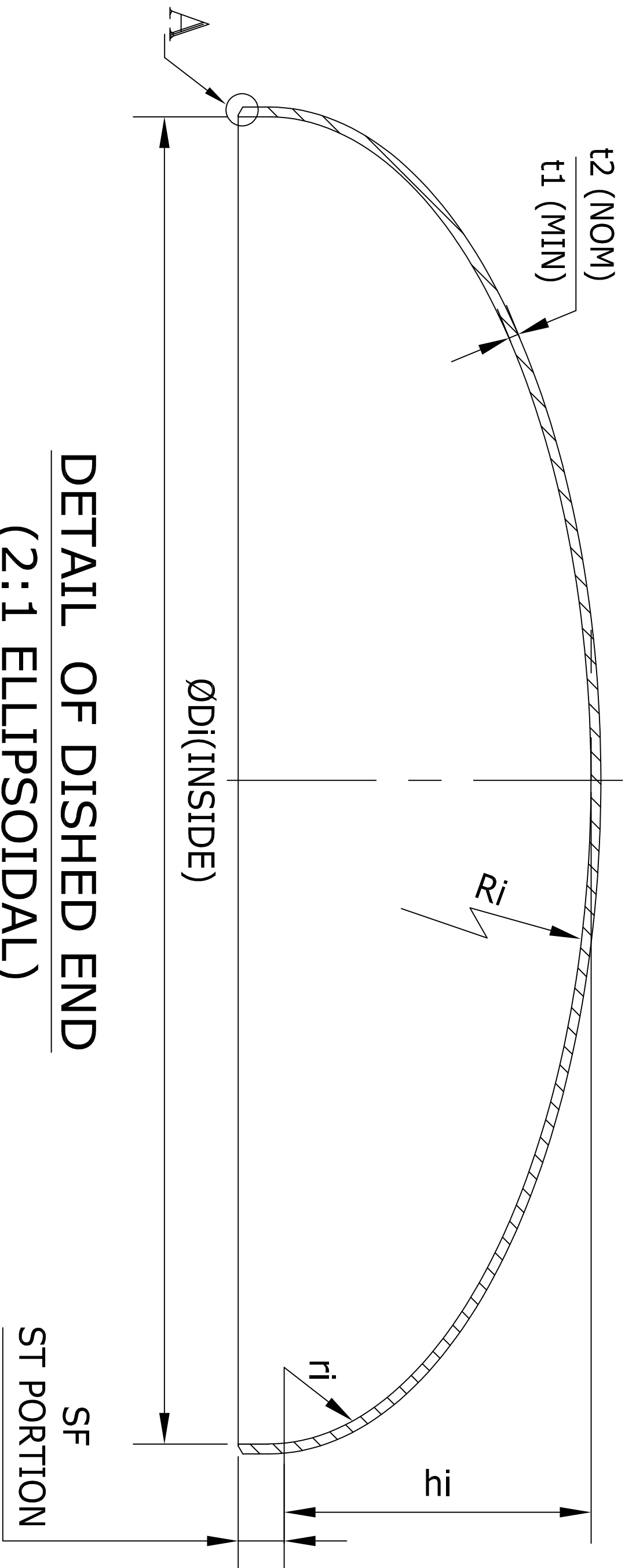




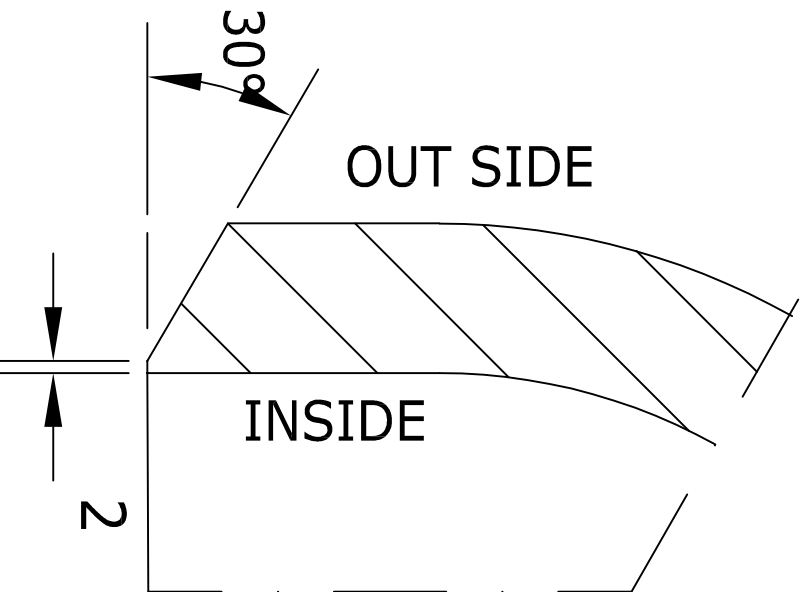
DETAIL OF DISHED END
(2:1 ELLIPSOIDAL)

NOTES:—

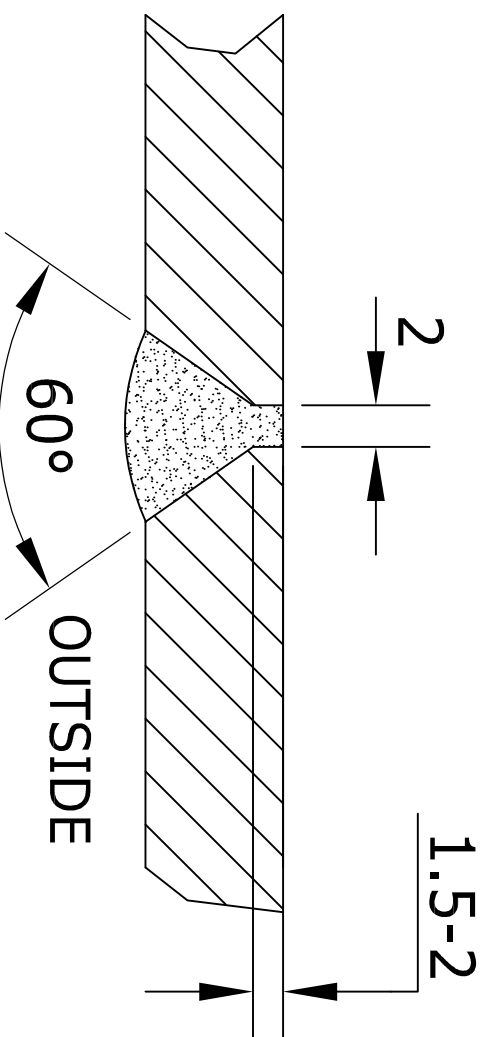
1. MATERIAL OF CONSTRUCTION : SA516 Gr.60/70 OF ASME SEC-II PART-A;2019 NORMALIZED. PLATE TO BE ULTRASONICALLY TESTED IN ACCORDANCE WITH SA435/LEVEL-A OF SA578.
2. FORMING TO BE DONE FROM SINGLE BLANK PLATE.
IF MADE IN TWO (02) SEGMENTS-WELD PREPARATION AND WELDING TO BE DONE AS SHOWN IN 'DETAIL-B' FOLLOWED BY DRESSING & 100% RADIOGRAPHED BEFORE FORMING AS PER UW-51 OF ASME SECTION-VIII DIV-1;2019.
3. EDGE PREP. REQUIRED AS PER DETAIL 'A' SHOWN.
4. HEAT TREATMENT :- DISHED END TO BE STRESS RELIEVED AFTER FORMING AS PER UCS-56 OF ASME SEC.-VIII DIV.-1;2019.
5. AFTER HEAT TREATMENT KNUCKLE PORTION, STRAIGHT FACE INCLUDING EDGE PREP. AND WELD FACE TO BE DYE PENETRATION TESTED AS PER APPENDIX-8 OF ASME SEC.VIII DIVN.1; 2019.
6. CENTRAL HOLE ON DISHED END IF ANY NOT TO BE PLUGGED.
7. PAINTING AFTER SURFACE CLEANING : ONE COAT OF RED OXIDE EPOXY PRIMER ON INSIDE & OUT SIDE SURFACE LEAVING 50 MM FROM EDGE.
8. TOLERANCE : (1) OVALITY SHOULD NOT EXCEED 0.5% OF DISHED END ID.
(DIFFERENCE MAX. & MIN. I.D.).

(II) MEASURED CIRCUMFERENCE SHOULD BE $\pm 6\%$ OF CALCULATED CIRCUMFERENCE BASED ON I.D. SPECIFIED.

9. CODE OF CONSTRUCTION : ASME SECTION VIII DIV. 1; 2019.
10. BLANK DIA AS SHOWN IS FOR REFERENCE ONLY. DISHED END SUPPLIER TO CHECK AND CAN MODIFY IT BEFORE CUTTING OF BLANK TO MEET THE END DIMENSIONS.



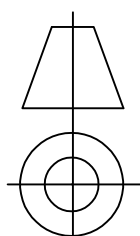
DETAIL-A



DETAIL-B

INVENTORY NO.									
REV.	DATE	ALTERED	बिना कुमर कुशाहा (AamKhal)	REV.	DATE	ALTERED	बिना कुमर कुशाहा (AamKhal)	REV.	DATE
		CHECKED	दीपक मौंदेकर दीपक भोंडर			CHECKED	राजियास बेसरा अजयबा		
		APPROVED ए. के. माहौर				APPROVED सुनील के बिशवास डुजोत			
04	28.08.2020			03	16.01.2020			02	25.09.19
ZONE		NOTE-2 MODIFIED.		ZONE		NOTES MODIFIED.		ZONE	
IT.-03 ADDED.									
शीर्षक TITLE				विभाग DEPT.	उत्तर. रेल. बाप की रेगी			उत्तुमात SCALE	भारत के. गी. WEIGHT(K.G.)
DISHED ENDS				कोड CODE	411	AA0230208			
DRAWING NO.									
3-16053-40485									
पृष्ठ क्र. SH. NO. 1 पृष्ठों की सं. NO. OF SH.									
पृष्ठ. REV.									

03	DISHED END - 12 tk.	1676	10	12	50	419	SA516 Gr.60/70	2049	311
02	DISHED END - 12 tk.	976	10	12	50	244	SA516 Gr.60/70	1250	115
01	DISHED END - 12 tk.	1976	10	12	50	494	SA516 Gr.60/70	2391	423
ITEM No.	DESCRIPTION	ØDi	t1 (MIN.)	t2 (NOM.)	SF	hi	MATERIAL	BLANK DIA	WEIGHT Kg.

उत्पन्न को प्रकार या श्रेणी / परिचयना का नाम TYPE OF PRODUCT OR									
NAME OF CUSTOMER/PROJECT									
FLASH TANK									
भारत हेवी इलेक्ट्रिकल्स लिमिटेड गोपाल									
BHARAT HEAVY ELECTRICALS LTD. BHOPAL									
विभाग DEPT./CODE	उत्पादना. नाम की श्रेणी UNTOOL. DIMS. GR.	उद्योगा SCALE	भार. वजन, WEIGHT(K.G.)	क्रमा DRN.	नाम / NAME	हस्ता / SIGN.	दि./ DATE	वेरि की संख्या। NO. OF VAR.	
कोड CODE 411	M AA0230208		NTS	जोडा CKD.	दीपक मौंदेकर	इनिआव	14.09.15	14.09.15	-
				प्रमाण APPD.	डी.के.चेरियन	इनिआव	14.09.15		
					जेने. ड्राईंग का संदर्भ REF. TO ASSY. DRG.				
TITLE	DRAWING NO.							पुन. REV.	
DISHED ENDS									
पृष्ठ क्र., SH.T. NO. 1 पृष्ठों की सं. NO. OF SH.T.									
3-16053-40485 04									