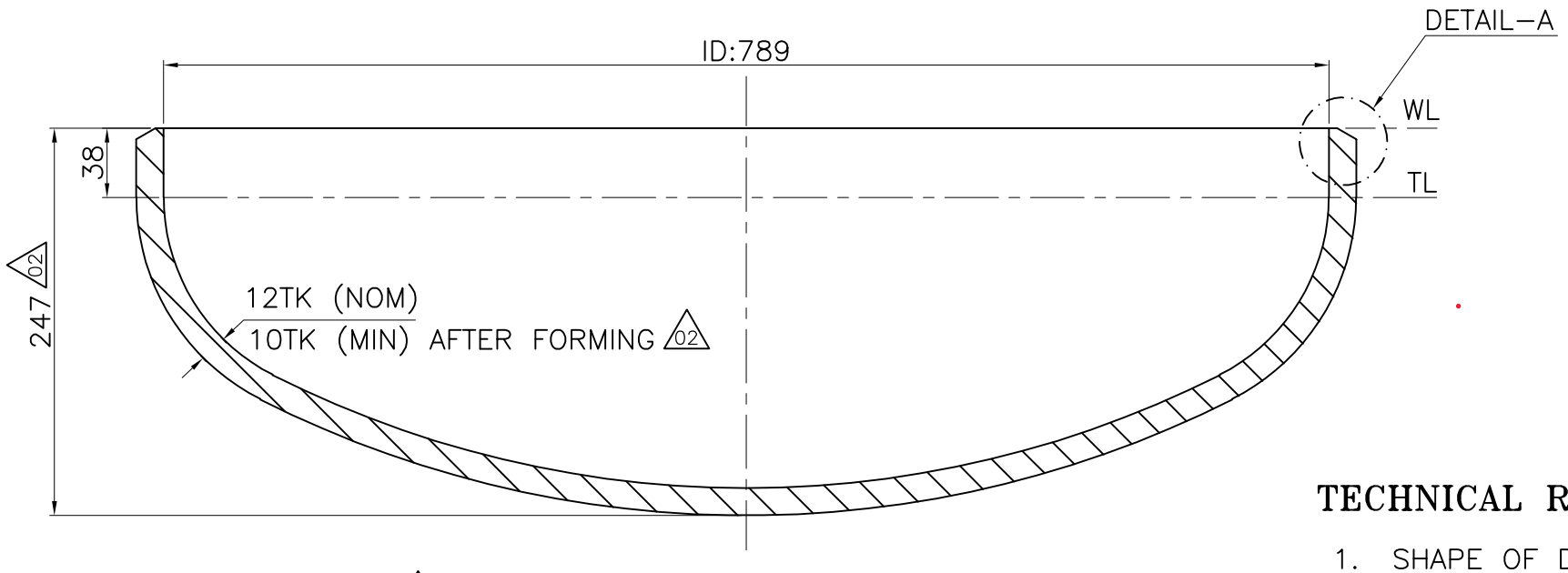
THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED.
IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

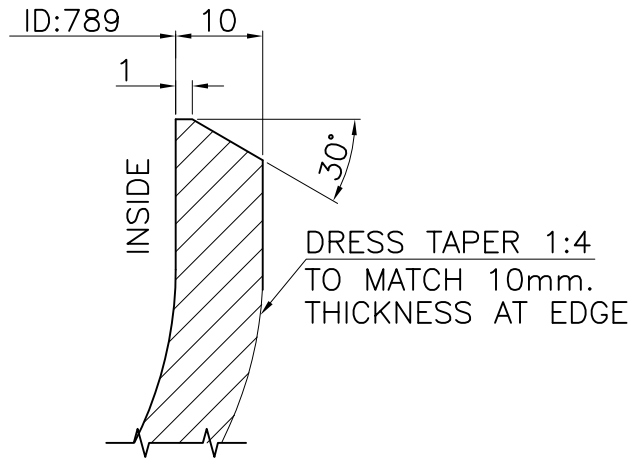
FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm

DRG. NO. 2-16503-40493



03 2:1 ELLIPSOIDAL DISHED END



EDGE PREP. DETAIL

DETAIL-A 02

न्यूक्लियर पावर कॉर्पोरेशन ऑफ इंडिया लिमिटेड
Nuclear Power Corporation of India Limited

- ☑ अनुमोदित / APPROVED
- ☐ टिप्पणी के अनुसार अनुमोदित / APPROVED AS NOTED
- ☐ संचिरचन को आगे बढ़ाएं / रोकें / PROCEED WITH/HOLD FABRICATION
- ☐ अंतिम ट्रांसपेरेन्सी एवं प्रतियाँ 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
23.09.2020 Gaurav Dubey	विधर्माधिकारी 23-09-2020 S.B.Dharmadhikari.	

किए जानेवाले कार्य का अनुमोदन आपूर्तिकर्ता संविदाकार को दिशिर्देशों 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) :-

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.

QTY. VAR00	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	VAR.	IT.NO.	MATL. CODE	A/C	UNIT	MATL. SPCN.	UNIT WT.	QTY.	GS	ZONE
01	BLANK ø1040		01	DISHED END 12 TK.					B.O. SA240TP304L				75.6 R/M 81.0			

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 3.2 OR BETTER.
REMOVE ALL BURRS.
REMOVE ALL EXTERNAL SHARP CORNERS AND EDGES BY CHAMFERING TO $^{0.15}_{0.40}$ x 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	रे.रि. की संख्या NO. OF VAR.
बनाया DRN.	विजय कुमार कुशवाहा		15/02/2019	–
जाँचा CKD.	नागेन्द्र सिंह अरुण कुमार सिंह		15/02/2019	
स्वीकृत APPD.	ए.के.माहौर		15/02/2019	

विभाग DEPT	उत्प. टा. नाप की त्रेणी 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)

इंजी.ग क्र./DRAWING NO.: 2-16503-40493 पुन/REV. 03

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

REV.	DATE	ALTERED / CHECKED / APPROVED	REMARKS
03	10.09.2020	ALTERED मोद कुमार जाजवाल; CHECKED नागेन्द्र सिंह; APPROVED ए.के.माहौर	– REVISION AS MARKED 03
02	13.03.2020	ALTERED मोद कुमार जाजवाल; 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.

A2