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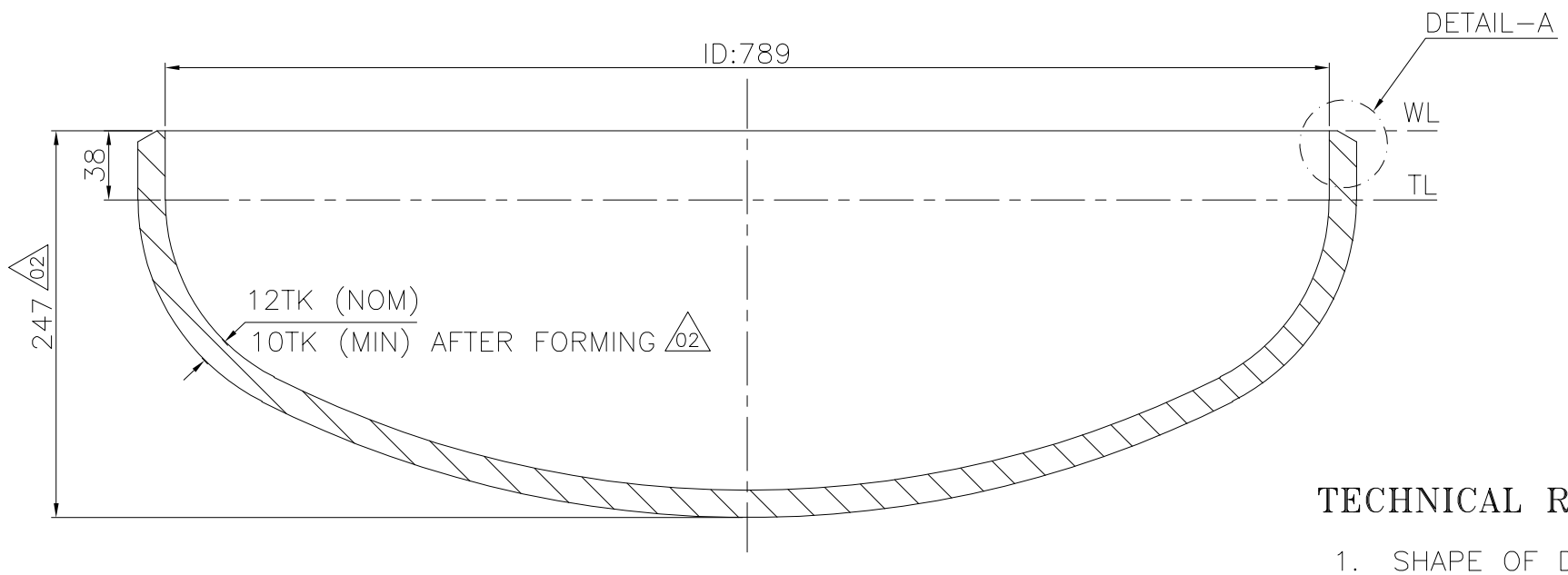
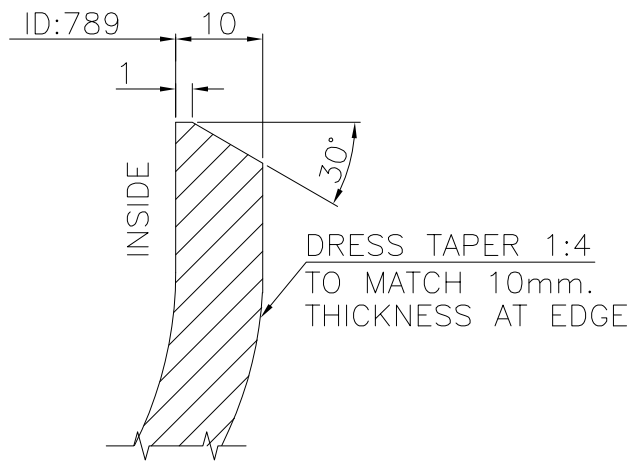
IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm

DRG. NO. 2-16503-40493





EDGE PREP. DETAIL

DETAIL–A 02

TECHNICAL REQUIREMENTS (TR) :–

1. SHAPE OF DISHED END : 2:1 ELLIPSOIDAL.
2. DISHED END SHALL BE MANUFACTURED AS PER ND–4200 OF ASME SEC.–III ND & NPCIL APPROVED TECH. SPECIFICATION NO. BHEL/NPCIL/30599/SS DISHED ENDS/CDE–19–3415.
3. FORMING PROCEDURE QUALIFICATION TEST TO BE CONDUCTED ON TEST COUPEN AS PER CLAUSE NO. 8 OF SPECIFICATION NO. BHEL/NPCIL/30599/SS DISHED ENDS/ CDE–19–3415.
4. NDT REQUIREMENT – AS PER SPECIFICATION NO. BHEL/NPCIL/30599/SS DISHED ENDS/CDE–19–3415.
5. TOLERANCE : AS PER CLAUSE ND–4222 OF ASME SEC.–III ND, UNLESS OTHERWISE SPECIFIED.
6. HEAT TREATMENT : AS PER TECHNICAL SPECIFICATION NO. BHEL/NPCIL/30599/ SS DISHED ENDS/CDE–19–3415.
7. PRESSING TO BE DONE FROM SINGLE PIECE BLANK.

02	01	BLANK ø1040		01	DISHED END 12 TK.				B.O.			75.6		
	QTY. VAR00	REMARKS		VAR. NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.NO. / VAR.	MATL. CODE / MATL. SPCN.	A/C	UNIT	UNIT WT. / QTY.	GS / ZONE
	59 64	65 75		78 79	25 27	29 58	59	60 77	29 31 / 32 33	SA240TP304L / 34 45 / 46 54	55	56 57	R/M 81.0 / 58 65 / 68 71	72
	28 → CARD TYPE–3					28 → CARD TYPE–1				28 → CARD TYPE–2				

DO NOT SCALE THE DRAWING. UNLESS OTHERWISE STATED:–

ALL DIMENSIONS ARE IN mm.
MACHINE ALL OVER.
SURFACE FINISH TO BE $\frac{3.2}{\nabla}$ OR BETTER.
REMOVE ALL BURRS.
REMOVE ALL EXTERNAL SHARP CORNERS AND EDGES BY CHAMFERING TO $^{0.15}_{0.40}$ × 45°.
ROUND ALL INTERNAL CORNERS AND EDGES TO R $^{0.15}_{0.40}$.
TOLERANCES ON RADII AND CHAMFERS (IS : 2102)

REDII AND CHAMFERS	0.5–3	3–6	6–30
TOLERANCES	±0.2	±0.5	±1.0

TOLERANCE ON LINEAR DIMENSIONS (IS:2102)

DIMENSIONS	TOL.	DIMENSIONS	TOL.
UP TO 6	±0.1	315 –1000	±0.8
6 – 30	±0.2	1000–2000	±1.2
30 – 120	±0.3	2000–4000	±2.0
120 – 315	±0.5	4000–8000	±3.0

TOLERANCE ON LINEAR DIMENSIONS

SPECIFIED DIMENSIONS	TOLERANCE
XX	± 0 . 40
XX.X	± 0 . 40
XX.XX	± 0 . 25

TOLERANCE ON ANGULAR DIMENSIONS : 0°–0.5°

ADDITIONAL INFORMATION
DRG. LIST : 4–16503–40362

STATUS OF DRAWING
W/O. NO. : 18085/86–W–04801

DISTRIBUTION OF PRINTS
CDE–1 HCM–1
FBM–1

NUCLEAR POWER CORPORATION OF INDIA LIMITED
(A GOVERNMENT OF INDIA ENTERPRISE)
PROJECT : GORAKHPUR HARIYANA ANU VIDHYUT PARIYOJANA 1&2 (700 MWe)
NPCIL PURCHASE ORDER NO. : CMM/FTP/10–33–1–1149/e–PO/30599, DATED 25.01.2019
NPCIL DRAWING NO : GHAVP–1&2/33331/2001/DD, SHT. 2 OF 6 REV.00

उत्पाद का प्रकार या ग्राहक/परियोजना का नाम
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT
IARS

भारत हेवी इलेक्ट्रिकल्स लिमिटेड भोपाल
BHARAT HEAVY ELECTRICALS LTD. BHOPAL

	नाम/ NAME	हस्ता./ SIGN.	दिनांक/DATE	वे.प्र. की संख्या NO. OF VAR.
बनाया DRN.	विजय कुमार कुशवाहा		15/02/2019	–
जाँचा CKD.	नागेन्द्र सिंह अरूण कुमार सिंह		15/02/2019	
स्वीकृत APPD.	ए.के.माहौर		15/02/2019	

विभाग DEPT	उत्पा. टा. नाप की श्रेणी UNTOL DIMS GR		अनुपात/SCALE	भार(कि. ग्रा.) WEIGHT (K.G.)	उसे. इंजी.ग का संदर्भ REF. TO ASSY. DRG.	ITEM NO.	मद संख्या NO. OF ITEM
CDE	M		–	75.6	1–16503–40865	–	–
कोड CODE 411	AA 0230205						

शीर्षक/TITLE: SS DISHED END (IARS)

ड्राईंग क्र./DRAWING NO.: 2–16503–40493 | पुन/REV. 02

पृष्ठ क्र./SHT. NO. | पृष्ठों की संख्या/NO. OF SHT.

REV.	DATE	ALTERED / CHECKED / APPROVED
02	13.03.2020	ALTERED नरेन्द्र कुमार जायसवाल CHECKED नागेन्द्र सिंह APPROVED ए.के.माहौर
		– DISHED END THICKNESS CHANGED FROM 10mm TO 12mm. – REVISION AS MARKED 02
01	18.04.19	ALTERED राधाकान्त मेहेर CHECKED नागेन्द्र सिंह APPROVED ए.के.माहौर
		DRG. REVISED AS PER NPCIL COMMENTS DTD 26.03.19.

REF. DRG. NO. | SIGN AND DATE | INVENTORY NO.

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