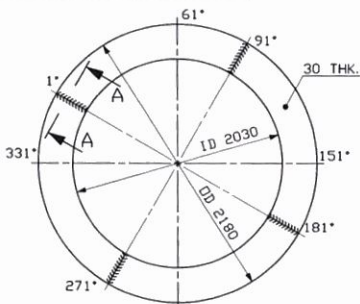
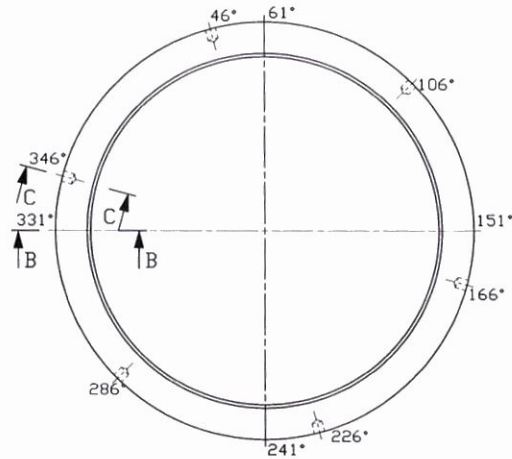


DRAWING NO. 2-93-171-05257



**SPACER RING**  
(NTS)  
(BEFORE MACHINING)



**SPACER RING**  
(NTS)  
(AFTER MACHINING)

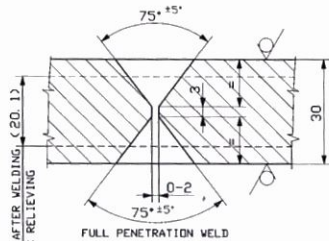
ALL DIMENSIONS ARE IN MILLIMETERS



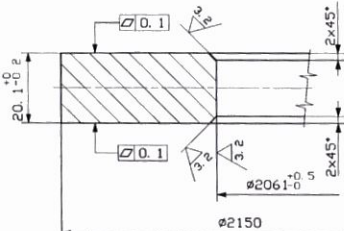
**NOTES: -**

- WELD EDGES SHALL BE SUBJECTED TO P.T AS PER RELEVANT SPECIFICATIONS.
- FIRST AND FINAL PASSES OF THE WELDS SHALL BE SUBJECTED TO P.T/M.T & 100% R.T AS PER RELEVANT SPECIFICATIONS.
- ENOUGH CARE SHALL BE TAKEN AND USE PROPER WELDING FIXTURE TO MINIMIZE THE WELD DISTORTION.
- MACHINING OF RING SHALL BE CARRIED OUT AFTER STRESS RELIEVING OF WELDED RING.
- Ø12 HOLE, SHOWN IN SECTION-CC IS FINISH MACHINED DURING ASSEMBLY REFER SECTION-GG OF DRG. NO. 0-93-171-05207 (GRID FLATS ASSEMBLY)
- TO RETAIN RING FLATNESS USE APPROVED RIGID MACHINED TRANSPORTATION STRUCTURE.
- ALL THE WELD SHALL BE GROOVED BACK TO SOUND METAL BEFORE WELDING FROM SECOND SIDE.
- MANUFACTURING OF SPACER RING FROM DIN 17195-1.5415 (15Mo3/16Mo3) MATERIAL SPECIFICATION IS ALSO PERMISSIBLE.

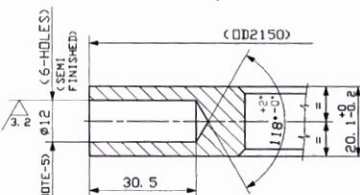
*Not applicable for AOPC/SC-SA21/02*  
*Kranthi Kumar 14/11/2022*



**SECTION-AA**  
(1:1)  
JT. NO. SA21/105 TO 156  
(SEE NOTE-3&7)



**SECTION-BB**  
(1:1)  
(MACHINED CONDITION)  
(SEE NOTE-4)



**SECTION-CC**  
(1:1)  
ORIENTATION AT 46°, 106°, 166°, 226°, 286° & 346°

LAST WELD JT. NO. 156

GENERAL TOLERANCES:  
 FOR FABRICATION : ±1.5  
 FOR ANGLES : ±1°  
 FOR MACHINING : IS 2102-m  
 FOR WELDING : DIN EN ISO 13920:1996-11

TOLERANCE IF NOT SPECIFIED SHALL BE AS BELOW (REFER IS 2102-m)

LINEAR		ANGULAR	
0.5 TO 3	±0.1	400 TO 1000	±0.8
3 TO 6	±0.1	1000 TO 2000	±1.2
6 TO 30	±0.2	2000 TO 4000	±2.0
30 TO 120	±0.3	-	120 TO 400
120 TO 400	±0.5	-	OVER 400

REV	DATE	ALTERED
01	02/11/18	CHDA/PPD

NOTE-2 REVISED, BASED ON NPCTL COMMENTS.

SPACER RING PL. 30		DIN EN10028-2:1.5415(16Mo3)		46.500					
VARIANT NUMBER	ITEM NUMBER	DESCRIPTION	STD	DRAWING NUMBER/SIZE	ITEM NO	MATERIAL CODE	UNIT WEIGHT	QUANTITY	ZONE

TYPE OF PRODUCT		700MWe Steam Generator					
OR NAME OF		W.O.No.: D157 TO D160-001-1-93-171-GHVP-1&2					
CUSTOMER/PROJECT		(Customer Drg: GHAVP-1&2/3311/4047/DD/REV:00)					
Bharat Heavy Electricals Ltd		TIRUCHIRAPALLI - 620014					
DEPT	NC	GRADE OF UNTOOL DIM	SCALE	WEIGHT (Kg)	REP TO ANY / OLD DRG	ITEM NO	NO. OF PAGES
06-259/D	01	C/M/P	1:1 : NTS	46.500	0-93-171-05207	01	01
TITLE		DRAWING NO :		REV			
SPACER RING		2-93-171-05257		01			

CAUTION: The information on this drawing is the property of Bharat Heavy Electricals Ltd. It is not to be used directly or indirectly in any way detrimental to the interest of the company.