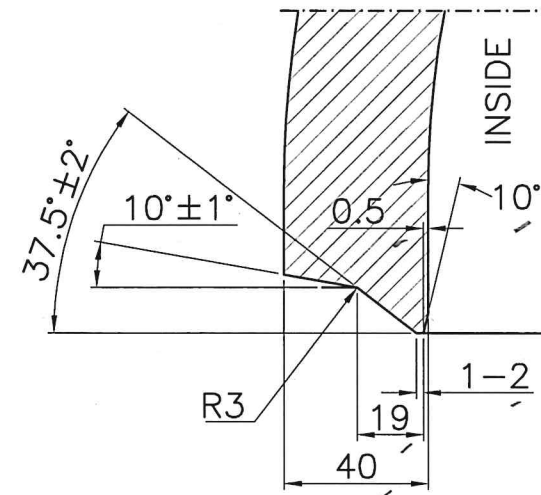
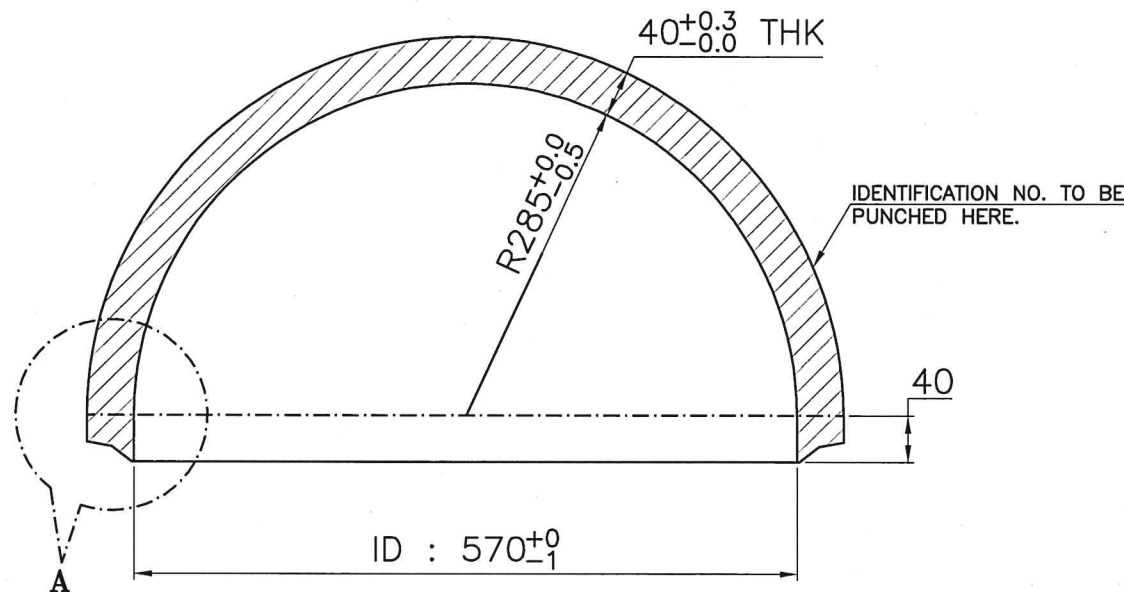


DRAWING NO. 3-16503-40892

EDGE PREP. DETAIL
DETAIL-A

न्यूक्लियर पावर कॉर्पोरेशन ऑफ इंडिया लिमिटेड Nuclear Power Corporation of India Limited		
☒ अनुमोदित / APPROVED		
☐ टिप्पणी के अनुसार अनुमोदित / APPROVED AS NOTED		
☐ संशोधन को आगे बढ़ाएं / सेकें / PROCEED WITH/HOLD FABRICATION		
☐ अंतिम ट्रांसपेरेंसी एवं प्रतियां भेजें / SEND FINAL TRANSPARENCIES & PRINTS		
☐ संशोधन करें एवं अनुमोदन के लिए पुनः प्रस्तुत करें REVISE & RESUBMIT FOR APPROVAL		
जाँचकर्ता / CHECKED BY	समीक्षाकर्ता / REVIEWED BY	अनुमोदन कर्ता / APPROVED BY
प्रमुख 31/5/19	शिवधामिका 31/5/19	अ.के.माहौर 31/5/19
किए जानेवाले कार्य का अनुमोदन आपूर्तिकर्ता संविदाकार को विनिर्देशनों के अनुसार आपूर्ति करने के उत्तरदायित्व से मुक्त नहीं करता है। This approval of the work to be done does not relieve the supplier of the responsibility of supply according to specifications.		

TECHNICAL REQUIREMENTS (TR):-

- SHAPE OF THE FORGING : HEMI SPHERICAL
- SUPPLY CONDITION : HEAT TREATED AND FINISH MACHINED ALL OVER.
- ALL TECHNICAL AND TESTING REQUIREMENTS SHALL BE AS PER NPCIL APPROVED SPECIFICATION No.- BHEL/NPCIL/30599/CS-FORGINGS/CDE-19-3411.
- NO REPAIRS/WELDING SHALL BE PERMITTED WITHOUT PRIOR APPROVAL OF NPCIL.
- TEST COUPON FOR TESTING SHALL BE FORMED AS PER SPECIFICATION NO.- BHEL/NPCIL/30599/CS-FORGINGS/CDE-19-3411.
- IDENTIFICATION TO BE STAMPED AT LOCATION SHOWN WITH FOLLOWING INFORMATION:
 - PURCHASE FORGING NUMBER.
 - HEAT NUMBER
 - BHEL PO NUMBER
 - MATERIAL DESIGNATION.
- MATERIAL OF CONSTRUCTION : SA 350 LF2 CLASS-1.
- TEMPORARY OIL BASED RUST PREVENTIVE TO BE APPLIED AFTER MACHINING ON ALL SURFACES.
- ALL DIMENSIONS INDICATED ARE IN mm.
- UNLESS OTHERWISE MENTIONED THE TOLERANCE ON LINEAR AND ANGULAR DIMENSIONS SHALL BE AS PER IS:2102.
- THE SURFACE FINISH OF FORGINGS SHALL BE 3.2 OR BETTER.
- ALL WELD EDGE & MACHINED SURFACES SHALL BE SUBJECTED TO MT/PT.
- FORGING SHALL BE AS CLOSED AS PRACTICABLE TO FINISHED FORGING SHAPE.

DO NOT SCALE THE DRAWING.
UNLESS OTHERWISE STATED:-
ALL DIMENSIONS ARE IN mm.
MACHINE ALL OVER.
SURFACE FINISH TO BE $\sqrt{3.2}$ OR BETTER.
REMOVE ALL BURRS.
REMOVE ALL EXTERNAL SHARP CORNERS AND EDGES BY CHAMFERING TO $0.5 \times 45^\circ$.
ROUND ALL INTERNAL CORNERS AND EDGES TO R 3.0.
TOLERANCES ON RADII AND CHAMFERS (IS : 2102)
RADI 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	318 - 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	

ADDITIONAL INFORMATION

DRG. LIST : 4-16503-40357

STATUS OF DRAWING

W/O. NO. : 18085/86-W-04801

DISTRIBUTION OF PRINTS

CDE - 1 HCM - 4 FWM - 4

REV.	DATE	ALTERED	कमलेश गामीत	REV.	DATE	ALTERED	कमलेश गामीत	REV.	DATE	ALTERED	कमलेश गामीत
03	22/05/19	CHECKED	नागेन्द्र सिंह	02	06/05/19	CHECKED	नागेन्द्र सिंह	01	25/03/19	CHECKED	नागेन्द्र सिंह
		APPROVED	ए.के.माहौर			APPROVED	ए.के.माहौर			APPROVED	ए.के.माहौर
ZONE	DRAWING REVISED BASED ON NPCIL COMMENTS DTD. 16/05/2019.			ZONE	DRAWING REVISED BASED ON NPCIL COMMENTS DTD. 16/04/2019.			ZONE	DRAWING REVISED BASED ON NPCIL COMMENTS DTD. 19/03/2019. TOLERANCE TABLE ADDED. DETAIL—A MARKED		
विभाग DEPT. CDE											
कोड 411											
शीर्षक/ TITLE											
SECONDARY DISHED HEAD											
उत्प. टोल. नाप की श्रेणी											
UNTOL. DIMS. GR. M											
AA0203208											
उत्पात											
SCALE											
-											
भार (कि.ग्रा)											
WEIGHT (K.G.)											
208.0											
उसे. इडिंग का संदर्भ											
REF. TO ASSY. DRG.											
3-16503-40874											
मद क्र. ITEM NO.											
001											
इडिंग क्र./DRAWING NO.											
3-16503-40892											
पृष्ठ क्र./ SHT. NO. 01											
पृष्ठों की संख्या/NO. OF SHT. 01											
मद संख्या NO. OF ITEM											
03											
पुन./ REV.											