PRITHPAL ENTERPRISES

Specialist in All Type of Machining Work, Tube Sheet Drilling, Reaming & Grooving, Tube Expanding, Retubing Job & Fabrication.
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Report No :	01
Date :	20-10-2018
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Client: GE Power	Equipment No: HP HEATER	Drawing No.	Sheet No:	4-1 4.2	4-2
Inspection By: GBCL	Godrej Project No: PCL000023	4HE-E-992	Rev. No:	1	
Item No: 301	Type of Tube sheet: STATIONARY TUBESHEET				

Sr. No	Description	Specified	Permissible	Actual	Remarks
1	O/D of the Tube sheet	1970	+2,0	1970	
2	Step Detail A2 on shell side	NA	--	NA	
3	Tube side O/D , I/D Detail A1	NA	--	NA	
4	Weld Overlay On Shell side	NA	--	NA	
5	Detail A4 Tube Sheet O/D	NA	--	NA	
6	Overall thickness of Tube sheet	590+10, 640	--	602 (590 + 10)	
7	Ligament size	4.55	4.55 Mini. Normal, 3.81 Mini. 3.66 Absolute	As per Annexure	
8	Pitch Distance	35.75 x 20.64, Angular (60°)	--	35.75 x 20.64 OK	
9	Tube Sheet Hole size	16.08	+0.15 for 96%, +0.3/+0.00 for 4%/	Go-16.08 No Go -16.23	
10	Chamfer on Tube Hole on Tube Side	Tube side R2 (2wd x 2dp)	-	OK	
11	Number of tube holes	2216	-	2216	
12	Chamfer on Tube Hole on shell Side	R1	-	OK	
13	Tie rod holes	8 No x M18 x 40Deep (35 Thread Length)	-	8 No x M18 x 40Deep (35 Thread Length)	
14	Degree Punching	0°-90°-180°-270°	-	0°-90°-180°-270°	
15	Tube Hole Lay-out Distance from CTR.	41.28 Typ. As per Drg.	-	41.28 Typ. As per Drg	
16	Tube Hole Layout	AS PER DRAWING	-	OK	
17	Hole finish	Ra 3.2	-	OK	
18	Perpendicularity of Holes	⊥0.15/1000	-	⊥0.15/1000	
19	Flatness & Parallelism	0.12 Flatness on Shell side, 0.3 Parallelism On Tube side with Shell side	-	0.12 Flatness on Shell side, 0.3 Parallelism On Tube side with Shell side	
20	Visual	--	-	-	
21	Material markings on Tube sheet	PCL000023 #301			

Remarks: Visual Inspection of offered Tubesheet Carried out found non Serration marks. Stamping done.

PRITHPAL ENTERPRISES RABALE Engineer-QC Date:	Dimensional Inspection of offered Some Deviation observed for Dimension. Report Client Date:	for Divine Engg. A.K. Mishra Surveyor Date: 20/10/18

ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE MENTIONED.