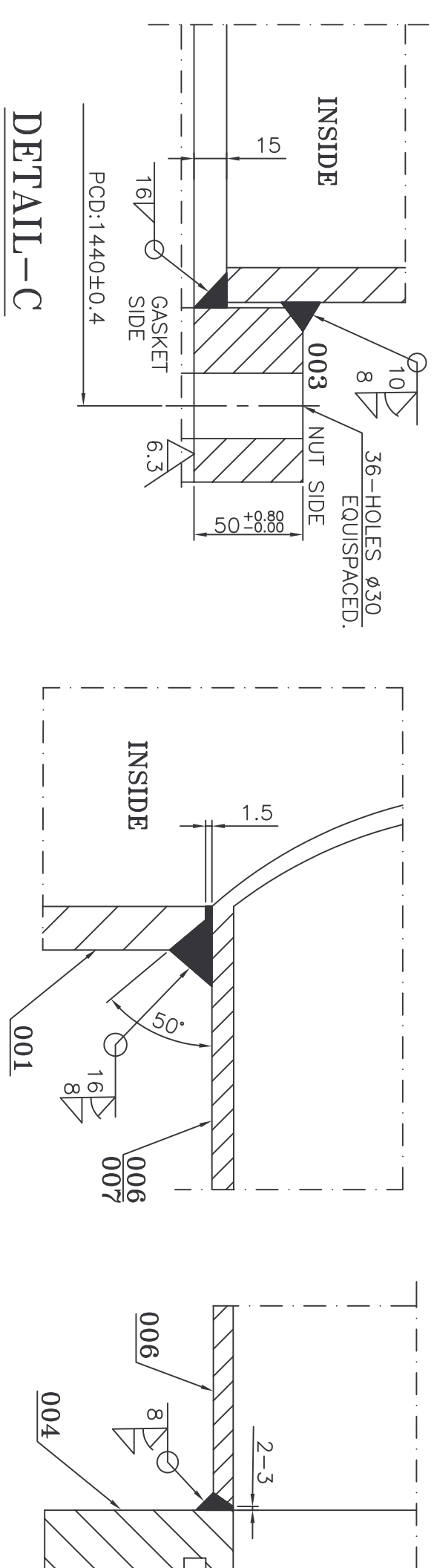
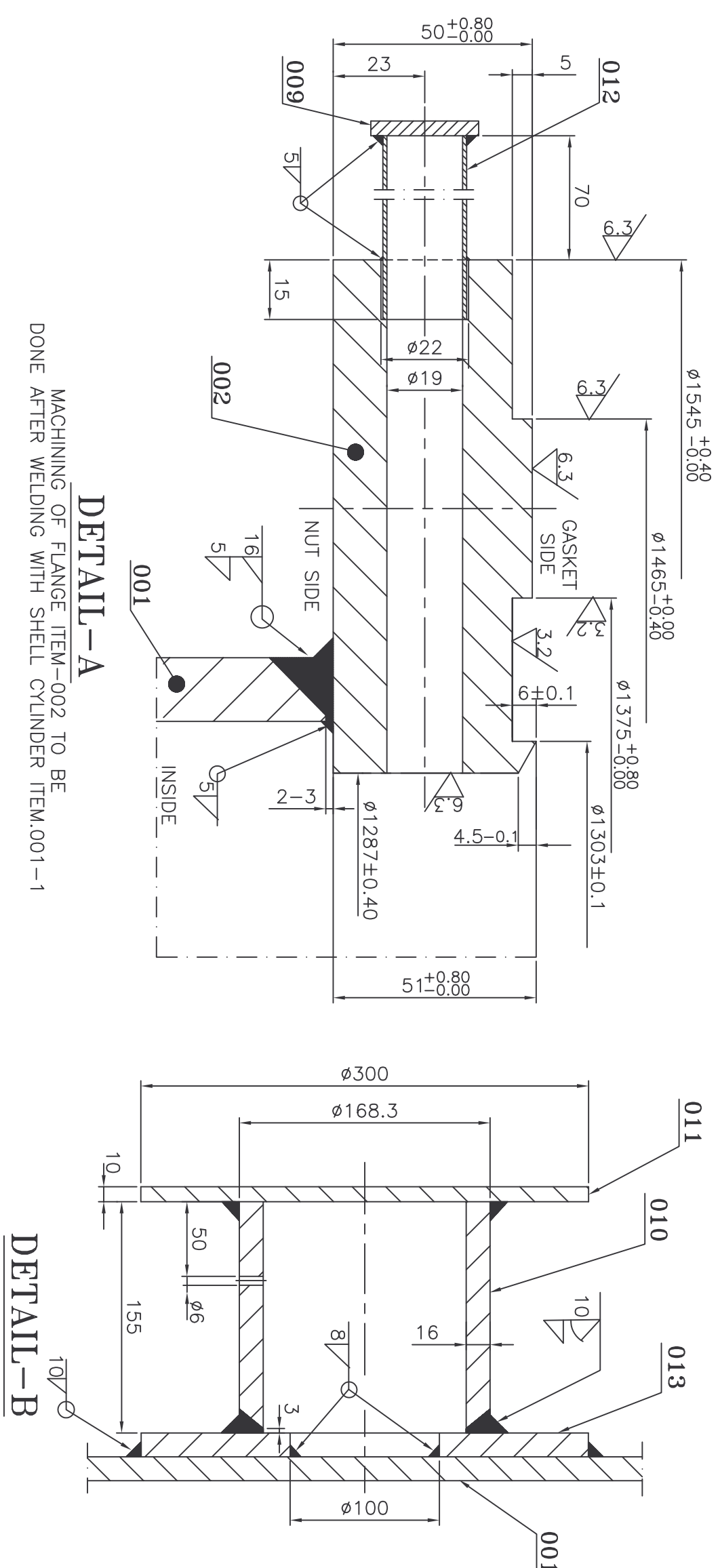
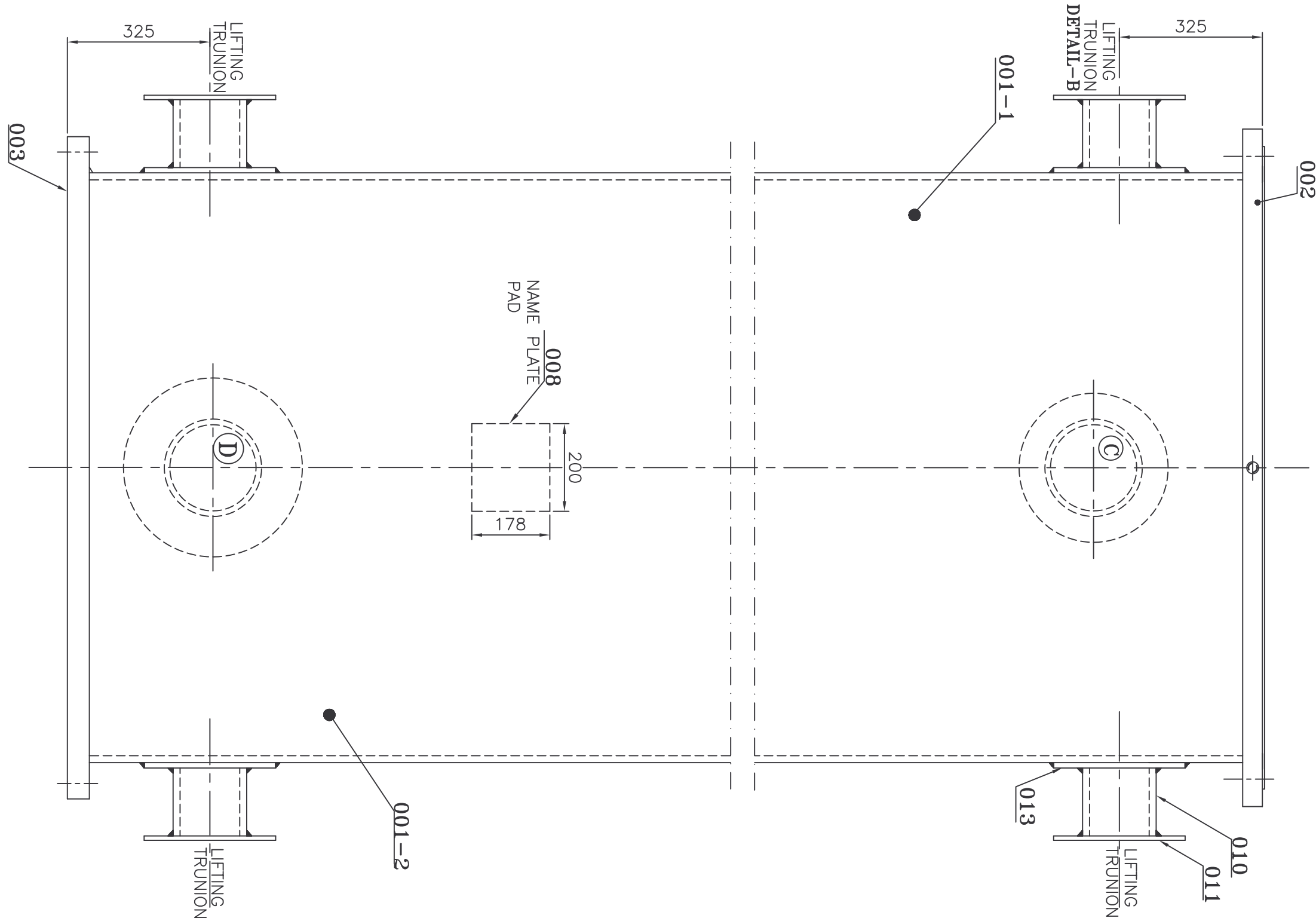
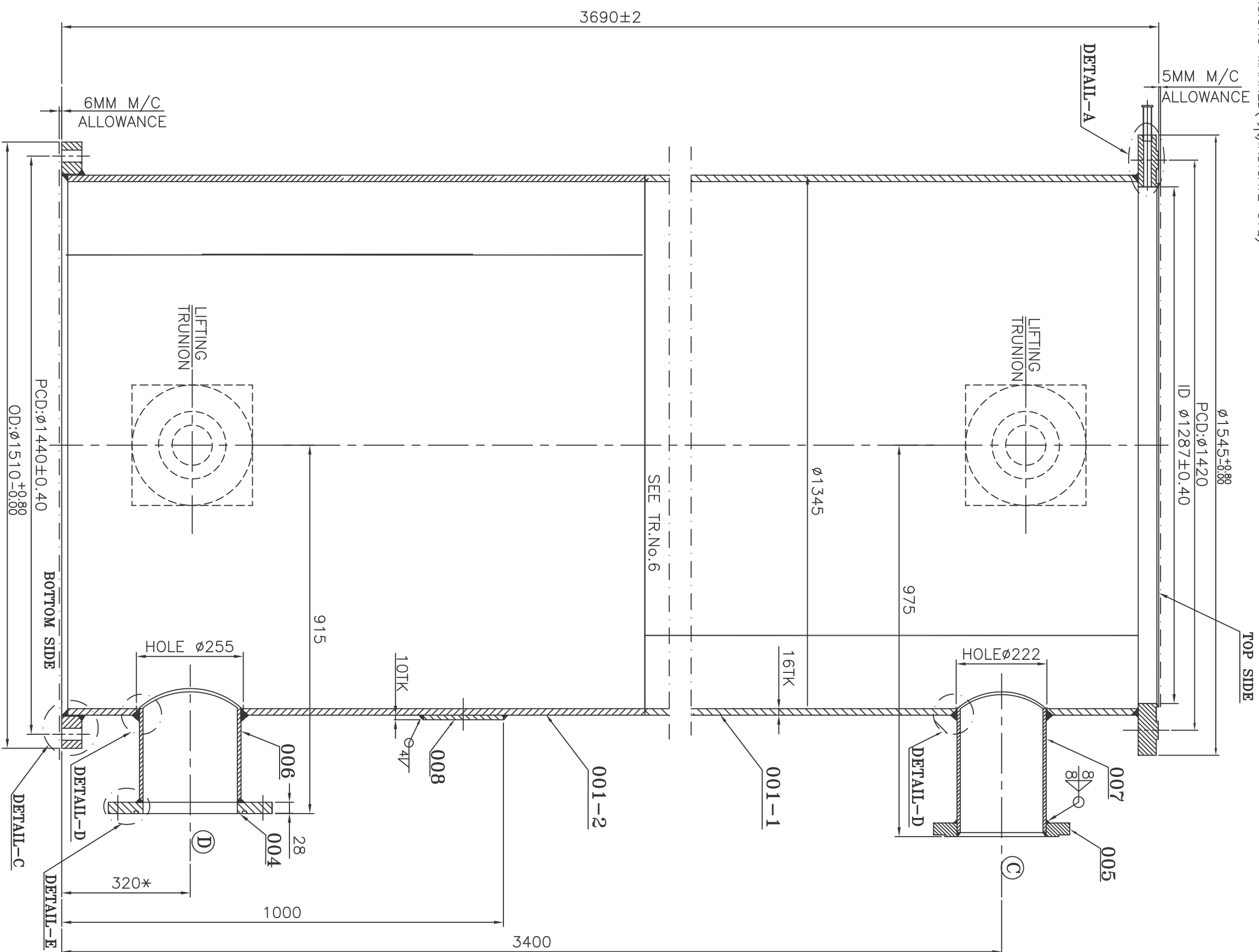


(DIMENSIONS MARKED (*))INDICATE CTQ)

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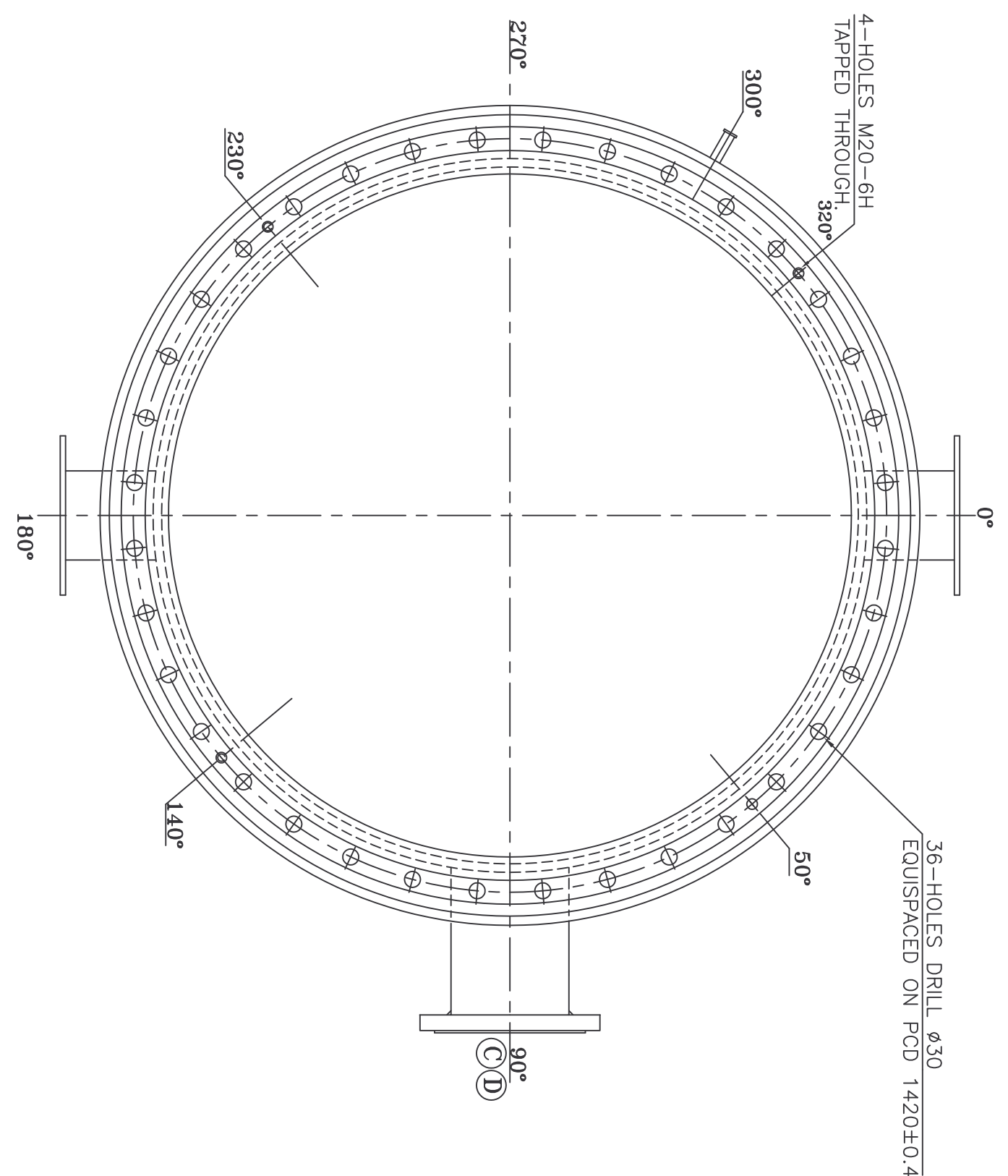
TECHNICAL REQUIREMENTS (TR)

1. FABRICATION TO BE CARRIED OUT AS PER ASME SEC.VIII, DIV.1:2007.
2. WELDING TO BE CARRIED OUT BY QUALIFIED WELDERS & APPROVED PROCEDURE ONLY
3. ALL WELDS TO BE DRESSED SMOOTH ID SURFACE TO BE DRESSED TO FLUSH.
4. ALL WELD JOINTS TO BE CHECKED BY DYE PENETRATION EXAMINATION AS PER

DETAIL-D

DETAIL-E
(SEE TR No.1)

5. FLANGE ITEM NO.004 IS TO BE WELDED AT FINAL ASSEMBLY OF THE OIL COOLER
AFTER ASSEMBLY NOTE NO. 08 ON OIL COOLER DRG.NO. 0-16501-70008.
6. AFTER WELDING OF UPPER FLANGE (ITEM NO.002) WITH SHELL UPPER PIECE
(ITEM NO.001-1), IT IS TO BE MACHINED AS PER DETAIL-A, SUBSEQUENTLY, SHELL LOWER
PIECE(ITEM NO.001-2) AND BOTTOM FLANGE (ITEM NO.003) ARE TO BE ASSEMBLED WITH
IT AND MACHINING DONE AS PER DETAIL-C. (REFER TR NO.5 OF DRG.NO-2-16501-70043)
7. WHILE WELDING TWO PICES OF SHELL (ITEM NO.001) WITH RESPECTIVE FLANGES
(ITEM NO.002,003), CO-AXIALITY TO BE MAINTAINED AS SHOWN.
8. PAINTING/PRESERVATION :
 - 8.1 FABRICATED ASSEMBLY TO BE CLEANED BY SHOT BLASTING TO Sa 2 1/2 FINISH AS PER
SIS-055900.
 - 8.2 INSIDE SURFACE: TO BE PROTECTED BY APPLYING DTE MEDIUM OIL.
 - 8.3 OUTSIDE SURFACE: TO BE PROTECTED BY APPLYING ONE COAT OF ZINC RICH PRIMER
AS PER AA-56114.



	REV.	DATE	ALTERED CHECKED	PAT. SAK
			CHECKED	SAX
			APPROVED	TALU
ZONE				
DRAWING RE—DRAWN.				

SYMBOL & SIZE OF SEAM 3/16" 5/16" 7/8" 1 1/8" 1 1/2" 1 3/4" 1 7/8" 2 1/8" 2 1/2" 2 3/4" 3 1/8" 3 1/2" 3 3/4" 4 1/8" 4 1/2" 4 3/4" 5 1/8" 5 1/2" 5 3/4" 6 1/8" 6 1/2" 6 3/4" 7 1/8" 7 1/2" 7 3/4" 8 1/8" 8 1/2" 8 3/4" 9 1/8" 9 1/2" 9 3/4" 10 1/8" 10 1/2" 10 3/4" 11 1/8" 11 1/2" 11 3/4" 12 1/8" 12 1/2" 12 3/4" 13 1/8" 13 1/2" 13 3/4" 14 1/8" 14 1/2" 14 3/4" 15 1/8" 15 1/2" 15 3/4" 16 1/8" 16 1/2" 16 3/4" 17 1/8" 17 1/2" 17 3/4" 18 1/8" 18 1/2" 18 3/4" 19 1/8" 19 1/2" 19 3/4" 20 1/8" 20 1/2" 20 3/4" 21 1/8" 21 1/2" 21 3/4" 22 1/8" 22 1/2" 22 3/4" 23 1/8" 23 1/2" 23 3/4" 24 1/8" 24 1/2" 24 3/4" 25 1/8" 25 1/2" 25 3/4" 26 1/8" 26 1/2" 26 3/4" 27 1/8" 27 1/2" 27 3/4" 28 1/8" 28 1/2" 28 3/4" 29 1/8" 29 1/2" 29 3/4" 30 1/8" 30 1/2" 30 3/4" 31 1/8" 31 1/2" 31 3/4" 32 1/8" 32 1/2" 32 3/4" 33 1/8" 33 1/2" 33 3/4" 34 1/8" 34 1/2" 34 3/4" 35 1/8" 35 1/2" 35 3/4" 36 1/8" 36 1/2" 36 3/4" 37 1/8" 37 1/2" 37 3/4" 38 1/8" 38 1/2" 38 3/4" 39 1/8" 39 1/2" 39 3/4" 40 1/8" 40 1/2" 40 3/4" 41 1/8" 41 1/2" 41 3/4" 42 1/8" 42 1/2" 42 3/4" 43 1/8" 43 1/2" 43 3/4" 44 1/8" 44 1/2" 44 3/4" 45 1/8" 45 1/2" 45 3/4" 46 1/8" 46 1/2" 46 3/4" 47 1/8" 47 1/2" 47 3/4" 48 1/8" 48 1/2" 48 3/4" 49 1/8" 49 1/2" 49 3/4" 50 1/8" 50 1/2" 50 3/4" 51 1/8" 51 1/2" 51 3/4" 52 1/8" 52 1/2" 52 3/4" 53 1/8" 53 1/2" 53 3/4" 54 1/8" 54 1/2" 54 3/4" 55 1/8" 55 1/2" 55 3/4" 56 1/8" 56 1/2" 56 3/4" 57 1/8" 57 1/2" 57 3/4" 58 1/8" 58 1/2" 58 3/4" 59 1/8" 59 1/2" 59 3/4" 60 1/8" 60 1/2" 60 3/4" 61 1/8" 61 1/2" 61 3/4" 62 1/8" 62 1/2" 62 3/4" 63 1/8" 63 1/2" 63 3/4" 64 1/8" 64 1/2" 64 3/4" 65 1/8" 65 1/2" 65 3/4" 66 1/8" 66 1/2" 66 3/4" 67 1/8" 67 1/2" 67 3/4" 68 1/8" 68 1/2" 68 3/4" 69 1/8" 69 1/2" 69 3/4" 70 1/8" 70 1/2" 70 3/4" 71 1/8" 71 1/2" 71 3/4" 72 1/8" 72 1/2" 72 3/4" 73 1/8" 73 1/2" 73 3/4" 74 1/8" 74 1/2" 74 3/4" 75 1/8" 75 1/2" 75 3/4" 76 1/8" 76 1/2" 76 3/4" 77 1/8" 77 1/2" 77 3/4" 78 1/8" 78 1/2" 78 3/4" 79 1/8" 79 1/2" 79 3/4" 80 1/8" 80 1/2" 80 3/4" 81 1/8" 81 1/2" 81 3/4" 82 1/8" 82 1/2" 82 3/4" 83 1/8" 83 1/2" 83 3/4" 84 1/8" 84 1/2" 84 3/4" 85 1/8" 85 1/2" 85 3/4" 86 1/8" 86 1/2" 86 3/4" 87 1/8" 87 1/2" 87 3/4" 88 1/8" 88 1/2" 88 3/4" 89 1/8" 89 1/2" 89 3/4" 90 1/8" 90 1/2" 90 3/4" 91 1/8" 91 1/2" 91 3/4" 92 1/8" 92 1/2" 92 3/4" 93 1/8" 93 1/2" 93 3/4" 94 1/8" 94 1/2" 94 3/4" 95 1/8" 95 1/2" 95 3/4" 96 1/8" 96 1/2" 96 3/4" 97 1/8" 97 1/2" 97 3/4" 98 1/8" 98 1/2" 98 3/4" 99 1/8" 99 1/2" 99 3/4" 100 1/8" 100 1/2" 100 3/4" 101 1/8" 101 1/2" 101 3/4" 102 1/8" 102 1/2" 102 3/4" 103 1/8" 103 1/2" 103 3/4" 104 1/8" 104 1/2" 104 3/4" 105 1/8" 105 1/2" 105 3/4" 106 1/8" 106 1/2" 106 3/4" 107 1/8" 107 1/2" 107 3/4" 108 1/8" 108 1/2" 108 3/4" 109 1/8" 109 1/2" 109 3/4" 110 1/8" 110 1/2" 110 3/4" 111 1/8" 111 1/2" 111 3/4" 112 1/8" 112 1/2" 112 3/4" 113 1/8" 113 1/2" 113 3/4" 114 1/8" 114 1/2" 114 3/4" 115 1/8" 115 1/2" 115 3/4" 116 1/8" 116 1/2" 116 3/4" 117 1/8" 117 1/2" 117 3/4" 118 1/8" 118 1/2" 118 3/4" 119 1/8" 119 1/2" 119 3/4" 120 1/8" 120 1/2" 120 3/4" 121 1/8" 121 1/2" 121 3/4" 122 1/8" 122 1/2" 122 3/4" 123 1/8" 123 1/2" 123 3/4" 124 1/8" 124 1/2" 124 3/4" 125 1/8" 125 1/2" 125 3/4" 126 1/8" 126 1/2" 126 3/4" 127 1/8" 127 1/2" 127 3/4" 128 1/8" 128 1/2" 128 3/4" 129 1/8" 129 1/2" 129 3/4" 130 1/8" 130 1/2" 130 3/4" 131 1/8" 131 1/2" 131 3/4" 132 1/8" 132 1/2" 132 3/4" 133 1/8" 133 1/2" 133 3/4" 134 1/8" 134 1/2" 134 3/4" 135 1/8" 135 1/2" 135 3/4" 136 1/8" 136 1/2" 136 3/4" 137 1/8" 137 1/2" 137 3/4" 138 1/8" 138 1/2" 138 3/4" 139 1/8" 139 1/2" 139 3/4" 140 1/8" 140 1/2" 140 3/4" 141 1/8" 141 1/2" 141 3/4" 142 1/8" 142 1/2" 142 3/4" 143 1/8" 143 1/2" 143 3/4" 144 1/8" 144 1/2" 144 3/4" 145 1/8" 145 1/2" 145 3/4" 146 1/8" 146 1/2" 146 3/4" 147 1/8" 147 1/2" 147 3/4" 148 1/8" 148 1/2" 148 3/4" 149 1/8" 149 1/2" 149 3/4" 150 1/8" 150 1/2" 150 3/4" 151 1/8" 151 1/2" 151 3/4" 152 1/8" 152 1/2" 152 3/4" 153 1/8" 153 1/2" 153 3/4" 154 1/8" 154 1/2" 154 3/4" 155 1/8" 155 1/2" 155 3/4" 156 1/8" 156 1/2" 156 3/4" 157 1/8" 157 1/2" 157 3/4" 158 1/8" 158 1/2" 158 3/4" 159 1/8" 159 1/2" 159 3/4" 160 1/8" 160 1/2" 160 3/4" 161 1/8" 161 1/2" 161 3/4" 162 1/8" 162 1/2" 162 3/4" 16									
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