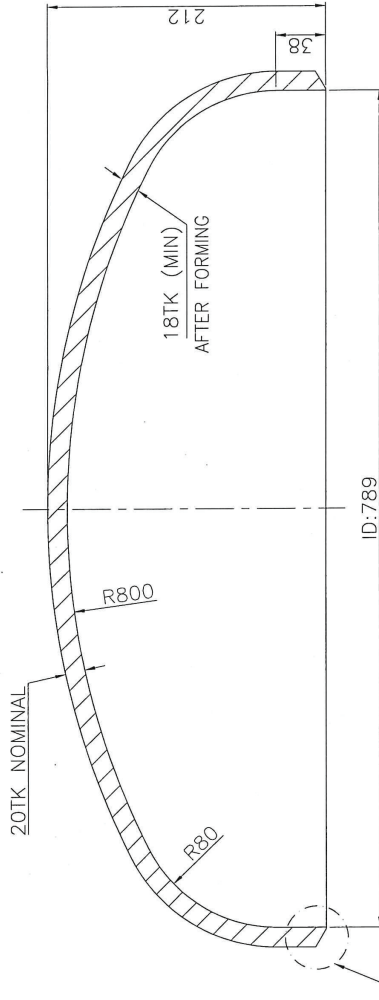


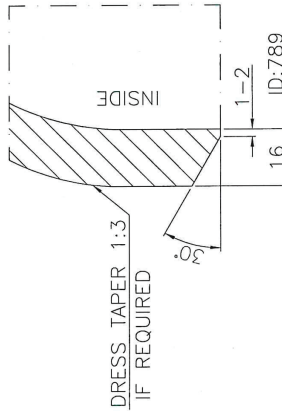
### TECHNICAL REQUIREMENTS (TR) :-

1. SHAPE OF DISHED END : TORISPHERICAL
2. DISHED ENDS SHALL BE MANUFACTURED AS PER ND-4200 OF ASME SECTION-III ND AND NPCIL APPROVED TECHNICAL SPECIFICATION NO : BHEL/NPCIL/30599/CS DISHED ENDS/CDE-19-3425.
3. FORMING PROCEDURE QUALIFICATION TEST TO BE CONDUCTED ON TEST COUPONS AS PER CLAUSE NO-8 OF SPECIFICATION NO : BHEL/NPCIL/30599/CS DISHED ENDS/CDE-19-3425.
4. PLATE MATERIAL TO BE USED FOR FORMING SHALL BE IN NORMALISED CONDITION & ULTRASONICALLY EXAMINED AS PER SA 578 LEVEL-B.
5. AFTER FORMING COMPLETE DISH END (INSIDE & OUTSIDE) INCLUDING KNUCKLE PORTION & EDGE PREPARED ENDS SHALL BE CHECKED BY LIQUID PENETRATION EXAMINATION AS PER SPECIFICATION NO : BHEL/NPCIL/30599/CS DISHED ENDS/CDE-19-3425 CLAUSE NO.11.
6. TOLERANCE ON FORMING : AS PER CLAUSE ND-4222 OF ASME SECTION-III ND, UNLESS OTHERWISE SPECIFIED
7. PRESSING TO BE DONE FROM SINGLE PIECE BLANK.
8. HEAT TREATMENT(HT) – AS PER SPECIFICATION NO. BHEL/NPCIL/30599/CS DISHED ENDS/CDE-19-3425. .



ID:789

DETAIL-A

[illegible]

DRESS TAPER 1:3  
IF REQUIRED

16 ID:789

## EDGE PREP. DETAIL

## DETAIL-A

**DO NOT SCALE THE DRAWING, UNLESS OTHERWISE STATED:—**

ALL DIMENSIONS ARE IN mm.

MACHINE ALL OVER.

SURFACE FINISH TO BE  $\sqrt{R}$  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  $R_{0.5}$ .

TOLERANCES ON RADI AND CHAMFERS (IS : 2102)

RADI AND CHAMFERS	0.5-1.2	1.2-6	6-30
TOLERANCES	$\pm 0.1$	$\pm 0.05$	$\pm 0.03$

TOLERANCE ON LINEAR DIMENSIONS (IS:2102)			
DIMENSIONS	TOL.	DIMENSIONS	TOL.
UP TO 6	$\pm 0.1$	315 - 1000	$\pm 0.8$
6 - 30	$\pm 0.2$	1000 - 2000	$\pm 1.2$
30 - 120	$\pm 0.3$	2000 - 4000	$\pm 2.0$
120 - 315	$\pm 0.5$	4000 - 8000	$\pm 3.0$

TOLERANCE ON LINEAR DIMENSIONS	
SPECIFIED DIMENSIONS	TOLERANCE
XX	$\pm 0.40$
XX.X	$\pm 0.40$
XX.XX	$\pm 0.25$

TOLERANCE ON ANGULAR DIMENSIONS : $\alpha = 0^\circ$ & $90^\circ$	
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[illegible]

28 ———→ CARD TYPE-2

**NUCLEAR POWER CORPORATION OF INDIA LIMITED**  
(A GOVERNMENT OF INDIA ENTERPRISE)

PROJECT : GORAKHPUR HARIYANA ANU VIDHYUT PARITYOJANA 1&2 (700 MWe)  
(A GOVERNMENT OF INDIA ENTERPRISE)  
NPCIL PURCHASE ORDER NO. : CMM/FTP/10-33-1-1149/e-P/O/30559, DATED 25.01.2019  
NDCCL DRAWING NO. : CHAD-1&2/32221/2003/IND PREV 00

BLEED COOLER

[illegible]