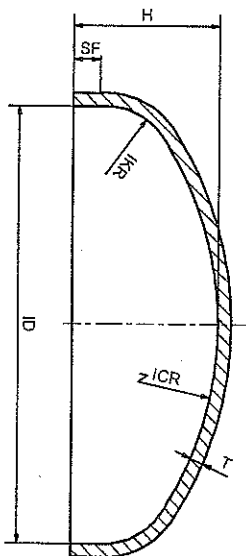


14010010956 ON DRG



- NOTES:
1. All the edges to be thoroughly de-burred.
 2. Visual inspection for internal cleanliness. Burrs shall be thoroughly cleaned.

TORISPHERICAL DISHED END TABLE.

VAR	DESCRIPTION	ID (mm) +/-2 mm	T (mm)	SF (mm)	ICR (mm)	IKR (mm)	H (mm)	MATERIAL	MATL CODE	BLANKET SIZE (mm)	BLANK WT (KG)
1	DISHED END FOR ADSORBER/VACUUM TANK	1100	12	50	1124	112.4	262	CS IS-2062	AA101181912	1330 x 1330	167
2	DISHED END FOR SURGE/STORAGE VESSEL	2200	16	20	2232	223.2	474.6	CS IS-2062	AA1011819112	2500x2500	785
3	DISHED END FOR AIR RECEIVER	1500	16	50	1532	153.2	339.2	CS IS-2062	AA1011819112	1760x1760	390

ID - Internal Diameter
T - Thickness
SF - Straight Face
ICR - Internal Crown Radius
IKR - Internal Knuckle Radius
H - Total Height

THE FOLLOWING CONDITIONS APPLY
EXCEPT OTHERWISE STATED.

1. REF. TO HYD20261 FOR UNSPECIFIED TOLERANCES
2. CHAMFER W/CD SHARP EDGES 1.2 TO 1.0 AT 45°
3. INTERNAL W/CD CORNER RADIUS 1 TO 0.7
4. THE SURFACE ROUGHNESS WHEREVER NOT SHOWN SHALL BE TAKEN FROM THE SURFACE ROUGHNESS SHOWN OUTSIDE DASHES GIVEN AT THE TOP MOST RIGHT CORNER OF THE DRG.

INVENTORY NO.		REF. DRG. NO.		COMP. FILE NAME		THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.	
REV. DATE	ALTERED	REV. DATE	ALTERED	REV. DATE	ALTERED	REV. DATE	ALTERED
CHECKED	APPRO.	CHECKED	APPRO.	CHECKED	APPRO.	CHECKED	APPRO.
ZONE		ZONE		ZONE		ZONE	
1		2		3		4	
5		6		7		8	

TYPE OF PRODUCT		1000 LPM OXYGEN GENERATION PLANT	
NAME OF THE CUSTOMER/PROJECT		BHARAT HEAVY ELECTRICALS LTD. DRN. KSR.	
HYDERABAD		CHD. LVRK.	
APPRO. REV. 1		19.07.2021	
DEPT.	SGD	SCALE	IS (mm)
CODE	435	NTS	0.0
TITLE		TORISPHERICAL DISHED END 1000LPM	
SHEET NO. 01		NO. OF SHEETS: 01	
DRAWING NO.		3560100104-1	
REV.		00	

Material 35601001041-03
 DISHED END TORI FOR AIR RECEIVER 1000LPM
 Plant P003
 Group 50382586
 DISHED END TORI FOR AIR RECEIVER 1000LPM
 50382586
 Use Size From 1
 1
 Status 4
 Plant P003
 99,999,999
 EA

Sequence	Seq. Cat.	Work Ctr	HA2817	Std. seq.	Plant P003
0010	Seq. Cat.	Work Ctr	HA2817	Std. seq.	Plant P003
0020	Operation	Setup Base Qty Ctrl Key Work Ctr	ZP01 HA9421	20 MIN Machine 140 MIN 140 MIN	1 EA Cut the 16 thk sheet to 1760 x 1760 mm
0030	Operation	Setup Base Qty Ctrl Key Work Ctr	ZP01 HA2825	20 MIN 60 MIN	1 EA Form the dish end shape on a press machine in 2 stages. Maintain final dimensions as below ID - Internal diameter - 1500 ICR - Internal crown radius - 1532 IKR - Internal knuckle radius - 153.2 SF - Straight face - 50 H - Total Height - 339.2
0040	Operation	Base Qty Ctrl Key Work Ctr	ZP04 HA9863	1 EA Inspection	1 EA Cut the remaining portion to maintain OD 1532 mm
0050	Operation	Base Qty Ctrl Key Work Ctr	ZP01 HA9421	1 EA Inspection	1 EA Cut the remaining portion to maintain OD 1532 mm
0060	Operation	Setup Base Qty Ctrl Key Work Ctr	ZP01 HA9863	40 MIN 80 MIN	1 EA Inspection

