6B.

Tube sheet drg.no. :,3-17505-01000 Rev.00 -- HP Heater - 7A and 7B.

Tube sheet drg.no. :,3-17501-01010 Rev.00 -- HP Heater - 8A and 8B.

- 1.,,Tube sheet shall be loaded on vendors who were having the deep hole drilling machine facility. Drilling depth 475 mm minimum.
- 2.,,A certificate to be produced along with technical bid by mentioning machine specifications , make and date of manufacturing of machine and machine condition.
- 3.,,Tube sheet forging will be supplied with Stainless steel overlay and machining and inspections of overlaid surface.
- 4.,,Tube sheet supplied with material attestation marks by concerned inspection agencies.
- 5.,,Mock up piece - 1 no. per machine shall be made and available for our BHEL QC and M/s Lloyds inspection with vendor material prior to start tube holes drilling on actual job. Two clusters of 7 holes each length of 475 mm minimum.
- 6.,,Clearance for drilling of tube holes to be taken from the BHEL nominated inspection agency.
- 7.,,All notes given on Tube sheet drawing shall be followed.
- 8.,,Mark axis on as per drawing and punch on marking at ends for further reference.
- 9.,,Every marking on tube sheet shall get inspection by BHEL nominated inspection agency.
- 10.,,All Tube holes to be drilled in single setting.
- 11.,,Get inspection of Tube holes after every 10 cycles for finish

Chkd. By	Dt.	ECR/ Rev No	Dt.	Pro.Plnr	Rate Fixr / Tool Plnr	Pg no	No.of Pgs
	25.07.2015					1	2

		TECHNOLOGICAL PROCESS				Production Order	Date
Plant:P006		Equipment No: HEH2321				101588746	06.05.2015
Type		Work Order / PGMA		Customer			Part No
		P-1032236100-17505/ 17505		GSECL			17505003
Drawing No.-Var		E.Rev.	T.Rev.	Material No.		Name Of The Part	
31750102328		01		31750102328-01		TUBE SHEET FOR HPH-6A/6B	
Pos.No	BOM Qty	Ord Qty	MU	St.	Nt.Wt.	Remarks	
0001	1.000	1.000	EA	IS06	9,876.200		
Operation Details							
Opr No	W.C.	Plant	Ctl. ky	Prep Time	Time/ PC(M)	Time/ PC(L)	QC Signature
PRT Cat	PRT No.			PRT Description			
Sub Operation Text							
<p><> ovality<> ligament and drift. 12.,,Tube holes finish as indicated in the drawing shall be maintained. 13.,,Tube holes shall be drilled according to tube holes layout and as per tube sheet drawing. 14.,,Drift on Tube holes will not be acceptable. 15.,,Tie rod holes to be drilled and tapped on shell side as per drawing. 16.,,T3, T4 and T5 Tapped holes on periphery shall be done as per respective details of the drawing. 17.,,Chamfering of Tube holes both on shell side and Tube side shall be done as per det.-P of drg. 18.,,Get dimensional inspection of tube holes for layout, tube hole finish, ovality, ligament and drift. 19.,,Tube holes shall be answered to the BHEL supplied Go-No Go gauge. 20.,,Any deviation on the job is not acceptable. 21.,,Easily removable rust preventive shall be applied on all machined surfaces. 22.,,Machining of shell side step as per det.-R and tube side weld bevel as per det.-Q will be carried out at our BHEL works. 23.,,Submit dimensional report sheet along with dispatch of Tube sheet. 24.,,Machined Tube sheet shall be covered properly while transportation. BHEL will not provide any packing material.</p>							

Chkd. By	Dt.	ECR/ Rev No	Dt.	Pro.Plnr	Rate Fixr / Tool Plnr	Pg no	No.of Pgs
	25.07.2015					2	2