



Sales Dept <sales@shubhlaxmigroup.com>

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## Fwd: Approval from NPCIL for manufacturing of Tubes.

1 message

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**Vivek Shah** <vivek.shah@shubhlaxmigroup.com>

Sat, Jan 12, 2013 at 3:43 PM

To: Sales Dept <sales@shubhlaxmigroup.com>

----- Forwarded message -----

From: **Manish Tak** <Manish.Tak@larsentoubro.com>

Date: Thu, Jan 3, 2013 at 9:38 AM

Subject: Approval from NPCIL for manufacturing of Tubes.

To: "vivek.shah@shubhlaxmigroup.com" <vivek.shah@shubhlaxmigroup.com>, "qc@shubhlaxmigroup.com" <qc@shubhlaxmigroup.com>, "PANKAJ JAIN (pcjain@shubhlaxmigroup.com)" <pcjain@shubhlaxmigroup.com>

Dear All,

Please find attached MOM in which NPCIL has given approval to M/s Shubhlaxmi for manufacturing of tubes.

Your effort came into good results. You have to maintain the same in future also.

Now we have to gear up the production in real speed.

Dear Vimal,

As discussed thru phone, please give load for first stage as per QAP available with you. Approval of the same will be done today from NPCIL.

If any query you can call at any time.

Regards,

Manish Tak

PMG-Nuclear

Larsen & Toubro Limited

[www.larsentoubro.com](http://www.larsentoubro.com)

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**MINUTES OF MEETING**

**Venue** : L&T Hazira Manufacturing complex.

**Subject** : Review of End shields for KAPP-3, 4 & RAPP-7,8

**Date of Meeting** : 02/01/2013

**P.O. Nos.** : CMM/FTP/1020/PO/ 6011 & 6362  
CMM/FTP/22-31-1-1085/PO/6396  
CMM/FTP/23-31-1-1065/PO/6382

**Following were present in the meeting:**

| M/s L&T Hazira  | NPCIL                |
|-----------------|----------------------|
| 1. R. Lomash    | 1. Shri M.K. Dipak   |
| 2. N.T. Shah    | 2. Shri N. Prasad    |
| 3. Kishan Babu  | 3. Shri S.N. Prasad  |
| 4. D. H. Goyal  | 4. Shri Sunil Gupta  |
| 5. A. P. Mistry | 5. Shri P. More      |
| 6. P. Sharma    |                      |
| 7. S.C. Modi    | <b>NPCIL-QS</b>      |
|                 | 1. Shri G. K. Saxena |
|                 | 2. Shri M. M. Master |

**1. Delivery Schedule:**

| Sr. No. | Item        | Project | Qty Nos | P.O. Delivery Schedule | Delivery Schedule attempted by L&T                           |
|---------|-------------|---------|---------|------------------------|--|
| 1.      | End Shields | KAPP-3  | 2       | 22/05/12               | 28/03/13 (KAPP-3A)<br>28/04/13 (KAPP-3B)                     |
| 2       | End Shields | KAPP-4  | 2       | 22/09/12               | 28/07/13   |
| 3       | End Shields | RAPP-7  | 2       | 22/03/13               | 31/12/13   |
| 4       | End Shields | RAPP-8  | 2       | 17/04/14               | 28/02/14   |
| 5       | Tube Sheets | RAPP-8  | 8       | 31/12/12               | 5 nos. already dispatched<br>& balance<br>3 nos. by 31/03/13 |

**2. Drgs & Procedures**

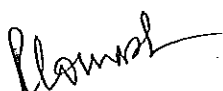
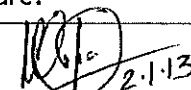
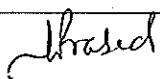
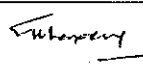
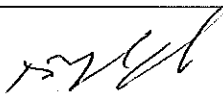
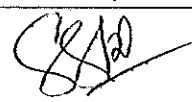
| Sr No | Drgs/Procedure                 | Date of submission /scheduled date | Status                         | Remarks |
|-------|--------------------------------|------------------------------------|--------------------------------|---------|
| 1.    | Manufacturing Drg.& Procedures |                                    | Approved/<br>Approved as noted |         |

NPCIL representatives visited the End Shields shops and reviewed the progress of each assembly. Technical points on final machining were discussed upon.

### 3. Technical/Miscellaneous:

| Sr. No. | Sub assembly                           | Action/Decision   |
|---------|--|---|
| 1       | CSTS #SE of 6 <sup>th</sup> End Shield | <p>During visit of NPCIL delegation the severe TGSCC indications on machined face of CSTS of 6<sup>th</sup> End Shield were shown. These indications were revealed after partial welding of CSTS with main shell. In-situ metallography was also done on these spots and reports submitted to NPCIL.</p> <p>In view of indications and review of test reports, NPCIL stated that the complete assembly of CSTS #SE is to be replaced due to severe TGSCC indications on CSTS. The current CSTS #SE assembly of RAPP-8 end shield (project no. 22029G) shall be used in 6<sup>th</sup> End Shield (project no. 22022F). Presently the CSTS#SE assembly for RAPP-8G is under lip machining in L&amp;T MHI pulverizer shops (HBM).</p> <p>As per the communication already received from NPCIL, L&amp;T is working on finalizing the LTFPS for cutting and removal of present CSTS #SE assembly from FSTS #Main Shell for End Shield F.</p>  |
| 2       | Profile and sniffer tubes              | <p>L&amp;T Shown the sample tubes drawn from M/s Shub laxmi to NPCIL.</p> <p>Based on condition of tubes and previous visits of NPCIL with NPCIL-QS, NPCIL has given approval to start Manufacturing of tubes at M/s Shubhlaxmi, Umbargam.</p>  |
| 3       | Final machining                        | <p>The drawings of final machining of End Shields were discussed upon in details and following points were concluded upon in various drawings:</p> <p>1: Drg No. Nu-22020-06.</p> <ul style="list-style-type: none"> <li>- In detail D1 the chamfer of 30° to be made as reference dimension. The spot face depth to be kept as reference dimension.</li> <li>- The chamfer of 0.5 on N1 face not to be considered as typical (applicable only for ID).</li> <li>- L&amp;T proposed that the individual flatness of faces N1 and N2 shall be revised to 0.25mm (presently achieved in 0.2mm). NPCIL accepted the proposal provided that the overall parallelism of face N1 and N2 within 0.4mm is maintained.</li> </ul> <p>2: Drg. No. Nu-22020, NU-22020-15, Nu-22020-15A</p> <ul style="list-style-type: none"> <li>- The across face dimensions of octagonal flange to be maintained by grinding or machining.</li> <li>- The radius of R300 at edges to be maintained during face machining of octagonal flanges.</li> </ul> |

|   |                     |  |
|---|---------------------|--|
|   |                     | <ul style="list-style-type: none"> <li>- For match drilling of lug plate with octagonal flange L&amp;T shall make a common jig for lug plate and for drilling on octagonal flange. L&amp;T to submit the drawing of jig to NPCIL for getting clearance for drilling additional holes on octagonal flange for jig locking.</li> <li>- The face machining profile on FMOF at transportation bracket location to be revised to match as per transportation bracket mating face.</li> </ul> <p>All above changes shall be reflected in L&amp;T drawings and immediately through L&amp;T ECR.</p> |
| 4 | Grouting holes size | NPCIL stated that for grouting holes size on support rib and FMOF, L&T to make holes suitable to allow 1" NB pipe SCH 40 to pass through the holes in support rib. IF required the current drilled holes in F/M support rib/ FMOF can be enlarged suitably.  |

| On Behalf of M/s L&T Hazira   | On Behalf Of NPCIL  |   |   |
|---|---|---|---|
|  | Signature:  |   |   |
| Name: R. Lomash   | <br>Name: M.K. Dipak<br>2-1-13 | <br>Name: N. Prasad<br>2-1-13 | <br>Name: G. K. Saxena |
|   | <br>Name: S. N. Prasad         | <br>Name: S. Gupta            |   |